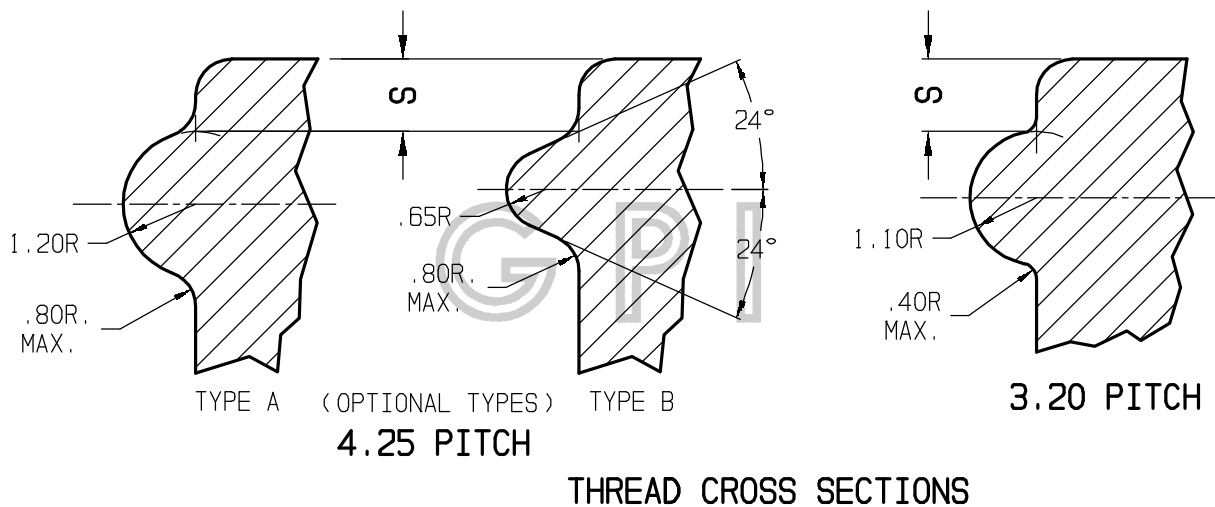


START AND FINISH OF
THREAD TO CONFORM
TO CUTTER RADIUS

SIZE	T	E	H SEE NOTE 1	I MIN.	S	L MIN.	W APPROX.	B	CUT. DIA.	THREAD TURNS MIN.	T.P.I.
18	17.65 ±.25	15.50 ±.25	13.05 ±.35	8.30	0.90 ±.30	8.75	2.00	3° 31'	9.50	1.5	3.20
20	19.65 ±.25	17.50 ±.25	13.80 ±.35	10.30	0.90 ±.30	8.75	2.00	3° 8'	9.50	1.5	3.20
22	21.65 ±.25	19.50 ±.25	14.60 ±.35	12.30	0.90 ±.30	9.15	2.00	2° 50'	9.50	1.5	3.20
24	23.60 ±.25	21.50 ±.25	16.15 ±.35	13.10	1.20 ±.40	10.70	2.00	2° 35'	9.50	2.0	3.20
28	27.30 ±.35	24.90 ±.35	17.75 ±.35	16.30	1.20 ±.40	10.30	2.40	2° 58'	12.70	1.25	4.25

- 'H' DIMENSION REPRESENTS DISTANCE FROM TOP OF FINISH DOWN TO POINT WHERE LINE TANGENT TO 'T' INTERSECTS TOP OF SHOULDER. WHEN SHOULDER IS FORMED IN THE BLOW MOLD 'H' DIMENSION PLUS TOLERANCE IS INCREASED BY .40.
- B = HELIX ANGLE OR ANGLE OF FIXTURE TO CUTTER.
- TANGENT $B = \frac{\text{PITCH}}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
- NUMBER OF TURNS OF THREAD INDICATED IN CHART SHOULD BE MAINTAINED; WITH FULL PROJECTION EXCEPT WHEN DEPRESSED OR INTERRUPTED AT MOLD SEAMS. REFER TO GLASS FINISH NO. 405 FOR DEPRESSED THREAD DETAIL.
- CONTOUR OF BEAD IS OPTIONAL PROVIDED THE DIAMETER AND 'W' ARE ADHERED TO.
- 'I' DIMENSION IS MEASURED THROUGH FULL LENGTH OF FINISH.
- FOR ALL SPECIAL APPLICATIONS, THE END USER SHOULD OBTAIN SPECIFICATIONS FROM THE SPECIFIC CLOSURE MANUFACTURER.



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GLASS FINISH NUMBER 410M		GPI DWG. NO.	
METRIC MEDIUM CONTINUOUS THREAD CONCEALED BEAD FINISH		FM-4104	