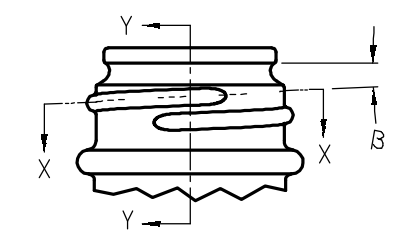


SECTION Y-Y

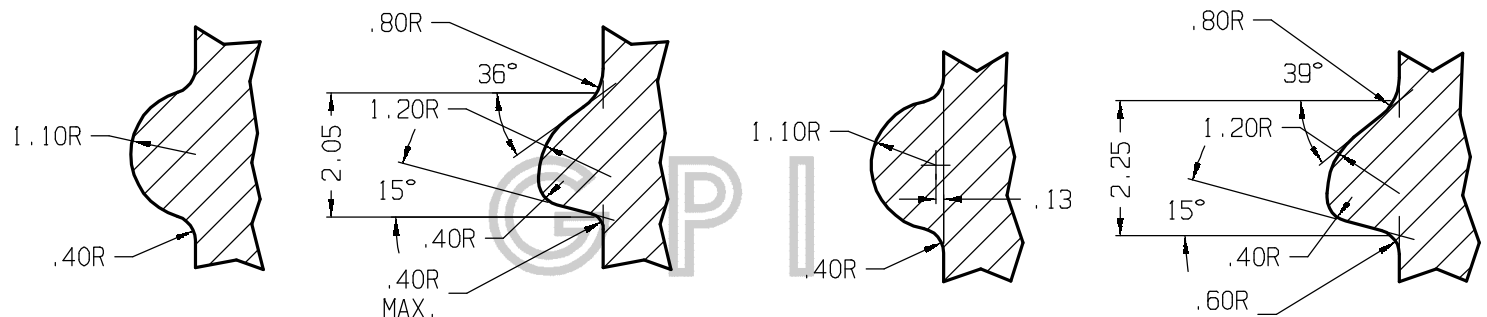


SECTION X-X

START AND END OF  
THREAD TO CONFORM  
TO CUTTER RADIUS

SIZE	T	E	H	S	I MIN.	R MAX.	R <sub>1</sub>	R <sub>2</sub>	N	Z FLAT	G	Δ	B	CUT DIA.	T.P.I.
18	17.65 ±.25	15.50 ±.25	11.90 ±.20	4.20 ±.20	7.30	1.10	0.80	0.80	13.35 ±.25	0.80	4.00	1.80	3° 31'	9.50	3.20
20	19.65 ±.25	17.50 ±.25	12.30 ±.20	4.20 ±.20	9.30	1.10	0.80	0.80	15.35 ±.25	0.80	4.00	1.80	3° 8'	9.50	3.20
22	21.65 ±.25	19.50 ±.25	12.30 ±.20	4.20 ±.20	11.10	1.10	0.80	0.80	17.35 ±.25	0.80	4.00	1.80	2° 50'	9.50	3.20
24	23.60 ±.25	21.50 ±.25	13.10 ±.20	5.00 ±.20	13.10	1.10	0.80	0.80	19.30 ±.25	0.80	4.80	1.80	2° 35'	9.50	3.20
28	27.30 ±.35	24.90 ±.35	13.50 ±.20	5.40 ±.20	15.60	1.60	1.20	1.60	22.80 ±.25	1.20	5.20	1.80	2° 14'	12.70	3.20
30	28.30 ±.35	25.90 ±.35	13.55 ±.25	5.40 ±.20	16.60	1.60	1.20	1.60	23.80 ±.25	1.20	5.20	1.80	2° 9'	12.70	3.20
33	31.80 ±.35	29.40 ±.35	13.90 ±.25	5.75 ±.20	19.60	2.00	1.20	1.60	26.90 ±.35	1.20	5.55	2.05	1° 54'	12.70	3.20
35	34.20 ±.45	31.85 ±.45	13.90 ±.25	5.75 ±.20	21.10	2.00	1.20	1.60	29.20 ±.35	1.20	5.55	2.05	1° 46'	12.70	3.20
38	37.05 ±.45	34.65 ±.45	15.20 ±.25	7.05 ±.25	23.80	2.00	1.20	1.60	32.05 ±.35	1.20	6.75	2.05	1° 38'	12.70	3.20
43	41.60 ±.45	39.20 ±.45	15.20 ±.25	7.05 ±.25	28.20	2.00	1.20	1.60	36.55 ±.35	1.20	6.75	2.05	1° 27'	12.70	3.20
48	47.05 ±.45	44.65 ±.45	15.20 ±.25	7.40 ±.25	33.50	2.00	1.20	1.60	42.05 ±.35	1.20	6.75	2.05	1° 17'	12.70	3.20
63	62.00 ±.50	59.60 ±.50	15.35 ±.40	7.40 ±.40	49.00	2.00	1.20	1.60	57.05 ±.35	1.20	6.75	2.05	0° 58'	12.70	3.20

- 'H' DIMENSION REPRESENTS DISTANCE FROM TOP OF FINISH DOWN TO POINT WHERE LINE TANGENT TO 'T' INTERSECTS TOP OF BEAD. WHEN FINISH IS MADE WITHOUT BEAD, 'H' DIMENSION IS MEASURED TO SHOULDER AND ITS PLUS TOLERANCE IS INCREASED BY .65.
- B = HELIX ANGLE OR ANGLE OF FIXTURE TO CUTTER.
- TANGENT  $B = \frac{\text{PITCH}}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
- THREAD START TO BE 90° FROM PARTING LINE. A MINIMUM OF ONE TURN OF THREAD 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 OR TRANSFER RING TO BE OPTIONAL PROVIDED TOP OF BEAD CLEARS A 5° MINIMUM DOWNWARD ANGLE.
- 'I' DIMENSION IS MEASURED THROUGH FULL LENGTH OF FINISH.



SIZES 18 THROUGH 24  
(OPTIONAL TYPES)

SIZES 28 THROUGH 63  
(OPTIONAL TYPES)

THREAD CROSS SECTIONS

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