



THREAD CROSS SECTIONS

SIZE	T	E	H	R	S	B	CUT. DIA. MAX.	T.P.I.
70	2.750 ±.020	2.625 ±.020	0.648 ^{+.018} / _{-.017}	0.078 MAX.	0.098 ^{+.020} / _{-.019}	1° 42'	1.500	4
86	3.400 ±.020	3.275 ±.020	0.692 ±.020	0.078	0.098 ^{+.020} / _{-.019}	1° 22'	1.500	4
96	3.748 ^{+.022} / _{-.023}	3.623 ^{+.022} / _{-.023}	0.698 ±.020	0.078	0.098 ^{+.020} / _{-.019}	1° 14'	1.500	4
132	5.168 ^{+.027} / _{-.028}	5.010 ^{+.027} / _{-.028}	0.779 ^{+.023} / _{-.022}	0.078	0.098 ^{+.020} / _{-.019}	0° 54'	1.500	4

- '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 .025.
- B = HELIX ANGLE OR ANGLE OF FIXTURE TO CUTTER.
- TANGENT B = $\frac{\text{PITCH}}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
- 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.
- FOR ALL SPECIAL APPLICATIONS, THE END USER SHOULD OBTAIN SPECIFICATIONS FROM THE SPECIFIC CLOSURE MANUFACTURER.

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Edward Grant CHAIRMAN	PRINTED AND DISTRIBUTED AS A VOLUNTARY STANDARD BY GLASS PACKAGING INSTITUTE COMMITTEE ON DESIGN AND SPECIFICATIONS	APPROVED FOR PUBLICATION 6-21-01	SUPERSEDES DWG. NO. 4535
GLASS FINISH NUMBER 450		GPI DWG. NO.	
DEEP CONTINUOUS THREAD FINISH		4536	