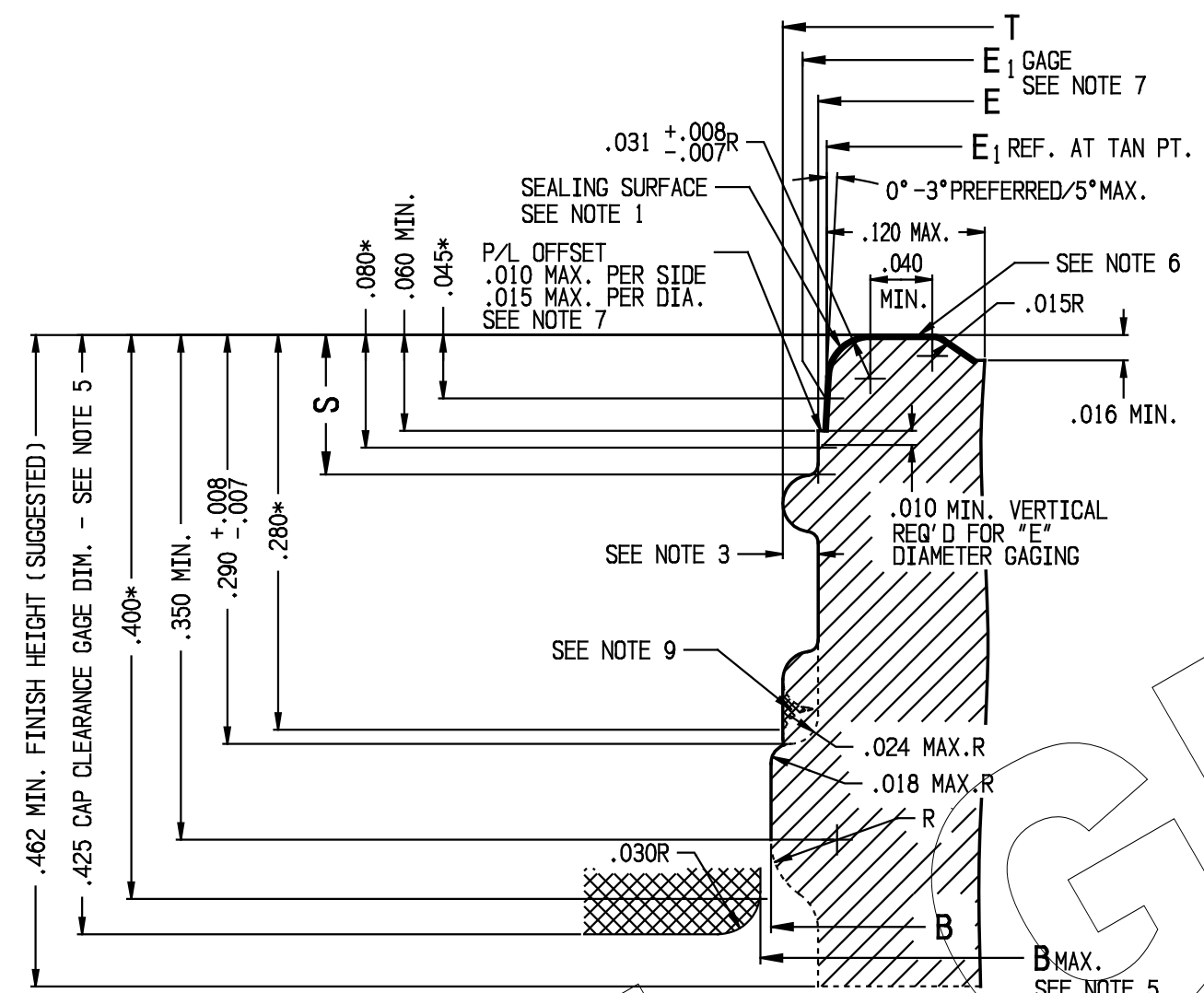
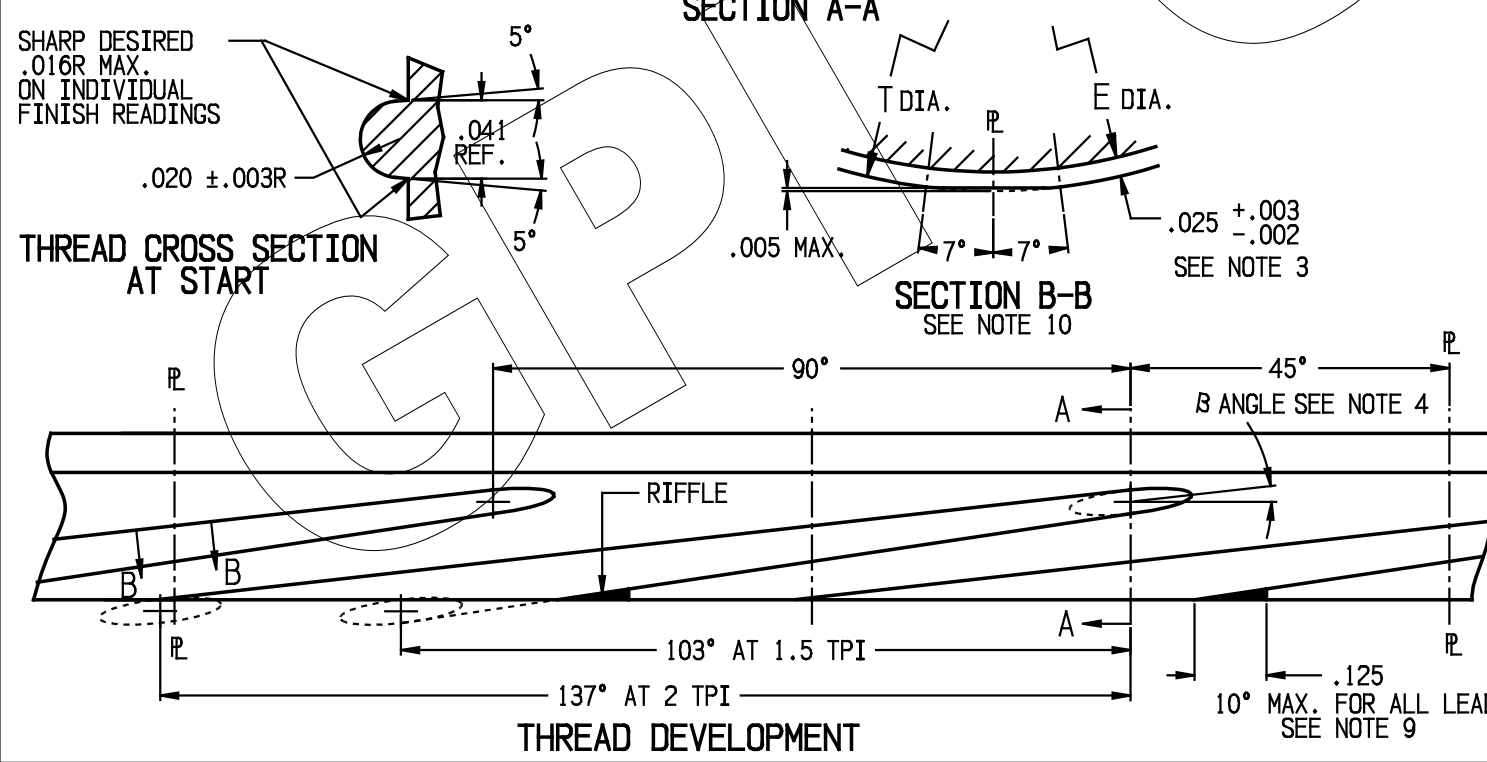


SIZE	T		E		E ₁ GAGE		E ₁	B		S		B	CTR. DIA.	LEADS	T.P.I.
	IDEAL	TOL.	IDEAL	TOL.	IDEAL	TOL.	REF.	IDEAL	TOL.	IDEAL	TOL.				
38	1.439	±.015	1.389	±.015	1.383	±.015	1.377	1.456	±.015	.099	+ ^{.008} / _{.007}	6°25'	.375	4	2.0 & 1.5



- THIS IS A TOP AND SIDE SEAL FINISH AND PROPER FUNCTION OF THE CLOSURE REQUIRES A SMOOTH SEALING SURFACE FREE OF CRIZZLES, DIPS AND OTHER SUCH IRREGULARITIES. SEALING SURFACE IS IDENTIFIED WITH A BOLD LINE AND THE .040 MIN. FLAT IS TO BE MAINTAINED.
- PROPER FUNCTION OF CLOSURE REQUIRES THAT "E₁", "E", "T" & "B" DIAMETERS TO BE AS LITTLE OUT-OF-ROUND AS POSSIBLE AND THE "E" AND "B" DIAMETERS BE PERPENDICULAR TO THE TOP OF FINISH. THE MAX. AND MIN. AVERAGES OF THESE DIAMETERS SHOULD BE AS CLOSE TO "IDEAL" AS POSSIBLE.
- PROPER CAM-OFF OF CLOSURE REQUIRES THAT THE THREADS PROJECT .025 +.003/-.002 OUT FROM THE 'E' DIA. BUT NOT TO EXCEED THE 'B' DIA. THREAD PROFILE MUST BE WELL DEFINED AND WITHIN THE .020 RADIUS ±.003
- FOUR LEADS, .375 IN. CUTTER DIAMETER, CUTTER INCLINED TO THE BETA ANGLE FOR ALL CUTS. TWO CUTTER PASSES REQUIRED PER LEAD. THE BETA ANGLE CORRESPONDS TO THE CUT AT 2.0 T.P.I., HOWEVER, THE CUTTER IS HELD AT THE SAME INCLINATION FOR THE SECOND CUT AT 1.5 T.P.I.
- SUGGESTED BEAD CONSTRUCTION IS SHOWN. BEAD MUST CLEAR CAP LIMITS SHOWN BY CROSSHATCHED AREA ABOVE THE .425 DIMENSION.
- A LEVEL TOP FINISH IS IDEAL. MAXIMUM SADDLE IS .010" WITHIN 180°. CORRECTIONS SHOULD BE MADE IF A GLASS LOT CHECK SHOWS IT "RUNNING TOWARD MAX. SADDLES".
- THE THICK LINE REFERS TO THE ONE PIECE TOP RING. THE OFFSET BETWEEN THE ONE PIECE TOP RING AND THE REMAINDER OF THE FINISH AT THE .060 MIN. DEPTH MAY BE UP TO .010" PER SIDE, .015" MAX. PER DIAMETER; I.E. THE AMOUNT ON ONE SIDE ADDED TO THE AMOUNT ON THE OTHER SIDE (DIAMETRICALLY OPPOSED) MUST NOT EXCEED .015" FOR PROPER CLOSURE FUNCTION. AN OVERHANG OUTSIDE THE "E" DIAMETER IS NOT PERMITTED. IT IS RECOMMENDED THAT THE "E₁" DIAMETER BE AS CONCENTRIC TO THE "E" DIAMETER AS POSSIBLE AS MEASURED AT THE GAGE POINT PER SECTION A-A.
- VERTICAL DIMENSIONS WITH ASTERISKS (*) DENOTE THE GAGING DEPTHS FOR THE "E₁", "E", "T", AND "B" DIAMETERS.
- OPTIONAL - THIS AREA AS SPECIFIED MAY BE FILLED IN WITH GLASS NOT TO EXCEED THE THREAD PROJECTION.
- OPTIONAL - FOR RELIEF OF MOLD OPENINGS. THREAD PROJECTION MAY BE DEPRESSED AT THE PARTING LINE. MAXIMUM ALLOWABLE DEPRESSION IS .005 PER SIDE FROM THE AVERAGE OF ACTUAL THREAD PROJECTIONS MEASURED ON A 7° ARC ON EITHER SIDE OF THE PARTING LINE. RIFFLING MAY BE INCORPORATED IN THE SAME AREA IF REQUIRED FOR PROPOER MOLD OPENING.
- TANGENT B = $\frac{LEAD}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$



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38 mm PRESS ON TWIST OFF MULTI-PASS FINISH (4 LEADS)			2225-00