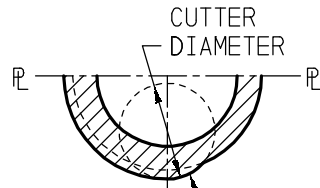
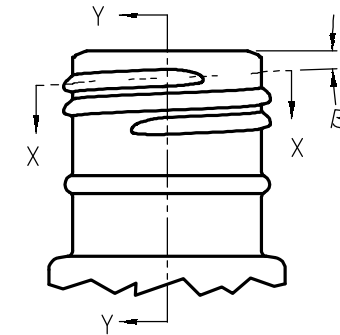
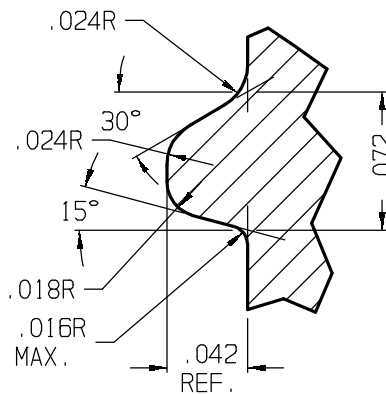


SECTION Y-Y

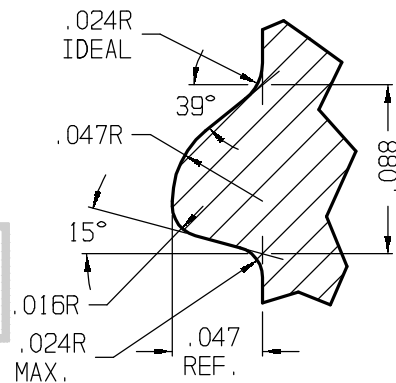


START AND STOP OF
THREAD TO CONFORM
TO CUTTER RADIUS

SECTION X-X



10 T.P.I.



8 T.P.I.
THREAD CROSS SECTIONS

SIZE	T	E	S	H	I	L	W	B	CUT. DIA.	T.P.I.
					MIN.	MIN.	APPR.			
20	0.773 ±.010	0.689 ±.010	0.095 ±.010	0.732 ^{+.013} / _{-.012}	0.404	0.440	0.078	2° 30'	0.375	10
22	0.852 ±.010	0.768 ±.010	0.095 ±.010	0.827 ^{+.013} / _{-.012}	0.483	0.530	0.078	2° 15'	0.375	10
24	0.930 ±.010	0.846 ±.010	0.095 ±.010	0.947 ^{+.013} / _{-.012}	0.516	0.545	0.078	2° 3'	0.375	10
28	1.076 ^{+.012} / _{-.013}	0.982 ^{+.012} / _{-.013}	0.095 ±.010	1.072 ^{+.013} / _{-.012}	0.680	0.639	0.094	2° 13'	0.500	8

- '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 .015.
- 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 TWO TURNS 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 IS OPTIONAL PROVIDED THE DIAMETER AND 'W' ARE ADHERED TO.
- 'I' DIMENSION IS MEASURED THROUGH FULL LENGTH OF FINISH.
- THIS FINISH TO BE MADE SMOOTH TOP CONSTRUCTION.

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CONTINUOUS THREAD FINISH FOR POLYPROPYLENE LINERLESS CLOSURE		4225	