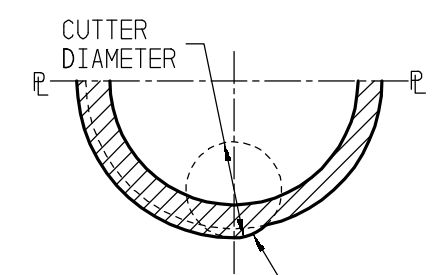
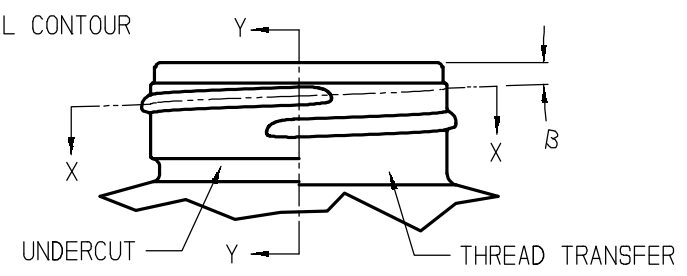
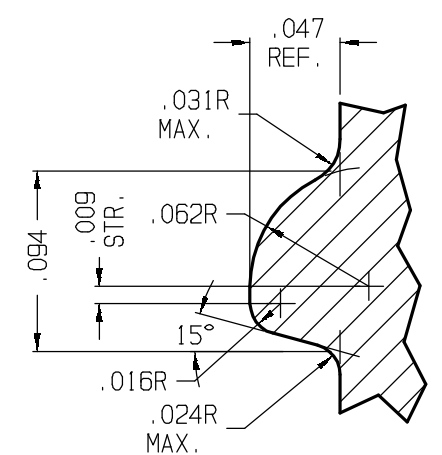


SECTION Y-Y



SECTION X-X



5 & 6 T.P.I.
THREAD CROSS SECTION

SIZE	T	E	S	H	B	CUT DIA.	T.P.I.
43	1.637 ^{+0.017} / _{-.018}	1.543 ^{+0.017} / _{-.018}	0.128 ^{+0.016} / _{-.015}	0.638 ^{+0.018} / _{-.017}	1° 55'	0.500	6
48	1.853 ^{+0.017} / _{-.018}	1.759 ^{+0.017} / _{-.018}	0.163 ^{+0.016} / _{-.015}	0.673 ^{+0.018} / _{-.017}	1° 41'	0.500	6
53	2.050 ^{+0.017} / _{-.018}	1.956 ^{+0.017} / _{-.018}	0.163 ^{+0.016} / _{-.015}	0.673 ^{+0.018} / _{-.017}	1° 31'	0.500	6
56	2.128 ^{+0.017} / _{-.018}	2.034 ^{+0.017} / _{-.018}	0.163 ^{+0.016} / _{-.015}	0.673 ^{+0.018} / _{-.017}	1° 28'	0.500	6
58	2.207 ^{+0.017} / _{-.018}	2.113 ^{+0.017} / _{-.018}	0.163 ^{+0.016} / _{-.015}	0.673 ^{+0.018} / _{-.017}	1° 25'	0.500	6
63	2.441 ±.020	2.347 ±.020	0.163 ^{+0.016} / _{-.015}	0.673 ^{+0.018} / _{-.017}	1° 17'	0.500	6
66	2.559 ±.020	2.465 ±.020	0.163 ^{+0.016} / _{-.015}	0.673 ^{+0.018} / _{-.017}	1° 13'	0.500	6
70	2.716 ±.020	2.622 ±.020	0.163 ^{+0.016} / _{-.015}	0.673 ^{+0.018} / _{-.017}	1° 8'	0.500	6
75	2.893 ±.020	2.799 ±.020	0.163 ^{+0.016} / _{-.015}	0.673 ^{+0.018} / _{-.017}	1° 4'	0.500	6
83	3.222 ±.020	3.128 ±.020	0.163 ^{+0.016} / _{-.015}	0.673 ^{+0.018} / _{-.017}	1° 9'	0.500	5

- '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.
- 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.
- FLAT SEALING SURFACE INDICATED BY HEAVY LINE IS RECOMMENDED FOR BEST SEALING.
- B = HELIX ANGLE OR ANGLE OF FIXTURE TO CUTTER.
- TANGENT $B = \frac{\text{PITCH}}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
- THE STEP AT TOP OF 'E' WALL IS FOR CLEARANCE OF LINER RETENTION BEAD IN CLOSURE AND TO ALLOW ADDITIONAL OVERHANG OF TACSEAL MATERIAL. THIS STEP MUST BE CONTROLLED IN GLASS FOR A DEPTH OF .109±.015.

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C.T. FINISH FOR LINER RETENTION CLOSURE			4525	

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