



SIZE	T		E		E ₁		S	B	I MIN.	β	CUT DIA.	T.P.I.
	IDEAL	TOL.	IDEAL	TOL.	IDEAL	TOL.						
40	1.565	±.015	1.471	±.015	1.465	±.015	0.117 ^{+.008} _{-.007}	1.555 ±.015	1.035	2°	0.500	6

- THIS IS A VACUUM TOP & SIDE SEAL FINISH AND PROPER FUNCTION OF CLOSURE REQUIRES A SMOOTH SEALING SURFACE FREE OF IRREGULARITIES THAT WOULD PREVENT A VACUUM SEAL FROM BEING MADE. SEALING SURFACE IS DENOTED BY A HEAVY BLACK LINE AND IS TO BE FORMED IN A ONE PIECE "SLEEVE" OR "GUIDE RING". NO SEAMS OR PARTING LINES PERMITTED. THE .040 FLAT IS TO BE MAINTAINED.
- A MINIMUM OF ONE COMPLETE TURN OF THREAD PROJECTION SHOULD BE MAINTAINED EXCEPT WHEN DEPRESSED AT MOLD SEAMS.
- OPTIONAL - FOR RELIEF OF MOLD OPENING. THREAD PROJECTION MAY BE DEPRESSED AT THE PARTING LINE. MAXIMUM ALLOWABLE DEPRESSION IS .006 PER SIDE FROM THE AVERAGE OF ACTUAL THREAD PROJECTIONS MEASURED ON A 6° ARC ON EITHER SIDE OF THE PARTING LINE.
- PARTING LINE OFFSET AT .065 MIN. DEPTH MAY BE UP TO .010 ON A SIDE WITH A .015 MAXIMUM PER DIAMETER. I.E. AMOUNT ON ONE SIDE ADDED TO AMOUNT ON OTHER SIDE OF SAME DIAMETER CAN BE EQUAL TO OR LESS THAN .015. AN OVERHANG OF THE .065 MIN. SECTION OUTSIDE OF THE 'E' DIAMETER IS NOT PERMITTED.
- 'I' DIMENSION IS MEASURED THROUGH ENTIRE LENGTH OF FINISH.
- CROSS-HATCHED AREA SHOWS CONTOUR TO BE CLEARED BY THE TOP OF GLASS FINISH.
- SUGGESTED BEAD CONSTRUCTION IS SHOWN BUT MUST CLEAR CAP LIMITS SHOWN BY CROSS-HATCHED AREA ABOVE .525 DIMENSION.
- β = HELIX ANGLE OR ANGLE OF FIXTURE TO CUTTER.
- TANGENT β = $\frac{\text{PITCH}}{\pi (\text{MEAN BETWEEN MEAN 'T' AND MEAN 'E'})}$
- MINIMUM SPECIFICATION DOES NOT APPLY TO 'E' BELOW BOTTOM END OF THREAD.
- A LEVEL TOP FINISH IS IDEAL. MAXIMUM SADDLE IS .010 WITHIN 180°. CORRECTIONS SHOULD BE MADE IF GLASS LOT CHECK SHOWS IT "RUNNING TOWARD MAXIMUM SADDLES."
- FOR OPTIMUM PACKAGE PERFORMANCE A DRAFT ANGLE OF 0° TO 3° IS PREFERRED. INDIVIDUAL READINGS OVER 5° ARE NOT PERMITTED.
- VERTICAL DIMENSIONS WITH (*) DENOTES THE GAGING DEPTHS FOR THE "E₁" AND "E" DIAMETERS.
- "E" DIAMETER IS MEASURED AT THIS LOCATION AND REPRESENTS ENTIRE "E" HEIGHT. THEREFORE IT MUST BE AS VERTICAL AS POSSIBLE WITHOUT IRREGULARITIES THAT INFLUENCE "E" DIA. MEASUREMENTS.

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