



SIZE	T	E	H	I	R	S	B	CUT. DIA.	PITCH
			SEE NOTE 1	MIN.	MAX.				
18	17.65 ±.25	15.50 ±.25	9.05 ±.20	8.3	1.1	0.9 ±.3	3° 31'	9.5	3.20
20	19.65 ±.25	17.50 ±.25	9.05 ±.20	10.3	1.1	0.9 ±.3	3° 8'	9.5	3.20
22	21.65 ±.25	19.50 ±.25	9.05 ±.20	12.3	1.1	0.9 ±.3	2° 50'	9.5	3.20
24	23.60 ±.25	21.50 ±.25	9.80 ±.20	13.1	1.1	1.2 ±.4	2° 35'	9.5	3.20
28	27.30 ±.35	24.90 ±.35	9.80 ±.20	16.3	1.6	1.2 ±.4	2° 58'	12.7	4.25
30	28.30 ±.35	25.90 ±.35	9.85 ±.25	16.6	1.6	1.2 ±.4	2° 51'	12.7	4.25
33	31.80 ±.35	29.40 ±.35	9.85 ±.25	20.1	2.0	1.2 ±.4	2° 32'	12.7	4.25
35	34.20 ±.45	31.85 ±.45	9.85 ±.25	22.2	2.0	1.2 ±.4	2° 21'	12.7	4.25
38	37.05 ±.45	34.65 ±.45	9.85 ±.25	25.1	2.0	1.2 ±.4	2° 10'	12.7	4.25
40	39.70 ±.45	37.30 ±.45	9.85 ±.25	27.7	2.0	1.2 ±.4	2° 1'	12.7	4.25
43	41.60 ±.45	39.20 ±.45	9.85 ±.25	29.6	2.0	1.2 ±.4	1° 55'	12.7	4.25
45	43.75 ±.45	41.35 ±.45	9.85 ±.25	31.8	2.0	1.2 ±.4	1° 49'	12.7	4.25
48	47.05 ±.45	44.65 ±.45	9.85 ±.25	35.1	2.0	1.2 ±.4	1° 41'	12.7	4.25
51	49.55 ±.45	47.15 ±.45	10.00 ±.40	37.6	2.0	1.2 ±.4	1° 36'	12.7	4.25
53	52.05 ±.45	49.65 ±.45	10.00 ±.40	40.1	2.0	1.2 ±.4	1° 31'	12.7	4.25
58	56.05 ±.45	53.65 ±.45	10.00 ±.40	44.1	2.0	1.2 ±.4	1° 25'	12.7	4.25
60	59.00 ±.50	56.60 ±.50	10.00 ±.40	47.1	2.0	1.2 ±.4	1° 20'	12.7	4.25
63	62.00 ±.50	59.60 ±.50	10.00 ±.40	50.1	2.0	1.2 ±.4	1° 12'	12.7	4.25
66	65.00 ±.50	62.60 ±.50	10.00 ±.40	53.1	2.0	1.2 ±.4	1° 13'	12.7	4.25
70	69.00 ±.50	66.60 ±.50	10.00 ±.40	57.1	2.0	1.2 ±.4	1° 9'	12.7	4.25
75	73.50 ±.50	71.10 ±.50	10.00 ±.40	61.6	2.0	1.2 ±.4	1° 4'	12.7	4.25
77	76.60 ±.50	74.20 ±.50	12.00 ±.40	64.7	2.0	1.6 ±.4	1° 2'	12.7	4.25
83	82.50 ±.50	79.45 ±.50	12.00 ±.40	69.9	2.0	1.6 ±.4	1° 9'	12.7	5.10
89	88.65 ±.55	85.60 ±.55	13.20 ±.40	74.1	2.0	1.6 ±.4	1° 4'	12.7	5.10
100	99.45 ±.55	96.40 ±.55	14.80 ±.40	84.9	2.0	1.6 ±.4	0° 57'	12.7	5.10
110	109.40 ±.60	106.35 ±.60	14.80 ±.40	94.9	2.0	1.6 ±.4	0° 53'	12.7	5.10
120	119.35 ±.65	116.30 ±.65	17.00 ±.40	104.9	2.0	1.6 ±.4	0° 47'	12.7	5.10

- "H" DIMENSION REPRESENTS DISTANCE FROM TOP OF FINISH DOWN TO POINT WHERE LINE TANGENT TO "T" INTERSECTS TOP OF BEAD. WHERE BEAD DIAMETER AND CONSTRUCTION IS AT OR NEAR SPECIFIED "T" DIAMETER, THE PLUS TOLERANCE IS NOT REQUIRED. WHEN FINISH IS MADE WITHOUT BEAD, "H" DIMENSION IS MEASURED TO SHOULDER AND ITS PLUS TOLERANCE IS INCREASED BY .40 ON SIZES UP TO AND INCLUDING 28 AND BY .65 ON SIZES LARGER THAN 28.
- B = HELIX 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 5°.
- "I" DIMENSION IS MEASURED THROUGH FULL LENGTH OF FINISH.
- FOR ENGLISH DIMENSIONS PLEASE REFER TO GPI DRAWING FOR 400 FINISHES.
- MANY CHILD RESISTANT CLOSURES RELY ON DISSIMILAR SIMULTANEOUS MOTIONS FOR THEIR PROPER FUNCTION. THE GPI 400 FINISH DOES NOT NECESSARILY PROVIDE PHYSICAL SPACE FOR THESE MOTIONS. ANY USER SHOULD OBTAIN SPECIFICATIONS FROM THE SPECIFIC CLOSURE MANUFACTURER.
- FOR ALL SPECIAL APPLICATIONS, THE END USER SHOULD OBTAIN SPECIFICATIONS FROM THE SPECIFIC CLOSURE MANUFACTURER.

5.10 PITCH  
THREAD CROSS  
SECTIONS

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