

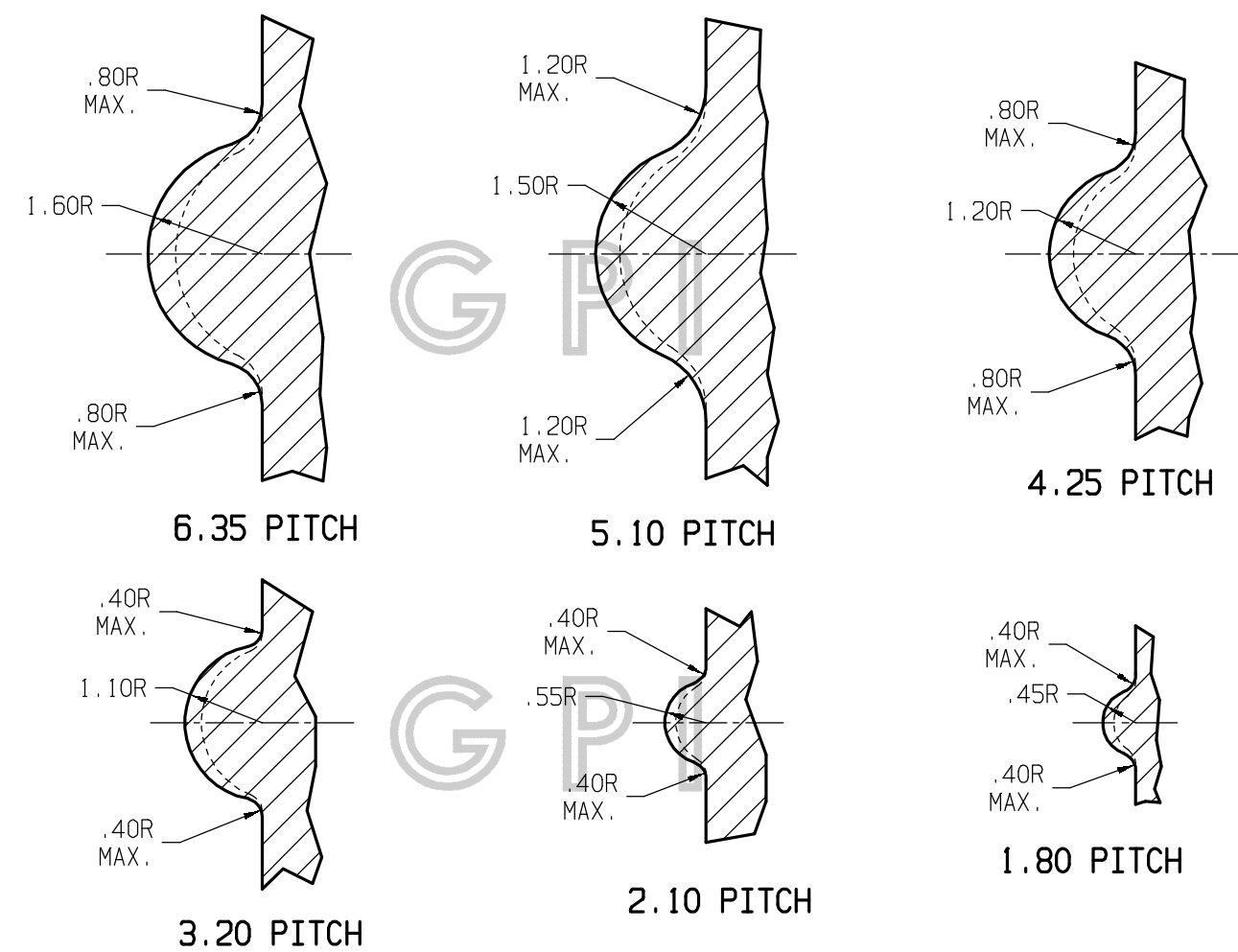
SIZE	PITCH	CUT. DIA.	α_1	α_2	REF. DEPRESS. MAX.	APPROX. CHORD	SIZE	PITCH	CUT. DIA.	α_1	α_2	REF. DEPRESS. MAX.	APPROX. CHORD
8	1.80	6.75	31°05'	62°10'	0.15	0.80	51	4.25	12.70	17°	34°	0.35	9.90
10	1.80	6.75	31°05'	62°10'	0.15	2.00	53	4.25	12.70	17°	34°	0.35	10.85
13	2.10	9.50	24°15'	48°30'	0.15	0.80	58	4.25	12.70	17°	34°	0.35	11.90
15	2.10	9.50	24°15'	48°30'	0.15	2.00	60	4.25	12.70	17°	34°	0.35	12.70
18	3.20	9.50	25°10'	50°20'	0.25	3.20	63	4.25	12.70	17°	34°	0.35	13.50
20	3.20	9.50	25°10'	50°20'	0.25	4.35	66	4.25	12.70	12°	24°	0.35	9.10
22	3.20	9.50	25°10'	50°20'	0.25	5.55	70	4.25	12.70	12°	24°	0.35	9.90
24	3.20	9.50	25°10'	50°20'	0.25	6.35	75	4.25	12.70	12°	24°	0.35	10.70
28	4.25	12.70	22°	44°	0.35	4.75	77	4.25	12.70	12°	24°	0.35	11.50
30	4.25	12.70	21°15'	42°30'	0.35	4.75	83	5.10	12.70	12°	24°	0.35	12.70
33	4.25	12.70	21°15'	42°30'	0.35	6.35	89	5.10	12.70	12°	24°	0.35	13.90
35	4.25	12.70	21°15'	42°30'	0.35	7.15	100	5.10	12.70	12°	24°	0.35	16.25
38	4.25	12.70	19°	38°	0.35	7.15	110	5.10	12.70	12°	24°	0.40	18.30
40	4.25	12.70	19°	38°	0.35	7.95	120	5.10	12.70	12°	24°	0.40	20.30
43	4.25	12.70	19°	38°	0.35	8.75	70	6.35*	12.70	12°	24°	0.40	9.90
45	4.25	12.70	19°	38°	0.35	9.50	86	6.35*	12.70	12°	24°	0.40	13.10
48	4.25	12.70	19°	38°	0.35	10.70	96	6.35*	12.70	12°	24°	0.40	15.05
							132	6.35*	12.70	12°	24°	0.40	22.60

* SEE NOTE 5

ENLARGED DETAIL OF DEPRESSED THREAD

1. THE DEPTH OF DEPRESSED THREAD SHOWN HEREON IS SUITABLE FOR USE WITH ALL CONTINUOUS THREAD CLOSURES EXCEPT 1600 SERIES
2. FOR MISSING SPECIFICATIONS REFER TO THE G.P.I. DRAWING CONVERTED TO METRIC NOTATION RELATIVE TO THE FINISH DESIRED.
3. MINIMUM TOLERANCES OF THREAD DIAMETER DO NOT APPLY TO THE DEPRESSED AREA.
4. WHEN DEPRESSED THREAD IS USED, AMOUNT OF DEPRESSION DESIRED IS ACHIEVED BY REDUCING DEPTH OF THREAD IN NECK RING REGARDLESS OF CONTOUR OF CUTTER.
5. WHEN LARGER CUTTER DIAMETER IS USED, α_1 AND α_2 MAY BE INCREASED ACCORDINGLY, SEE FOLLOWING EXAMPLE:

SIZE	PITCH	CUTTER DIA. = 38.10		APPROX. CHORD
		α_1	α_2	
70	6.35	20°	40°	12.70
86	6.35	20°	40°	19.45
96	6.35	20°	40°	23.00
132	6.35	20°	40°	36.10



TYPICAL SAMPLES OF THREAD PROFILES

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