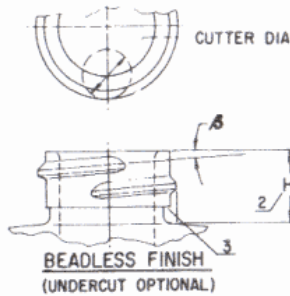
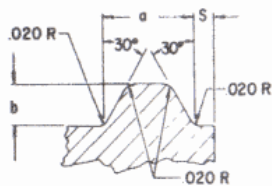


BEAD FINISH

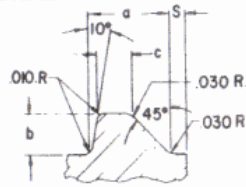


BEADLESS FINISH
(UNDERCUT OPTIONAL)



"L" STYLE

ALL PURPOSE THREAD (Plastic or Metal Caps)		
THDS/IN	a	b
5	.120	.060
6	.094	.047
8	.084	.042



"M" STYLE

MODIFIED BUTTRESS THD. (Plastic Caps)			
THDS/IN	a	b	c
5	.120	.060	.049
6	.094	.047	.039
8	.084	.042	.035

THREAD CROSS SECTIONS

Example Thread Nomenclature

"L" Style: L28SP400 or "M" Style: M28SP400

NOTES:

1. A MINIMUM OF One full turn of thread shall be maintained.
2. Dimension H is measured from the top of the finish to the point where diameter T, extended parallel to the centerline, intersects the bead or shoulder.
3. Contour of bead, undercut or shoulder is optional.
4. Unless otherwise specified, I min. applies to the full length of the opening.
5. Concentricity of I min. with respect to diameters T and E is not included. I min. is specified for filler tube only.
6. T and E dimensions are the average of two measurements taken 90° apart. The limits of ovality will be determined by the container supplier and container customer, as necessary.
7. All dimensions are in inches unless otherwise indicated.

To the best of our knowledge the information contained herein is accurate. However, The Society of the Plastics Industry, Inc., assumes no liability whatsoever for the accuracy or completeness of the information contained herein. Final determination of the suitability of any information or material for the use contemplated, the manner of use and whether there is any infringement of patents is the sole responsibility of the user.

SP-400 FINISH FOR PLASTIC BOTTLES

mm	T $\frac{S}{2}$		E $\frac{S}{2}$		H $\frac{2}{2}$		S		I $\frac{4.85}{2}$	HELIX ANGLE β	CUTTER DIA.	THD'S PER INCH
	MAX	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.				
18	.704	.688	.620	.604	.386	.356	.052	.022	.325	3°30'	.375	8
20	.783	.767	.699	.683	.386	.356	.052	.022	.404	3°7'	.375	8
22	.862	.846	.778	.762	.386	.356	.052	.022	.483	2°49'	.375	8
24	.940	.924	.856	.840	.415	.385	.061	.031	.516	2°34'	.375	8
28	1.088	1.068	.994	.974	.415	.385	.061	.031	.614	2°57'	.500	6
30	1.127	1.107	1.033	1.013	.418	.388	.061	.031	.653	2°51'	.500	6
33	1.265	1.241	1.171	1.147	.418	.388	.061	.031	.791	2°31'	.500	6
35	1.364	1.340	1.270	1.246	.418	.388	.061	.031	.875	2°21'	.500	6
38	1.476	1.452	1.382	1.358	.418	.388	.061	.031	.987	2°9'	.500	6
40	1.580	1.550	1.486	1.456	.418	.388	.061	.031	1.091	2°0'	.500	6
43	1.654	1.624	1.560	1.530	.418	.388	.061	.031	1.165	1°55'	.500	6
45	1.740	1.710	1.646	1.616	.418	.388	.061	.031	1.251	1°49'	.500	6
48	1.870	1.840	1.776	1.746	.418	.388	.061	.031	1.381	1°41'	.500	6
51	1.968	1.933	1.874	1.839	.423	.393	.061	.031	1.479	1°36'	.500	6
53	2.067	2.032	1.973	1.938	.423	.393	.061	.031	1.578	1°31'	.500	6
58	2.224	2.189	2.130	2.095	.423	.393	.061	.031	1.735	1°25'	.500	6
60	2.342	2.307	2.248	2.213	.423	.393	.061	.031	1.853	1°20'	.500	6
63	2.461	2.426	2.367	2.332	.423	.393	.061	.031	1.972	1°16'	.500	6
66	2.579	2.544	2.485	2.450	.423	.393	.061	.031	2.090	1°13'	.500	6
70	2.736	2.701	2.642	2.607	.423	.393	.061	.031	2.247	1°8'	.500	6
75	2.913	2.878	2.819	2.784	.423	.393	.061	.031	2.424	1°4'	.500	6
77	3.035	3.000	2.941	2.906	.502	.472	.075	.045	2.546	1°1'	.500	6
83	3.268	3.233	3.148	3.113	.502	.472	.075	.045	2.753	1°9'	.500	5
89	3.511	3.476	3.391	3.356	.550	.520	.075	.045	2.918	1°4'	.500	5
100	3.937	3.902	3.817	3.782	.612	.582	.075	.045	3.344	0°57'	.500	5
110	4.331	4.296	4.211	4.176	.612	.582	.075	.045	3.737	0°51'	.500	5
120	4.724	4.689	4.604	4.569	.700	.670	.075	.045	4.131	0°47'	.500	5