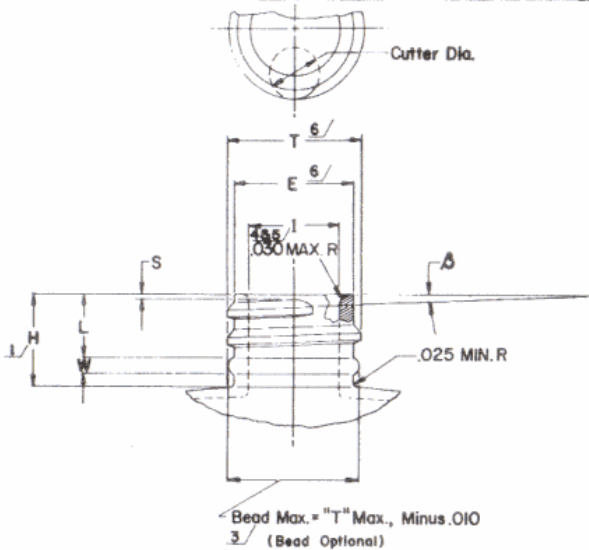


SP-410 FINISH FOR PLASTIC BOTTLES

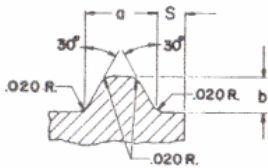


mm	T $\frac{6}{}$		E $\frac{6}{}$		H $\frac{1}{}$		L	S		I $\frac{4.65}{}$	W $\frac{3}{}$	HELIX ANGLE β	CUTTER DIA	THDS PER INCH
	MAX	MIN	MAX	MIN	MAX	MIN		MIN	MAX	MIN	MIN	MAX		
18	.704	.688	.620	.604	.538	.508	.361	.052	.022	.325	.084	3°30'	.375	8
20	.783	.767	.699	.683	.569	.539	.361	.052	.022	.404	.084	3°7'	.375	8
22	.862	.846	.778	.762	.600	.570	.376	.052	.022	.483	.084	2°49'	.375	8
24	.940	.924	.856	.840	.661	.631	.437	.061	.031	.516	.084	2°34'	.375	8
28	1.088	1.068	.994	.974	.723	.693	.421	.061	.031	.614	.094	2°57'	.500	6

NOTES:

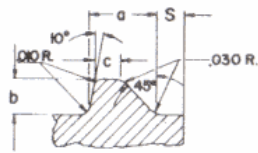
1. Dimension "H" is measured from the top of the finish to the point where diameter T, extended parallel to the centerline, intersects the top of the shoulder.
2. A MINIMUM OF 1½ Full turns of thread shall be maintained.
3. Use of bead is optional. If bead is used, bead dia. and "L" MINIMUM must be maintained.
4. Hole dia. "I" to be measured through full length of finish unless otherwise specified.
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.

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"L" Style

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



"M" Style

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

THREAD CROSS SECTIONS

Example thread nomenclature:

"L" Style : L22SP410

"M" Style : M22SP410