

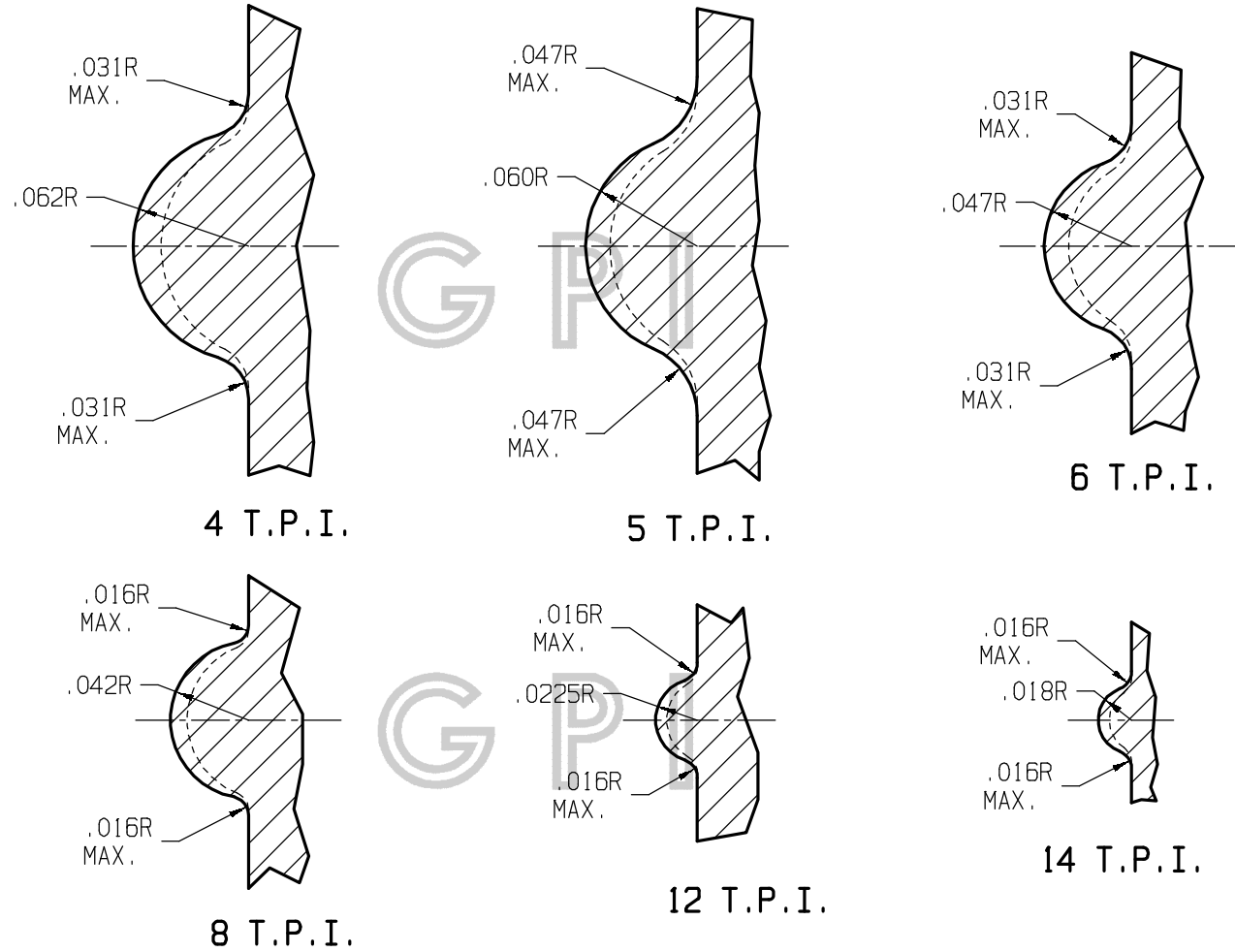
SIZE	TPI	CUT. DIA.	α_1	α_2	REF. DEPRESS. MAX.	APPROX. CHORD
8	14	0.266	31°05'	62°10'	0.006	0.031
10	14	0.266	31°05'	62°10'	0.006	0.078
13	12	0.375	24°15'	48°30'	0.006	0.031
15	12	0.375	24°15'	48°30'	0.006	0.078
18	8	0.375	25°10'	50°20'	0.009	0.125
20	8	0.375	25°10'	50°20'	0.009	0.172
22	8	0.375	25°10'	50°20'	0.009	0.219
24	8	0.375	25°10'	50°20'	0.009	0.250
28	6	0.500	22°	44°	0.013	0.188
30	6	0.500	21°15'	42°30'	0.013	0.188
33	6	0.500	21°15'	42°30'	0.013	0.250
35	6	0.500	21°15'	42°30'	0.013	0.281
38	6	0.500	19°	38°	0.013	0.281
40	6	0.500	19°	38°	0.013	0.313
43	6	0.500	19°	38°	0.013	0.344
45	6	0.500	19°	38°	0.013	0.375
48	6	0.500	19°	38°	0.013	0.422
51	6	0.500	17°	34°	0.013	0.391
53	6	0.500	17°	34°	0.013	0.422
58	6	0.500	17°	34°	0.013	0.469
60	6	0.500	17°	34°	0.013	0.500
63	6	0.500	17°	34°	0.013	0.531
66	6	0.500	12°	24°	0.013	0.359
70	6	0.500	12°	24°	0.013	0.391
75	6	0.500	12°	24°	0.013	0.422
77	6	0.500	12°	24°	0.013	0.453
83	5	0.500	12°	24°	0.013	0.500
89	5	0.500	12°	24°	0.013	0.547
100	5	0.500	12°	24°	0.013	0.640
110	5	0.500	12°	24°	0.015	0.719
120	5	0.500	12°	24°	0.015	0.797
70	4*	0.500	12°	24°	0.015	0.391
86	4*	0.500	12°	24°	0.015	0.516
96	4*	0.500	12°	24°	0.015	0.594
132	4*	0.500	12°	24°	0.015	0.891

* 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 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	TPI	CUTTER DIA. = 1.500		APPROX. CHORD
		α_1	α_2	
70	4	20°	40°	0.500
86	4	20°	40°	0.766
96	4	20°	40°	0.906
132	4	20°	40°	1.422



TYPICAL SAMPLES OF THREAD PROFILES

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DEPRESSED THREAD FOR CONTINUOUS THREAD FINISHES		4056	