## ENLARGED DETAIL OF DEPRESSED THREAD

**Typical Samples of Thread Profiles**

- **4 TPI:**
  - .031R Max.
  - .038R Max.

- **5 TPI:**
  - .031R Max.
  - .041R Max.

- **8 TPI:**
  - .035R Max.
  - .062R Max.

- **12 TPI:**
  - .069R Max.

<table>
<thead>
<tr>
<th>SIZE</th>
<th>TPI</th>
<th>CUT. DIA.</th>
<th>( A_1 )</th>
<th>( A_2 )</th>
<th>REF. DEPRESS.</th>
<th>APPR. CHORD</th>
</tr>
</thead>
<tbody>
<tr>
<td>8</td>
<td>14</td>
<td>.266</td>
<td>31°05</td>
<td>62°10</td>
<td>.006</td>
<td>.016</td>
</tr>
<tr>
<td>10</td>
<td>14</td>
<td>.265</td>
<td>31°05</td>
<td>62°10</td>
<td>.006</td>
<td>.016</td>
</tr>
<tr>
<td>13</td>
<td>12</td>
<td>.275</td>
<td>24°15</td>
<td>40°20</td>
<td>.006</td>
<td>.016</td>
</tr>
<tr>
<td>15</td>
<td>12</td>
<td>.275</td>
<td>24°15</td>
<td>40°20</td>
<td>.006</td>
<td>.016</td>
</tr>
<tr>
<td>18</td>
<td>11</td>
<td>.285</td>
<td>21°05</td>
<td>50°20</td>
<td>.009</td>
<td>.125</td>
</tr>
<tr>
<td>20</td>
<td>11</td>
<td>.275</td>
<td>25°10</td>
<td>50°20</td>
<td>.009</td>
<td>.125</td>
</tr>
<tr>
<td>22</td>
<td>10</td>
<td>.275</td>
<td>25°10</td>
<td>50°20</td>
<td>.009</td>
<td>.172</td>
</tr>
<tr>
<td>24</td>
<td>10</td>
<td>.275</td>
<td>25°10</td>
<td>50°20</td>
<td>.009</td>
<td>.250</td>
</tr>
</tbody>
</table>

- **6 TPI:**
  - .500
  - 22°
  - .030

- **8 TPI:**
  - .500
  - 22°
  - .030

- **12 TPI:**
  - .500
  - 25°
  - .030

- **14 TPI:**
  - .500
  - 19°
  - .030

1. The depth of depressed thread shown herein is suitable for use with all continuous thread closures except the 1800 series.
2. For metric specifications refer to the G.F.I. drawing relative to the finished design.
3. Minimum tolerances of thread diameter do not apply to the depressed area.
4. When depresssed thread is used, the amount of depression desired is achieved by reducing the depth of thread in the neck ring regardless of contour of cutter.
5. When larger cutter diameter is used, \( A_1 \) and \( A_2 \) may be increased accordingly.

### Example:

**Size** | **TPI** | **Outer Dia.** | **A1** | **A2** | **Appr. Chord**
-------|--------|----------------|--------|--------|----------------|
70     | 4      | 20°            | .800   | .900   | .500          |
85     | 4      | 20°            | .800   | .990   | .500          |
100    | 4      | 20°            | .800   | .990   | .500          |
115    | 4      | 20°            | .800   | .990   | .500          |
120    | 4      | 20°            | .800   | .990   | .500          |
125    | 4      | 20°            | .800   | .990   | .500          |
130    | 4      | 20°            | .800   | .990   | .500          |
135    | 4      | 20°            | .800   | .990   | .500          |
140    | 4      | 20°            | .800   | .990   | .500          |
145    | 4      | 20°            | .800   | .990   | .500          |
150    | 4      | 20°            | .800   | .990   | .500          |
155    | 4      | 20°            | .800   | .990   | .500          |
160    | 4      | 20°            | .800   | .990   | .500          |
165    | 4      | 20°            | .800   | .990   | .500          |
170    | 4      | 20°            | .800   | .990   | .500          |
175    | 4      | 20°            | .800   | .990   | .500          |
180    | 4      | 20°            | .800   | .990   | .500          |
185    | 4      | 20°            | .800   | .990   | .500          |
190    | 4      | 20°            | .800   | .990   | .500          |
195    | 4      | 20°            | .800   | .990   | .500          |
200    | 4      | 20°            | .800   | .990   | .500          |

**Depressed Thread for Continuous Thread Finishes**

**Glass Finish Number:** 405

**GPI 2405**

---

Edward Grant (Chairman)

**Glass Packaging Institute**

**Prepared for Publication:** 6-21-01

**Approved by:** Preparations Panel, 4055