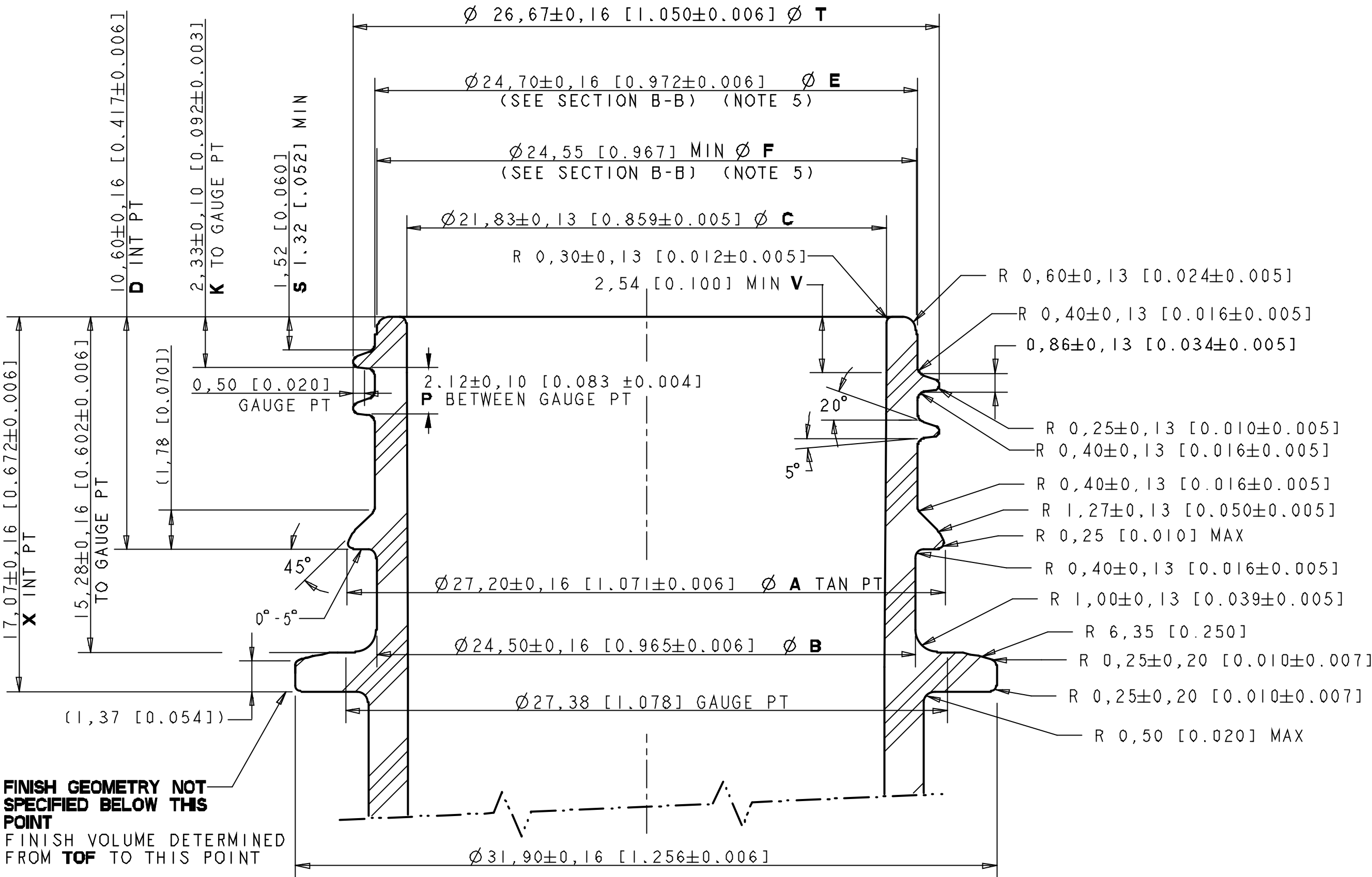
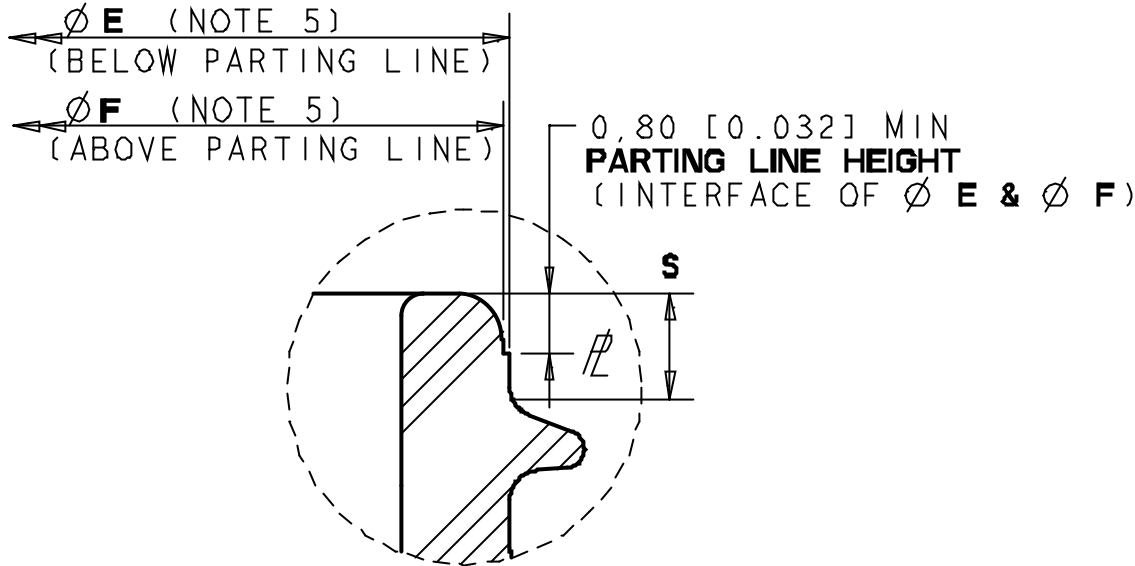


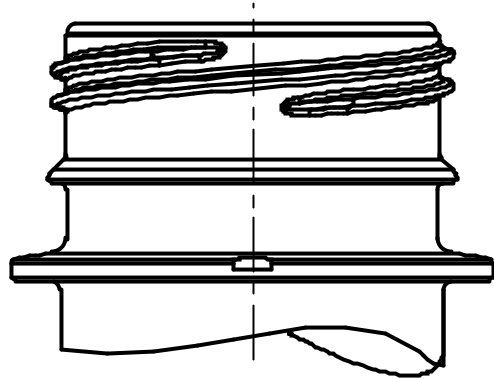
FINISH REV	DATE	DESCRIPTION	BY
000	99/03/18	ORIGINAL ALCOA SPECIFICATION #969-1844-001	SWM-DB
001	02/05/15	SPECIFICATION CONVERTED TO STANDARDIZED FORMAT	MNR-SG



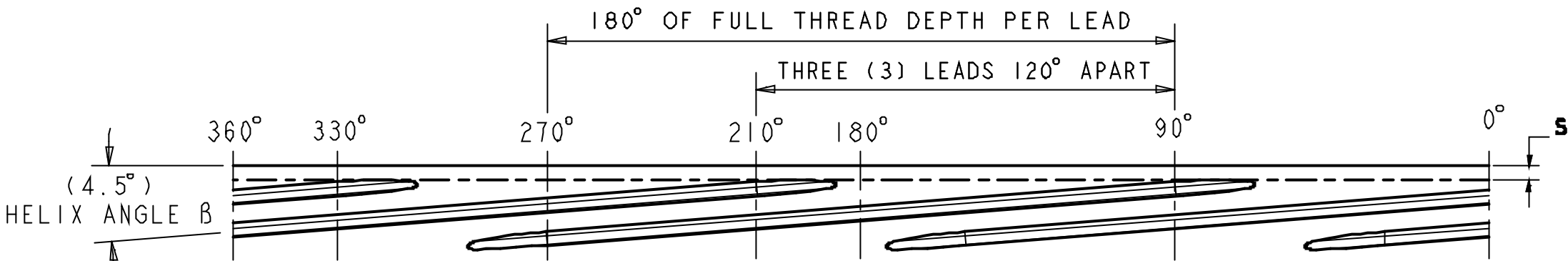
FINISH GEOMETRY NOT SPECIFIED BELOW THIS POINT
FINISH VOLUME DETERMINED FROM **TOF** TO THIS POINT



SECTION B-B

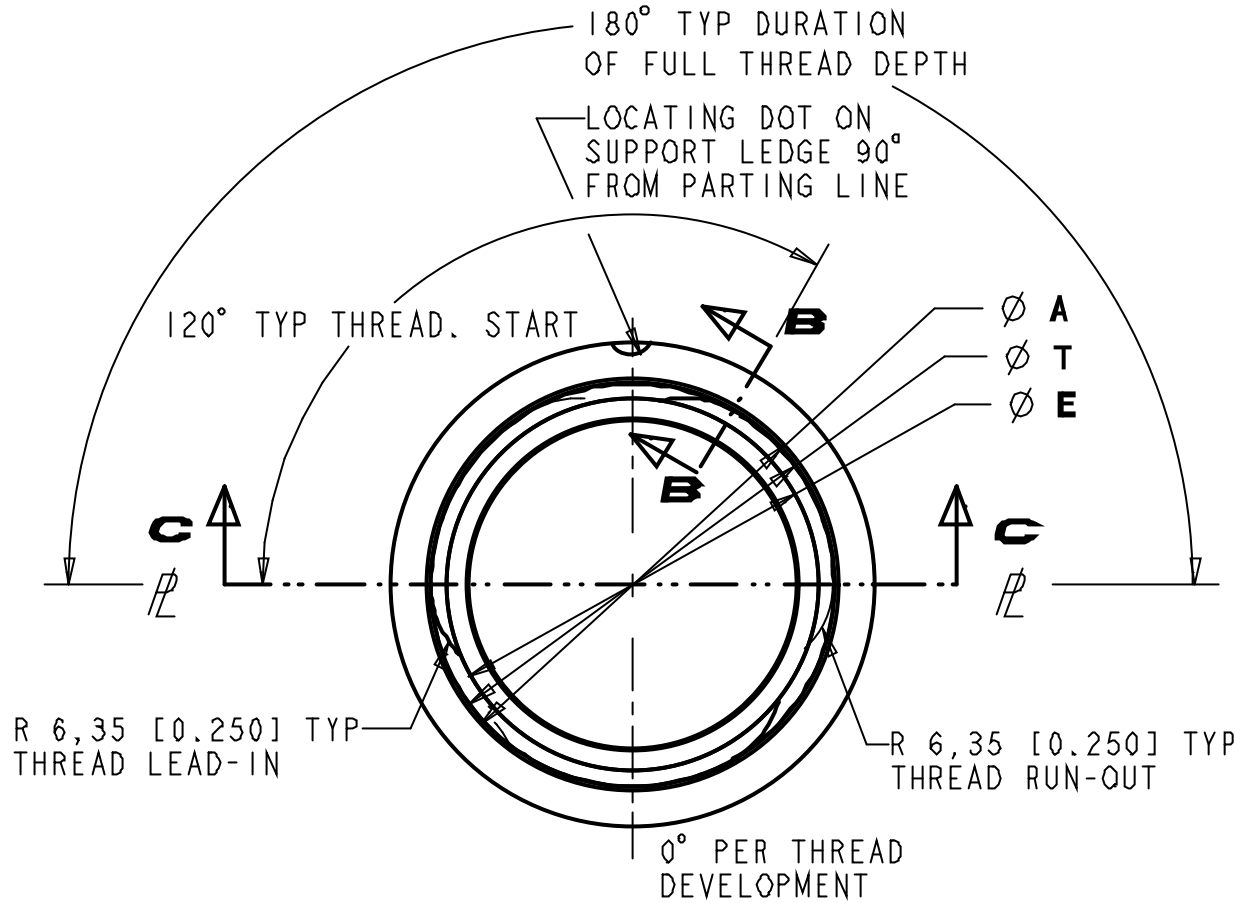


PROFILE VIEW
AT 0° AS PER THREAD DEVELOPMENT



THREAD DEVELOPMENT
SHOWN FROM OUTSIDE OF FINISH

- THREE (3) LEADS 120° APART
- 2.12 TPI PER LEAD
- 6.35 mm [0.250] TRAVEL PER TURN
- RIGHT HAND THREAD
- THREAD LEAD-IN/RUN-OUT PER CUTTER PROFILE



TOP VIEW

NOTES

- THIS IS A TOP, SIDE AND INSIDE SEAL FINISH. THE FINISH SHOULD BE SMOOTH AND FREE OF ANY DEFECTS THAT WILL CONTRIBUTE TO LEAKS. FLASH NOT TO EXCEED 0.13mm [0.005] PER SIDE, AND NOT TO BE CONTINUOUS.
- REQUIREMENTS FOR GOOD CLOSURE APPLICATION ON FINISH
A. 0.13mm **MAX** [0.005] OUT-OF-PARALLEL SEALING SURFACE WITH NECK SUPPORT LEDGE IS ALLOWED FOR COCKED NECKS AND SLANTED FINISHES.
B. AN OFFSET OR VERTICAL MISMATCH OF THREAD IS NOT TO EXCEED 0.10mm [0.004] AT THE MOLD SEAM. ϕ **T** DIMENSION IS NOT MEASURED IN THE DEPRESSED AREA.
- THE (3) THREAD STARTS ARE TO BE ORIENTED AS INDICATED WITH RESPECT TO THE PARTING LINE.
- VARIATIONS IN ϕ **E** ARE TO FOLLOW UNIFORMLY THOSE OF ϕ **T**.
- NO OVERHANG ALLOWED AT ANY POINT IN 360° BETWEEN ϕ **E** AND ϕ **F**. A FLUSH TO 0.15mm [0.006] **MAXIMUM** STEP IS ALLOWABLE ON ONE SIDE ONLY.
- FINISH VOLUME IS ESTIMATED AT 6.39 cm³ FROM **TOF** TO THE BOTTOM OF THE SUPPORT LEDGE, BASED ON NOMINAL DIMENSIONS.
- REFER TO DRAWING #1168216 FOR **VOLUNTARY STANDARD PET FINISH DIMENSION NOMENCLATURE**.

THESE SPECIFICATIONS ARE VOLUNTARY. PRIOR TO USE, YOU SHOULD FIRST DETERMINE WHETHER THE USE OF THESE SPECIFICATIONS IS APPROPRIATE IN YOUR PARTICULAR APPLICATION. YOU, THE USER, ASSUME ALL RESPONSIBILITY FOR THE USE AND INTERPRETATION OF THESE SPECIFICATIONS AND AGREE TO USE AT YOUR OWN RISK.

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DIMENSIONS SHOWN ARE FINISHED PLASTIC SIZES			DESCRIPTION		3Plastics INTERNATIONAL SOCIETY OF BEVERAGE TECHNOLOGISTS	
GENERAL TOLERANCES	METRIC MILLIMETRES		[IMPERIAL] [INCHES]		PCF-26P-1 VOLUNTARY STANDARD FLATWATER FINISH	
	X,X ±0,3 (.XX ±0.01)				Web: www.3plastics.com	
	X,XX ±0,3 (.XXX ±0.005)				Email: sales@3plastics.com	
	X° ±2°				FINISH No. PCF-26P-1	
	X°X' ±0°15'				DRAWING No 2072573-1	
			DWN	S. GUO	DATE	2002/05/15