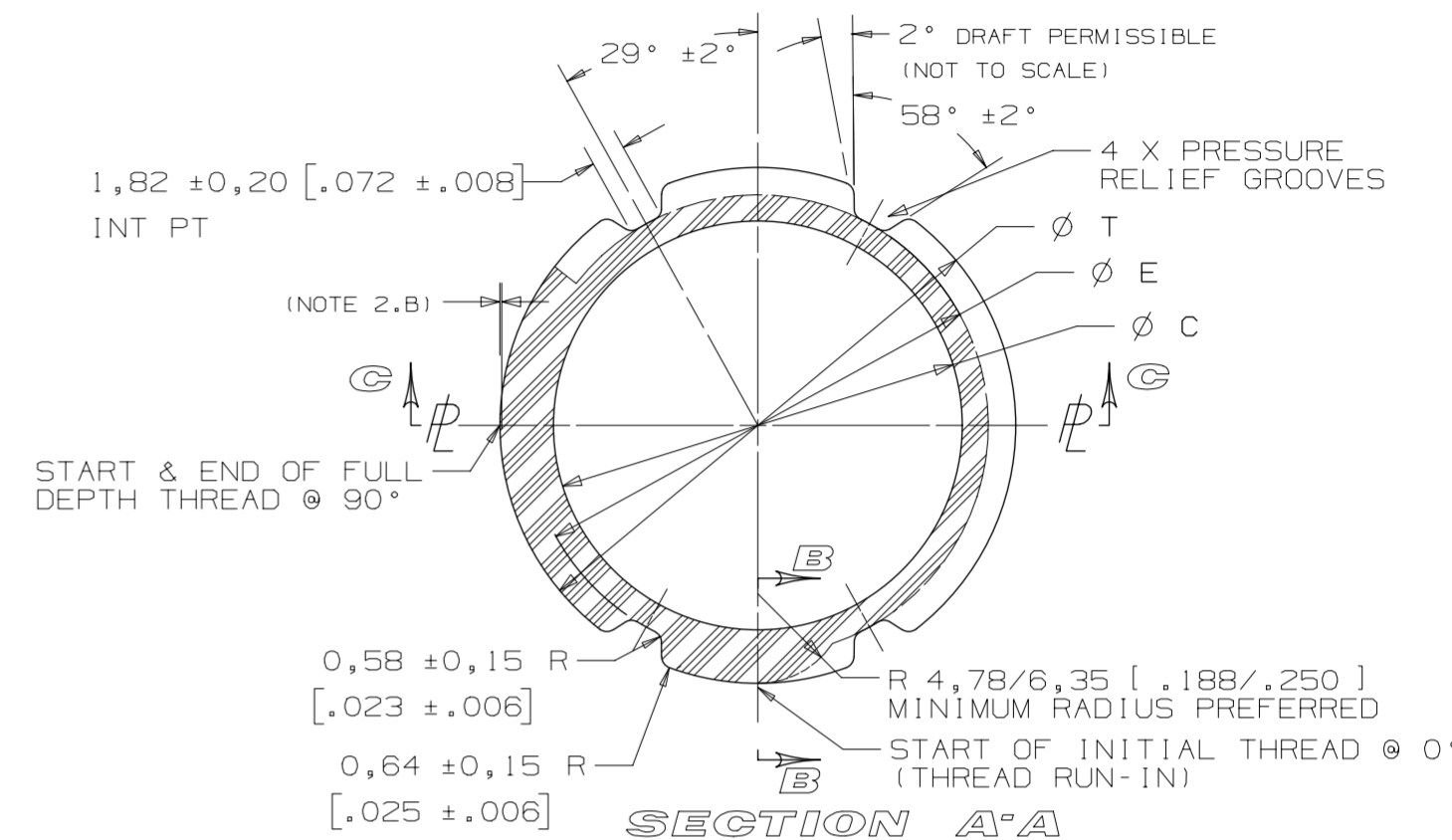
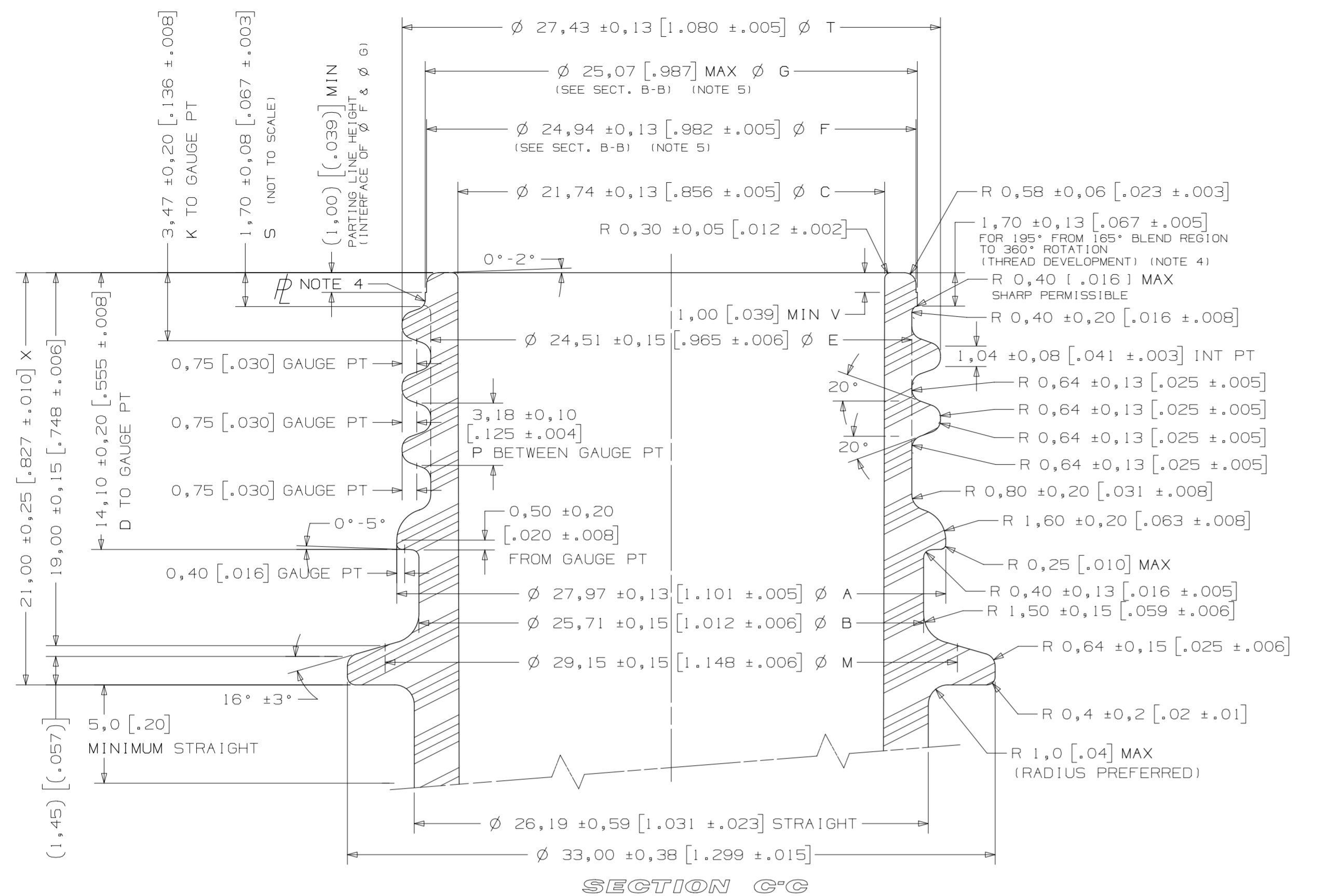
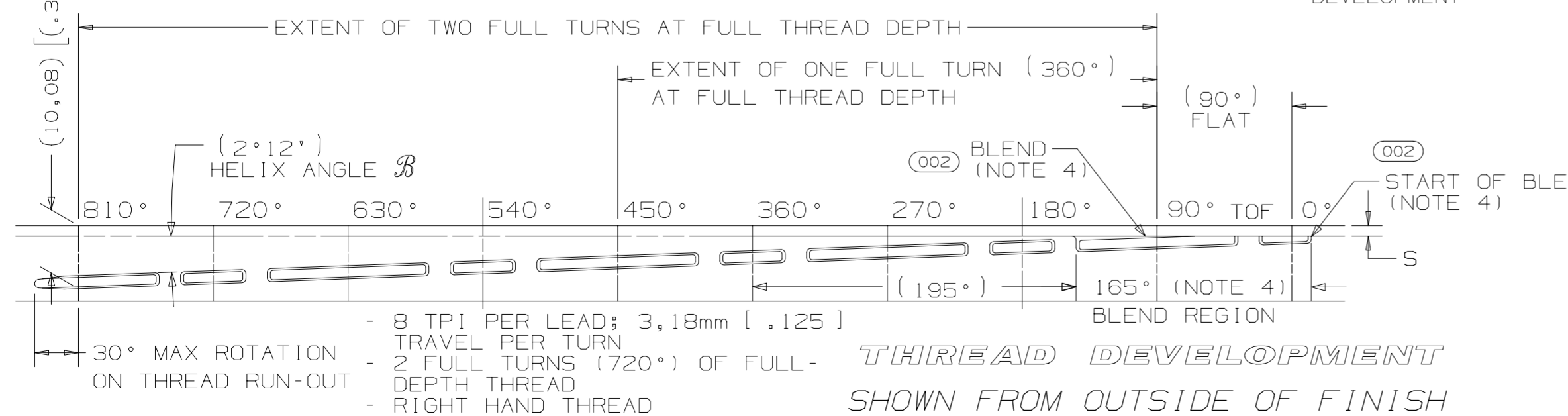
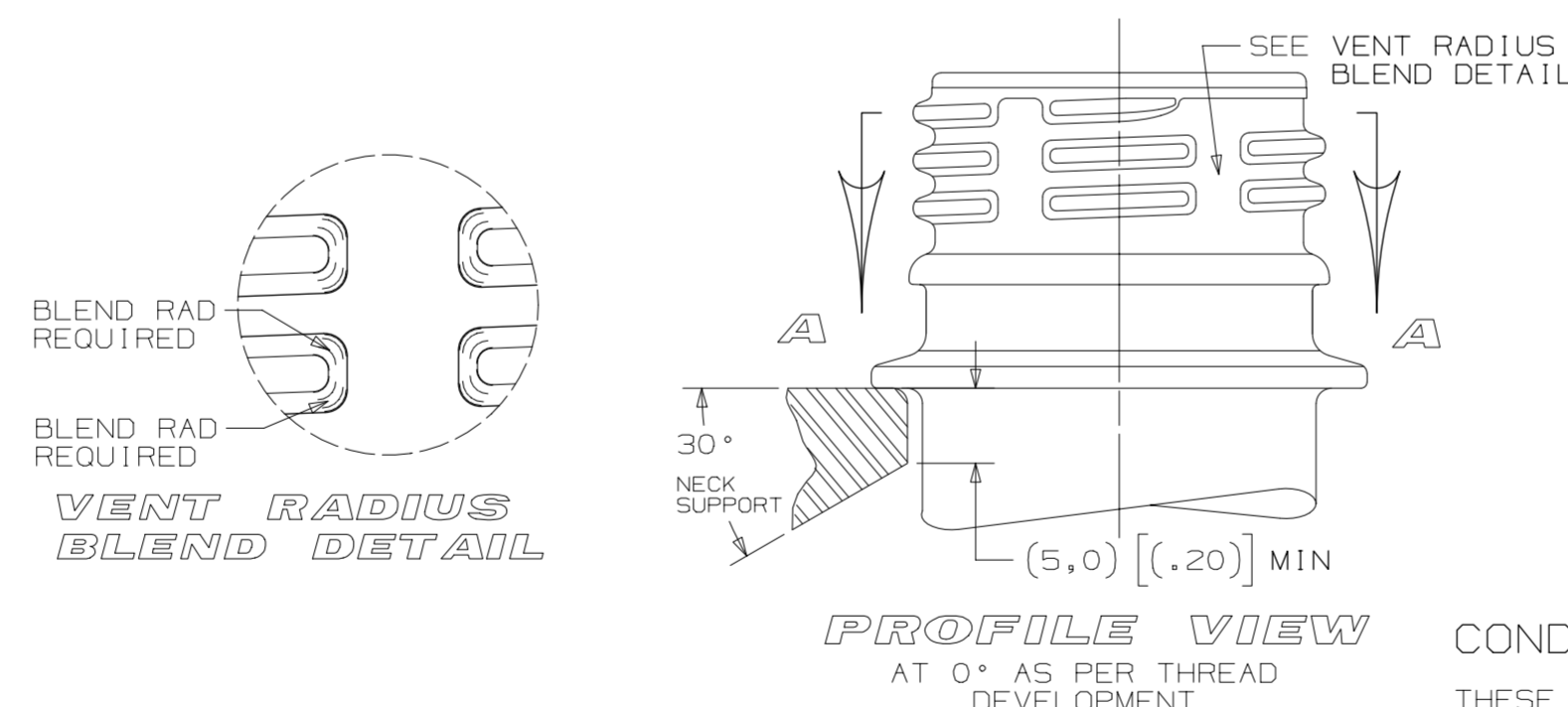
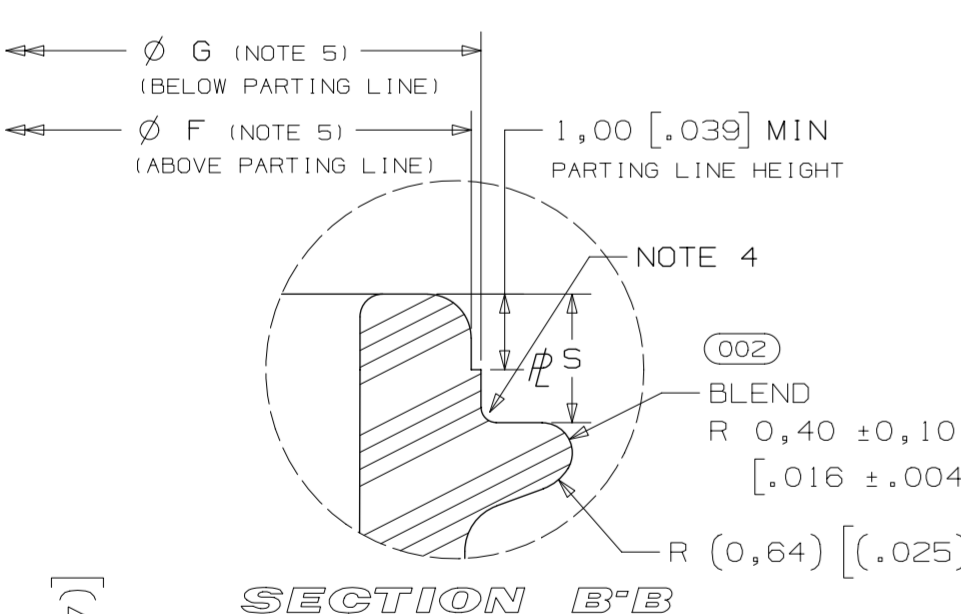


FINISH REV	DATE	DESCRIPTION	BY
000	93/06/21	ORIGINAL ALCOA SPECIFICATION	SWM
001	98/05/29	SPECIFICATION CONVERTED TO STANDARDIZED FORMAT	SYK
002	2003/04/21	R0,35 ±0,10 WAS R0,2 TO R0,5; ±0,10 ADDED TO R0,40 BLEND; TITLE BLOCK LOGO AND INFO UPDATED	SYK



**NOTES**

- THIS IS A PRESSURE TOP, SIDE, AND INSIDE BORE SEAL FINISH. THE FINISH SHOULD BE SMOOTH AND FREE OF ANY DEFECTS THAT WILL CONTRIBUTE TO LOSS OF PRESSURE. FLASH NOT TO EXCEED 0,13mm [.005] PER SIDE, AND NOT TO BE CONTINUOUS.
- REQUIREMENTS FOR GOOD CLOSURE APPLICATION ON FINISH
  - 0,13mm MAX [.005] OUT-OF-PARALLEL SEALING SURFACE WITH NECK SUPPORT LEDGE IS ALLOWED FOR COCKED NECKS AND SLANTED FINISHES.
  - AN OFFSET OR VERTICAL MISMATCH OF THREAD IS NOT TO EXCEED 0,10mm [.004] AT THE MOLD SEAM. IT IS PERMISSIBLE TO RELIEVE THREAD AT MOLD SEAM, BUT NOT TO EXCEED 0,20mm [.008] ON DIAMETER IN AN ARC OF 15°. Ø T DIMENSION IS NOT MEASURED IN THE DEPRESSED AREA.
- THE START OF THREAD RUN-IN IS TO BE 90°±2° FROM PARTING LINE ON ALL FINISHES. (SECTION A-A)
- THE Ø G CONTACTING THE FIRST 165° OF THREAD IS "BLENDED" INTO THE UPPER SURFACE OF THE THREAD WITH A CONSTANT RADIUS OF 0,35 ±0,10 [.014 ±.004]. BLEND STARTS AT TIP OF THREAD RUN-IN. (THREAD DEVELOPMENT)
- NO OVERHANG ALLOWED AT ANY POINT IN 360° BETWEEN Ø F AND Ø G. A FLUSH TO 0,13mm [.005] MAXIMUM STEP IS ALLOWABLE ON ONE SIDE ONLY.
- REFER TO DRAWING #1168216 FOR VOLUNTARY STANDARD PET FINISH DIMENSION NOMENCLATURE



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GENERAL TOLERANCES	DIMENSIONS SHOWN ARE FINISHED PLASTIC SIZES	
	METRIC MILLIMETRES	[ IMPERIAL ] [ INCHES ]
	X,X ±0,3	[.XX ±0.01]
	X,XX ±0,13	[.XXX ±0.005]
	X° ±2°	
	X°X' ±0°15'	

DESCRIPTION	
PCO-1810 VOLUNTARY STANDARD 28mm CSD FINISH	
DWN J.SYKES	DATE 98/05/29

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FINISH No  
PCO 969-1810-002

DRAWING No 1165362-2