



# PLANT STANDARD

## HEEP-HARDWAR

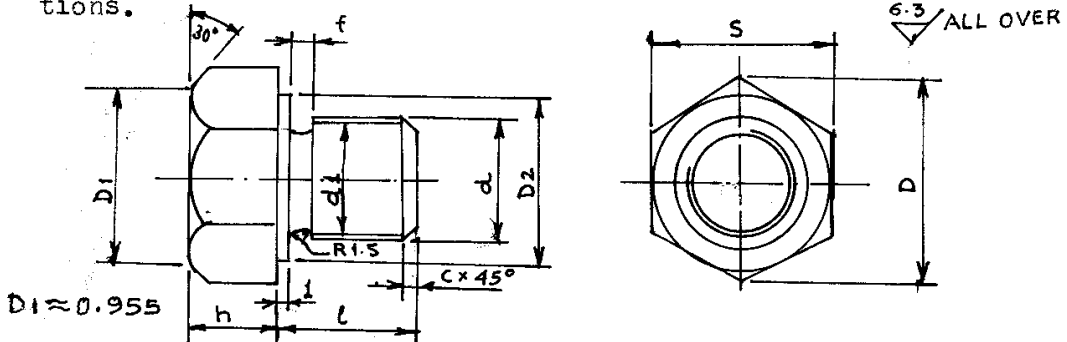
72.8322

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SUPERSEDES OLD STANDARD  
No. 71-74.8322

### PLUGS WITH PIPE THREADS

- These Plant Standards deal with steel plugs with cylindrical pipe threads (with cadmium/zinc plating) meant for tight closing of holes in the walls of the bearing housings and in other units. If the holes are not to be left opened during operation of the machine these plugs are also used for joint having pipe connections.



- The dimensions of the plugs, their code nos. and weights shall be as per Table given below:

THREAD d	d IN MM	s		h		D	D <sub>2</sub>	ALLOWABLE ECCENTRICITY OF HEAD	l		f	d <sub>1</sub>	C	WT. OF ONE PLUG	CODE NO.
		SIZE	TOL.	SIZE	TOL.				SIZE	TOL.					
G 1/4"	13.16	22	-0.28	9	±0.36	25.4	21	0.4	12	±1	3	11	1	0.044	010
G 3/8"	16.66	24	-0.28	10	±0.36	27.7	23	0.5	14	±1	3	14	1.5	0.063	011
G 1/2"	20.96	30	-0.28	13	±0.43	34.5	29	0.6	16	±1	4	18	1.5	0.121	012
G 3/4"	26.44	36	-0.34	15	±0.43	41.6	35	0.6	20	±1	4	23	2	0.215	014
G 1"	33.25	46	-0.34	19	±0.52	53.1	45	0.6	22	±1	5	29	2	0.415	016
G 1 1/4"	41.91	55	-0.40	23	±0.52	63.5	54	0.7	26	±1	5	38	2.5	0.742	018
G 1 1/2"	47.80	65	-0.40	26	±0.52	75	64	0.8	28	±1	5	44	2.5	1.129	019

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SIGN & DATE  
21/1/98

INVENTORY No.  
P-92

					NAME	SIGN & DATE
				DRAWN		
				WORKED	L. B. MALHOTRA	<i>[Signature]</i>
				CHECKED	S. KUMAR	<i>[Signature]</i>
AGREED DEPTT	NAME	SIGN & DATE	SUPERVISED	D. N. JOSHI	<i>[Signature]</i>	19/1/98
			APPROVED:			
			PLANT			
			STANDARDIZATION COMMITTEE			3.35
REVISION-01 (reaffirm)			PREPARED:	ISSUED:	DATE:	
17-10-2007			TSX	STANDARDS DIVISION	19-01-98	



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3. Material : Steel having mechanical properties as per C/D ROUND BAR CARBON STEEL [C20], AA10112 or IS: 9550
4. The pipe threads are of class B as per IS:2643-64, (Part-2).
5. The tolerances on dimensions (besides d.s.h. and 1) are as per 7th class of accuracy as per Product Group B to IS:1367 Part-II.
6. Sealing Rings - as per standards 18.8370.
7. Threads should be clean and free of burrs, stripped turns and dents.
8. Technical supply conditions are as per IS:1367 (Part-I).
9. The plug should be manufactured as per this Plant standard without making separate drawings (blank drg.No.0317.029)
10. If required, the steel plugs can be cadmium plated/Zinc plated with a supplementary chromate treatment, as per IS:1572 /IS:1573- as detailed below:
  - Plugs with  $\frac{1}{4}$ ",  $\frac{3}{8}$ " ,  $\frac{1}{2}$ " ,  $\frac{3}{4}$ " and 1" pipe threads - Cadmium plated Cd13Cr.
  - Plugs with 1  $\frac{1}{4}$ " , 1  $\frac{1}{2}$ " pipe threads-Zinc plated Zn 25Cr.
11. In an assembly/sub-assembly drgg., as an example, for plug having  $\frac{1}{4}$ " pipe threads and made of steel Round Bar Carbon steel C20, AA10112. The following should be written:
  - In the column "DESIGNATION - 72.8322.010
  - In the column "DESCRIPTION - Plug  $\frac{1}{4}$ " Pipe.

REVISION : 01	WORKED BY	L.B.MALHOTRA	<i>Signature</i>
	CHECKED BY	S.KUMAR	<i>Signature</i>