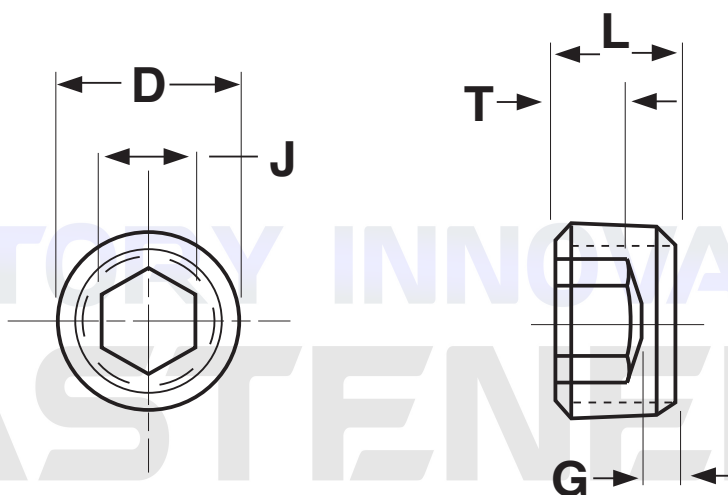


Flush Seating

PIPE PLUGS



VICTORY INNOVATIVE
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SOCKET PIPE PLUGS - FLUSH TYPE

ANSI B1.20.3

Nominal Size	D Nominal Outside Diameter	Threads Per Inch	J Hex Socket Size	T Key Engagement		G Wall Thickness		L Overall Length		Tightening Torque (Inch - Lbs)	Tap Drill Size*
				Min	Min	Max	Min				
				1/16	0.307	27	5/32	.140	.052		
1/8	0.401	27	3/16	.140	.049	.250	.235	250	21/64		
1/4	0.529	18	1/4	.218	.045	.406	.391	600	27/64		
3/8	0.667	18	5/16	.250	.040	.406	.391	1200	9/16		
1/2	0.830	14	3/8	.312	.067	.531	.516	1800	11/16		
3/4	1.041	14	9/16	.312	.054	.531	.516	3000	57/64		
1	1.302	11-1/2	5/8	.375	.112	.656	.641	4200	1-1/8		
1-1/4	1.647	11-1/2	3/4	.437	.102	.656	.641	5400	37.5MM		

*Taper reaming after drilling is recommended for tapping ease and to give fully formed, uniform threads.

Description	A flush type plug is one having a tapered (0.875" diametral per 12") thread extending its entire length and designed to provide a flush condition with a standard tapped hole (0.750" diameter per 12"). Both ends of the plug shall be flat and chamfered approximately 45°. The chamfer shall extend slightly below the root of the thread, and the edge between flat and chamfer shall be slightly rounded. Six equally spaced identification grooves are located equidistant between corners of the hex socket and edge of the chamfer (Note: On the 1/16-27 plug, 3 identification grooves are permitted because of limited space).	
Applications/ Advantages	A high pressure seal is achieved through the difference in taper, with dimensions precalculated to provide a higher sealing load near the large end of the plug and the threads near the top of the tapped hole. The flush type plug is preferred where high pressures are encountered and where protrusion is undesirable.	
Material	High grade alloy steel	Commercial brass
Heat Treatment	Pipe plugs shall be heat-treated by quenching in oil from above the hardening temperature and tempered to achieve the hardness requirement listed below.	-
Hardness	Rockwell C36 - 43	-
Finish	Plugs are supplied with a standard black finish.	Plugs are supplied plain.