



## SOCKET PIPE PLUGS - FLUSH TYPE

ANSI  
B1.20.3

Nominal Size	D	Threads Per Inch	J	T	G	L		Tightening Torque (Inch - Lbs)	Tap Drill Size*
	Nominal Outside Diameter		Hex Socket Size	Key Engagement	Wall Thickness	Overall Length			
						Min	Min		
1/16	0.307	27	5/32	.140	.052	.250	.235	150	15/64
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.

<b>Description</b>	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" diametral 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).
<b>Applications/ Advantages</b>	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.
<b>Material</b>	High grade alloy steel
<b>Heat Treatment</b>	Pipe plugs shall be heat-treated by quenching in oil from above the hardening temperature and tempered to achieve the hardness requirement listed below.
<b>Hardness</b>	Rockwell C36 - 43
<b>Finish</b>	Plugs are supplied with a standard black finish.