

# COMPANY STANDARDS

CPL01 &amp; 02

TITLE :

PIPE PLUG ( TAPER THREAD )

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DATE :

1998-08-10

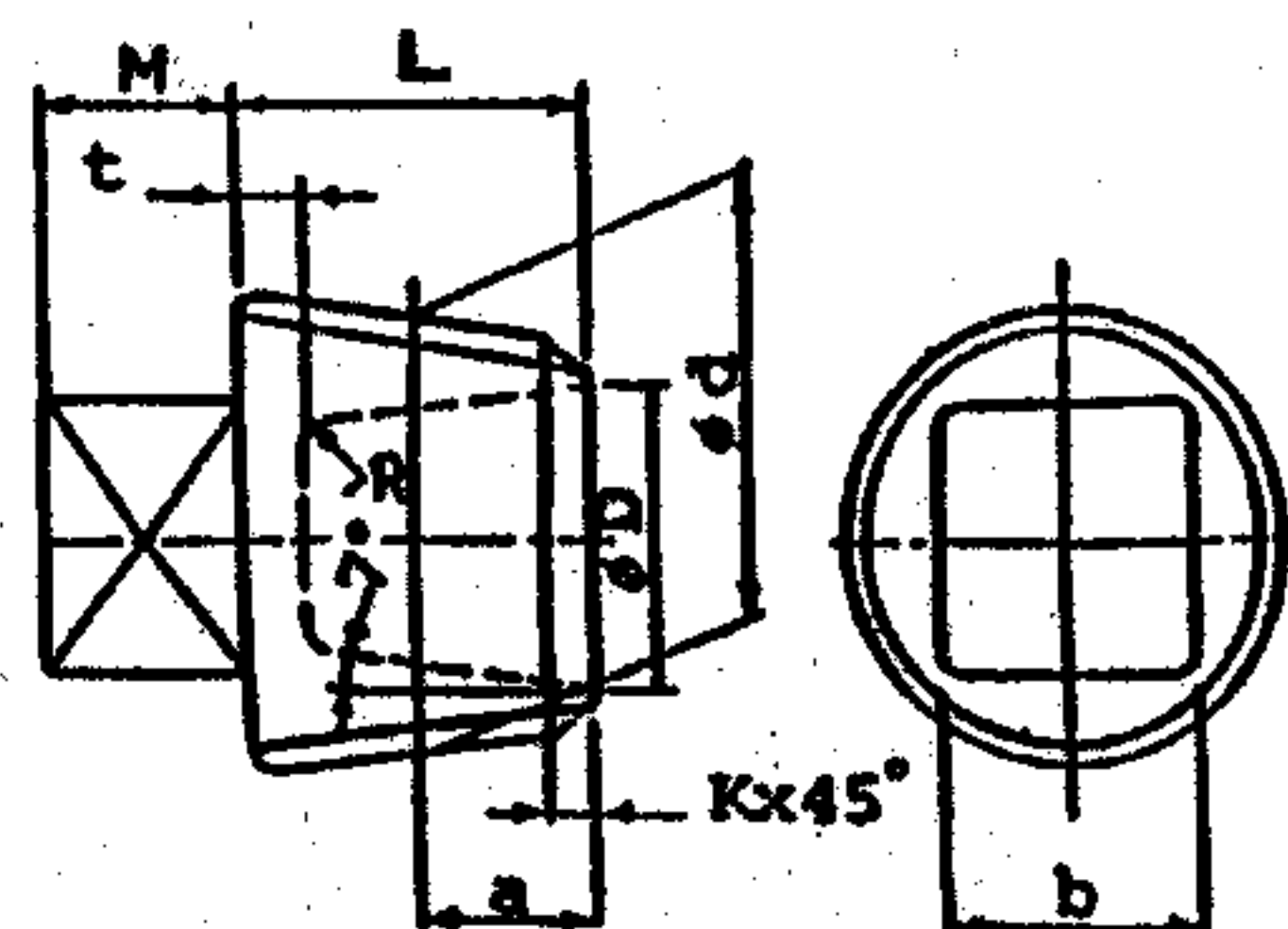
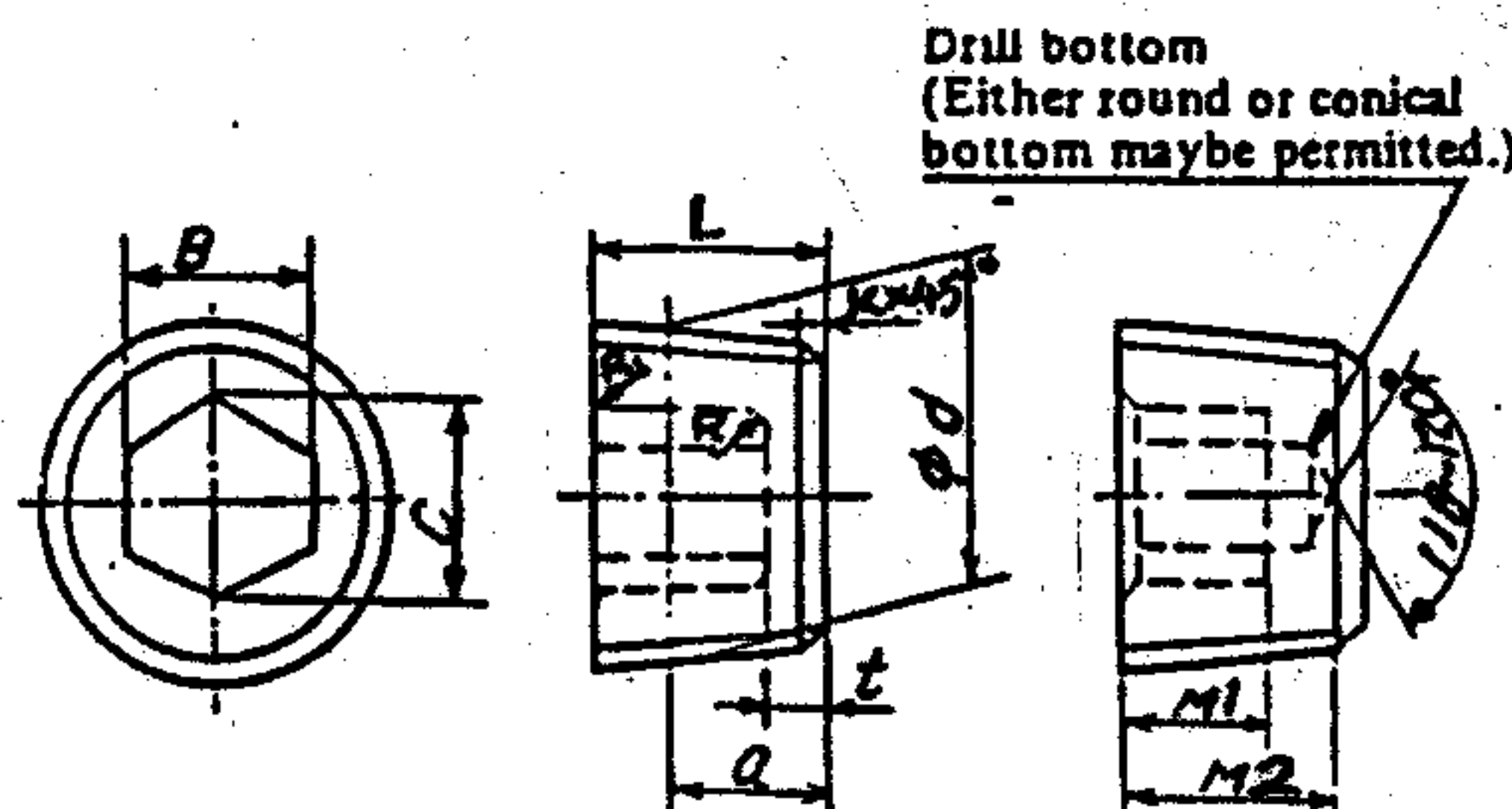
FIGURE-1  
TYPE-01 RAISED HEADFIGURE-2  
TYPE-02 HEX. SOCKET HEAD

TABLE-1 - DIMENSIONS

Unit : mm

Nom.size-Inch	PT 1/8	PT 1/4	PT 3/8	PT 1/2	PT 3/4	PT 1	PT 1 1/4	PT 1 1/2	PT 2
Pitch	0.907	1.337	1.337	1.814	1.814		2.309		
d (std. dia)	9.728	13.157	16.662	20.955	26.441	33.249	41.910	47.803	59.614
Threads/Inch	28	19		14			11		
L	8	11	12	15	17	19	22		26
a Basic	3.97	6.01	6.35	8.16	9.53	10.39	12.7		15.88
Tol.	±0.91	±1.34		±1.81			±2.31		
K		1		1.5			2		
M	7	8	9	10	11	12	13	14	15
M1	4	7	8	9	10	12	13		15
M2	6	9	10	13	15	17	20		24
b	7	9	12	14	17	19	23	26	32
D (max)	-	-	-	-	-	20	25	30	35
t (min)	4		6		7		9		11
B Nom.	5	6	8	10	14	17	22		27
Tol.	+0.085		+0.103		+0.196		+0.230		
	+0.010		+0.013		+0.060		+0.020		
C	5.8	8.1	9.2	11.5	16.2	19.6	25.4		31.2
R max.			1				1.5		2
Qty/bag	500	300	150	90	50	30	18	12	7
Size code	0810	1113	1217	1521	1726	1933	2242	2248	2660

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PREPARED BY:

CSD

ISSUE No:

ONE

REPLACEMENT FOR:

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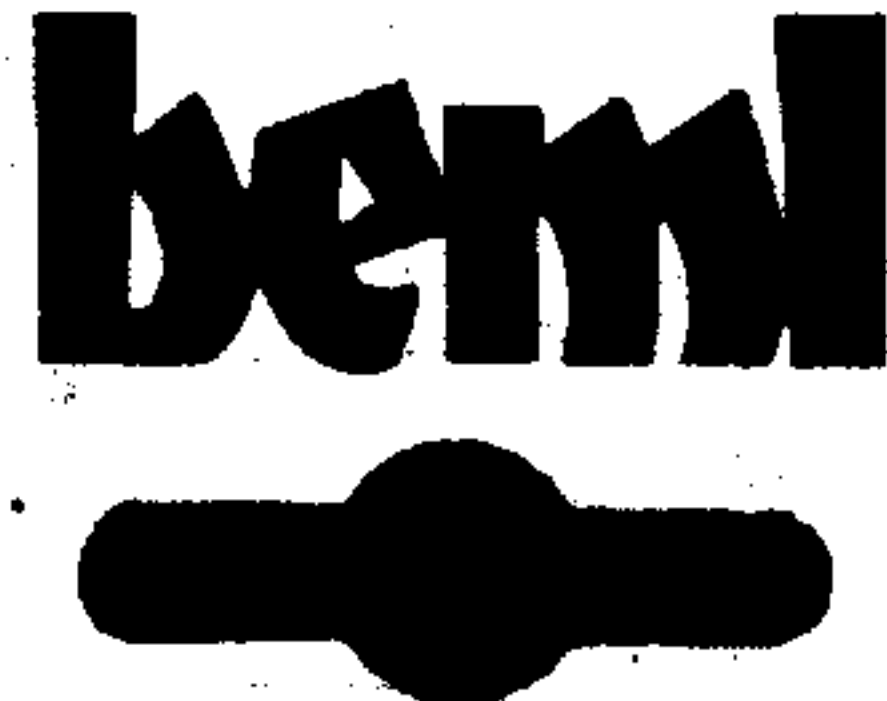
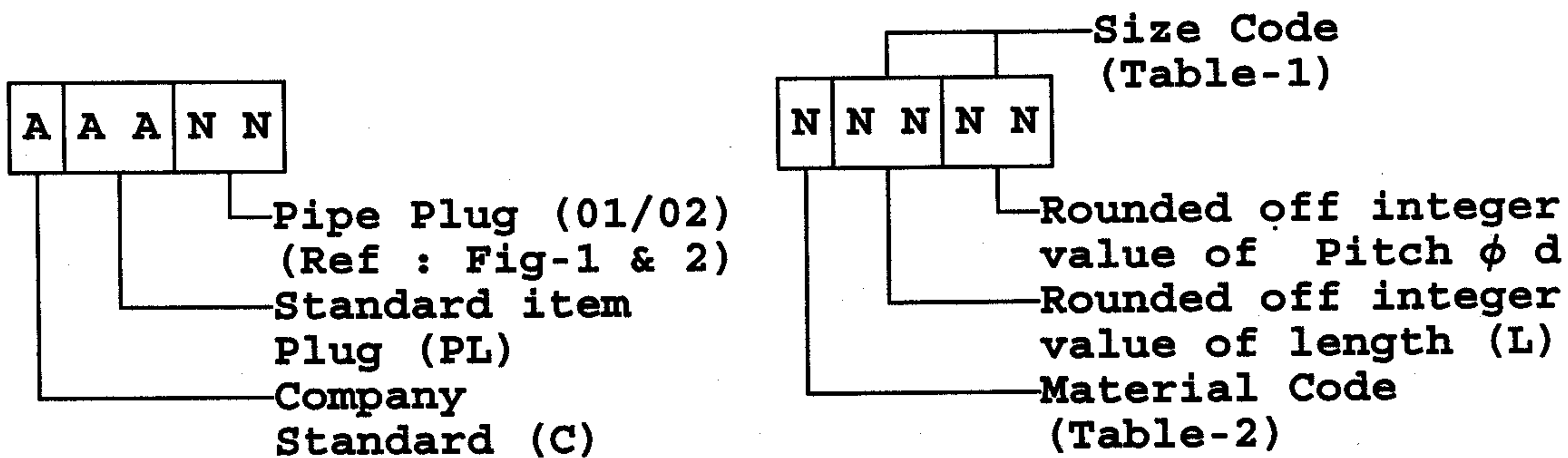
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TABLE-2  
MATERIAL AND SURFACE TREATMENT

Material Code	1	2
Material	C1001	C1101
Heat treatment	--	Q & T : 26 ~ 32 HRC
Surface treatment	Zinc plating & chromate conversion as per Co. Std PR1033-C	Rust preventive oil as per Co. Std C6001-10.

1. DESIGNATION :

Part no. & description shall be as shown below.  
The first five digits appear on the document.



Example : A Pipe plug of steel having taper thread PT 1/4" of length 11 mm and pitch diameter 13.157 mm.

The Part number : CPL0111113 - For raised head.

CPL0211113 : For hexagonal socket head.

Description : Pipe plug, PT 1/4".

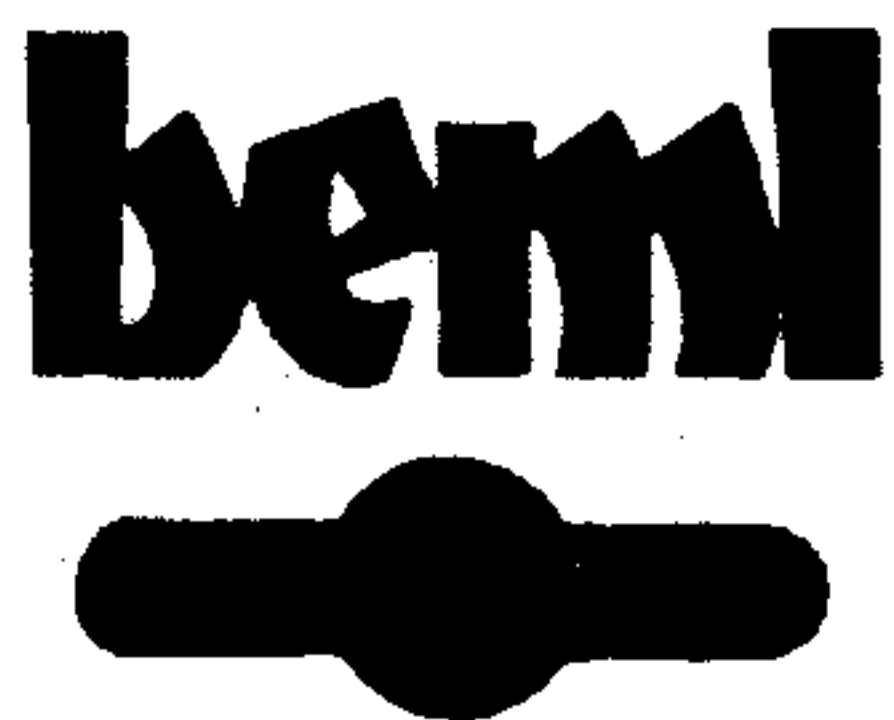
2. SIZE CODE :

The size code consists of 4 digits. The first 2 digits indicate the rounded off value of length 'L' of plug and the last 2 digits indicate the rounded off integer value of the pitch diameter 'd' of the thread.

3. Dimensions, tolerances shall be in accordance with Table-1 and Figure-1 & 2.

4. Thread tolerances shall be as per IS:554 "Dimensions for pipe threads where pressure tight joints are made on threads".

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## 5. SAMPLING & ACCEPTANCE CRITERIA :

- 5.1 In any consignment, all the pipe plugs of the same size and type manufactured under essentially similar conditions shall be grouped together to constitute a lot. Pipe plugs shall be selected and examined for each lot separately for ascertaining their conformity to the requirement of this standard.
- 5.2 The number of pipe plugs to be selected shall depend on the size of the lot and shall be in accordance with column-1 & column-2 of Table-3, These shall be selected at random.
- 5.3 The pipe plugs selected according to 5.2 shall be examined for material, dimension and finish. If the number of pipe plugs failing to meet the above requirements is less than or equal to the acceptance number given in column-3 of Table-3, the lot shall be considered as conforming to the requirements of these characteristics.

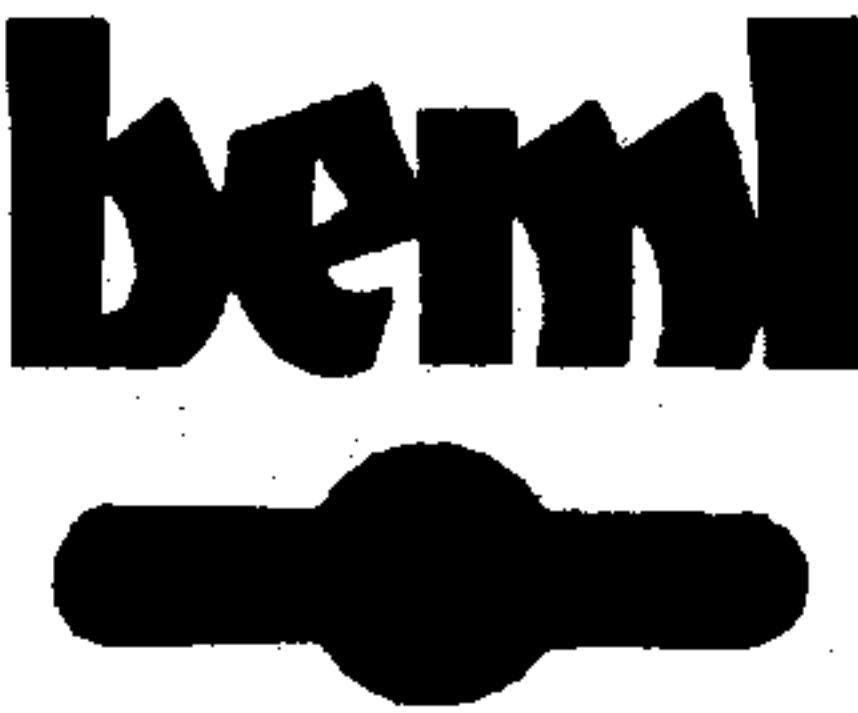
TABLE-3  
SAMPLE SIZE AND CRITERIA FOR CONFORMITY

LOT SIZE (1)	SAMPLE SIZE (2)	ACCEPTANCE NUMBER (3)
Upto 100	5	0
101 to 150	8	0
151 to 300	13	1
301 to 500	20	1

- 5.4 The lot shall be declared as conforming to the requirements of this standard if conditions given in 5.3 are satisfied.

## 6. PACKING :

The pipe plug shall be protected by protective plugs / caps to company standard C3001-01. The pipe plugs shall be packed first in high density polyethylene bags with quantities specified in Table-1. These polyethylene bags containing the pipe plugs shall in turn be packed in cartons / crates depending on the mass. Each bag shall contain only one size of pipe plugs.

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<div>7. MARKING :</div> <div>The bags shall be marked clearly with the following information :</div> <div><div>a) The product designation</div><div>b) Total number of pieces in each package</div><div>c) Net mass of the package and</div><div>d) Name or identification symbol (trade mark) of manufacturer.</div></div> <div>The label or tag shall be placed on the package in such a way that the package can be identified easily during transport and storage. It should be fixed on the package as is customary and shall be removable with difficulty only.</div> <div>xx</div>			