



PLANT STANDARD

HPBP TIRUCHIRAPALLI

BPS 718501

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PLUG, BEADED T-9 -CAST IRON

1 SCOPE

1.1 This standard gives information as to the correct designation, material, sizes, dimensions and information required for ordering purposes for beaded plugs T9.

1.2 These plugs shall be suitable for working pressure up to 1.380 N/mm² in the case of water and upto 1.035 N/mm² in the case of steam, air gas and oil.

2 DESIGNATION

2.1 A beaded plug T9 of nominal size 1" shall be designated as:

2.1.1 On drawings:

- a) Material code column: ~~17-047-023~~ 17043011
- b) Description column: BEADED PLUG T9-~~02~~-1/2
- c) Drawing Number column: 718501-002 15

2.1.2 For placing indents on purchase: Beaded plug 1"-
BPS: 718501

2.1.3 For issuing enquiries and purchase orders: While issuing enquiries and purchase orders delete the plant standard number from the clause 2.1.2 and add the information given under clause 3.

3 COMPLIANCE WITH STANDARDS

3.1 Dimensions, tolerances and general requirements : To IS: 1879 (Part IX)-75 Table 1

3.2 Material: The material used shall be white-heart malleable cast iron conforming to tensile and bend tests specified for Grade B of IS: 2107.

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REVISIONS

*Some drawings
for BHEL
17043011*

DATE

17043011/116522

APPROVED

STANDARDS SECTION
ENGINEERING AND DEVELOPMENT CENTRE
HPBP TIRUCHIRAPALLI

PREPARED

ISSUED

DATE

HPBP TIRUCHY.

STANDARDS

JAN 1983



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3.3 Threads: Taper in accordance with IS: 554 and shall be clean and well cut.

3.4 Finish: Galvanised. The minimum weight of zinc coating on the fitting shall be 610 g/m^2 as per IS: 4759.

4 NOTE

4.1 Weights given in this standard are for general reference only and are not meant for commercial transactions.

4.2 For dimensions of screwed ends of fittings refer corporate standard AA 023 18 13.

4.3 For dimensions of pipe threads of fittings refer corporate standard AA 023 18 15.

4.4 For sampling and acceptance refer Appendix A of IS:1879 (Part I)-1975.

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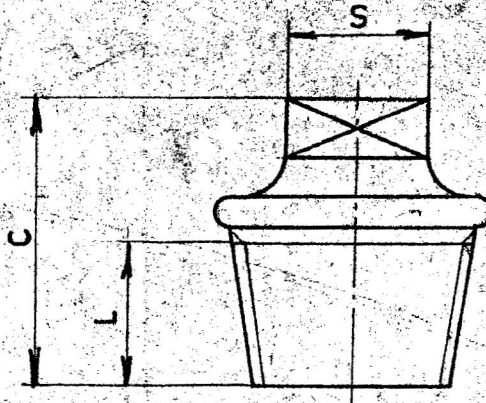


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(All dimensions are in millimetres)

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Sl. No.	Nom size		C		S h14	L	Weight in kg	EPS Code Bin code
	mm	inch	Basic	Tol				
01	6	1/4	22	± 1.5	11	13	0.020	718501 0006 17017 037
02	10	3/8	24	± 1.5	11	13	0.026	718501 0010 17 017 021
03	15	1/2	26	± 1.5	14	16	0.038	718501 0015 17 043 011
04	20	3/4	32	± 1.5	17	19	0.072	718501 0020 17 017 027
05	25	1	36	± 2.0	19	22	0.106	718501 0025 17 017 023
06	32	1 1/4	39	± 2.0	22	25	0.170	718501 0032 17 017 024
07	40	1 1/2	41	± 2.0	24	25	0.212	718501 0040 17 017 028
08	50	2	48	± 2.0	27	28	0.343	718501 0050 17 017 025
09	70	2 1/2	54	± 2.5	32	32	0.576	
10	80	3	60	± 2.5	36	35	0.776	718501 0075 17 017 026

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