

## PORT PLUGS AND SAFETY PLUGS

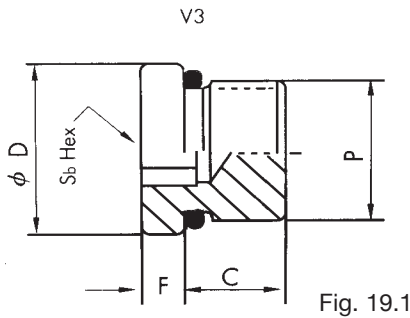


Fig. 19.1

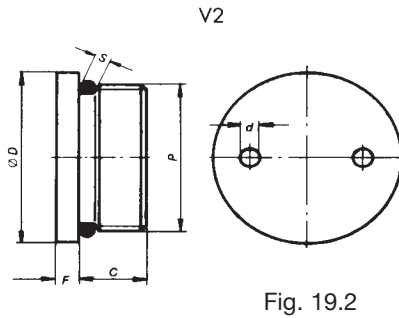


Fig. 19.2

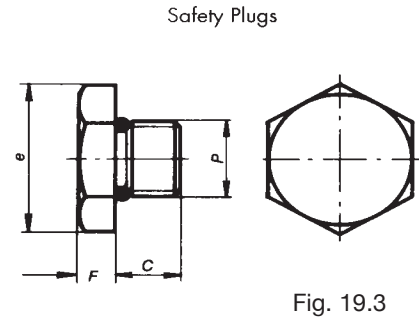


Fig. 19.3

**IMPORTANT:** Do not weld the plugs to the plates. Do not use tapered plugs.

TYP	P THREAD	C	F	Ød	ØD		e	O-RING ØDxØS	FOR MAX. DRILLED DIAM.
PORT PLUGS									
NP - 77-5	1/2" - 20	11	8	-	SW17	-	-	-	10
NP - 77-8	3/4" - 16	11	9	-	SW22	-	-	-	16
V3 - 14	M 14 x 1.5	12	5	-	19	-	-	-	12
V3 - 20	M 20 x 1.5	14	5	-	26	-	-	-	18
V3 - 27	M 27 x 2	16	5	-	32	-	-	-	24
V2 - 36	M 36 x 2	15	5	4.1	42	-	-	32 x 3	33
V2 - 42	M 42 x 2	15	5	4.1	48	-	-	38 x 3	39
V2 - 48	M 48 x 2	15	5	4.1	54	-	-	44 x 3	45
V2 - 64	M 64 x 2	15	5	4.1	70	-	-	60 x 3	60
V2 - 80	M 80 x 2	20	10	6.1	88	-	-	76 x 4	76
V2 - 100	M 100 x 2	20	10	6.1	108	-	-	96 x 4	96
V2 - 130	M 130 x 2	25	10	8.1	145	-	-	126 x 4	126

### SAFETY PLUGS

BS - 150/5	1/2" - 20	11	8	-	SW17	-	19.5	9 x 2	10
BS - 170/5	1/2" - 20	11	8	-	SW17	-	19.5	9 x 2	10
BS - 250/5	1/2" - 20	11	8	-	SW17	-	19.5	9 x 2	10
BS - 150/11	M20 x 1.5	15	10	-	SW19	-	27.0	17 x 2.5	16

Drilled diameters larger than 126 mm should be capped with a plate and "O" rings (see fig. 19.4) The number, grade, and preload of the screws must be specified for a pressure of 165 bars (the maximum pressure of the safety plugs), a safety factor of 1.5, and a cyclic fatigue loading.

Fig. 19.4

