

Heavy-duty hexagon head screw plugs

DIN
910

Verschlußschrauben mit Bund und Außensechskant;
schwere Ausführung, zylindrisches Gewinde

Supersedes DIN 910 Part 1,
June 1983 edition.

In keeping with current practice in standards published by the International Organization for Standardization (ISO), a comma has been used throughout as the decimal marker.

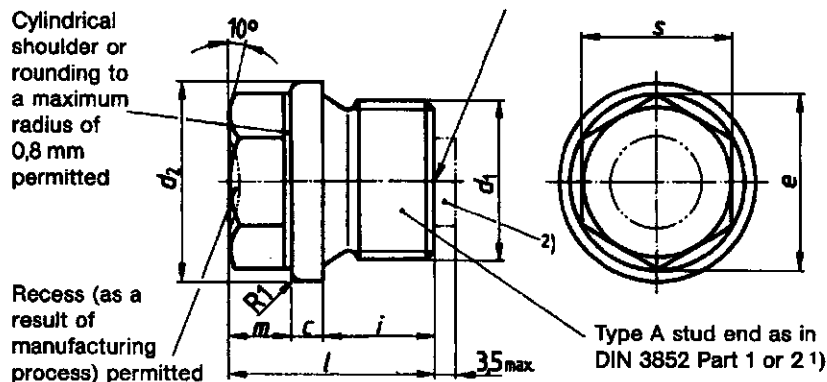
Dimensions in mm

1 Scope and field of application

This standard specifies dimensions and technical delivery conditions for screw plugs which are intended to be screwed into holes with parallel thread as specified in DIN 13 Part 5, 6 or 7, or ISO 228-1. Such plugs may be used together with seal rings as specified in DIN 7603, type and material of which are to be selected as a function of the operating conditions (e.g. pressure, temperature, fluid with which the threaded parts are in contact, etc.).

2 Dimensions and designation

Dimension l may be up to 0,25 mm greater for thread sizes up to M 24 and up to 0,5 mm greater for thread sizes above M 24



Designation of an M 20 × 1,5 steel (St) screw plug:

Screw plug DIN 910 – M 20 × 1,5 – St

Designation of a G ½ A steel (St) screw plug:

Screw plug DIN 910 – G ½ A – St

1) Where required, screw plugs may be supplied with type B stud end complying with the specifications of DIN 3852 Part 1 or 2. The designation will then read, for example:

Screw plug DIN 910 – B – M 20 × 1,5 – St

2) Screw plugs may be supplied with an integral permanent magnet (PM), which may protrude to a maximum of 3,5 mm. The type and dimensions of the magnet and the space to receive it are at the manufacturer's discretion. The designation of a screw plug with an integral permanent magnet will then read, for example:

Screw plug DIN 910 – M 20 × 1,5 – St – PM

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Thread size (d_1)		as in ISO 228-1 (pipe thread)	c +0,5 0	d_2 h14	e min.	i $\pm 0,2$	l \approx	m $\pm 1/15$	s Toler- ance	Approximate mass (7,85 kg/dm ³) per 1000 units, in kg	
as in DIN 13 Part 5, 6 or 7 (metric fine pitch thread)											
M 10 × 1	-	G 1/8 A	3	14	10,89	8	17	6	10	h14	12,0
M 12 × 1,5	-	-	3	17	14,20	12	21	6	13		20,3
-	-	G 1/4 A ²⁾	3	18	14,20	8	17	6	13		20,0
-	-	G 1/4 A	3	18	14,20	12	21	6	13		23,8
M 14 × 1,5	-	-	3	19	14,20	12	21	6	13		25,0
M 16 × 1,5	-	-	3	21	18,72	12	21	6	17		35,2
-	-	G 3/8 A ²⁾	3	22	18,72	8	17	6	17		32,2
-	-	G 3/8 A	3	22	18,72	12	21	6	17		38,1
M 18 × 1,5	-	-	4	23	18,72	12	24	8	17		48,6
M 20 × 1,5	M 20 × 2 ¹⁾	-	4	25	20,88	14	26	8	19		64,5
-	-	G 1/2 A ²⁾	4	26	20,88	10	22	8	19		57,8
-	-	G 1/2 A	4	26	20,88	14	26	8	19		66,6
M 22 × 1,5	-	-	4	27	20,88	14	26	8	19		73,4
M 24 × 1,5	-	-	4	29	23,91	14	27	9	22		93,5
M 26 × 1,5	-	-	4	31	26,17	16	30	10	24		120
-	-	G 3/4 A ²⁾	4	32	26,17	12	26	10	24	109	
-	M 27 × 2	G 3/4 A	4	32	26,17	16	30	10	24	127	
M 30 × 1,5	M 30 × 2	-	4	36	26,17	16	30	10	24	148	
-	M 33 × 2	G 1 A	5	39	29,56	16	32	11	27	195	
M 36 × 1,5	M 36 × 2	-	5	42	29,56	16	32	11	27	220	
M 38 × 1,5	-	G 1 1/8 A	5	44	29,56	16	32	11	27	238	
-	M 39 × 2	-	5	46	29,56	16	32	11	27	255	
M 42 × 1,5	M 42 × 2	G 1 1/4 A	5	49	32,95	16	33	12	30	300	
M 45 × 1,5	M 45 × 2	-	5	52	32,95	16	33	12	30	340	
M 48 × 1,5	M 48 × 2	G 1 1/2 A	5	55	32,95	16	33	12	30	375	
M 52 × 1,5	M 52 × 2	-	5	60	32,95	16	33	12	30	430	
-	-	G 1 3/4 A	5	62	39,55	20	40	15	36	572	
-	M 56 × 2	-	5	64	39,55	20	40	15	36	620	
-	M 60 × 2	G 2 A	5	68	39,55	20	40	15	36	695	
-	M 64 × 2	-	5	72	39,55	20	40	15	36	774	

1) Only for tapped holes in indicator valves as specified in DIN 6273.

2) This size (with short stud end) is not recommended. Where the purchaser, however, requires such a size, the stud length, i , shall be stated in the designation, e.g.:

Screw plug DIN 910 - G 1/4 A × 8 - St

3 Material

Screw plugs shall be manufactured from 9 SMnPb 28 K steel as in DIN 1651 or UQSt 36 steel as in DIN 17 111 (St), at the manufacturer's discretion, stainless steel (A1) as in DIN 267 Part 11, aluminum alloy (Al) as in DIN 267 Part 18, copper-zinc alloy (CuZn) as in DIN 267 Part 18, or from polyamide (PA).

Use of other materials or material grades shall be the subject of agreement.

4 Product grade, surface roughness, width across flats and tolerances

Screw plugs shall be manufactured to the general tolerances, accuracy grade c, as specified in ISO 2768 Part 1, be of product grade B as specified in ISO 4749 Part 1 and have a surface roughness complying with the specifications of

DIN 267 Part 2. The widths across flats shall comply with DIN 475 Part 1.

5 Surface finish

DIN 267 Part 9 shall apply with regard to electroplating and DIN 50 942, with regard to phosphating, other finishes being subject to agreement.

6 General requirements

Screw plugs shall comply with the general requirements specified in DIN 267 Part 1.

7 Acceptance inspection

DIN 267 Part 5 shall apply with regard to acceptance inspection.