

Hexagon socket screw plugs

DIN
908

Verschlußschrauben mit Bund und Innensechskant; zylindrisches Gewinde

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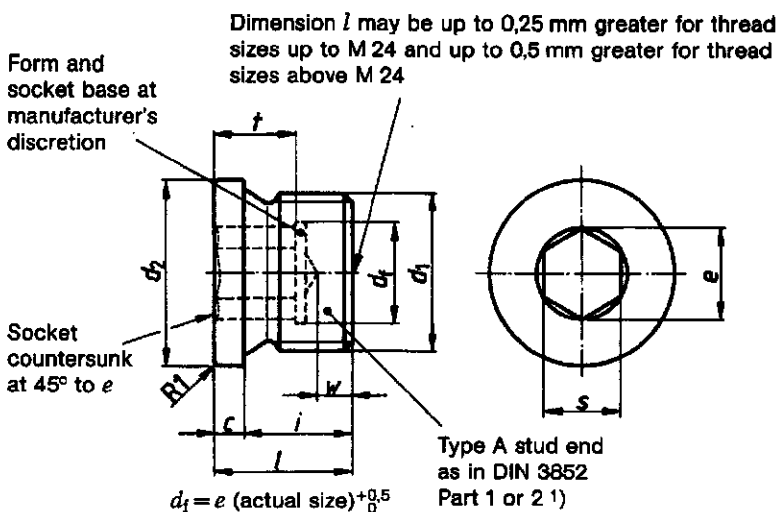
In keeping with current practice in standards published by the International Organization for Standardization (ISO), a comma has been used throughout as the decimal marker.

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 Part 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



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

Screw plug DIN 908 – M 20 × 1,5 – St

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

Screw plug DIN 908 – 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 908 – B – M 20 × 1,5 – St

Continued on pages 2 and 3

| Thread size (d_1) | | c +0,5 0 | d_2 h14 | e_1 min. | i $\pm 0,2$ | l \approx | s D12 | t min. | w min. | 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) | as in ISO 228 Part 1 (pipe thread) | | | | | | | | | | |
| M 10 × 1 | - | G 1/8 A | 3 | 14 | 5,7 | 8 | 11 | 5 | 5 | 3 | 6,34 |
| M 12 × 1,5 | - | - | 3 | 17 | 6,9 | 12 | 15 | 6 | 7 | 3 | 11,3 |
| - | - | G 1/4 A | 3 | 18 | 6,9 | 12 | 15 | 6 | 7 | 3 | 14,6 |
| M 14 × 1,5 | - | - | 3 | 19 | 6,9 | 12 | 15 | 6 | 7 | 3 | 16,0 |
| M 16 × 1,5 | - | - | 3 | 21 | 9,2 | 12 | 15 | 8 | 7,5 | 3 | 19,0 |
| - | - | G 3/8 A | 3 | 22 | 9,2 | 12 | 15 | 8 | 7,5 | 3 | 21,4 |
| M 18 × 1,5 | - | - | 4 | 23 | 9,2 | 12 | 16 | 8 | 7,5 | 3 | 28,3 |
| M 20 × 1,5 | - | - | 4 | 25 | 11,4 | 14 | 18 | 10 | 7,5 | 4 | 37,5 |
| - | - | G 1/2 A | 4 | 26 | 11,4 | 14 | 18 | 10 | 7,5 | 4 | 40,8 |
| M 22 × 1,5 | - | - | 4 | 27 | 11,4 | 14 | 18 | 10 | 7,5 | 4 | 47,5 |
| M 24 × 1,5 | - | - | 4 | 29 | 13,7 | 14 | 18 | 12 | 7,5 | 4 | 53,5 |
| M 26 × 1,5 | - | - | 4 | 31 | 13,7 | 16 | 20 | 12 | 9 | 4 | 68,7 |
| - | M 27 × 2 | G 3/4 A | 4 | 32 | 13,7 | 16 | 20 | 12 | 9 | 4 | 73,5 |
| M 30 × 1,5 | M 30 × 2 | - | 4 | 36 | 19,4 | 16 | 20 | 17 | 9 | 4 | 84,0 |
| - | M 33 × 2 | G 1 A | 5 | 39 | 19,4 | 16 | 21 | 17 | 9 | 4 | 111 |
| M 36 × 1,5 | M 36 × 2 | - | 5 | 42 | 21,7 | 16 | 21 | 19 | 10,5 | 4 | 134 |
| M 38 × 1,5 | - | G 1 1/8 A | 5 | 44 | 21,7 | 16 | 21 | 19 | 10,5 | 4 | 149 |
| - | M 39 × 2 | - | 5 | 46 | 21,7 | 16 | 21 | 19 | 10,5 | 4 | 163 |
| M 42 × 1,5 | M 42 × 2 | G 1 1/4 A | 5 | 49 | 25,2 | 16 | 21 | 22 | 10,5 | 4 | 187 |
| M 45 × 1,5 | M 45 × 2 | - | 5 | 52 | 25,2 | 16 | 21 | 22 | 10,5 | 4 | 215 |
| M 48 × 1,5 | M 48 × 2 | G 1 1/2 A | 5 | 55 | 27,4 | 16 | 21 | 24 | 10,5 | 4 | 246 |
| M 52 × 1,5 | M 52 × 2 | - | 5 | 60 | 27,4 | 16 | 21 | 24 | 10,5 | 4 | 302 |
| - | - | G 1 3/4 A | 5 | 62 | 36,6 | 20 | 25 | 32 | 14 | 4 | 320 |
| - | M 56 × 2 | - | 5 | 64 | 36,6 | 20 | 25 | 32 | 14 | 4 | 386 |
| - | M 60 × 2 | G 2 A | 5 | 68 | 36,6 | 20 | 25 | 32 | 14 | 4 | 445 |
| - | M 64 × 2 | - | 5 | 72 | 36,6 | 20 | 25 | 32 | 14 | 4 | 530 |

1) $e_{\min} = 1,14 s_{\min}$ (values rounded).

3 Material

Screw plugs shall be manufactured from 9 SMnPb 28 K steel as in DIN 1851 or UQSt 36 steel as in DIN 17 111 (St), at the manufacturer's discretion, stainless steel (A1) as in DIN 267 Part 11, aluminium 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 and tolerances

Screw plugs shall be manufactured to the general tolerances, accuracy grade c, as specified in ISO 2768, be of product grade B as specified in ISO 4759 Part 1 and have a surface roughness complying with the specification of DIN 267 Part 2.

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

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.