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Hexagon socket screw plugs

DIN 908

Verschlußschrauben mit Bund und Innensechskant; zylindrisches Gewinde

Supersedes
June 1983 edition.

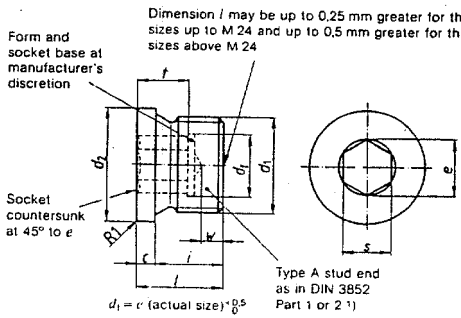
In keeping with current practice in standards published by the International Organization for Standardization (ISO), a comma has been used throughout as the decimal marker.

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 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) as in DIN 13 Part 5, 6 or 7 (metric fine pitch thread)		Thread size (d_1) as in ISO 228 Part 1 (pipe thread)	c +0,5 0	d_2 h13	e [1] min	i ±0,2	l ≈	s D12	t min	w min	Approximate mass (7,85 kg/dm³) per 1000 units, in kg
M 10 × 1	–	G ⅛ A	3	14	5,7	8	11	5	5	3	8,34
M 12 × 1,5	–	–	3	17	6,9	12	15	6	7	3	11,3
–	–	G ¼ 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 ⅜ 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 ½ 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 ¾ 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 1⅛ 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 1¼ 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 1½ 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 1¾ 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 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, 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.

Standards referred to

DIN 13 Part 5	ISO metric screw threads; 1 mm and 1,25 mm fine pitch threads with diameters from 7,5 mm to 200 mm; nominal sizes
DIN 13 Part 6	ISO metric screw threads; 1,5 mm fine pitch threads with diameters from 12 mm to 300 mm; nominal sizes
DIN 13 Part 7	ISO metric screw threads; 2 mm fine pitch threads with diameters from 17 mm to 300 mm; nominal sizes
DIN 267 Part 1	Fasteners; technical delivery conditions; general requirements
DIN 267 Part 2	Fasteners; technical delivery conditions; product grades and tolerances
DIN 267 Part 5	Fasteners; technical delivery conditions; acceptance inspection (modified version of ISO 3269 : 1984)
DIN 267 Part 9	Fasteners; technical delivery conditions; electroplated components
DIN 267 Part 11	Fasteners; technical delivery conditions; stainless and acid-resistant steel components (with addenda to ISO 3506)
DIN 267 Part 18	Fasteners; technical delivery conditions; non-ferrous metal components
DIN 1651	Free cutting steel; technical delivery conditions
DIN 3852 Part 1	Stud ends, tapped holes and screw plugs for compression couplings and valves, with metric fine pitch thread; dimensions
DIN 3852 Part 2	Stud ends, tapped holes and screw plugs for compression couplings and valves, with pipe thread; dimensions
DIN 7603	Sealing rings for use with compression couplings and screw plugs
DIN 17 111	Low carbon unalloyed steel for bolts, nuts and rivets; technical delivery conditions
DIN 50 942	Phosphating of metals; methods of test
ISO 228-1 : 1982	Pipe threads where pressure-tight joints are not made on the threads; designation, dimensions and tolerances
ISO 2768-1 : 1989	Tolerances for linear and angular dimensions without individual tolerance indications
ISO 4759-1 : 1978	Tolerances for fasteners; bolts, screws, and nuts with thread diameters from 1,6 to 150 mm and product grades A, B and C

Other relevant standards

DIN 906	Hexagon socket pipe plugs
DIN 909	Hexagon head screw plugs
DIN 910	Heavy duty hexagon head screw plugs
DIN 5586	Compressed-air equipment for rail vehicles; screw plugs with vent
DIN 7604	Light-duty hexagon head screw plugs

Previous editions

DIN 908: 04.25, 12.43, 04.56, 09.59, 01.73, 06.83.

Amendments

In comparison with the June 1983 edition, the standard has been editorially revised

International Patent Classification

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