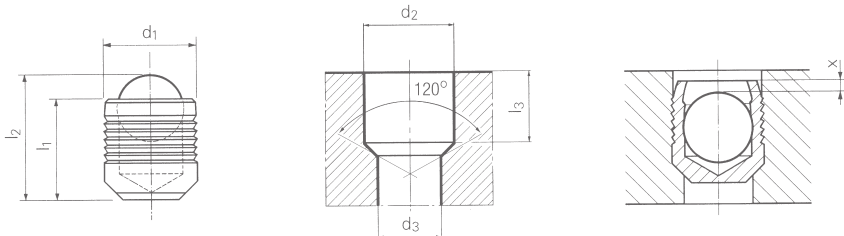




# MB 600 Series Sealing Plugs



- **Sleeve**  
Stainless Steel  
DIN 1.4305, AISI 303
- **Hardness**  
HB = 220
- **Ball**  
Stainless Steel  
DIN 1.4301, AISI 304

Sleeve and Ball clear passivated per MIL S 5002 Aerospace quality.

Equivalent working pressure capability can be obtained when using base materials with similar mechanical characteristics.

However, the appropriate installation instructions must be followed. Anchorage between sleeve and base material is achieved when the sleeve is a minimum of HB=30 greater than the base material.

If the hardness difference is less, hole roughness of 10 to 30 µm is needed to achieve indicated working pressures.

### Security Range

The security range (the difference between working pressure and Test B pressure) allows for uncontrollable variations. For instance, dynamic loading at 1 million cycles and a frequency of 3-4Hz has shown that burst pressure Test A and Test B pressure are reduced about 20% after this point.

Type	Dimensions in mm						
	d <sub>1</sub>	l <sub>1</sub>	l <sub>2</sub> -	d <sub>2</sub> + 0.1	d <sub>3</sub> max.	l <sub>3</sub> min.	x ±0.2
MB 600-030	3.0	3.6	4.6	3.0	2.2	3.4	0.4
MB 600-040	4.0	4.0	5.2	4.0	3.3	3.8	0.2
MB 600-050	5.0	5.5	7.0	5.0	4.3	5.3	0.4
MB 600-060	6.0	6.5	8.6	6.0	5.3	6.3	0.4
MB 600-070	7.0	7.5	10.1	7.0	6.4	7.3	0.4
MB 600-080	8.0	8.5	11.7	8.0	7.4	8.3	0.3
MB 600-090	9.0	10.0	13.7	9.0	8.4	9.8	0.4
MB 600-100	10.0	11.0	15.2	10.0	9.4	10.8	0.4
MB 600-120	12.0	13.0	18.0	12.0	10.6	12.8	0.4
MB 600-140	14.0	15.0	20.8	14.0	12.7	14.5	0.4

1 - Proof Pressure Test B    2 - Maximum allowable working pressure = nominal pressure

## PRESSURE PERFORMANCE

	Base Material / Minimum Hardness HB						
	High Strength Stl ETG-100 AISI 1144	Free Machining Case Hard Stl. C15 Pb	Cast Iron GG-25 DIN 1691	Ductile Cast Iron GGG-50 DIN 1693 DIN 1.0403	Aluminium Alloy Al Cu Mg 2 DIN 3.1354 AA2024	Aluminium Alloy Al Mg Si Pb DIN 3.0615 AA6262	Cast Al Alloy G-Al Si 7 Mg 3.2371 AA356-T6
	280	180	160	170	120	90	80
d, mm	P Test B <sup>1</sup> Bar	P Test B <sup>1</sup> Bar		PW <sup>2</sup> Bar	PW <sup>2</sup> Bar	P Test B <sup>1</sup> Bar	PW <sup>2</sup> Bar
3-10	1400	1400		450	450	1200	380
12-14	1000	1000		350	350	900	280