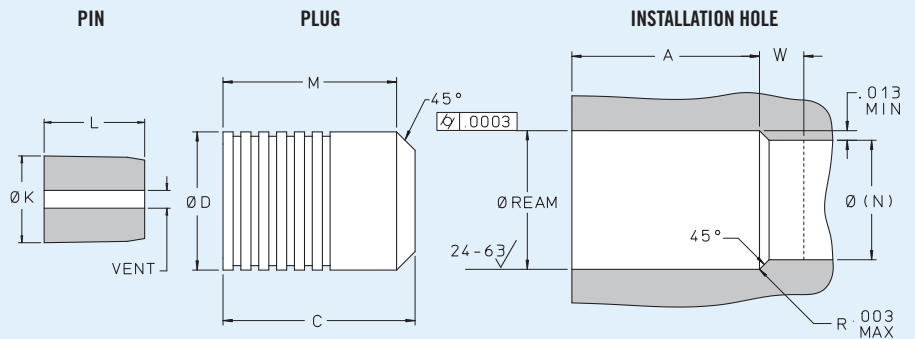


MP35N LEE PLUG®

The new MP35N Lee Plug® is the latest addition to our comprehensive product line of field-proven Lee Plug expansion plugs. Constructed entirely from MP35N, a nickel-cobalt based material, these plugs are compliant with NACE MR0175/ISO15156. MP35N Lee Plugs are specifically designed to offer exceptional corrosion resistance and performance for the harsh environments found in the oil and gas industry. Controlled expansion, perfected by The Lee Company, causes the lands and grooves of the plug to “bite” into the surrounding material forming independent seals and retaining rings resulting in a positive, reliable, leak and trouble-proof seal for both liquids and gases. MP35N Lee Plugs have a proof pressure rating of 30,000 psi and are offered in nine diameters: 0.093", 0.125", 0.156", 0.187", 0.218", 0.250", 0.281", 0.312", and 0.343".

- NACE compliant materials
- 30,000 psi proof pressure
- 400°F temperature rating
- Permanent, leak-tight seal for liquids and gases
- Easy installation



LEE PART NUMBER	DIMENSIONS (inches)									
	PIN AND PLUG						INSTALLATION HOLE			
	D MAX.	D MIN.	C NOM.	M NOM.	K NOM.	L NOM.	Ø REAM	A MIN.	N REF.	W MIN.
PLGA0931350A	0.0937	0.0928	0.148	0.128	0.067	0.096	0.0937 - 0.0942	0.145	0.062	0.060
PLGA1251350A	0.1250	0.1241	0.193	0.173	0.096	0.125	0.1250 - 0.1255	0.190	0.093	0.060
PLGA1561350A	0.1562	0.1553	0.245	0.215	0.121	0.175	0.1562 - 0.1567	0.235	0.125	0.060
PLGA1871350A	0.1875	0.1866	0.260	0.235	0.156	0.181	0.1875 - 0.1880	0.254	0.156	0.060
PLGA2181350A	0.2187	0.2178	0.307	0.277	0.184	0.218	0.2187 - 0.2192	0.297	0.187	0.060
PLGA2501350A	0.2500	0.2491	0.365	0.333	0.211	0.265	0.2500 - 0.2505	0.352	0.218	0.060
PLGA2811350A	0.2812	0.2803	0.370	0.340	0.245	0.280	0.2812 - 0.2817	0.360	0.250	0.060
PLGA3121350A	0.3124	0.3115	0.436	0.406	0.278	0.309	0.3124 - 0.3129	0.423	0.281	0.060
PLGA3431350A	0.3437	0.3428	0.500	0.410	0.309	0.334	0.3437 - 0.3442	0.437	0.312	0.060

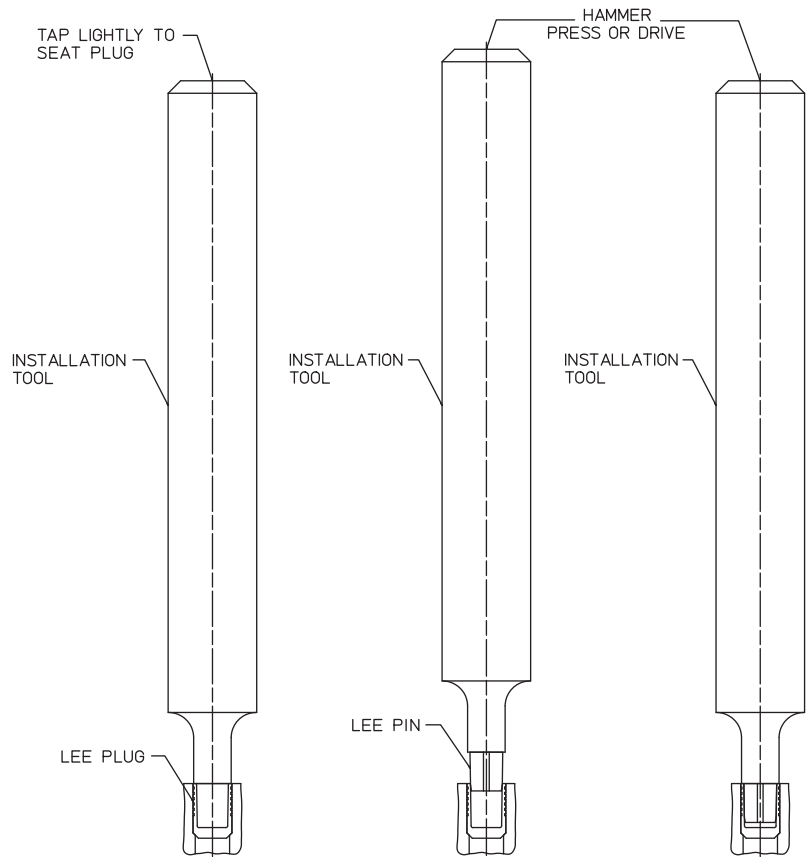
MATERIALS	
PART	MATERIAL
Pin	MP35N Chemistry per AMS 5844 and heat treat per NACE MR0175
Plug	

FINISH
Pin: Wax Coat
Plug: None

INSTALLATION

1. The installation hole and O.D. of the plug should be clean and dry.
2. Firmly support the item to be plugged.
3. Slip the plug into the hole until it is firmly seated on the support shoulder in the mounting hole. Lightly tap the back of the plug with the installation tool or a punch that bottoms on the flat portion at the base of the plug's I.D. This is a technique that will ensure firm seating. If this is not done, the plug may slide forward while the pin is being driven and cause longitudinal scratch marks in the reamed hole. Do not apply any more than a few pounds of force to the bottom of the plug in an attempt to ensure a firmer seat.
4. Start the pin, small end first, into the tapered hole of the plug. Avoid tilting the pin. Press or drive the pin with the proper installation tool (see table below) until the end of the pin is flush with the end of the plug. Flushness limits are 0.010" into the plug to 0.005" out of the plug.

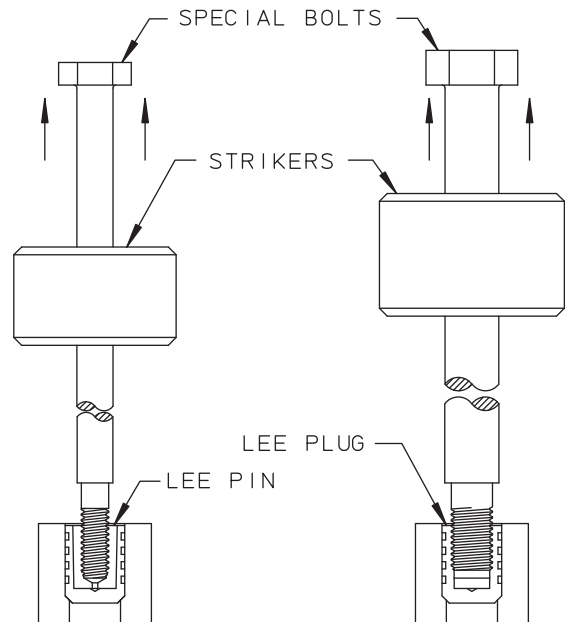
LEE PLUG DIAMETER (inches)	INSTALLATION TOOL
0.093	CUTA0930203A
0.125	CUTA1250203A
0.156	CUTA1560203A
0.187	CUTA1870203A
0.218	CUTA2180203A
0.250	CUTA2500203A
0.281	CUTA2810203A
0.312	CUTA3120203A
0.343	CUTA3430203A



EXTRACTION

1. Drill and tap the pin (using taps from the appropriate extraction set).
2. Remove the pin with the appropriate bolt and striker (see extraction set part numbers below).
3. Tap the plug (using taps from the appropriate extraction set).
4. Remove the plug with the appropriate bolt and striker.

LEE PLUG DIAMETER (inches)	EXTRACTION SET
0.093	CUTA0930113A
0.125	CUTA1250113A
0.156	CUTA1560113A
0.187	CUTA1870113A
0.218	CUTA2180113A
0.250	CUTA2500113A
0.281	CUTA2810113A
0.312	CUTA3120113A
0.343	CUTA3430113A



For more information on installation, extraction, and design criteria, visit the Support & Resources section of our website or contact your local Lee Sales Engineer and ask for Lee Process Specification 203.

