

ZI 942/... Sealing Plugs

for heating / cooling lines in molds and dies

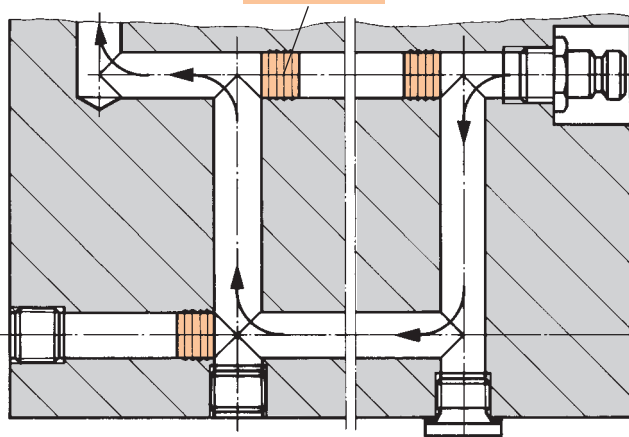
Available in
Inch-dimensions

Dia.	1/4	5/16	3/8
Dia.	7/16	9/16	11/16



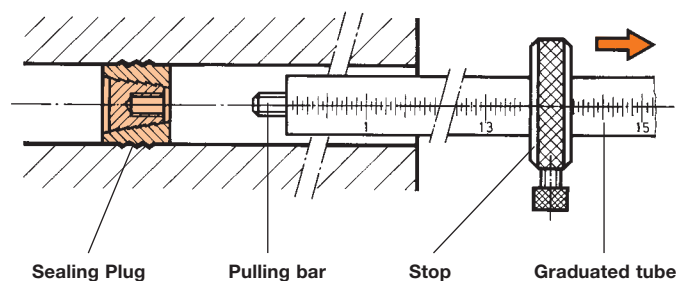
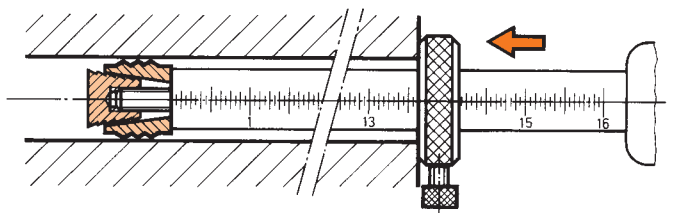
Figure 1.

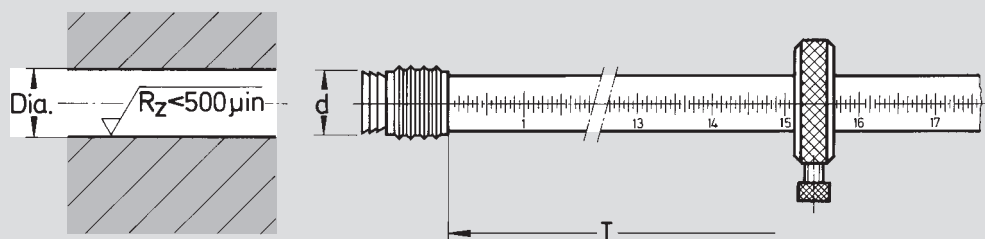
ZI 942/...



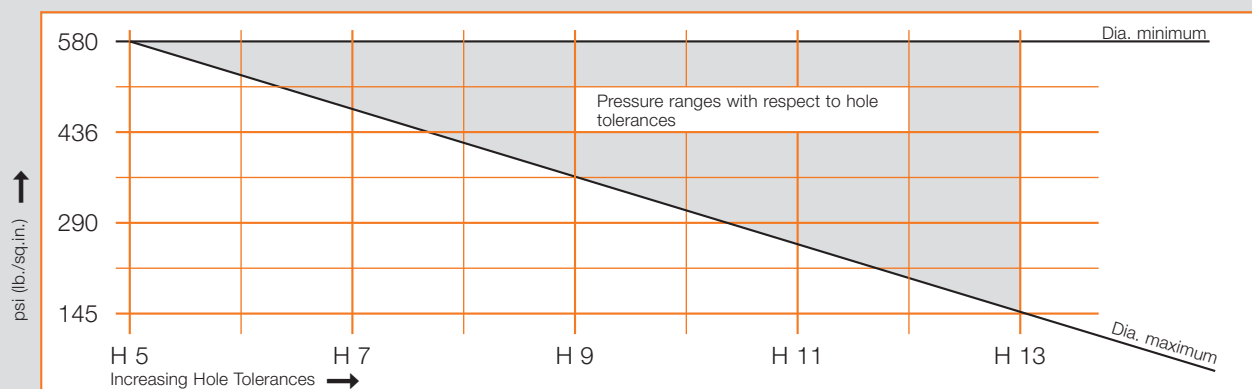
Features

- Tried and true solution for the diverting of water, oil or air flow through intersecting circuits in molds and dies.
- Rust-free Seal Plugs are made with inner stainless steel core and outer brass sleeve.
- Easy to use assembly tool for installing Seal Plugs.
- Positioning Seal Plugs is fast and easy with scale tube and positive stop.
- Draw bar unscrews quickly after plugs have been set.
- Handy storage kit for all components.
- Multiple plugs installed in just minutes.




Table 1. Applicable mounting depths for the various plug sizes

d \ T	5-7/8	7-7/8	9-1/4	9-7/8	12-3/8	15-3/4	24-3/4	31-1/2
1/4	ZI 945/#1							
5/16		ZI 945/#1			ZI 947/#1			
3/8			ZI 945/#1			ZI 947/#1		
7/16				ZI 945/#2		ZI 947/#2		
9/16				ZI 945/#2			ZI 947/#2	
11/16				ZI 945/#2				ZI 947/#2

Table 2. Standard Values for Hole Tolerances and Pressures

Table 3. Hole Tolerances

Dia. [inch]	Standard Fits (Values are in thousandths of an inch)				
	H 5	H 7	H 9	H 11	H 13
1/4	+0.24	+0.59	+1.42	+3.54	+8.66
5/16	0	0	0	0	0
3/8					
7/16	+0.31	+0.71	+1.69	+4.33	+10.63
9/16	0	0	0	0	0
11/16					

For further information please refer to the "HASCO-Specification Sheet for Allowances and Tolerances".

Important Information

HASCO Sealing Plugs are a tried and true solution for the diverting of water, oil or air flow through intersecting circuits in molds and dies. Accurate spacing and positive sealing is insured. For gun drilled holes, the extended

mounting bar ZI 947/... should be used (see Table 1). Depending on the bore tolerance (see Table 2), the mounted Sealing Plugs withstand pressure up to 680 psi (40 bar).

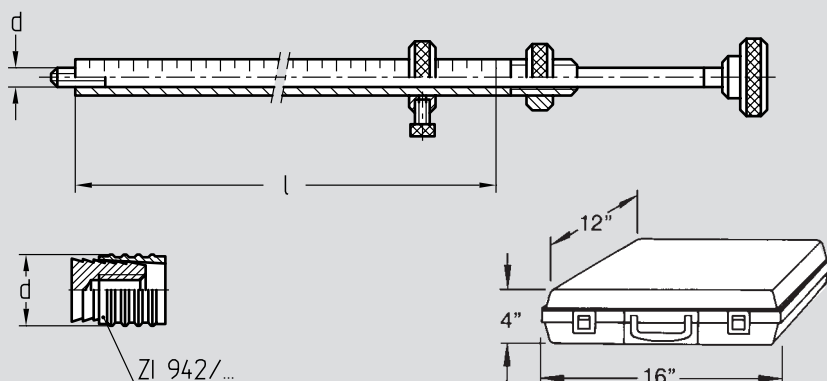
The Sealing Plugs ZI 942/... should not be used in place of pipe plugs. For this purpose, only threaded plugs must be used. Please refer to Figure 1.

Mounting Kit


The mounting kit ZI 945/.. contains an assortment of three sealing plug sizes, the assembly tool and matching

mounting bars. These can easily be inserted into the assembly tool. When working with different Sealing Plug

sizes the matching mounting bar must be used with the assembly tool. Two types of mounting kits are offered.

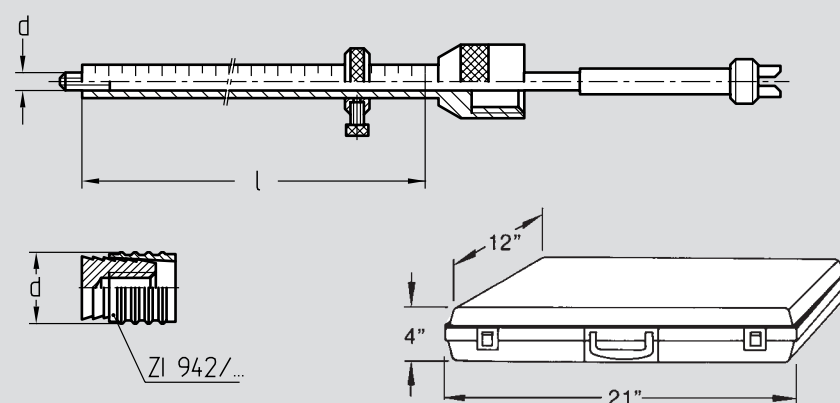


ZI 945/#1 Mounting Kit


Qty		d	l	#	Order No.
25	ZI 942/1/4	1/4	5-7/8	1	ZI 945/#1
25	ZI 942/5/16	5/16	7-7/8		
25	ZI 942/3/8	3/8	9-1/4		

ZI 947/#1/... Extended Mounting Kit

#	d	l	Order No.
1	5/16	12-3/8	ZI 947/#1/5/16x12-3/8
1	3/8	15-3/4	ZI 947/#1/3/8x15-3/4



ZI 945/#2 Mounting Kit

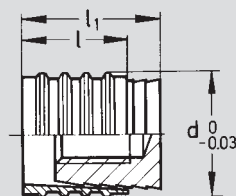
Qty		d	l	#	Order No.
25	ZI 942/7/16	7/16	9-7/8	2	ZI 945/#2
20	ZI 942/9/16	9/16	9-7/8		
15	ZI 942/11/16	11/16	9-7/8		

ZI 947/#2/... Extended Mounting Kit

#	d	l	Order No.
2	7/16	15-3/4	ZI 947/#2/7/16x15-3/4
2	9/16	24-3/4	ZI 947/#2/9/16x24-3/4
2	11/16	31-1/2	ZI 947/#2/11/16x31-1/2

ZI 942/... Sealing Plug

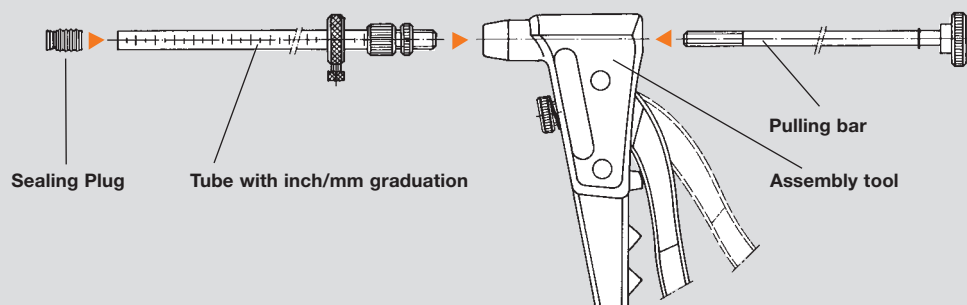
Mat.: Brass/Stainless Steel



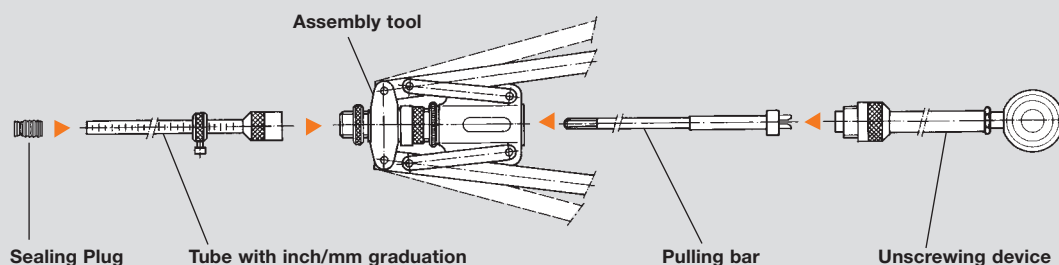
Contained in Mounting Kit	l_1	l	d	Order No.
ZI 945/#1	29/64	5/16	1/4	ZI 942/1/4
	29/64	5/16	5/16	ZI 942/5/16
	9/16	25/64	3/8	ZI 942/3/8

Contained in Mounting Kit	l_1	l	d	Order No.
ZI 945/#2	9/16	25/64	7/16	ZI 942/7/16
	5/8	15/32	9/16	ZI 942/9/16
	5/8	15/32	11/16	ZI 942/11/16

ZI 945/#1



ZI 945/#2



Notes:

Please note: Metric dimensions of Sealing Plugs with diameters of 6, 8, 10, 12 and 16 mm for water line depth up to 31-1/2 (800 mm) are offered in

the HASCO Metric Catalog. To distinguish them, the inch Sealing Plugs are black anodized and the metric Sealing Plugs have a metallic finish.

Please refer to our Operating Manual for further information.

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