NAVISTAR, INC.			
Material, Parts, and Process Specifications (MPAPS)		*NUMBER:* **MPAPS S-J-14.101-GS/PL**	
		Former Designation: **ESP-J-14.101-GS**	
TITLE: **Expansion Plugs – English Series (Noun Code 6400)**		*CURRENT REV No.:* **1506**	*DATE:* **June 2015**
WRITTEN/EDITED BY: **Materials Engineering**	*APPROVED BY:* **Materials Engineering**	*SUPERSEDES:* **ESP-J-14.101-GS - August 2006**	

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This specification may involve hazardous materials, equipment, and procedures. This specification does not purport to address all of the safety issues associated with its use. The user is responsible to consult appropriate safety and health practices and to determine the applicability of regulatory limits prior to use.

Change Notice: **Changed to New MPAPS format; Combined GS, PP, NPP.**

1.0 MATERIAL:

Steel - SAE 1008 or 1010 per MPAPS A-0, Part II, Code 0-100, Rockwell Hardness B-50 minimum, recommended maximum B-80.

Brass – C36000 per CEMS C-3.
Aluminum - AA 1100-H18 (Hard Temper) per MPAPS C-10.

2.0 RESTRICTED CHEMICAL SUBSTANCES: Effective January 1, 2007, all product supplied to the requirements of this specification must comply with the requirements of the MPAPS B-50 specification.

3.0 FINISHES: As designated by part number, plugs will be furnished plain, or plated in accordance with MPAPS and class listed below:

Zinc Trivalent (ZN6A) – MPAPS G-20, Class 6A.

4.0 DEFECTS: Expansion plugs must be free from burrs, loose scale, sharp edges and all other defects that might affect their serviceability.

5.0 POLICY FOR SELECTING PARTS FOR NEW DESIGN OF NOT DRILLED PLUGS:

For new design, parts shall be selected from "Approved" part list only.

Nominal Sizes:	5/16 to 1-1/2 – 5/16 inch increments 1-1/2 to 2-1/2 – 1/8 inch increments 2-1/2 and over – 1/4 inch increments
Thickness:	5/16 to 13/16 – .065 Thick 7/8 to 3 – .083 Thick 3 and over – .134 Thick
Material:	Steel
Finish	Plain

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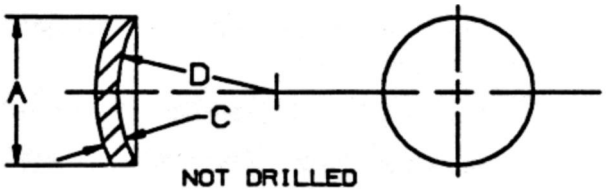
6.0 PART LIST:

6.1 Approved:



Note: The edge on these standard plugs is that resulting from punching flat stock and is not shaved or beveled after forming. Edge must be parallel to centerline.

Dimensions in inches:

Nominal Size	A Diameter		C Thickness ± .005	D Spherical Radius	Material	Finish	Part Number
	Max	Min		Basic			
1 - 3/4	1.755	1.745	.083	2-11/16	Steel	Plain	172578
2- 3/8	2.380	2.370	.083	3- 7/8	Steel	Plain	172599

7.0 TECHNICAL INFORMATION:

For further information related to the technical content of this specification, contact:	Suppliers may purchase controlled copies of this specification by contacting:
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