

## LEE HI-BAR® PLUG

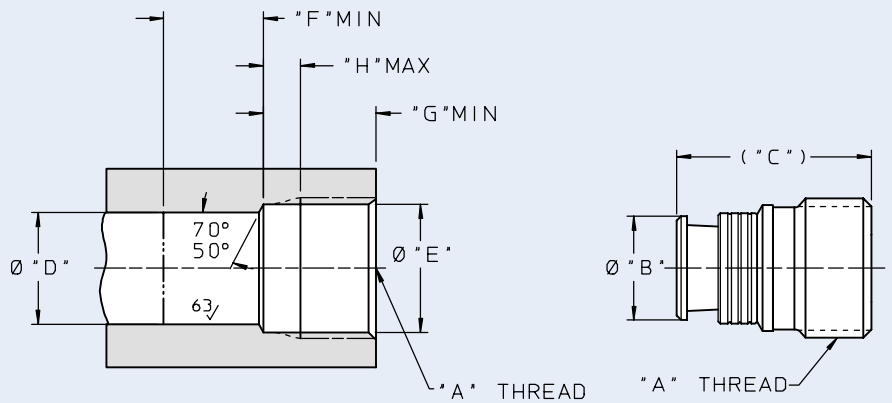
**PROOF 12,500 psi / BURST 25,000 psi**

The Lee HI-BAR® Plug is a reliable, economical, leak-tight threaded plug designed to seal large passageways in hydraulic and fuel system manifolds. Rated for system pressures up to 5000 psi and temperatures from -65°F to 275°F (temperatures as high as 400°F can be tolerated at reduced pressures), Lee HI-BAR Plugs offer many advantages over existing threaded plug devices.

Significant savings are realized in reduced machining, assembly, and inspection costs. A drilled and tapped hole is all that is required along with a simple installation tool. Installation is quick and easy, and HI-BAR Plugs can be reused several times.

Installation hole dimensions and material specifications are listed in the tables below.

- High pressure, leak-tight seal without o-rings
- No safety wire or locking rings required
- Easy installation
- Inexpensive boss machining
- Increased system reliability
- Reusable, dependable Lee MultiSeal™



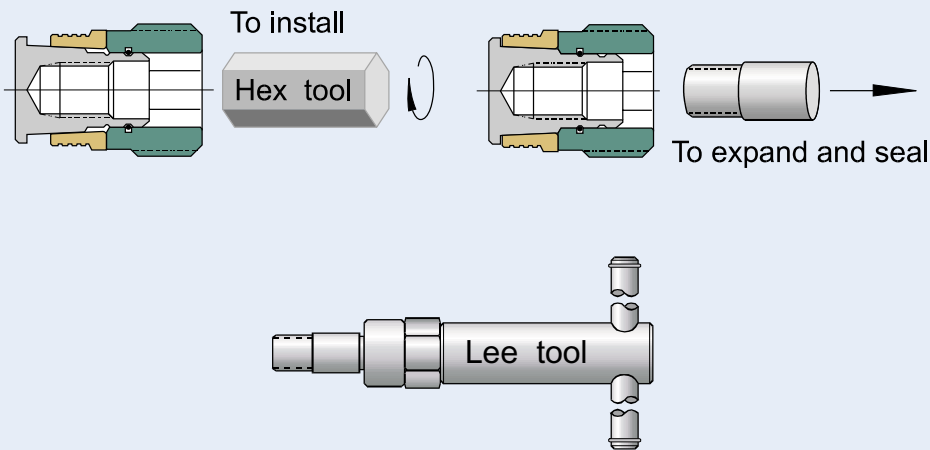
HI-BAR PLUG AND INSTALLATION HOLE DIMENSIONS (in.)								
LEE PART NUMBERS	A THREAD SIZE	B	C (REF.)	D	E	F (MIN.)	G (MIN.)	H (MAX.)
PTHB1008010A	5/8-18 UNJF	.47	.9	.500 - .502	.5709 - .5788	.45	.51	.17
PTHB1210010A	3/4-16 UNJF	.59	1.1	.625 - .627	.6892 - .6977	.48	.62	.22
PTHB1412010A	7/8-14 UNJF	.72	1.3	.750 - .752	.8055 - .8152	.56	.75	.26

	MATERIAL	SPECIFICATION	FINISH
Nut	2024-T351 AL	QQ-A225/6 & AMS 4120	Green Anodize per AMS-A-8625 TYPE II
Pin	2024-T351 AL	QQ-A225/6 & AMS 4120	Black Anodize per AMS-A-8625 TYPE III
MultiSeal	Polyamide-imide	ASTM D5204	—
Retaining Ring	17-7 PH CRES H900	AMS 5678	Passivate Per ASTM A967

# LEE HI-BAR® PLUG

- Sealing is achieved by the use of the controlled expansion principle found in our classic Lee Plug. Matching tapers provide compressive sealing forces on multiple lands and grooves.
- The self-locking feature eliminates safety wires, locking rings, or other methods of anti-rotation. Break-away torque exceeds twice that specified by MIL-F-18240 for threaded fasteners.
- Elimination of o-rings and other types of elastomeric seals improves system reliability since there are no seal cure dates, shelf lives, or service dates.
- The use of our Lee MultiSeal in the HI-BAR design reduces the stresses transferred to the threads and housing. Since the thread stresses are low, thinner walls can be used to reduce weight.
- Lee HI-BAR Plugs are 4 component, lightweight, pre-assembled units. The aluminum threaded plug and pin, and polyamide-imide MultiSeal save considerable weight.

## INSTALLATION & EXTRACTION



### INSTALLATION

Thread the plug into the installation hole and torque to the proper value (see table below). Expand the seal by threading the Lee installation tool, or similar bolt, into the back of the pin and pulling out to the solid stop. This can be accomplished manually or with a pneumatic pop rivet gun. The detent mechanism then holds the pin and seal in place. Note that fluid pressure works in the direction that activates the MultiSeal.

### EXTRACTION

De-activate the seal by threading our Lee tool, or similar tool, into the pin and driving the pin inward. The HI-BAR Plug can then be threaded out of the hole.

### HI-BAR PLUG INSTALLATION TORQUE

LEE PART NUMBER	INSTALLATION TORQUE (ft. – lbs.)
PTHB1008010A	5
PTHB1210010A	10
PTHB1412010A	15

Please contact a Lee Sales Engineer for additional information.