

# Technical Bulletin - Core Plug Update

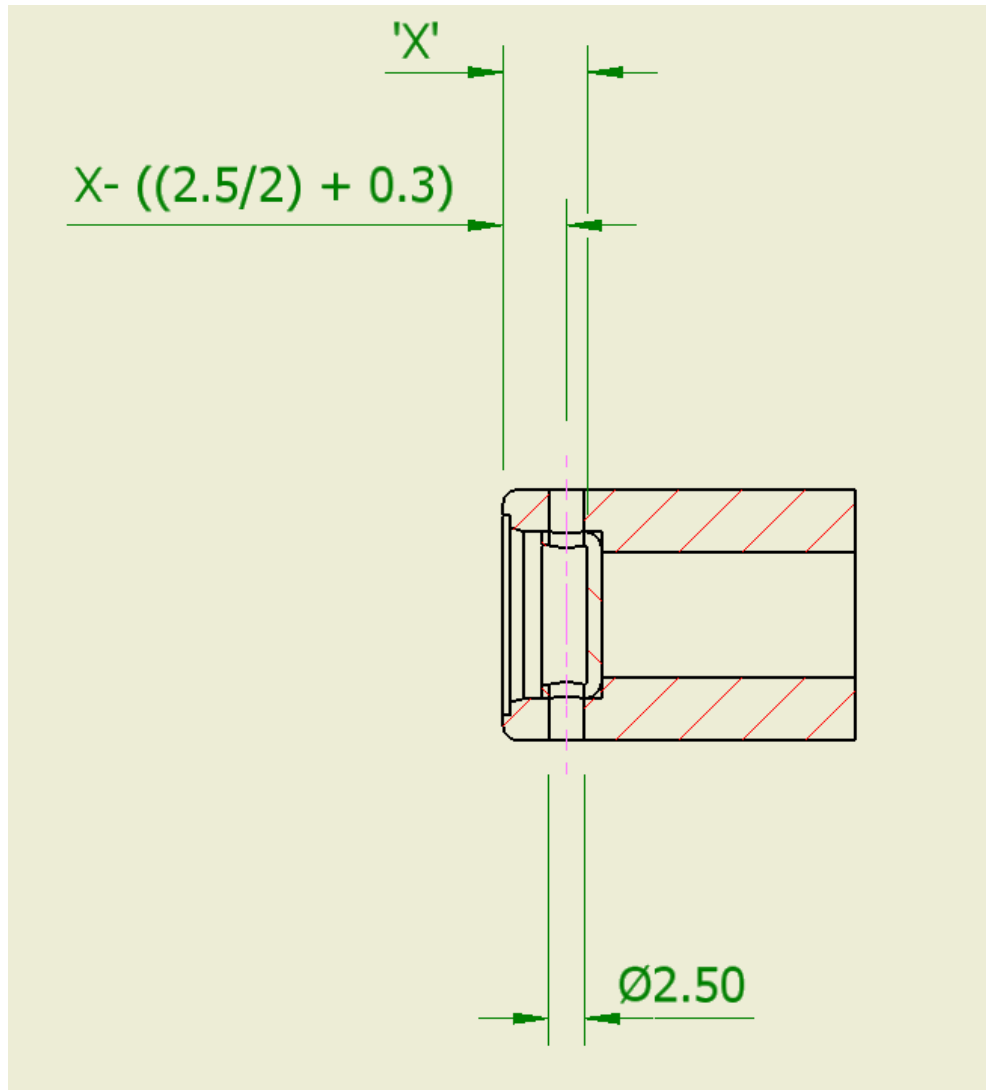
## **Series 2 – PRV Plug**

This bulletin concerns pumps with a serial beginning B40P to B52P and B01Q to B20Q. The update ultimately requires the core plug for sealing the cross drilling of the PRV to be drilled and pinned.

An alternative, but non-preferred solution for this, is to gently peen over the edges of the counter bore where the plug is inserted to ensure no movement of the plug can occur.

The preferred method for this is cross drilling the body and inserting a 3/32 selok pin provided by Titan.

Measure components to face of core plug as shown. Subtract half the diameter of the pin plus clearance then drill 2.5 x 19 deep.



*Fig 1: Cross drilling of body and core plug*

Once the body has been drilled insert the pin across core plug till flush with cast body. (Fig 2). The final result should look as shown in Fig 3



*Fig 2: Pin inserted flush with casting*



*Fig 3: View showing pin inserted across core plug*

**Titan can perform this service free of charge if required.**