



Snap-It tube plugs provide a safe, weld-free solution for sealing heat exchanger, boiler, and condenser tubes. When installed correctly, they stop leaks without damaging tubes or tube sheets. The system includes full tube preparation and installation tooling for both near-end and far-end applications, making tube plugging faster, easier, and more reliable than traditional methods.

SNAP-IT PLUG TECHNICAL SPECIFICATIONS & BENEFITS

INSTALLATION PERFORMANCE:

- Consistent, controlled installation with predictable holding forces.
- Installation per plug completed in minutes, reducing labor costs up to 80% and minimizing downtime.
- Rear Head Cover removal not required for through-the-tube plugging. (*Jr. model plugs*)

SAFETY & RISK REDUCTION:

- Eliminates welding—no sparks or open flames.
- Design minimizes risk of plugs becoming projectiles during removal.
- Prevents damage to tube sheets or ligaments from welding or overdriving tapered plugs.

SEALING & RELIABILITY:

- Leak-tight helium seal: $\geq 1 \times 10^{-9}$ c/sec.
- Reduces reloading time when plugging tubular reactors; does not impede catalyst loading systems.

COMPATIBILITY & FLEXIBILITY:

- Each plug covers a range of tube diameters.
- Available in multiple materials to meet application requirements.
- Tooling compatible with similar mechanical tube plugs for installation/removal.
- Can plug tube sheets directly when tubes are absent.
- Ideal for plugging through headers in air-cooled exchangers.

STANDARDS COMPLIANCE & SUPPORT:

- Complies with ASME PCC-2 recommendations.
- Installation & removal kit available to purchase or rent
- 24/7/365 manufacturing and technical support.

Snap-It Plugs must be installed within the tube's rolled section in the tubesheet. If tubes are not rolled, contact USA Industries (800-456-8721) before installation. Clean scale and pitting using Snap-It Brushes, and remove any weld droop to ensure proper seating of the plug.

*Snap It
Installation
& Removal
Tools Kit*



AVAILABLE IN THE FOLLOWING MATERIALS:

- (S) Stainless Steel (C) Carbon Steel (B) Brass (J) 70/30 CuNi (K) 90/10 CuNi (Y) Chrome/Moly (H) Hastelloy (I) Inconel (N) Incoloy (M) Monel (N200) Nickel 200 (T) Titanium (Z) Zirconium

Other materials available upon request

SNAP IT JR.



Rated holding pressures of **1,000 PSID**

SNAP IT SR.



Rated holding pressures up to **7,000 PSID**

SR. PLUG SIZES		PSID	
0.400	→	0.680	= 7000
0.700	→	0.960	= 4500
0.980	→	2.000	= 2000

WHEN ORDERING SPECIFY:

- Tube ID (*or OD and BWG/Wall Thickness - Snap It Jr only*)
- Material
- Maximum Temperature & Pressure
- Type of Tube or Tube Sheet Joint (*Rolled, Welded, Etc.*)
- # of Brush Kits Needed
- Tooling Needed
- Quantity
- Delivery Date



WARNING: Never stand in front of any installed plug under pressure. Plugs ejected under pressure can cause serious bodily injury.



SNAP IT® ENGINEERED TUBE PLUGS

Superior Sealing Under Pressure



SNAP IT® JR SPECS & ACCESSORIES

Plug #	Plug Range - Tube ID In(mm)	Pin Length In(mm)	Brush Kit	Positioner	Pull Rod	Channel Head Pull Rod
JR-471-"m"	0.472-0.515 (11.99-13.08)	1.63 (41.4)	JRA-471" ^{**} "	PP-471	I	CHPRA-"X"-I
JR-491-"m"	0.492-0.540 (12.50-13.72)	1.67 (42.4)	JRA-491" ^{**} "	PP-491		
JR-512-"m"	0.513-0.562 (13.03-14.27)	1.59 (40.3)	JRA-512" ^{**} "	PP-512		
JR-524-"m"	0.525-0.585 (13.34-14.86)	1.28 (32.5)	JRA-524" ^{**} "	PP-524		
JR-555-"m"	0.556-0.616 (14.12-15.65)	1.40 (35.6)	JRA-555" ^{**} "	PP-555		
JR-584-"m"	0.585-0.649 (14.86-16.48)	1.32 (35.5)	JRA-584" ^{**} "	PP-584	II	CHPRA-"X"-II
JR-621-"m"	0.622-0.689 (15.80-17.50)	1.57 (39.9)	JRA-621" ^{**} "	PP-621		
JR-649-"m"	0.650-0.713 (16.51-18.11)	1.32 (35.5)	JRA-649" ^{**} "	PP-649		
JR-670-"m"	0.671-0.740 (17.04-18.80)	1.66 (42.2)	JRA-670" ^{**} "	PP-670		
JR-712-"m"	0.713-0.777 (18.11-19.74)	1.32 (35.5)	JRA-712" ^{**} "	PP-712		
JR-735-"m"	0.736-0.810 (18.69-20.57)	1.68 (42.7)	JRA-735" ^{**} "	PP-735		
JR-774-"m"	0.775-0.838 (19.69-21.29)	1.32 (35.5)	JRA-774" ^{**} "	PP-774	III	CHPRA-"X"-III
JR-804-"m"	0.805-0.890 (20.45-22.61)	1.7 (43.2)	JRA-804" ^{**} "	PP-804		
JR-837-"m"	0.838-0.902 (21.29-22.91)	1.32 (35.5)	JRA-837" ^{**} "	PP-837		
JR-853-"m"	0.854-0.949 (21.69-24.10)	1.72 (43.7)	JRA-853" ^{**} "	PP-853		
JR-899-"m"	0.900-0.963 (22.86-24.46)	1.32 (35.5)	JRA-899" ^{**} "	PP-899		
JR-919-"m"	0.920-1.019 (23.37-25.88)	1.76 (44.7)	JRA-919" ^{**} "	PP-919		
JR-962-"m"	0.963-1.027 (24.46-26.09)	1.32 (35.5)	JRA-962" ^{**} "	PP-962		
JR-979-"m"	0.980-1.079 (24.89-27.41)	1.82 (46.2)	JRA-979" ^{**} "	PP-979		
JR-1024-"m"	1.025-1.088 (26.04-27.64)	1.32 (35.5)	JRA-1024" ^{**} "	PP-1024		
JR-1054-"m"	1.055-1.156 (26.80-29.31)	1.90 (48.3)	JRA-1054" ^{**} "	PP-1054		
JR-1087-"m"	1.088-1.152 (27.65-29.26)	1.32 (35.5)	JRA-1087" ^{**} "	PP-1087		
JR-1103-"m"	1.104-1.203 (28.04-30.56)	1.90 (48.3)	JRA-1103" ^{**} "	PP-1103		
JR-1149-"m"	1.150-1.213 (29.21-30.81)	1.32 (35.5)	JRA-1149" ^{**} "	PP-1149		
JR-1171-"m"	1.172-1.270 (29.77-32.26)	2.00 (50.8)	JRA-1171" ^{**} "	PP-1171		
JR-1212-"m"	1.213-1.336 (30.81-33.93)	2.00 (50.8)	JRA-1212" ^{**} "	PP-1212		



Notes:

"m" - Substitute the suffix "m" with the following material code: C - carbon steel, S - 316 stainless, B - brass, Y - Cr/Moly, M - monel, K - 90/10 CuNi, J - 70/30 CuNi. Other Materials Available.

"*" - For Brass, Copper, or Copper Nickel tubes add the Suffix -LD to the Brush Kit. Tube Preparation Brushes are required for use with Snap It™ Jr Plugs.

"X" - Channel Head Pull Rod Assemblies are available in 2', 4', or 6' lengths. Insert the appropriate # for the length required. For Through the Tube Applications, Extension Assemblies (See page 7T) are available in 2', 4', or 6' lengths. Specify the total # of each size needed for your application.



SNAP IT® ENGINEERED TUBE PLUGS

Superior Sealing Under Pressure



SNAP IT® SR SPECS & ACCESSORIES

SR Kit Part No.	Plug Range - Tube ID Inches (mm)	Brush Kit	Positioner	Plug Positioner	Pull Rod Assembly	Channel Head Pull Rod
SR-400-"m"	0.401-0.420 (10.16-10.68)	SRA-400- ^{†*}	PP-400	PP 400-440	I	CHPRA-"X"-I
SR-420-"m"	0.421-0.440 (10.69-11.19)	SRA-420- ^{†*}	PP-420			
SR-440-"m"	0.441-0.460 (11.20-11.70)	SRA-440- ^{†*}	PP-440			
SR-460-"m"	0.461-0.480 (11.71-12.21)	SRA-460- ^{†*}	PP-460	PP 460-500		
SR-480-"m"	0.481-0.500 (12.22-12.72)	SRA-480- ^{†*}	PP-480			
SR-500-"m"	0.501-0.520 (12.73-13.22)	SRA-500- ^{†*}	PP-500			
SR-520-"m"	0.521-0.540 (13.23-13.73)	SRA-520- ^{†*}	PP-520	PP 520-580		
SR-540-"m"	0.541-0.560 (13.74-14.24)	SRA-540- ^{†*}	PP-540			
SR-560-"m"	0.561-0.580 (14.25-14.75)	SRA-560- ^{†*}	PP-560			
SR-580-"m"	0.581-0.600 (14.76-15.26)	SRA-580- ^{†*}	PP-580			
SR-600-"m"	0.601-0.620 (15.27-15.76)	SRA-600- ^{†*}	PP-600	PP 600-680	II	CHPRA-"X"-II
SR-620-"m"	0.621-0.640 (15.77-16.27)	SRA-620- ^{†*}	PP-620			
SR-640-"m"	0.641-0.660 (16.28-16.78)	SRA-640- ^{†*}	PP-640			
SR-660-"m"	0.661-0.680 (16.79-17.27)	SRA-660- ^{†*}	PP-660			
SR-680-"m"	0.681-0.700 (17.28-17.79)	SRA-680- ^{†*}	PP-680			
SR-700-"m"	0.701-0.720 (17.80-18.30)	SRA-700- ^{†*}	PP-700	PP 700-780		
SR-720-"m"	0.721-0.740 (18.31-18.81)	SRA-720- ^{†*}	PP-720			
SR-740-"m"	0.741-0.760 (18.82-19.32)	SRA-740- ^{†*}	PP-740			
SR-760-"m"	0.761-0.780 (19.33-19.83)	SRA-760- ^{†*}	PP-760			
SR-780-"m"	0.781-0.800 (19.84-20.34)	SRA-780- ^{†*}	PP-780			
SR-800-"m"	0.801-0.820 (20.35-20.84)	SRA-800- ^{†*}	PP-800	PP 800-860		
SR-820-"m"	0.821-0.840 (20.85-21.35)	SRA-820- ^{†*}	PP-820			
SR-840-"m"	0.841-0.860 (21.36-21.86)	SRA-840- ^{†*}	PP-840			
SR-860-"m"	0.861-0.880 (21.87-22.37)	SRA-860- ^{†*}	PP-860			
SR-880-"m"	0.881-0.900 (22.38-22.87)	SRA-880- ^{†*}	PP-880			
SR-900-"m"	0.901-0.920 (22.88-23.38)	SRA-900- ^{†*}	PP-900			
SR-920-"m"	0.921-0.940 (23.39-23.87)	SRA-920- ^{†*}	PP-920			
SR-940-"m"	0.941-0.960 (23.88-24.40)	SRA-940- ^{†*}	PP-940			
SR-960-"m"	0.961-0.980 (24.41-24.89)	SRA-960- ^{†*}	PP-960			
SR-980-"m"	0.981-1.000 (24.90-25.40)	SRA-980- ^{†*}	PP-980	PP 980-1060		
SR-1000-"m"	1.001-1.020 (25.41-25.91)	SRA-1000- ^{†*}	PP-1000			
SR-1020-"m"	1.021-1.040 (25.92-26.42)	SRA-1020- ^{†*}	PP-1020			
SR-1040-"m"	1.041-1.060 (26.43-26.92)	SRA-1040- ^{†*}	PP-1040			
SR-1060-"m"	1.061-1.080 (26.93-27.43)	SRA-1060- ^{†*}	PP-1060			
SR-1080-"m"	1.081-1.100 (27.44-27.94)	SRA-1080- ^{†*}	PP-1080	PP 1080-1160		
SR-1100-"m"	1.101-1.120 (27.95-28.45)	SRA-1100- ^{†*}	PP-1100			
SR-1120-"m"	1.121-1.140 (28.46-28.96)	SRA-1120- ^{†*}	PP-1120			
SR-1140-"m"	1.141-1.160 (28.97-29.46)	SRA-1140- ^{†*}	PP-1140			
SR-1160-"m"	1.161-1.180 (29.47-29.97)	SRA-1160- ^{†*}	PP-1160			

Notes:

Standard Sr Kit includes 10 plugs, 1 Brush and 1 Go/No Go Gauge. However, plugs and items can be ordered individually - Consult factory for more information.

"m" - Substitute the suffix "m" with the following material code: C - carbon steel, S - 316 stainless, B - brass, Y - Cr/Moly, M - monel, K - 90/10 CuNi, J - 70/30 CuNi. Other Materials Available.

"*" - Brush and Go/No Go Gauge furnished with every 10 plugs.

"X" - Channel Head Pull Rod Assemblies (See Page 7T) are available in 2', 4', or 6' lengths. Insert the appropriate # for the length required.





SNAP IT® ENGINEERED TUBE PLUGS

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SNAP IT® SIZING CHART FOR ROLLED TUBES JR. MODEL

	TUBE GAUGE		TUBE O.D. *					
	BWG	WALL TKNS	5/8"	3/4"	7/8"	1"	1 1/4"	1 1/2"
Rolled I.D.	8				.578	.703	.953	1.203
Near End	8				555-M	670-M	919-M	1171-M
Far End	8				524-M	649-M	899-M	1171-M
Rolled I.D.	9	0.148		.484	0.609	0.734	0.984	1.234
Near End	9	0.148		471-M	584-M	712-M	979-M	1212-M
Far End	9	0.148		471-M	555-M	670-M	919-M	1171-M
Rolled I.D.	10	0.134		.509	.634	.759	1.009	1.259
Near End	10	0.134		491-M	621-M	735-M	979-M	1212-M
Far End	10	0.134		471-M	584-M	712-M	962-M	1171-M
Rolled I.D.	11	0.12		.534	.659	.784	1.034	1.284
Near End	11	0.12		524-M	649-M	774-M	1024-M	1212-M
Far End	11	0.12		491-M	621-M	735-M	979-M	1212-M
Rolled I.D.	12	0.109		.554	.679	.804	1.054	1.304
Near End	12	0.109		524-M	670-M	774-M	1024-M	1212-M
Far End	12	0.109		512-M	621-M	735-M	979-M	1212-M
Rolled I.D.	13	0.095		.579	.704	.829	1.079	1.329
Near End	13	0.095		555-M	670-M	804-M	1054-M	1212-M
Far End	13	0.095		524-M	649-M	774-M	1024-M	1212-M
Rolled I.D.	14	0.083	.476	.601	.726	.851	1.101	
Near End	14	0.083	471-M	584-M	712-M	837-M	1087-M	
Far End	14	0.083		555-M	670-M	804-M	1054-M	
Rolled I.D.	15	0.072	.495	.620	.745	.870	1.120	
Near End	15	0.072	491-M	584-M	735-M	853-M	1103-M	
Far End	15	0.072	471-M	584-M	712-M	837-M	1054-M	
Rolled I.D.	16	0.065	.508	.633	.758	.883	1.133	
Near End	16	0.065	491-M	621-M	735-M	853-M	1103-M	
Far End	16	0.065	471-M	584-M	712-M	837	1054-M	
Rolled I.D.	17	0.058	.521	.646	.771	.896	1.146	
Near End	17	0.058	512-M	621-M	735-M	853-M	1103-M	
Far End	17	0.058	491-M	584-M	735-M	853-M	1103-M	
Rolled I.D.	18	0.049	.537	.662	.770	.912	1.162	
Near End	18	0.049	524-M	649-M	774-M	899-M	1149-M	
Far End	18	0.049	491-M	621-M	735-M	853-M	1103-M	
Rolled I.D.	19	0.042	.549	.674	.799	.924	1.174	
Near End	19	0.042	524-M	649-M	774-M	899-M	1149-M	
Far End	19	0.042	512-M	621-M	735-M	853-M	1149-M	
Rolled I.D.	20	0.035	.562	.687	.812	.937	1.187	
Near End	20	0.035	524-M	649-M	774-M	899-M	1149-M	
Far End	20	0.035	524-M	649-M	774-M	853-M	1149-M	
Rolled I.D.	21	0.032	.567	.692	.817	.942	1.192	
Near End	21	0.032	555-M	670-M	804-M	919-M	1171-M	
Far End	21	0.032	524-M	649-M	774-M	853-M	1149-M	
Rolled I.D.	22	0.028	.575	.700	.825	.950	1.200	
Near End	22	0.028	555-M	670-M	804-M	919-M	1171-M	
Far End	22	0.028	524-M	649-M	774-M	919-M	1171-M	
Rolled I.D.	23	0.025	.580	.705	.830	.955	1.205	
Near End	23	0.025	555-M	670-M	804-M	919-M	1171-M	
Far End	23	0.025	555-M	670-M	804-M	919-M	1171-M	
Rolled I.D.	24	0.022	.585	.710	.835	.960	1.210	
Near End	24	0.022	555-M	670-M	804-M	919-M	1171-M	
Far End	24	0.022	555-M	670-M	804-M	899-M	1171-M	

Substitute the suffix "M" with the following material code:

- C = Carbon Steel
- B = Brass
- S = 316 SS
- J = 70/30 CuNi
- K = 90/10 CuNi
- Y = Chrome/Moly
- M = Monel
- I = Inconel
- N = Nickel 200
- T = Titanium
- H = Hastelloy
- Z = Zirconium

Near End = Plugging front end of tube sheet

Far End = "Through the tube," plugging rear end of tube sheet

NOTES:

1) Tube ID's often vary between inlet & outlet due to corrosion and/or erosion, this chart and recommended tube sizes are to be used as Reference only.

2) Tube Preparation Brushes are required for use with all Snap It Plugs.

* Larger sizes available upon request

AVAILABLE IN REQUEST



All tube inner diameters listed above are based upon a 10% wall reduction