



Designation: E675–94 (Reapproved 1998) Designation: E 675 – 02 (Reapproved 2007)

Standard Specification for Interchangeable Taper-Ground Stopcocks And Stoppers¹

This standard is issued under the fixed designation E 675; the number immediately following the designation indicates the year of original adoption or, in the case of revision, the year of last revision. A number in parentheses indicates the year of last reapproval. A superscript epsilon (ϵ) indicates an editorial change since the last revision or reapproval.

1. Scope

1.1 The specification provides standard dimensional requirements for obtaining, within practical limits, interchangeability in stopcocks and stoppers for ordinary laboratory and industrial applications. It covers dimensional interchangeability of the ground surfaces only and does not involve design characteristics of the item except where specified.

NOTE 1—The dimensions pertaining to stopcocks and stoppers were taken from the Commercial Standard CS 21 of the U.S. Department of Commerce.

NOTE 2—Although glass is the most commonly used material for stopcocks and stoppers, other materials may be used as specified. Stopcocks and stoppers constructed from glass should conform to Specifications E 438 and E 671.

2. Referenced Documents

2.1 ASTM Standards:²

E 438 Specification for Glasses in Laboratory Apparatus

E 671 Specification for Maximum Permissible Thermal Residual Stress in Annealed Glass Laboratory Apparatus

E 920 Specification for Commercially Packaged Laboratory Apparatus

E 921 Practice Specification for Export Packaged Laboratory Apparatus

E 1133 Practice for Performance Testing of Packaged Laboratory Apparatus for United States Government Procurements

E 1157 Specification for Sampling and Testing of Reusable Laboratory Glassware

2.2 U.S. Department of Commerce Standard:

CS 21 Interchangeable Taper-Ground Joints, Stopcocks, Stoppers, and Spherical-Ground Joints³

3. Requirements for Single Straight-Bore Taper-Ground Stopcocks

3.1 The designations and dimensions for single straight-bore stopcocks shall be as shown in Fig. 1 and Table 1.

3.2 *Taper*—All straight-bore stopcocks shall have a taper of 1 ± 0.006 mm of diameter per 10 mm of length (1 to 10).

3.3 *Master Gages*—Dimensions and tolerances for master gages shall be as shown in Fig. 2 and Fig. 3, and Table 2 and Table

3. Overall diameter of ring gage shall be approximately twice the diameter of the bore at the reference line in the window, but not less than 25 mm.

3.3.1 *Plug Gage*—Plug shall have two short axial lines $180 \pm 0.5^\circ$ apart intersecting the reference line for checking location of bore hole. In addition to the two axial lines 180° apart intersecting the reference line on the 4 and 6-mm plugs, two additional axial lines shall be provided on each of these plugs for checking the location of the bore hole of T-bore and 120-deg bore stopcocks. These two additional axial lines shall be placed 90 and $120^\circ (\pm 0.5^\circ)$ from one of the first two axial lines.

3.3.2 *Ring Gage*—The central milled recess, or window, shall be placed approximately midway between the ends of the ring gage. Width of recess measured parallel with the axis shall be approximately one fourth of the length of the ring, and the width of the opening at the inner surface of ring, measured perpendicular to the axis, shall not exceed one fourth of the length of the ring. Reference line in recess shall be placed approximately midway between ends of ring gage.

3.3.3 *Fit of Product in Working Gages*—The product (both inner and outer members) shall fit the corresponding working gages so that the centerline through the bore corresponds with the reference line on the gage within ± 0.3 mm for 1, $1\frac{1}{2}$, and 2-mm bores; ± 0.5 mm for 3 and 4-mm bores; and ± 1.0 mm for 5-mm and larger bores.

¹ This specification is under the jurisdiction of ASTM Committee E-41 on Laboratory Apparatus and is the direct responsibility of Subcommittee E41.01 on Apparatus. Current edition approved Feb. 15, 1994. Published March 1994. Originally published as E675–79. Last previous edition E675–79(1989).

² This specification is under the jurisdiction of ASTM Committee E41 on Laboratory Apparatus and is the direct responsibility of Subcommittee E41.01 on Apparatus. Current edition approved Nov. 1, 2007. Published January 2008. Originally approved in 1979. Last previous edition approved in 2002 as E 675 – 02.

³ Annual Book of ASTM Standards, Vol 14.04.

⁴ For referenced ASTM standards, visit the ASTM website, www.astm.org, or contact ASTM Customer Service at service@astm.org. For Annual Book of ASTM Standards volume information, refer to the standard's Document Summary page on the ASTM website.

⁵ Discontinued 1979—U.S. Department of Commerce, Washington, DC 20234.

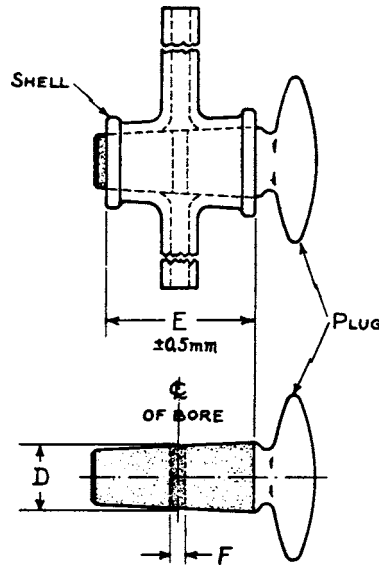


FIG. 1 Stopcock

TABLE 1 Single Straight-Bore Stopcocks

Stopcock Designation	Diameter of Plug at Center-Line of Bore, mm <i>D</i>	Length of Shell, ±0.5 mm <i>E</i>	Diameter of Bore Hole in Plug, mm <i>F</i>
1-M ^A	7	20	1
1	12	30	1½
1½	12	30	1½
2	12	30	2
3	17	40	3
4	17	40	4
5	20	44	5
6	20	44	6
8	25	52	8
10	35	56	10

^A Micro size.

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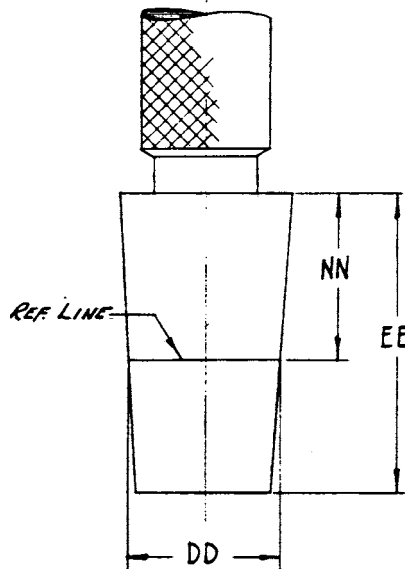


FIG. 2 Master Plug Gage for Single Straight-Bore Stopcocks

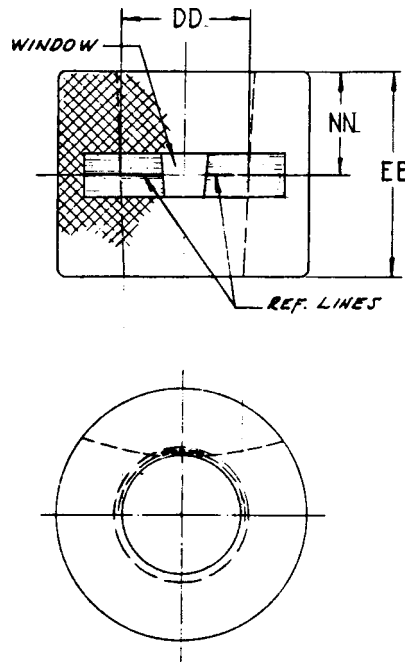


FIG. 3 Master Ring Gage for Single Straight-Bore Stopcocks

TABLE 2 Master Plug Gages for Single Straight-Bore Stopcocks

Stopcock Designation	Length of Tapered Portion +2.0 mm, -0 mm <i>EE</i>	Diameter at Gaging Point ± 0.003 mm <i>DD</i>	Distance from Large End of Tapered Portion to Gaging Point, mm <i>NN</i>
1-M ^A	32	7	20
1	42	12	25
1½	42	12	25
2	42	12	25
3	52	17	30
4	52	17	30
5	56	20	32
6	56	20	32
8	64	25	36
10	68	35	38

^A Micro size.

TABLE 3 Master Ring Gages for Single Straight-Bore Stopcocks

Stopcock Designation	Length of Ring, +0.2 mm, -0 mm <i>EE</i>	Inside Diameter at Gaging Point, ± 0.003 mm <i>DD</i>	Distance from Top to Gaging Point, mm <i>NN</i>
1-M ^A	20	7	10
1	30	12	15
1½	30	12	15
2	30	12	15
3	40	17	20
4	40	17	20
5	44	20	22
6	44	20	22
8	52	25	26
10	56	35	28

^A Micro size.

4. Requirements for Single Oblique-Bore Stopcocks

4.1 Design, dimensions, and tolerances for 1, 1½, 2, 3, and 4-mm oblique-bore stopcocks shall be as shown in Fig. 4 and Table 4.

4.2 *Taper*—All single oblique-bore stopcocks shall have a taper of 1 ± 0.006 mm of diameter per 10 mm of length (1 to 10).

4.3 *Master Gages*—The dimensions and tolerances for master gages shall be as shown in Fig. 5 and Fig. 6 and Table 5 and Table

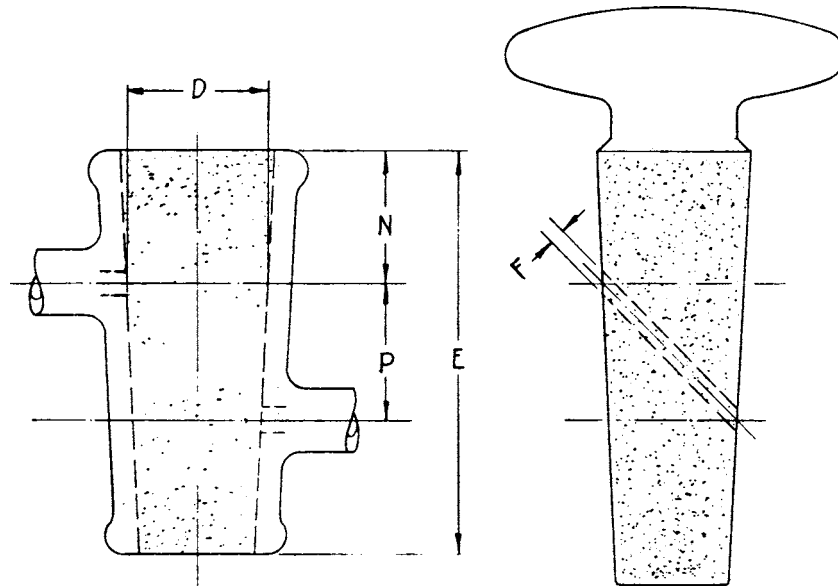


FIG. 4 Single Oblique-Bore Stopcock

TABLE 4 Single Oblique-Bore Stopcock

Stopcock Designation	Diameter of Plug at Gaging Point, mm <i>D</i>	Length of Shell, ±0.5 mm <i>E</i>	Diameter of Bore in Plug, mm <i>F</i>	Distance from Large End of Shell to Gaging Point, ±0.5 mm <i>N</i>	Distance between Bore Holes, <i>P</i> ^A
1	12.60	40	1	14.0	12
1½	12.60	40	1½	14.0	12
2	12.60	40	2	14.0	12
3	17.35	50	3	16.5	17
4	17.35	50	4	16.5	17

^A See 3.3.3.

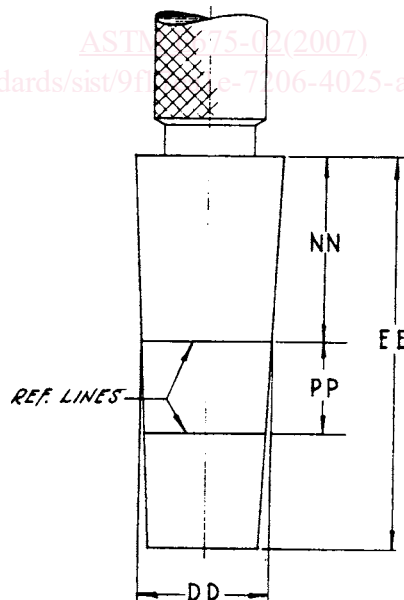


FIG. 5 Master Plug Gage for Single Oblique-Bore Stopcocks

6. The overall diameter of the ring gage shall be approximately twice the diameter of the bore at its midpoint, but not less than 25 mm.

4.3.1 *Plug Gage*—The upper circumferential reference line shall be the gaging point. Each reference line shall have a short axial line intersecting it, the two axial lines being on opposite sides of the plug and in the same plane running through the axis ($180 \pm 0.5^\circ$ apart) for checking location of bore holes.

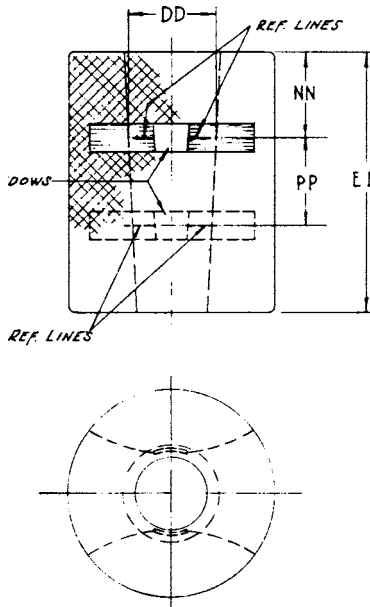


FIG. 6 Master Ring Gage for Single Oblique-Bore Stopcocks

TABLE 5 Master Plug Gages for Single Oblique-Bore Stopcocks

Stopcock Designation	Length of Tapered Portion, +2.0 mm, -0 mm <i>EE</i>	Diameter at Gaging Point, ± 0.003 mm <i>DD</i>	Distance from Large End of Tapered Portion to Gaging Point +1.5 mm, -0 mm <i>NN</i>	Distance from Gaging Point to Lower Reference Line ± 0.03 mm <i>PP</i>
1	52	12.60	24.5	12
1½	52	12.60	24.5	12
2	52	12.60	24.5	12
3	62	17.35	27.0	17
4	62	17.35	27.0	17

TABLE 6 Master Ring Gages for Single Oblique-Bore Stopcocks

Stopcock Designation	Length of Ring, +0.2 mm, -0 mm <i>EE</i>	Inside Diameter at Gaging Point, ± 0.003 mm <i>DD</i>	Distance from Top to Gaging Point (Approximate) <i>NN</i>	Distance from Gaging Point to Lower Reference Point, ± 0.03 mm <i>PP</i>
1	40	12.60	14.0	12
1½	40	12.60	14.0	12
2	40	12.60	14.0	12
3	50	17.35	16.5	17
4	50	17.35	16.5	17

4.3.2 *Ring Gage*—The width of the milled recesses, or windows, measured parallel with the axis shall be approximately one fourth of the length of the ring, and the width of the opening at the inner surface of ring, measured perpendicular to the axis, shall not exceed one fourth of the length of the ring. The recesses shall be so placed that the reference lines fall approximately midway in the recess.

4.3.3 *Fit of Product in Working Gages*— The product (both inner and outer members) shall fit the corresponding working gages so that the centerlines through the openings correspond with the reference lines on the gages within ± 0.3 mm for 1, 1½, and 2-mm bores, and ± 0.5 mm for 3 and 4-mm bores.

5. Requirements for Double Oblique-Bore (Three-Way) Stopcocks

5.1 Design, dimensions, and tolerances for 1, 1½, 2, 3, and 4-mm, three-way bore stopcocks shall be as shown in Fig. 7 and Table 7.

5.2 *Taper*—All double oblique-bore stopcocks shall have a taper of 1 ± 0.006 mm of diameter per 10 mm of length (1 to 10).

5.3 *Master Gages*—Dimensions and tolerances for master gages shall be as shown in Fig. 8 and Fig. 9 and Table 8 and Table 9. The overall diameter of the ring gage shall be approximately twice the diameter of the bore at the reference line in the central window.

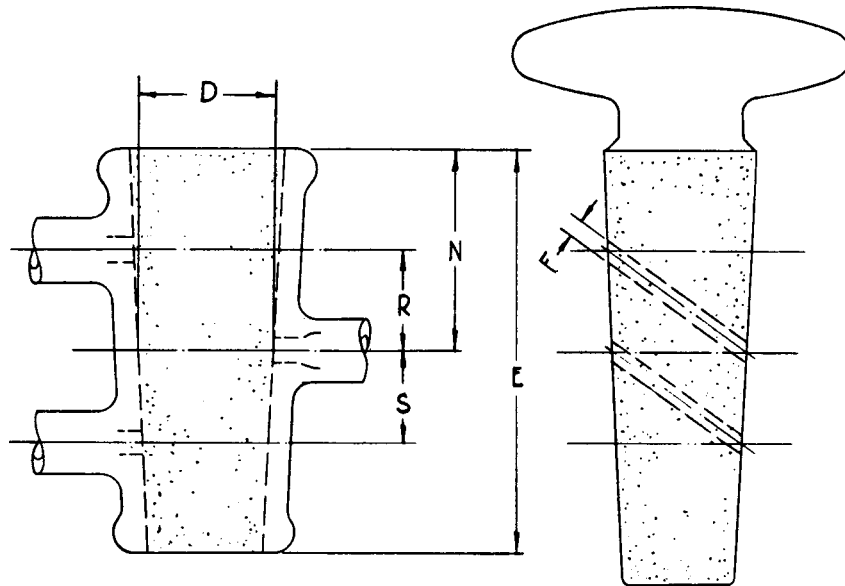


FIG. 7 Double Oblique-Bore Stopcock

TABLE 7 Double Oblique-Bore Stopcock

Stopcock Designation	Diameter of Plug at Gaging Point, mm <i>D</i>	Length of Shell, ± 0.5 mm <i>E</i>	Diameter of Bore in Plug, mm <i>F</i>	Distance from Large End of Shell to Gaging point, ± 0.5 mm <i>N</i>	Distance from Gaging Point to Centerline of Bore Near Large End, mm <i>R</i> ^A	Distance from Gaging Point to Centerline of Bore Near Small End <i>S</i> ^A
1	14.5	50	1	25	12.5	11.5
1½	14.5	50	1½	25	12.5	11.5
2	14.5	50	2	25	12.5	11.5
3	16.2	56	3	28	14.0	12.9
4	16.2	56	4	28	14.0	12.9

^A See 3.3.3.

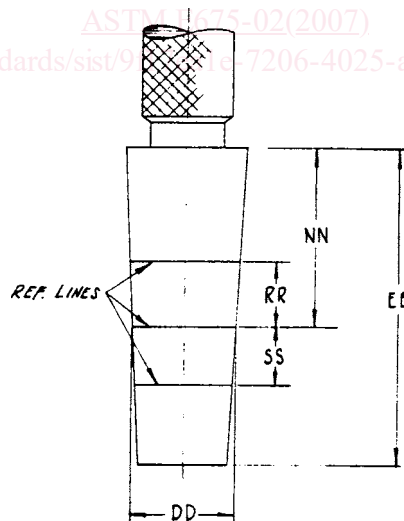


FIG. 8 Master Plug Gage for Double Oblique-Bore Stopcock (Three-Way)

5.3.1 *Plug Gage*—The central circumferential reference line shall be the gaging point. A short axial reference line shall intersect each of the circumferential reference lines. The axial line intersecting the central circumferential reference line shall be on the opposite side of the plug from the other two axial lines. All three axial lines shall be in the same plane running through the axis ($180 \pm 0.5^\circ$) to check the location of the bore holes.

5.3.2 *Ring Gage*—The width of the milled recesses, or windows, measured parallel with the axis shall be approximately one fourth of the length of the ring, and the width of the opening at the inner surface of ring, measured perpendicular to the axis, shall