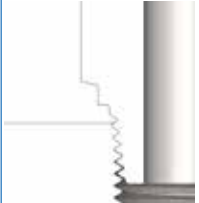
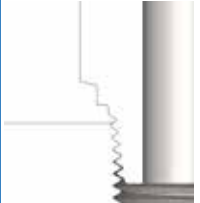

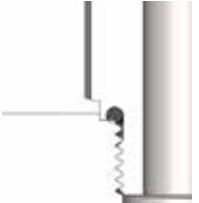


Torques for screw-in threads

(standard values)

1. Stainless steel and steel

				
	for threads R / M conical	for threads NPT	for threads with edge seal	for threads with O-ring
1/16		15		
1/8	20	25	30	20
1/4	35	40	70	50
3/8	45	55	100	70
1/2	60	110	150	100
3/4	110	150	180	120
1	180		220	150
1 1/4	200			
M5	2		10	
M6X0.75	3		15	
M8x1	10		15	
M10x1	20		30	
M12x1.5	25		35	30
M14x1.5			45	
M16x1.5			65	
M18x1.5			100	
M22x1.5	150		190	130
M26x1.5			200	
M33x2			250	

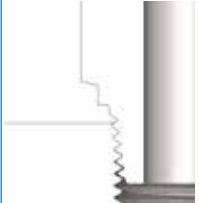
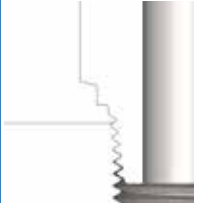

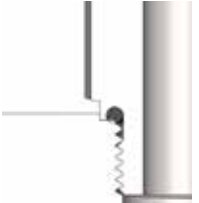
For steel the torques need to be reduced by approx. 10 % lower.

Depending on the lubricant the necessary torques may be up to 10 % lower.

Torques for screw-in threads

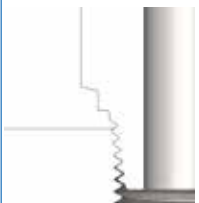
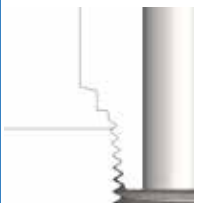


(standard values)

2. Brass and aluminium

				
	für Gewinde R / M konisch pour filetages R / M conique for threads R / M conical	für Gewinde NPT pour filetages NPT for threads NPT	für Gewinde mit Dichtkante pour filetage avec arête d'étanchéité for threads with edge seal	für Gewinde mit O-Ring pour filetages avec joint torique for threads with O-ring
1/8	8	15	20	15
1/4	12	25	50	35
3/8	20	40	80	50
1/2	30	80	90	80
3/4	30	90	110	90
1		110	150	
1 1/4	50			
M5			4	3
M6x0.75			6	
M6			6	
M8x1	5		9	
M10x1	5		10	
M12x1.5	20		20	
M14x1.5	30		30	
M16x1.5	50		50	
M18x1.5			60	
M22x1.5			80	

Depending on the lubricant and when using gaskets the necessary torques may be up to 10 % lower.

3. PVDF and PA

				
1/8	1	1.5	2	1.5
3/8	3	5	8	6
M12x1.5			3.5	2.5