

COUPLING & ADAPTOR TORQUE



For DIN 2353 12°, 30° and Universal Inverted Cone

Size	Ft-Lbs.	Newton-Meters
2	20	25
4	25	35
6	35	45
8	45	60
12	55	75
16	65	90
20	80	110
24	95	130
32	120	160

For BSP 30° Inverted Cone

Size		Ft. Lbs.		Newton-meters	
Dash	Inch	Min.	Max.	Min.	Max.
-2	1/8	7	9	9	12
-4	1/4	11	18	15	24
-6	3/8	19	28	26	38
-8	1/2	30	36	41	49
-10	5/8	37	44	50	60
-12	3/4	50	60	68	81
-16	1	79	95	107	129
-20	1 1/4	127	152	172	206
-24	1 1/2	167	190	226	258
-32	2	262	314	355	426

Maximum Recommended Torque for Dry NPTF (Tapered) Pipe Threads*

Size	Ft-Lbs.	Newton-Meters
2	20	25
4	25	35
6	35	45
8	45	60
12	55	75
16	65	90
20	80	110
24	95	130
32	120	160

Notes:

1. The 4-bolt flange seal is a face seal. The shoulder which contains the seal must fit squarely against the mating surface and be held there with even tension on all bolts.
2. Torque values apply to plated bolts and bolts with light engine oil.
3. Lubricate o-ring with a light oil (SAE 10W or 20W) before assembly.
4. Finger tighten all four bolts making sure the flange and fitting shoulder are started square.
5. Tighten all bolts evenly by partially tightening each bolt and repeating the sequence until all bolts are tightened to the specific torque in the table.

For 4-Bolt Flange Connections

Bolt Size	Line Size	Torque Nm	Torque Lb-Ft
.31	-8	23	17
.38	-12	35	26
.44	-16	58	43
.50	-20	88	65
.63	-24	176	130
.75	-32	298	220

Maximum Recommended Torque for Dry NPTF (Tapered) Pipe Threads*

Size	Ft-Lbs.	Newton-Meters
2	20	25
4	25	35
6	35	45
8	45	60
12	55	75
16	65	90
20	80	110
24	95	130
32	120	160

*Notes:

1. The torque values obtained from tightening pipe threads can vary considerably depending on thread condition. Adequate sealing can occur at values much lower than the maximum values listed above. Only enough torque to achieve adequate sealing should be applied.
2. When using a male tapered pipe thread with a female straight or parallel pipe thread, maximum values are 50% of those listed in the table.
3. If thread sealant is used, maximum values shown should be decreased by 25%.