



TIGHTENING TORQUES OF SCREW-IN THREAD

TIGHTENING TORQUES SCREW-IN PLUG DIN EN ISO 9974 AND ISO 1179 FORM B IMPERIAL THREAD

The following fastening torques apply for the specified screw-in plugs made of steel and the associated screw-in threads made of the material given in the table.

SERIES	PIPE OUTER DIAMETER	PIPE THREAD	STEEL	ALUMINIUM F22	ALUMINIUM F28	ALUMINIUM F45
L	6	G 1/8 A	18	5	8	12
	8	G 1/4 A	35	7	10	16
	10	G 1/4 A	35	7	10	16
	12	G 3/8 A	70	25	35	55
	15	G 1/2 A	140	30	45	65
	18	G 1/2 A	100	30	45	65
	22	G 3/4 A	180	60	90	140
	28	G 1 A	330	100	150	220
	35	G 1 1/4 A	540	150	225	340
	42	G 1 1/2 A	630	180	275	400
S	6	G 1/4 A	55	7	10	16
	8	G 1/4 A	55	7	10	16
	10	G 3/8 A	90	25	35	55
	12	G 3/8 A	90	25	35	55
	16	G 1/2 A	130	30	45	65
	20	G 3/4 A	270	60	90	140
	25	G 1 A	340	100	150	220
	30	G 1 1/4 A	540	150	225	340
	38	G 1 1/2 A	700	180	275	400

Notes:

- The values only apply for steel couplings (galvanized) and the counter-materials mentioned above
- Screw-in plugs are to be greased before they are screwed in
- Permissible tolerance of assembly torques $\pm 10\%$
- Reduced or higher tightening torques will reduce the maximum possible operating pressure
- Reduced tightening torques require the coupling to be secured against loosening torques from the outside in particular

TIGHTENING TORQUES SCREW-IN PLUG DIN EN ISO 9974 AND ISO 1179 FORM B METRIC THREAD

The following fastening torques apply for the specified screw-in plugs made of steel and the associated screw-in threads made of the material given in the table.

SERIES	PIPE OUTER DIAMETER	PIPE THREAD	STEEL	ALUMINIUM F22	ALUMINIUM F28	ALUMINIUM F45
L	6	M 10x1	18	5	8	12
	8	M 12x1.5	30	8	12	20
	10	M 14x1.5	45	15	20	32
	12	M 16x1.5	65	18	28	45
	15	M 18x1.5	80	25	35	55
	18	M 22x1.5	140	40	60	90
	22	M 26x1.5	190	55	80	120
	28	M 33x2	340	100	150	220
	35	M 42x2	500	150	225	340
	42	M 48x2	630	170	250	400
S	6	M 12x1.5	35	8	12	20
	8	M 14x1.5	55	15	20	32
	10	M 16x1.5	70	18	28	45
	12	M 18x1.5	110	25	35	55
	16	M 22x1.5	170	40	60	90
	20	M 27x2	270	60	90	130
	25	M 33x2	410	100	150	220
	30	M 42x2	540	150	225	340
	38	M 48x2	700	170	250	400

Notes:

- The values only apply for steel couplings (galvanized) and the counter-materials mentioned above
- Screw-in plugs are to be greased before they are screwed in
- Permissible tolerance of assembly torques $\pm 10\%$
- Reduced or higher tightening torques will reduce the maximum possible operating pressure
- Reduced tightening torques require the coupling to be secured against loosening torques from the outside in particular