



TIGHTENING TORQUES OF SCREW-IN THREAD

TIGHTENING TORQUES FOR SCREW-IN PLUG ISO 6149 METRIC THREAD WITH O-RING SEAL

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
L	6	M 10x1	15
	8	M 12x1.5	25
	10	M 14x1.5	35
	12	M 16x1.5	40
	15	M 18x1.5	45
	18	M 22x1.5	60
	22	M 26x1.5	100
	28	M 33x2	160
	35	M 42x2	210
	42	M 48x2	260
S	6	M 12x1.5	35
	8	M 14x1.5	45
	10	M 16x1.5	55
	12	M 18x1.5	70
	16	M 22x1.5	100
	20	M 27x2	170
	25	M 33x2	310
	30	M 42x2	330
	38	M 48x2	420

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 ISO 6149 UNF 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 THREAD	STEEL
L	7/16-20UNF	19
	9/16-18UNF	40
	3/4-16UNF	60
	7/8-14UNF	80
	1 1/16-12UN	110
	1 5/16-12UN	160
	1 5/8-12UN	300
	1 7/8-12UN	340
S	7/16-20UNF	21
	9/16-18UNF	50
	3/4-16UNF	80
	7/8-14UNF	140
	1 1/16-12UN	190
	1 5/8-12UN	350
	1 7/8-12UN	430

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 FOR SCREW-IN PLUG ISO 6149 IMPERIAL THREAD WITH O-RING SEAL AND CHAMBER RING

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 THREAD	STEEL
L	G 1/8 A	25
	G 1/4 A	50
	G 3/8 A	80
	G 1/2 A	105
	G 3/4 A	220
	G 1 A	370
	G 1 1/4 A	500
	G 1 1/2 A	600
S	G 1/4 A	50
	G 3/8 A	80
	G 1/2 A	105
	G 3/4 A	220
	G 1 A	370
	G 1 1/4 A	500
	G 1 1/2 A	600

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 ISO 6149 METRIC THREAD WITH O-RING AND CHAMBER RING SEAL

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 THREAD	STEEL
L	M 10x1	15
	M 12x1.5	25
	M 14x1.5	35
	M 16x1.5	40
	M 18x1.5	45
	M 22x1.5	60
	M 27x2	100
	M 33x2	160
	M 42x2	210
	M 48x2	260
S	M 12x1.5	35
	M 14x1.5	45
	M 16x1.5	55
	M 18x1.5	70
	M 22x1.5	100
	M 27x2	170
	M 33x2	310
	M 42x2	330
	M 48x2	420

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