



# TIGHTENING TORQUES OF SCREW-IN THREAD

## TIGHTENING TORQUES SCREW-IN PLUG FOR SBD WITH IMPERIAL THREAD FOR SEALING EDGE/DKA

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	G 1/8 A	20
	8	G 1/4 A	45
	10	G 1/4 A	45
	12	G 3/8 A	70
	15	G 1/2 A	100
	18	G 1/2 A	100
	22	G 3/4 A	140
S	6	G 1/4 A	45
	8	G 1/4 A	56
	10	G 3/8 A	70
	12	G 3/8 A	70
	16	G 1/2 A	100
	20	G 3/4 A	100

### 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 FOR SBD WITH METRIC THREAD FOR SEALING EDGE/DKA

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	25
	8	M 12x1.5	40
	10	M 14x1.5	55
	12	M 16x1.5	65
	15	M 18x1.5	90
	18	M 22x1.5	130
	22	M 26x1.5	140
S	6	M 12x1.5	40
	8	M 14x1.5	55
	10	M 16x1.5	65
	12	M 18x1.5	90
	16	M 22x1.5	130
	20	M 27x2	150

### Notes:

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- Screw-in plugs are to be greased before they are screwed in
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- 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 FOR SBE/SGE WITH IMPERIAL THREAD FOR DKA

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	G 1/8 A	20
	8	G 1/4 A	50
	10	G 1/4 A	50
	12	G 3/8 A	75
	15	G 1/2 A	130
	18	G 1/2 A	130
	22	G 3/4 A	250
	28	G 1 A	350
	35	G 1 1/4 A	600
	42	G 1 1/2 A	800
S	6	G 1/4 A	50
	8	G 1/4 A	50
	10	G 3/8 A	75
	12	G 3/8 A	75
	16	G 1/2 A	130
	20	G 3/4 A	250
	25	G 1 A	350
	30	G 1 1/4 A	600
	38	G 1 1/2 A	800

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## TIGHTENING TORQUES SCREW-IN PLUG FOR SBE/SGE WITH METRIC THREAD FOR DKA

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	25
	8	M 12x1.5	50
	10	M 14x1.5	60
	12	M 16x1.5	90
	15	M 18x1.5	110
	18	M 22x1.5	150
	22	M 26x1.5	350
	28	M 33x2	400
	35	M 42x2	600
	42	M 48x2	800
S	6	M 12x1.5	50
	8	M 14x1.5	60
	10	M 16x1.5	90
	12	M 18x1.5	110
	16	M 22x1.5	150
	20	M 27x2	350
	25	M 33x2	400
	30	M 42x2	600
	38	M 48x2	800

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## TIGHTENING TORQUES SCREW-IN PLUG FOR SBE/SGE WITH IMPERIAL THREAD FOR EDE

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	G 1/8 A	20
	8	G 1/4 A	50
	10	G 1/4 A	50
	12	G 3/8 A	75
	15	G 1/2 A	130
	18	G 1/2 A	130
	22	G 3/4 A	250
	28	G 1 A	350
	35	G 1 1/4 A	600
	42	G 1 1/2 A	800
S	6	G 1/4 A	50
	8	G 1/4 A	50
	10	G 3/8 A	75
	12	G 3/8 A	75
	16	G 1/2 A	130
	20	G 3/4 A	250
	25	G 1 A	350
	30	G 1 1/4 A	600
	38	G 1 1/2 A	800

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## TIGHTENING TORQUES SCREW-IN PLUG FOR SBE/SGE WITH METRIC THREAD FOR EDE

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	25
	8	M 12x1.5	50
	10	M 14x1.5	60
	12	M 16x1.5	90
	15	M 18x1.5	110
	18	M 22x1.5	150
	22	M 26x1.5	350
	28	M 33x2	400
	35	M 42x2	600
	42	M 48x2	800
S	6	M 12x1.5	50
	8	M 14x1.5	60
	10	M 16x1.5	90
	12	M 18x1.5	110
	16	M 22x1.5	150
	20	M 27x2	350
	25	M 33x2	400
	30	M 42x2	600
	38	M 48x2	800

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## TIGHTENING TORQUES SCREW-IN PLUG FOR SBE/SGE WITH IMPERIAL THREAD FOR KDE

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	G 1/8 A	20
	8	G 1/4 A	50
	10	G 1/4 A	50
	12	G 3/8 A	75
	15	G 1/2 A	130
	18	G 1/2 A	130
	22	G 3/4 A	250
	28	G 1 A	350
	35	G 1 1/4 A	600
	42	G 1 1/2 A	800
S	6	G 1/4 A	50
	8	G 1/4 A	50
	10	G 3/8 A	75
	12	G 3/8 A	75
	16	G 1/2 A	130
	20	G 3/4 A	250
	25	G 1 A	350
	30	G 1 1/4 A	600
	38	G 1 1/2 A	800

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## TIGHTENING TORQUES SCREW-IN PLUG FOR SBE/SGE WITH METRIC THREAD FOR KDE

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	25
	8	M 12x1.5	50
	10	M 14x1.5	60
	12	M 16x1.5	90
	15	M 18x1.5	110
	18	M 22x1.5	150
	22	M 26x1.5	350
	28	M 33x2	400
	35	M 42x2	600
	42	M 48x2	800
S	6	M 12x1.5	50
	8	M 14x1.5	60
	10	M 16x1.5	90
	12	M 18x1.5	110
	16	M 22x1.5	150
	20	M 27x2	350
	25	M 33x2	400
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