



TIGHTENING TORQUES OF SCREW-IN THREAD

TIGHTENING TORQUES VSCH FORM E IMPERIAL THREAD

The following fastening torques apply for the screw-in plugs made of steel and the counter-material steel.

PIPE THREAD	STEEL
G 1/8 A	10
G 1/4 A	30
G 3/8 A	40
G 1/2 A	80
G 3/4 A	120
G 1 A	200
G 1 1/4 A	350
G 1 1/2 A	400
G 2 A	650

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 VSCH FORM E METRIC THREAD

The following fastening torques apply for the screw-in plugs made of steel and the counter-material steel.

PIPE THREAD	STEEL
M 10x1	10
M 12x1.5	20
M 14x1.5	30
M 16x1.5	40
M 18x1.5	50
M 20x1.5	60
M 22x1.5	80
M 26x1.5	100
M 27x2	120
M 33x2	200
M 42x2	350
M 48x2	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