

TORQUE VALUES

JIC 37° - SAE J514

Dash Size	Thread	ft - lb	Nm
-4	7/16-20	11-13	15-17
-5	1/2-20	14-16	19-22
-6	9/16-18	20-22	27-30
-8	3/4-16	37-45	50-61
-10	7/8-14	50-58	68-79
-12	1 1/16-12	79-88	107-119
-14	1 3/16-12	94-103	128-140
-16	1 5/16-12	117-125	158-170
-20	1 5/8-12	126-150	172-200
-24	1 7/8-12	158-180	215-240
-32	2 1/2-12	250-283	339-384

NPTF (Tapered)

Dash Size	Thread	ft - lb	Nm
-2	1/2	20	25
-4	1/4	25	35
-6	0	35	45
-8	1/2	45	60
-12	3/4	55	75
-16	1	65	90
-20	1 1/4	80	110
-24	1 1/2	95	130
-32	2	120	160

Code 61 Flange - SAE J518

Dash Size	Thread	ft - lb	Nm
-8	1/2	15-19	20-25
-12	3/4	21-29	28-40
-16	1	27-35	37-48
-20	1 1/4	35-46	48-62
-24	1 1/2	46-58	62-79
-32	2	54-66	73-90
-40	2 1/2	79-91	107-124
-48	3	137-149	186-203

O-Ring Face Seal - SAE J1453

Dash Size	Thread	ft - lb	Nm
-4	9/16-18	10-12	14-16
-6	1 1/16-16	18-20	24-27
-8	1 3/16-16	32-35	43-47
-10	1-14	46-50	62-68
-12	1 3/16-12	65-70	88-95
-16	1 7/16-12	92-100	125-136
-20	1 11/16-12	125-140	170-190
-24	2 1/2	150-165	204-224

O-Ring Boss Straight - SAE J514

Dash Size	Thread	ft - lb	Nm
-3	3/8-24	8-9	12-13
-4	7/16-20	13-15	18-20
-5	1/2-20	14-15	19-21
-6	9/16-18	23-24	32-33
-8	3/4-16	40-43	55-57
-10	7/8-14	43-48	59-64
-12	1 1/16-12	68-75	93-101
-14	1 3/16-12	83-90	113-122
-16	1 5/16-12	112-123	152-166
-20	1 5/8-12	146-161	198-218
-24	1 7/8-12	154-170	209-230
-32	2 1/2-12	218-240	296-325

Code 62 Flange - SAE J518

Dash Size	Thread	ft - lb	Nm
-8	1/2	15-19	20-25
-12	3/4	25-33	34-45
-16	1	42-50	56-68
-20	1 1/4	62-75	85-102
-24	1 1/2	116-133	158-181
-32	2	199-216	271-294

BECAUSE WE CONTINUALLY EXAMINE WAYS TO IMPROVE OUR PRODUCTS, WE RESERVE THE RIGHT TO ALTER SPECIFICATIONS WITHOUT NOTICE.

TORQUE VALUES

BSPP (no O-Ring)

Dash Size	Thread	ft - lb	Nm
-2	1/8-28	7	10
-4	1/4-19	15	20
-6	3/8-19	26	35
-8	1/2-14	44	60
-10	5/8-14	52	70
-12	3/4-14	85	115
-16	1-11	103	140
-20	1 1/4-11	155	210
-24	1 1/2-11	214	290
-32	2-11	295	400

BSPP (with O-Ring)

Dash Size	Thread	ft - lb	Nm
-2	1/8-28	11	15
-4	1/4-19	15	20
-6	3/8-19	26	35
-8	1/2-14	37	50
-10	5/8-14	44	60
-12	3/4-14	63	85
-16	1-11	85	115
-20	1 1/4-11	140	190
-24	1 1/2-11	177	240
-32	2-11	221	300

Metric

Thread	Dash	ft - lb	Nm
M10 x 1.0	10	14	19
M12 x 1.5	12	17	23
M14 x 1.5	14	19	26
M16 x 1.5	16	22	30
M18 x 1.5	18	30	41
M20 x 1.5	20	39	53
M22 x 1.5	22	56	76
M24 x 1.5	24	65	88
M26 x 1.5	26	78	106
M30 x 2.0	30	86	116
M36 x 2.0	36	98	133
M42 x 2.0	42	111	151
M45 x 2.0	45	128	173
M52 x 2.0	52	149	202

JIS 60° - B8363

Dash Size	Thread	ft - lb	Nm
-4	1/4-19	19	25
-6	3/8-19	25	34
-8	1/2-14	49	64
-10	5/8-14	63	85
-12	3/4-14	100	132
-16	1-11	149	196
-20	1 1/4-11	171	225
-24	1 1/2-11	194	255
-32	2-11	240	316

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 used.
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%.