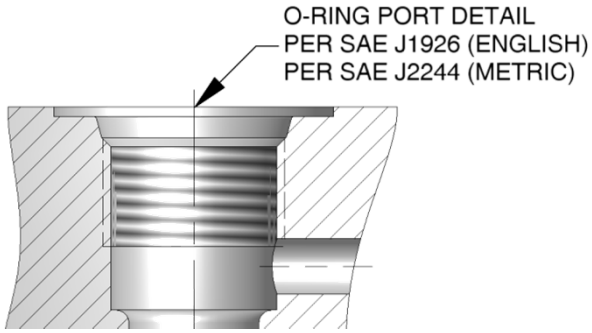
TORQUE SPECIFICATIONS

CARTRIDGE
INCH & METRIC THREADS

CONNECTION IMAGE



TYPICAL THREADED CONNECTION FOR CARTRIDGE PRODUCT

CONNECTION DETAILS / PERFORMANCE

SEE **SAE J1926** – CONNECTIONS FOR GENERAL USE AND FLUID POWER – PORTS AND STUD ENDS WITH ISO 725 THREADS AND O-RING SEALING.

SEE **SAE J2244** – CONNECTIONS FOR FLUID POWER AND GENERAL USE – PORTS AND STUD ENDS WITH ISO 261 THREADS AND O-RING SEALING.

SEE **VONBERG TECHNICAL SPECIFICATIONS – CAVITY DETAILS** FOR SPECIFIC CAVITY DIMENSIONS.

CAUTIONS

⚠ **USE WRENCHES WITH FLAT ENGAGEMENT SURFACES (i.e. – OPEN END, CRESCENT WRENCH, OR SOCKET), PIPE WRENCHES CAN DAMAGE VALVE BODY!**

⚠ **USING WRENCH HANDLE EXTENSIONS OR "CHEATER BARS" CAN LEAD TO OVER-TORQUE OF CONNECTION AND VALVE DAMAGE, MALFUNCTION, OR FAILURE!**

DESCRIPTION

1. INSPECT MALE AND FEMALE THREADS, PORT AND MATING SURFACES, AND O-RINGS TO ENSURE THAT ALL ARE FREE OF BURRS, NICKS, SCRATCHES OR ANY FOREIGN MATERIAL.
2. LUBRICATE O-RINGS WITH LIGHT COATING OF SYSTEM FLUID OR COMPATIBLE OIL.
3. SCREW THE VALVE INTO THE MATING PORT OR FITTING UNTIL THE O-RING(S) IS FULLY ENGAGED. LIGHT WRENCHING MAY BE NECESSARY.

   NOTE: IF THREADING BECOMES DIFFICULT BEFORE O-RING IS ENGAGED, UN-SCREW VALVE AND ENSURE COMPONENTS ARE NOT CROSS-THREADED OR DAMAGED.

4. TIGHTEN TO RECOMMENDED TORQUE FOR THE CORRESPONDING THREAD SIZE FROM THE TABLE BELOW.

CAVITY SIZE	CARTRIDGE THREAD SIZE	ASSEMBLY TORQUE (ft.–lbs.) +10% / -0	HEX (TYPICAL) (in.)
04 – X	7/16 – 20 UNF – 2A	10	0.562
06 – X	9/16 – 18 UNF – 2A	15	0.688
08 – X	3/4 – 16 UNF – 2A	20	0.875
10 – X	7/8 – 14 UNF – 2A	25	1.000
12 – X	1 1/16 – 12 UN – 2A	40	1.250
16 – X	1 5/16 – 12 UN – 2A	60	1.500
T–163A	M16 X 1.5 – 6H	20	0.750
T–11A	M20 X 1.5 – 6H	30	0.937
T–2A	1 – 14 UNS – 2A	45	1.120

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