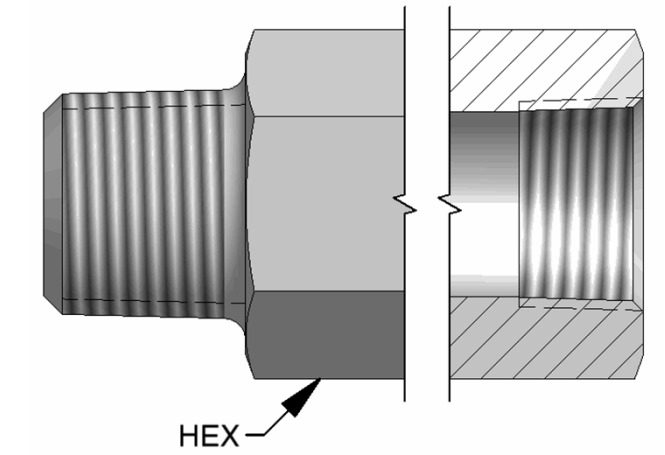
TORQUE SPECIFICATIONS

INLINE
NPTF CONNECTIONS

CONNECTION IMAGE



DRYSEAL AMERICAN STANDARD TAPER PIPE THREAD (NPTF)

CONNECTION DETAILS / PERFORMANCE

SEE **SAE J476a** - DRYSEAL PIPE THREADS

CAUTIONS

- **EXCESSIVE TAPE MAY CAUSE DISTORTION OR CRACKING OF ONE OR BOTH COMPONENTS!**
- **USE WRENCHES WITH FLAT ENGAGEMENT SURFACES (i.e. – OPEN END OR CRESCENT WRENCH), 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!**
- **WRENCH TO BE POSITIONED AS CLOSE TO THREADS AS POSSIBLE TO PREVENT SIDE LOAD ON THREADS!**

DESCRIPTION

1. INSPECT MALE AND FEMALE THREADS TO ENSURE THAT BOTH ARE FREE OF BURRS, NICKS OR ANY FOREIGN MATERIAL.
2. APPLY SEALANT/LUBRICATION TO MALE PIPE THREADS. WITH ANY SEALANT, THE FIRST 1-2 THREADS SHOULD BE LEFT UNCOVERED TO AVOID SYSTEM CONTAMINATION.

   NOTE: IF PTFE TAPE IS USED, IT SHOULD BE WRAPPED 1 1/2 – 2 TURNS IN CLOCKWISE DIRECTION WHEN VIEWED FROM THE MALE PIPE THREAD END.
3. SCREW THE VALVE INTO THE MATING PORT OR FITTING TO THE FINGER TIGHT POSITION.
4. WRENCH TIGHTEN THE VALVE TO THE **"TURNS PAST FINGER TIGHT"** VALUES SHOWN IN THE TABLE BELOW.

   NOTE: NEVER BACK OFF (LOOSEN) PIPE THREADED CONNECTORS TO ACHIEVE ALIGNMENT.

   NOTE: TORQUE RECOMMENDATIONS BELOW ARE FOR VALVE CONNECTED TO A COMPATIBLE FITTING, ADAPTER, OR BLOCK. IF VALVE IS CONNECTED TO FEMALE SWIVEL CONNECTION, REFER TO SWIVEL MANUFACTURER'S TORQUE RECOMMENDATION FOR THAT JOINT.

NPTF THREAD SIZE	TURNS PAST FINGER TIGHT	HEX (TYPICAL) (in.)		
		MALE → MALE	FEMALE → FEMALE	MALE ←→ FEMALE
1/8 – 27	2 – 3	0.438	0.625	0.625
1/4 – 18	2 – 3	0.625	0.750	0.750
3/8 – 18	2 – 3	0.750	0.875	0.875
1/2 – 14	2 – 2.5	0.875	1.125	1.125
3/4 – 14	2 – 2.5	1.125	1.375	1.375
1 – 11 1/2	1.5 – 2.5	1.375	1.625	1.625
1 1/4 – 11 1/2	1.5 – 2.5	1.750	2.000	2.000
1 1/2 – 11 1/2	1.5 – 2.5	2.000	2.375	2.375

Vonberg Valve, inc.
Hydraulic Valve Specialists

3800 Industrial Avenue • Rolling Meadows, IL 60008-1085 USA © 2012
phone: 847/259/3800 • fax: 847/259/3997 • email: info@vonberg.com