



**– Recommended torque wrench setting MT in Nm**

For male stud couplings with DIN 3852 Type B Part 2 type seal and flat GG with DIN 3852 Type E Part 11

Series	Pipe Ø	THREADS – TORQUE WRENCH SETTINGS					
		B.S.P. ThreadØ	Type B MT (Nm)	Type E MT (Nm)	Metric Thread Ø	Type B MT (Nm)	Type E MT (Nm)
L	6	G 1/8"	25	20	M10x1	25	20
	8	G 1/4"	45	40	M12x1,5	30	30
	10	G 1/4"	45	40	M14x1,5	50	50
	12	G 3/8"	85	80	M16x1,5	80	60
	15	G 1/2"	160	100	M18x1,5	90	80
	18	G 1/2"	105	100	M22x1,5	150	140
	22	G 3/4"	230	200	M26x1,5	240	200
	28	G 1"	390	380	M33x2	400	380
	35	G 1" 1/4	600	500	M42x2	600	500
	42	G 1" 1/2	800	600	M48x2	800	600
S	6	G 1/4"	60	60	M12x1,5	45	45
	8	G 1/4"	60	60	M14x1,5	60	60
	10	G 3/8"	110	90	M16x1,5	95	80
	12	G 3/8"	110	90	M18x1,5	120	100
	14	G 1/2"	170	130	M20x1,5	170	140
	16	G 1/2"	140	130	M22x1,5	190	150
	20	G 3/4"	320	200	M27x2	320	200
	25	G 1"	390	380	M33x2	450	380
	30	G 1" 1/4	600	500	M42x2	600	500
	38	G 1" 1/2	800	600	M48x2	800	600

– The torque values given here are only approximate and referring to the assembly of steel fittings with a protective surface treatment of galvanizing of the components made of the same material by using a lubricant (or a special anti-seizure agent in case of stainless steel - values given on request), following the directions of the Assembly Instructions.

Said values can change according to materials employed, tolerances and surface finishing of the assembling components as well as the assembly method.

– Use the values relative to the S series for TN 141 couplings.

**– Types of thread for DIN 2353 / ISO 8434-1 couplings**

- B.S.P. PARALLEL = UNI EN ISO 228
- B.S.P. TAPER = UNI ISO 7/1 (UNI EN ISO 10226/1)
- METRIC PARALLEL = UNI 4535-64 - ISO 261 (1973)
- METRIC TAPER = DIN 158
- NPT = ANSI/ASME B.1.20.1 (1983)
- UNF-UN = ANSI/ASME B.1.1 (1989)

**– Hermetic seals for taper threads**

Taper threads are not hermetically sealed. To obtain a watertight hermetic seal additional sealing elements are required such as PTFE sealing tape (e. g.: TEFLON).

