

Tightening torques Screw-in plug DIN 3852 Form A imperial thread

The following tightening torques apply for the specific screw-in plugs made of steel and the associated screw-in threads made of steel.

series	tube	pipe thread	steel
L	6	G 1/8 A	10
	8	G 1/4 A	40
	10	G 1/4 A	40
	12	G 3/8 A	50
	15	G 1/2 A	70
	18	G 1/2 A	70
	22	G 3/4 A	100
	28	G 1 A	165
	35	G 1 1/4 A	265
	42	G 1 1/2 A	320
S	6	G 1/4 A	40
	8	G 1/4 A	40
	10	G 3/8 A	50
	12	G 3/8 A	50
	16	G 1/2 A	70
	20	G 3/4 A	100
	25	G 1 A	165
	30	G 1 1/4 A	265
	38	G 1 1/2 A	320

Notes:

- Values only apply for steel tube fittings [galvanized] and the counter-materials mentioned above.
- Screw-in plugs are to be oiled 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 connection to be secured against loosening!

Tightening torques Screw-in plug DIN 3852 Form A metric thread

The following tightening torques apply for the specific screw-in plugs made of steel and the associated screw-in threads made of steel.

series	tube OD	pipe thread	steel
L	6	M 10x1	10
	8	M 12x1,5	25
	10	M 14x1,5	40
	12	M 16x1,5	50
	15	M 18x1,5	60
	18	M 22x1,5	70
	22	M 26x1,5	100
	28	M 33x2	165
	35	M 42x2	265
	42	M 48x2	320
S	6	M 12x1,5	25
	8	M 14x1,5	40
	10	M 16x1,5	50
	12	M 18x1,5	60
	16	M 22x1,5	70
	20	M 27x2	100
	25	M 33x2	165
	30	M 42x2	265
	38	M 48x2	320

Notes:

- Values only apply for steel tube fittings (galvanized) and the counter-materials mentioned above.
- Screw-in plugs are to be oiled 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 connection to be secured against loosening!