

## Tightening torques Screw-in plug DIN EN ISO 9974 and ISO 1179 Form B imperial thread

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

series	tube OD	pipe thread	steel	alu- minium F22	alu- minium F28	alu- minium F45
L	6	G 1/8 A	18	5	8	12
	8	G 1/4 A	35	7	10	16
	10	G 1/4 A	35	7	10	16
	12	G 3/8 A	70	25	35	55
	15	G 1/2 A	140	30	45	65
	18	G 1/2 A	100	30	45	65
	22	G 3/4 A	180	60	90	140
	28	G 1 A	330	100	150	220
	35	G 1 1/4 A	540	150	225	340
	42	G 1 1/2 A	630	180	275	400
S	6	G 1/4 A	55	7	10	16
	8	G 1/4 A	55	7	10	16
	10	G 3/8 A	90	25	35	55
	12	G 3/8 A	90	25	35	55
	16	G 1/2 A	130	30	45	65
	20	G 3/4 A	270	60	90	140
	25	G 1 A	340	100	150	220
	30	G 1 1/4 A	540	150	225	340
	38	G 1 1/2 A	700	180	275	400

**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 EN ISO 9974 und ISO 1179 Form B metric thread

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

series	tube OD	pipe thread	steel	alu- minium F22	alu- minium F28	alu- minium F45
L	6	M 10x1	18	5	8	12
	8	M 12x1,5	30	8	12	20
	10	M 14x1,5	45	15	20	32
	12	M 16x1,5	65	18	28	45
	15	M 18x1,5	80	25	35	55
	18	M 22x1,5	140	40	60	90
	22	M 26x1,5	190	55	80	120
	28	M 33x2	340	100	150	220
	35	M 42x2	500	150	225	340
	42	M 48x2	630	170	250	400
S	6	M 12x1,5	35	8	12	20
	8	M 14x1,5	55	15	20	32
	10	M 16x1,5	70	18	28	45
	12	M 18x1,5	110	25	35	55
	16	M 22x1,5	170	40	60	90
	20	M 27x2	270	60	90	130
	25	M 33x2	410	100	150	220
	30	M 42x2	540	150	225	340
	38	M 48x2	700	170	250	400

**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!