

## Tightening torques Screw-in plug for SBD with imperial thread for sealing edge/ DKA

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
L	6	G 1/8 A	20
	8	G 1/4 A	45
	10	G 1/4 A	45
	12	G 3/8 A	70
	15	G 1/2 A	100
	18	G 1/2 A	100
	22	G 3/4 A	140
S	6	G 1/4 A	45
	8	G 1/4 A	56
	10	G 3/8 A	70
	12	G 3/8 A	70
	16	G 1/2 A	100
	20	G 3/4 A	100

### 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 for SBD with metric thread for sealing edge/ DKA

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
L	6	M 10x1	25
	8	M 12x1,5	40
	10	M 14x1,5	55
	12	M 16x1,5	65
	15	M 18x1,5	90
	18	M 22x1,5	130
	22	M 26x1,5	140
S	6	M 12x1,5	40
	8	M 14x1,5	55
	10	M 16x1,5	65
	12	M 18x1,5	90
	16	M 22x1,5	130
	20	M 27x2	150

### Notes:

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- 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 for SBE/SGE with imperial thread for DKA

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
L	6	G 1/8 A	20
	8	G 1/4 A	50
	10	G 1/4 A	50
	12	G 3/8 A	75
	15	G 1/2 A	130
	18	G 1/2 A	130
	22	G 3/4 A	250
	28	G 1 A	350
	35	G 1 1/4 A	600
	42	G 1 1/2 A	800
S	6	G 1/4 A	50
	8	G 1/4 A	50
	10	G 3/8 A	75
	12	G 3/8 A	75
	16	G 1/2 A	130
	20	G 3/4 A	250
	25	G 1 A	350
	30	G 1 1/4 A	600
	38	G 1 1/2 A	800

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## Tightening torques Screw-in plug for SBE/SGE with metric thread for DKA

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
L	6	M 10x1	25
	8	M 12x1,5	50
	10	M 14x1,5	60
	12	M 16x1,5	90
	15	M 18x1,5	110
	18	M 22x1,5	150
	22	M 26x1,5	350
	28	M 33x2	400
	35	M 42x2	600
	42	M 48x2	800
S	6	M 12x1,5	50
	8	M 14x1,5	60
	10	M 16x1,5	90
	12	M 18x1,5	110
	16	M 22x1,5	150
	20	M 27x2	350
	25	M 33x2	400
	30	M 42x2	600
	38	M 48x2	800

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## Tightening torques Screw-in plug for SBE/SGE with imperial thread for EDE

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
L	6	G 1/8 A	20
	8	G 1/4 A	50
	10	G 1/4 A	50
	12	G 3/8 A	75
	15	G 1/2 A	130
	18	G 1/2 A	130
	22	G 3/4 A	250
	28	G 1 A	350
	35	G 1 1/4 A	600
	42	G 1 1/2 A	800
S	6	G 1/4 A	50
	8	G 1/4 A	50
	10	G 3/8 A	75
	12	G 3/8 A	75
	16	G 1/2 A	130
	20	G 3/4 A	250
	25	G 1 A	350
	30	G 1 1/4 A	600
	38	G 1 1/2 A	800

### 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.
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## Tightening torques Screw-in plug for SBE/SGE with metric thread for EDE

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
L	6	M 10x1	25
	8	M 12x1,5	50
	10	M 14x1,5	60
	12	M 16x1,5	90
	15	M 18x1,5	110
	18	M 22x1,5	150
	22	M 26x1,5	350
	28	M 33x2	400
	35	M 42x2	600
	42	M 48x2	800
S	6	M 12x1,5	50
	8	M 14x1,5	60
	10	M 16x1,5	90
	12	M 18x1,5	110
	16	M 22x1,5	150
	20	M 27x2	350
	25	M 33x2	400
	30	M 42x2	600
	38	M 48x2	800

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## Tightening torques Screw-in plug for SBE/SGE with imperial thread for KDE

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
L	6	G 1/8 A	20
	8	G 1/4 A	50
	10	G 1/4 A	50
	12	G 3/8 A	75
	15	G 1/2 A	130
	18	G 1/2 A	130
	22	G 3/4 A	250
	28	G 1 A	350
	35	G 1 1/4 A	600
	42	G 1 1/2 A	800
S	6	G 1/4 A	50
	8	G 1/4 A	50
	10	G 3/8 A	75
	12	G 3/8 A	75
	16	G 1/2 A	130
	20	G 3/4 A	250
	25	G 1 A	350
	30	G 1 1/4 A	600
	38	G 1 1/2 A	800

**Notes:**

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- Reduced tightening torques require the connection to be secured against loosening!

## Tightening torques Screw-in plug for SBE/SGE with metric thread for KDE

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
L	6	M 10x1	25
	8	M 12x1,5	50
	10	M 14x1,5	60
	12	M 16x1,5	90
	15	M 18x1,5	110
	18	M 22x1,5	150
	22	M 26x1,5	350
	28	M 33x2	400
	35	M 42x2	600
	42	M 48x2	800
S	6	M 12x1,5	50
	8	M 14x1,5	60
	10	M 16x1,5	90
	12	M 18x1,5	110
	16	M 22x1,5	150
	20	M 27x2	350
	25	M 33x2	400
	30	M 42x2	600
	38	M 48x2	800

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