

Tightening torques VSCH Form E imperial thread

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

pipe thread	steel
G 1/8 A	10
G 1/4 A	30
G 3/8 A	40
G 1/2 A	80
G 3/4 A	120
G 1 A	200
G 1 1/4 A	350
G 1 1/2 A	400
G 2 A	650

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 VSCH Form E metric thread

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

pipe thread	steel
M 10x1	10
M 12x1,5	20
M 14x1,5	30
M 16x1,5	40
M 18x1,5	50
M 20x1,5	60
M 22x1,5	80
M 26x1,5	100
M 27x2	120
M 33x2	200
M 42x2	350
M 48x2	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!