



# TIGHTENING TORQUES OF SCREW-IN THREAD



## TIGHTENING TORQUES SCREW-IN PLUG DIN EN ISO 9974 AND ISO 1179 FORM E IMPERIAL THREAD

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

SERIES	PIPE OUTER DIAMETER	PIPE THREAD	STEEL	ALUMINIUM F22	ALUMINIUM F28	ALUMINIUM F38	ALUMINIUM F45
L	6	G 1/8 A	18	5	8	10	12
	8	G 1/4 A	35	7	10	20	16
	10	G 1/4 A	35	7	10	20	16
	12	G 3/8 A	70	25	35	30	55
	15	G 1/2 A	90	30	45	70	65
	18	G 1/2 A	90	30	45	70	65
	22	G 3/4 A	180	60	90	110	140
	28	G 1 A	310	100	150	180	220
	35	G 1 1/4 A	450	150	225	290	340
	42	G 1 1/2 A	540	180	275	370	400
S	6	G 1/4 A	55	7	10	20	16
	8	G 1/4 A	55	7	10	20	16
	10	G 3/8 A	80	25	35	30	55
	12	G 3/8 A	80	25	35	30	55
	16	G 1/2 A	115	30	45	70	65
	20	G 3/4 A	180	60	90	110	140
	25	G 1 A	310	100	150	180	220
	30	G 1 1/4 A	450	150	225	290	340
	38	G 1 1/2 A	540	180	275	370	400

**Notes:**

- The values only apply for steel couplings (galvanized) and the counter-materials mentioned above
- Screw-in plugs are to be greased 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 coupling to be secured against loosening torques from the outside in particular

# TIGHTENING TORQUES SCREW-IN PLUG DIN EN ISO 9974 AND ISO 1179 FORM E METRIC THREAD

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

SERIES	PIPE OUTER DIAMETER	PIPE THREAD	STEEL	ALUMINIUM F22	ALUMINIUM F28	ALUMINIUM F38	ALUMINIUM F45
L	6	M 10x1	18	5	8	10	12
	8	M 12x1.5	25	8	12	15	20
	10	M 14x1.5	45	15	20	20	32
	12	M 16x1.5	55	18	28	30	45
	15	M 18x1.5	70	25	35	40	55
	18	M 22x1.5	125	40	60	70	90
	22	M 26x1.5	180	55	80	90	120
	28	M 33x2	310	100	150	160	220
	35	M 42x2	450	150	225	300	340
S	42	M 48x2	540	170	250	320	400
	6	M 12x1.5	35	8	12	15	20
	8	M 14x1.5	55	15	20	20	32
	10	M 16x1.5	70	18	28	30	45
	12	M 18x1.5	90	25	35	40	55
	16	M 22x1.5	135	40	60	70	90
	20	M 27x2	180	60	90	110	130
	25	M 33x2	310	100	150	160	220
	30	M 42x2	450	150	225	300	340
38	M 48x2	540	170	250	320	400	

## Notes:

- The values only apply for steel couplings (galvanized) and the counter-materials mentioned above
- Screw-in plugs are to be greased 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 coupling to be secured against loosening torques from the outside in particular