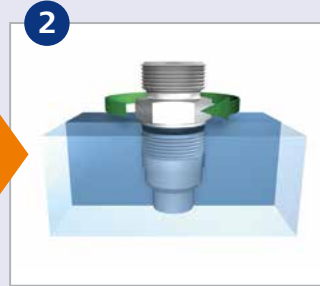




Make better connections!

Assembly of BSPP port connections



BSPP Thread
DIN ISO 6149-2/3
ISO 9974-2/3
DIN 3859-T2
ISO 1179-1

Attention! Stainless steel threads must be lubricated

- Use special Volz high-performance lubricant (ABF grease)
- Rubber seals always have to be lubricated

• Screw in until handtight

• Then tighten according to chart

Tightening torques for carbon steel zink plated fittings into carbon steel ports

Product Series	Tube O.D.	Thread size T	Straight male stud fittings with port tapping				Non-return valve RSVV / RSVZ Form E with WD softseal	Banjo fittings		Adjustable ends O-ring and retaining ring	Blanking plugs VSCH-WD Form E with WD softseal
			Form A for sealing washer	Form B with cutting-face	Form E with softseal (WD)	with O-ring sealing and retaining-ring		EWHV / ETHV	EWHB		
		inch	Nm	Nm	Nm		Nm	Nm	Nm	Nm	
L	6	G 1/8 A	9	18	18	18	18	18	18	18	13
	8	G 1/4 A	35	35	35	35	35	45	40	35	30
	10	G 1/4 A	35	35	35	35	35	45	40	35	
	12	G 3/8 A	45	70	70	70	50	70	65	70	60
	15	G 1/2 A	65	140	90	90	85	120	90	110	80
	18	G 1/2 A	65	100	90	90	65	120	90	110	
	22	G 3/4 A	90	180	180	180	140	230	125	180	140
	28	G 1 A	150	330	310	310	190	320		310	200
	35	G 1 1/4 A	240	540	450	450	360	540		450	400
42	G 1 1/2 A	290	630	540	540	540	700		540	450	
S	6	G 1/8 A	25	13							
	6	G 1/4 A	35	55	40		45	45	40	55	30
	8	G 1/4 A	35	55	40		45	45	40	55	(30)
	10	G 3/8 A	45	90	80		60	70	65	90	60
	12	G 3/8 A	45	90	80		60	70	65	90	(60)
	14	G 1/2 A	65	150	115		145	120	90	110	80
	16	G 1/2 A	65	130	115		100	120	90	110	(80)
	20	G 3/4 A	90	270	180		145	230	125	115	140
	25	G 1 A	150	340	310		260	320		420	200
	30	G 1 1/4 A	240	540	450		360	540		550	400
38	G 1 1/2 A	290	700	540		540	700		600	450	

- Tolerance of tightening torques listed in above table +10%
- Lubricate thread and rubber seals

Tightening torques relate to counterparts made of steel. When used with e.g. Aluminum or other soft alloys we recommend to use special calibrated fittings to avoid damages.

Available on request at Volz. Tightening torques might need to be adjusted for the material combination used.