



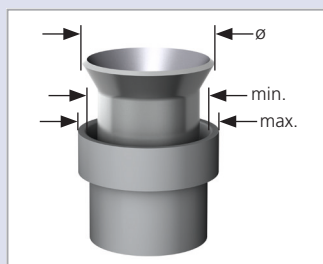
Make better connections!

JIC Connection (stainless steel)

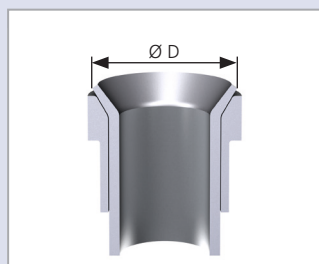
Checking the flare



- Clean flare for inspection
- Check sealing surface visually for e.g. burrs, cracks, scratches, pitting...

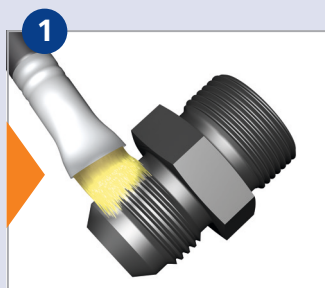


- Dimensional check of the flare

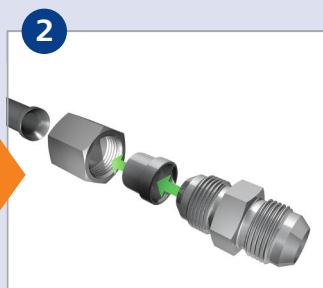


Tube O.D.		Ø D	
mm	inch	min.	max.
6	1/4"	8,6	9,7
8	5/16"	10,2	11,3
10	3/8"	11,7	12,7
12	1/2"	16,0	17,3
14		19,3	20,2
15		19,3	20,2
16	5/8"	19,3	20,2
18		23,4	24,7
20	3/4"	23,4	24,7
22	7/8"	26,5	27,8
25	1"	29,7	31,0
28		37,6	38,9
30		37,6	38,9
32	1 1/4"	37,6	38,9
35		43,2	45,3
38	1 1/2"	43,2	45,3
42		52,0	54,8
	2"	59,2	61,2

Assembly



Please note! Lightly grease stainless steel threads with e.g. Volz-Fettpaste 325



- Tighten to full metal contact (finger tight)
- Mark body and nut as quality check



- Tighten with spanner
- Use spanner extension for larger fittings

JIC connections

Dash Size	Metric Tube mm	Inch Tube inch	Thread UN/UNF	Assembly torque Nm -0% +10%
-4	6	1/4"	7/17-20	30
-5	8	5/16"	1/2-20	40
-6	10	3/8"	9/16-18	60
-8	12	1/2"	3/4-16	115
-10	14, 15, 16	5/8"	7/8-14	145
-12	18, 20	3/4"	1 1/16-12	180
-16	22, 25	7/8"	1 5/16-12	255
-20	30, 32	1 1/4"	1 5/8-12	295
-24	38	1 1/2"	1 7/8-12	345
-28	42	2	2 1/4-12	400
-32		2	2 1/2-12	470