

Application Data

Technical Torque Specifications

SAE 37° AND 45° FLARE FITTINGS FOR ZINC PLATED STEEL WITHOUT THREAD SEALANT OR LUBRICATION

Size	Fraction	Decimal	Inch-Pounds	Foot-Pounds	Meter-Newtons	Additional Turns of Hex-Flats**
- 04	1/4"	0.250	130-150	11-12	15-17	2
- 05	5/16"	0.312	165-195	14-16	19-22	2
- 06	3/8"	0.375	235-265	20-22	27-30	1-1/4
- 08	1/2"	0.500	525-575	44-48	59-65	1
- 10	5/8"	0.625	600-700	50-58	68-79	1
- 12	3/4"	0.750	950-1050	79-88	107-119	1
- 16	1"	1.000	1400-1500	117-125	158-170	1
- 20	1-1/4"	1.250	1900-2100	158-175	215-237	1
- 24	1-1/2"	1.500	2250-2550	188-213	254-288	1
- 32	2"	2.000	3000-3400	250-283	339-384	1

**Additional Turns of Hex-Flats required after finger tightening.
THIS IS THE RECOMMENDED METHOD OF TIGHTENING BOTH 37° SWIVELS & 45° FLARE FITTINGS.

STRAIGHT THREAD O-RING FITTINGS FOR ZINC PLATED STEEL WITHOUT SEALANT OR LUBRICATION

Size	Fraction	Decimal	Inch-Pounds	Foot-Pounds	Meter-Newtons
- 04	1/4"	0.250	156-180	13-15	18-20
- 05	5/16"	0.312	204-228	17-19	23-26
- 06	3/8"	0.375	264-288	22-24	30-33
- 08	1/2"	0.500	480-516	40-43	54-58
- 10	5/8"	0.625	516-576	43-48	58-65
- 12	3/4"	0.750	816-900	68-75	92-102
- 16	1"	1.000	1344-1476	112-123	152-167
- 20	1-1/4"	1.250	1752-1932	146-161	198-218
- 24	1-1/2"	1.500	1848-2040	154-170	209-231
- 32	2"	2.000	2616-2880	218-240	296-325

FOR-SEAL® FITTINGS FOR ZINC PLATED STEEL WITHOUT THREAD SEALANT OR LUBRICATION

Size	Fraction	Decimal	FOR-SEAL Swivel Nut Fitting			O-Ring Boss Straight Thread O-Ring Locknut		
			Inch-Pounds	Foot-Pounds	Meter-Newtons	Inch-Pounds	Foot-Pounds	Meter-Newtons
- 04	1/4"	0.250	120-144	10-12	14-16	168-192	14-16	19-22
- 06	3/8"	0.375	216-240	18-20	24-27	288-312	24-26	33-35
- 08	1/2"	0.500	384-420	32-35	43-48	600-720	50-60	68-81
- 10	5/8"	0.625	552-600	46-50	62-68	864-960	72-80	98-109
- 12	3/4"	0.750	780-840	65-70	88-95	1500-1620	125-135	170-183
- 16	1"	1.000	1104-1200	92-100	125-136	2400-2640	200-220	271-298
- 20	1-1/4"	1.250	1500-1680	125-140	170-190	2520-3360	210-280	285-380
- 24	1-1/2"	1.500	1800-1980	150-165	203-224	3240-4320	270-360	366-488

TORQUE VALUE CONVERSION CHART

Inch - Pounds = 0.0833 Foot - Pounds	Foot - Pound = 12 Inch - Pounds
Inch - Pounds = 0.1131 Meter - Newtons	Foot - Pounds = 1.357 Meter - Newtons
Meter - Newtons = 8.8430 Inch - Pounds	Meter - Newtons = 0.7369 Foot - Pounds

NOTE: Please consult Eaton for other material torque ratings.