

### SAE Straight Thread Port Assembly (SAE J1926)

SAE Dash Size	Thread Size UN/UNF	Assembly Torque (+10% -0)															
		Non-Adjustable						Adjustable						Plugs			
		Seal-Lok		Triple-Lok Ferulok Pipe Fittings		Seal-Lok Lite		Seal-Lok		Triple-Lok Ferulok		Seal-Lok Lite		Hollow Hex		Hex Head	
		ft.lbs. (in. lbs)	N-m	ft.lbs. (in. lbs)	N-m	ft.lbs. (in. lbs)	N-m	ft.lbs. (in. lbs)	N-m	ft.lbs. (in. lbs)	N-m	ft.lbs. (in. lbs)	N-m	ft.lbs. (in. lbs)	N-m	ft.lbs. (in. lbs)	N-m
2	5/16-24			(85)	10					(60)	7			(30)	3.5	(85)	10
3	3/8-24			(155)	18					(100)	11			(55)	6	(155)	18
4	7/16-20	(310)	35	(260)	29			(180)	20	(180)	20			(120)	13.5	(260)	29
5	1/2-20	(360)	40	(280)	32			(360)	40	(250)	28			(170)	19	(280)	32
6	9/16-18	(420)	46	(350)	40	(260)	29	(420)	46	(350)	40	(260)	30	(410)	46	(350)	40
8	3/4-16	60	80	(620)	70	(350)	40	60	80	(620)	70	(350)	40	60	80	(620)	70
10	7/8-14	100	135	85	115			100	135	85	115			100	135	85	115
12	1 1/16-12	135	185	135	183	65	85	135	185	135	183	65	85	135	185	135	183
14	1 3/16-12	175	235	175	237			175	235	175	237			175	235	175	237
16	1 5/16-12	200	270	200	271	80	110	200	270	200	271	80	110	200	270	200	271
20	1 5/8-12	250	340	250	339			250	340	250	339			250	340	250	339
24	1 7/8-12	305	415	305	414			305	415	305	414			305	415	305	414
32	2 1/2-12	375	510	375	509			375	510	375	509			375	510	375	509

**Note:** Lubricate threads before assembly! Values in chart are for steel fittings in steel ports. For stainless steel fittings, please use the upper limit of torque range. For brass (and other soft metals), decrease torque value by 35%.

**Table T1 – SAE J1926 Straight Thread Port Assembly Torques**

### BSPP (Thread G) Port Assembly (ISO 1179 / DIN 3852-2)

Series	Tube O.D.	BSPP Thread G Size	Assembly Torque Nm +10% -0								
			Straight Male Stud Fittings			Non-Return Valves RHV / RHZ	Banjo Fittings		Plugs VSTI-ED	Straight and Adjustable Fittings	
			Form A for Sealing Washer	Form B with Cutting Face	Form E with ED-Sealing	Form E with ED-Sealing	WH / TH	SWVE	Form E with ED-Sealing	O-Ring with Retaining Ring and Bonded Washer	
	6	G 1/8A	9	18	18	18	18	18	18	13	18
	8	G 1/4A	35	35	35	35	45	40	30	30	35
	10	G 1/4A	35	35	35	35	45	40	30	30	35
L	12	G 3/8A	45	70	70	50	70	65	60	60	70
	15	G 1/2A	65	140	90	85	120	90	80	80	90
	18	G 1/2A	65	100	90	65	120	90	80	80	90
	22	G 3/4A	90	180	180	140	230	125	140	140	180
	28	G 1A	150	330	310	190	320		200	200	310
	35	G 1 1/4A	240	540	450	360	540		450	450	450
	42	G 1 1/2A	290	630	540	540	700		450	450	540
S	6	G 1/4A	35	55	55	45	45	40			35
	8	G 1/4A	35	55	55	45	45	40			35
	10	G 3/8A	45	90	80	60	70	65			70
	12	G 3/8A	45	90	80	60	70	65			70
	14	G 1/2A	65	150	115	145	120	90			90
	16	G 1/2A	65	130	115	100	120	90			90
	20	G 3/4A	90	270	180	145	230	125			180
	25	G 1A	150	340	310	260	320				310
	30	G 1 1/4A	240	540	450	360	540				450
	38	G 1 1/2A	290	700	540	540	700				540

**Note:** Lubricate threads before assembly! Tightening torques are for steel fittings assembled in steel components. Values in chart are for steel fittings in steel ports. For stainless steel fittings, please use the upper limit of torque range. For brass (and other soft metals), decrease torque value by 35%.

**Table T2 – Assembly Torques for ISO 1179-1 / DIN 3852-2 Port**

Dimensions and pressures for reference only, subject to change.