



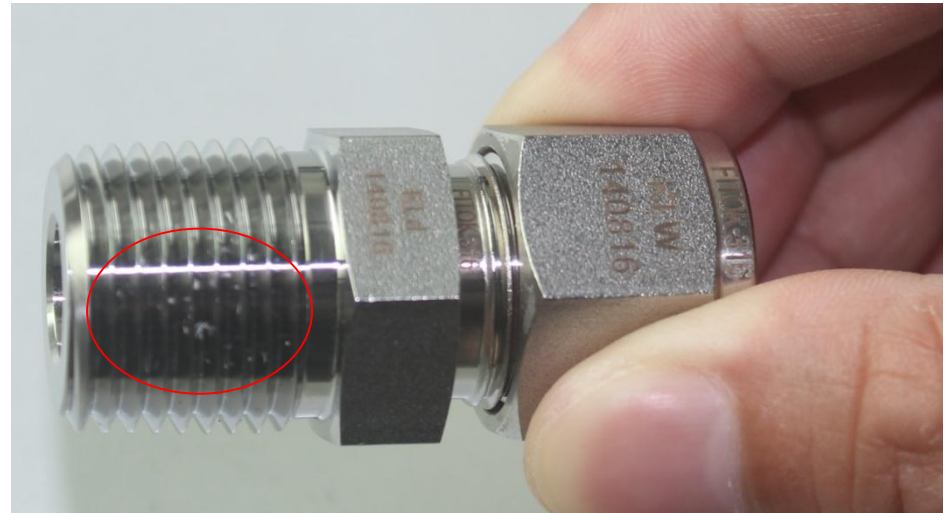
Assembling of Thread Fittings

Male tapered pipe fitting should apply PTFE tape or thread sealant for sealing. Installation steps are as follows:



Step 1:

Clean both the male and female thread. Remove all the dirt or residual tape.





Assembling of Thread Fittings

Step 2:

Wrap the thread with PTFE tape starting from the first full thread in the direction of thread spiral with suggested number of wrapping turns as in below table.

Tapered Threads Size	Number of Wrapping Turns
1/16,1/8	4-5
1/4,3/8	5-8
1/2,3/4	8-12
1	12-16
More than 1 Inch	16 or more



Assembling of Thread Fittings



Caution:

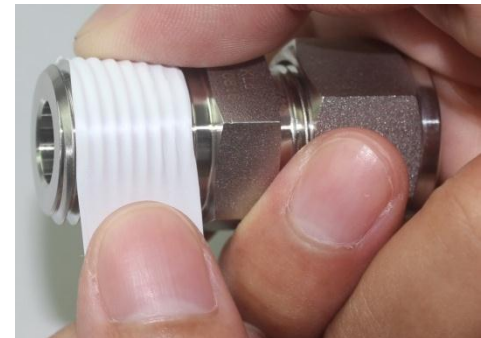
The tape should not exceed the first full thread as the excess tape may be shredded and get into the fluid system.



Wrong



Right



Right



Assembling of Thread Fittings

Step 3:

Cut the extra tape off or tear it apart. Press the tape in the thread for one circle from the free end in the direction of thread spiral.



Wrong



Right

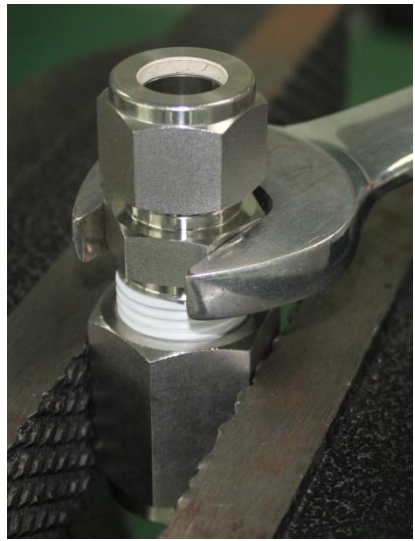


Assembling of Thread Fittings

Step 4:

Finger tight first. Then use a torque wrench to tighten up.

Keep the right direction in order to avoid damaging the thread (refer to the suggested torque in the table of the next page).





Assembling of Thread Fittings

Installation Torque of Tapered Threads

Tapered Thread Size	Initial Installation Torque (N.m)	Max. Installation Torque (N.m)
1/8	8	17
1/4	14	28
3/8	20	51
1/2	35	90
3/4	40	113
1	50	137
1-1/4	60	164
1-1/2	65	175
2	70	186