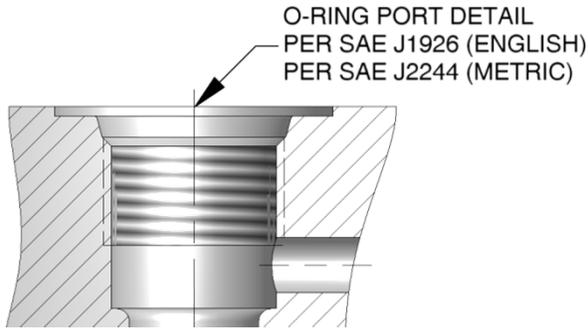


#### CONNECTION IMAGE



TYPICAL THREADED CONNECTION FOR CARTRIDGE PRODUCT

#### CONNECTION DETAILS / PERFORMANCE

SEE **SAE J1926** – CONNECTIONS FOR GENERAL USE AND FLUID POWER – PORTS AND STUD ENDS WITH ISO 725 THREADS AND O-RING SEALING.

SEE **SAE J2244** – CONNECTIONS FOR FLUID POWER AND GENERAL USE – PORTS AND STUD ENDS WITH ISO 261 THREADS AND O-RING SEALING.

SEE **VONBERG TECHNICAL SPECIFICATIONS – CAVITY DETAILS** FOR SPECIFIC CAVITY DIMENSIONS.

#### CAUTIONS

- ⚠ **USE WRENCHES WITH FLAT ENGAGEMENT SURFACES (i.e. – OPEN END, CRESCENT WRENCH, OR SOCKET), PIPE WRENCHES CAN DAMAGE VALVE BODY!**
- ⚠ **USING WRENCH HANDLE EXTENSIONS OR “CHEATER BARS” CAN LEAD TO OVER-TORQUE OF CONNECTION AND VALVE DAMAGE, MALFUNCTION, OR FAILURE!**

#### DESCRIPTION

1. INSPECT MALE AND FEMALE THREADS, PORT AND MATING SURFACES, AND O-RINGS TO ENSURE THAT ALL ARE FREE OF BURRS, NICKS, SCRATCHES OR ANY FOREIGN MATERIAL.
2. LUBRICATE O-RINGS WITH LIGHT COATING OF SYSTEM FLUID OR COMPATIBLE OIL.
3. SCREW THE VALVE INTO THE MATING PORT OR FITTING UNTIL THE O-RING(S) IS FULLY ENGAGED. LIGHT WRENCHING MAY BE NECESSARY.

*NOTE: IF THREADING BECOMES DIFFICULT BEFORE O-RING IS ENGAGED, UN-SCREW VALVE AND ENSURE COMPONENTS ARE NOT CROSS-THREADED OR DAMAGED.*

4. TIGHTEN TO RECOMMENDED TORQUE FOR THE CORRESPONDING THREAD SIZE FROM THE TABLE BELOW.

| CAVITY SIZE | CARTRIDGE THREAD SIZE | ASSEMBLY TORQUE (ft.-lbs.)<br>+10% / -0 | HEX (TYPICAL) (in.) |
|-------------|-----------------------|---|---------------------|
| 04 – X      | 7/16 – 20 UNF – 2A    | 10                                      | 0.562               |
| 06 – X      | 9/16 – 18 UNF – 2A    | 15                                      | 0.688               |
| 08 – X      | 3/4 – 16 UNF – 2A     | 20                                      | 0.875               |
| 10 – X      | 7/8 – 14 UNF – 2A     | 25                                      | 1.000               |
| 12 – X      | 1 1/16 – 12 UN – 2A   | 40                                      | 1.250               |
| 16 – X      | 1 5/16 – 12 UN – 2A   | 60                                      | 1.500               |
| T-163A      | M16 X 1.5 – 6H        | 20                                      | 0.750               |
| T-11A       | M20 X 1.5 – 6H        | 30                                      | 0.937               |
| T-2A        | 1 – 14 UNS – 2A       | 45                                      | 1.120               |

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