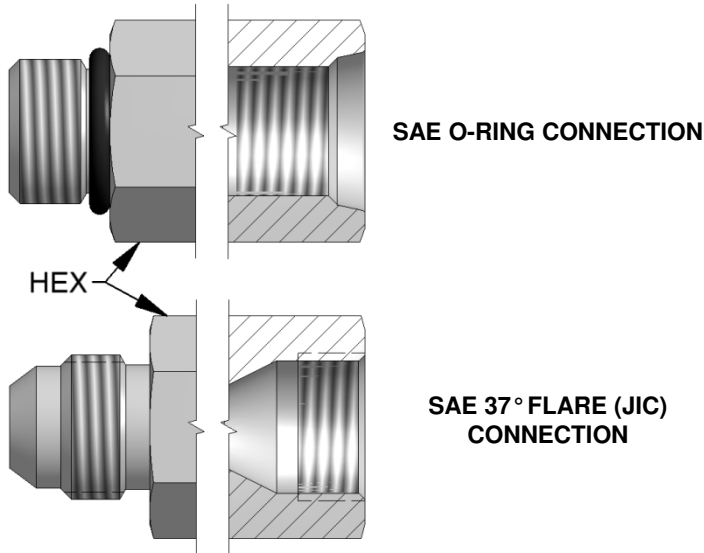


CONNECTION IMAGE



CONNECTION DETAILS / PERFORMANCE

SEE **SAE J514** – HYDRAULIC TUBE FITTINGS

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

CAUTIONS

- ⚠ **USE WRENCHES WITH FLAT ENGAGEMENT SURFACES (i.e. – OPEN END OR CRESCENT WRENCH), 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!**
- ⚠ **WRENCH TO BE POSITIONED AS CLOSE TO THREADS AS POSSIBLE TO PREVENT SIDE LOAD ON THREADS!**

DESCRIPTION

1. INSPECT MALE AND FEMALE THREADS, PORT AND MATING SURFACES, AND O-RING (IF APPLICABLE) TO ENSURE THAT ALL ARE FREE OF BURRS, NICKS, SCRATCHES OR ANY FOREIGN MATERIAL.
2. LUBRICATE O-RING 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(S) 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.

NOTE: TORQUE RECOMMENDATIONS BELOW ARE FOR VALVE CONNECTED TO A COMPATIBLE FITTING, ADAPTER, OR BLOCK. IF VALVE IS CONNECTED TO FEMALE SWIVEL CONNECTION, REFER TO SWIVEL MANUFACTURER'S TORQUE RECOMMENDATION FOR THAT JOINT.

| PORT SIZE | THREAD SIZE | ASSEMBLY TORQUE (ft.-lbs.) +10% / -0 | HEX (TYPICAL) (in.) | |
|-----------|----------------|--------------------------------------|---------------------|------------------------|
| | | | MALE → MALE | FEMALE → FEMALE / MALE |
| -04 | 7/16 – 20 UNF | 10 | 0.562 | 0.625 |
| -06 | 9/16 – 18 UNF | 15 | 0.750 | 0.750 |
| -08 | 3/4 – 16 UNF | 20 | 0.875 | 0.938 |
| -10 | 7/8 – 14 UNF | 25 | 1.000 | 1.125 |
| -12 | 1 1/16 – 12 UN | 40 | 1.250 | 1.375 |
| -16 | 1 5/16 – 12 UN | 60 | 1.500 | 1.625 |
| -20 | 1 5/8 – 12 UN | 85 | 1.875 | 2.000 |
| -24 | 1 7/8 – 12 UN | 110 | 2.125 | 2.250 |

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