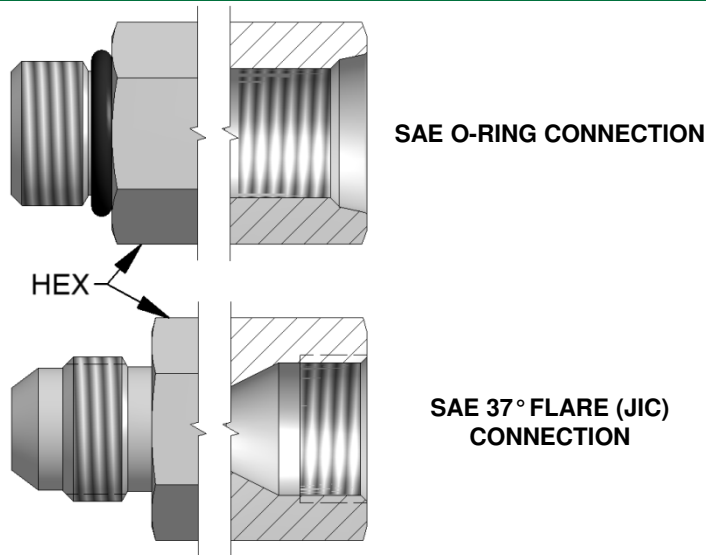


CONNECTION IMAGE



SAE O-RING CONNECTION

SAE 37° FLARE (JIC) CONNECTION

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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