



# TIGHTENING TORQUES OF SCREW-IN THREAD



## TIGHTENING TORQUES SCREW-IN PLUG DIN 3852 FORM A IMPERIAL THREAD

The following fastening torques apply for the screw-in plugs specified and the associated screw-in threads made of steel.

SERIES	PIPE OUTER DIAMETER	PIPE THREAD	STEEL
L	6	G 1/8 A	10
	8	G 1/4 A	40
	10	G 1/4 A	40
	12	G 3/8 A	50
	15	G 1/2 A	70
	18	G 1/2 A	70
	22	G 3/4 A	100
	28	G 1 A	165
	35	G 1 1/4 A	265
	42	G 1 1/2 A	320
S	6	G 1/4 A	40
	8	G 1/4 A	40
	10	G 3/8 A	50
	12	G 3/8 A	50
	16	G 1/2 A	70
	20	G 3/4 A	100
	25	G 1 A	165
	30	G 1 1/4 A	265
	38	G 1 1/2 A	320

### Notes:

- The values only apply for steel couplings (galvanized) and the counter-material mentioned above
- Screw-in plugs are to be greased before they are screwed in
- Permissible tolerance of assembly torques  $\pm 10\%$
- Reduced or higher tightening torques will reduce the maximum possible operating pressure
- Reduced tightening torques require the coupling to be secured against loosening torques from the outside in particular

## TIGHTENING TORQUES SCREW-IN PLUG DIN 3852 FORM A METRIC THREAD

The following fastening torques apply for the screw-in plugs specified and the associated screw-in threads made of steel.

SERIES	PIPE OUTER DIAMETER	PIPE THREAD	STEEL
L	6	M 10x1	10
	8	M 12x1.5	25
	10	M 14x1.5	40
	12	M 16x1.5	50
	15	M 18x1.5	60
	18	M 22x1.5	70
	22	M 26x1.5	100
	28	M 33x2	165
	35	M 42x2	265
	42	M 48x2	320
S	6	M 12x1.5	25
	8	M 14x1.5	40
	10	M 16x1.5	50
	12	M 18x1.5	60
	16	M 22x1.5	70
	20	M 27x2	100
	25	M 33x2	165
	30	M 42x2	265
	38	M 48x2	320

### Notes:

- The values only apply for steel couplings (galvanized) and the counter-material mentioned above
- Screw-in plugs are to be greased before they are screwed in
- Permissible tolerance of assembly torques  $\pm 10\%$
- Reduced or higher tightening torques will reduce the maximum possible operating pressure
- Reduced tightening torques require the coupling to be secured against loosening torques from the outside in particular