

Assembly Instructions for O-Ring Face Seal Fittings and Adapters

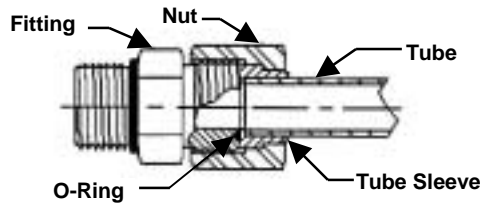


Fig.A4 ORFS Fitting Assembly

Table A3. Assembly Torque, O-Ring Face Seal Fittings¹

Tube Size	Thread Size	Ft. Lbs.	Nm.
-4	9/16-18	10-12	14-16
-6	11/16-16	18-20	24-27
-8	13/16-16	32-35	43-47
-10	1-14	46-50	60-68
-12	1-3/16-12	65-70	90-95
-14	1-3/16-12	65-70	90-95
-16	1-7/16-12	92-100	125-135
-20	1-11/16-12	125-140	170-190
-24	2-12	150-165	200-225

1) Lubricated assembly

1. Inspect components for damage or contamination.
2. Install correct O-ring in face groove (if not installed).
3. Lubricate assembly.
4. Align tube/hose to mating fitting allowing hand connection. Mating flat face end should fully contact O-ring
5. Tighten tube nut to recommended torque listed in Table A3.

