

Assembly Instructions for O-Ring Port Non-Adjustable Stud Ends

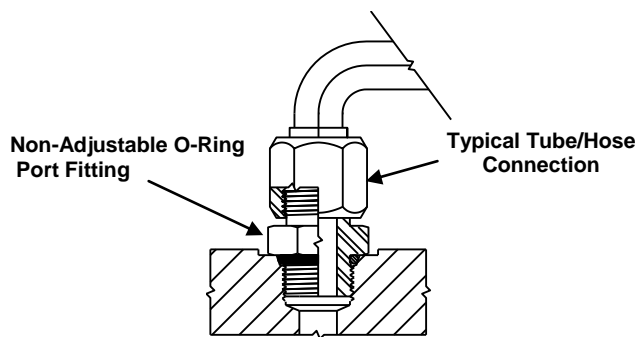


Fig. 13 Typical Non-Adjustable Stud End O-Ring Port Installation

1. Inspect components for damage or contamination.
2. If O-Ring is not present, install O-Ring on the port end of the connector using a proper O-Ring installation tool, taking care not to cut or nick the O-Ring.
3. Lubricate the O-Ring with a light coat of system fluid or compatible oil.
4. Screw stud into the O-Ring port and tighten to recommended torque listed in the following tables.

Assembly Torque, SAE J1926-3 Light Duty (L series) Stud Ends (Ref. SAE J514 Tube Fittings and Port Plugs)			
Tube Size	Thread Size	Ft. Lbs.	Nm.
-2	5/16-24	6-7	8-9
-3	3/8-24	8-9	11-12
-4	7/16-20	13-15	18-20
-5	1/2-20	17-19	23-26
-6	9/16-18	22-24	29-33
-8	3/4-16	36-39	49-53
-10	7/8-14	43-48	59-64
-12	1-1/16-12	68-75	93-102
-14	1-3/16-12	90-99	122-134
-16	1-5/16-12	112-123	151-166
-20	1-5/8-12	146-161	198-218
-24	1-7/8-12	154-170	209-231
-32	2-1/2-12	218-240	296-325

Assembly Torque, SAE J1926-2 Heavy Duty (S series) Stud Ends (Ref. SAE J1453 ORFS Fittings)			
Tube Size	Thread Size	Ft. Lbs.	Nm.
-3	3/8-24	8-10	11-13
-4	7/16-20	14-16	20-22
-5	1/2-20	30-33	40-44
-6	9/16-18	33-37	45-50
-8	3/4-16	63-69	85-94
-10	7/8-14	85-94	115-127
-12	1-1/16-12	125-138	170-187
-14	1-3/16-12	160-175	215-237
-16	1-5/16-12	200-220	270-300
-20	1-5/8-12	210-231	285-313
-24	1-7/8-12	273-300	370-407

Assembly Torque, ISO 1179-3 Light Duty (L series) Stud Ends – Types G & H			
Dash Size	Thread Size	Ft. Lbs.	Nm.
-2	G 1/8	18-20	25-28
-4	G 1/4	37-41	50-55
-6	G 3/8	59-65	80-88
-8	G 1/2	77-85	105-116
-12	G 3/4	162-178	220-242
-16	G 1	273-300	370-407
-20	G 1-1/4	369-405	500-550
-24	G 1-1/2	442-486	600-660

Assembly Torque, ISO 6149-3 Light Duty (L Series) Stud Ends			
Tube Size mm	Thread Size	Ft. Lbs.	Nm.
-4	M8 x 1	6-7	8-9
-5	M10 x 1	11-12	15-17
-6	M12 x 1.5	18-20	25-28
-8	M14 x 1.5	26-28	35-39
-10	M16 x 1.5	29-32	40-44
-12	M18 x 1.5	33-36	45-50
-16	M22 x 1.5	44-49	60-66
-20	M27 x 2	74-81	100-110
-22	M30 x 2	96-105	130-143
-25	M33 x 2	118-130	160-176
-30	M42 x 2	155-170	210-231
-38	M48 x 2	192-211	260-286
-50	M60 x 2	232-255	315-347

Assembly Torque, ISO 6149-2 Heavy Duty (S Series) Stud Ends			
Tube Size mm	Thread Size	Ft. Lbs.	Nm.
-4	M8 x 1	7-8	10-11
-5	M10 x 1	15-16	20-22
-6	M12 x 1.5	26-28	35-39
-8	M14 x 1.5	33-36	45-50
-10	M16 x 1.5	41-45	55-61
-12	M18 x 1.5	52-57	70-77
-14	M20 x 1.5	59-65	80-88
-16	M22 x 1.5	74-81	100-110
-20	M27 x 2	125-138	170-187
-22	M30 x 2	158-174	215-237
-25	M33 x 2	228-251	310-341
-30	M42 x 2	243-268	330-363
-38	M48 x 2	310-340	420-462
-50	M60 x 2	369-405	500-550

Assembly Torque, ISO 9974-2 Light Duty Stud Ends (O-Ring/Retaining Ring Type)			
Tube Size mm	Thread Size	Ft. Lbs.	Nm.
-5	M10 x 1	15-16	20-22
-6	M12 x 1.5	22-24	30-33
-8	M14 x 1.5	37-41	50-55
-10	M16 x 1.5	44-49	60-66
-12	M18 x 1.5	59-65	80-88
-16	M22 x 1.5	103-113	140-154
-20	M27 x 2	147-162	200-220
-25	M33 x 2	280-308	380-418
-30	M42 x 2	369-405	500-550
-38	M48 x 2	442-486	600-660