

Assembly Instructions for O-Ring Face Seal Fittings and Adapters

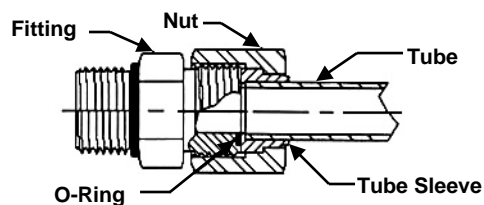


Fig.19 ORFS Fitting Assembly

Assembly Torque, O-Ring Face Seal Fittings			
Tube Size	Thread Size	Ft. Lbs. +25%-0	Nm. +25%-0
-4	9/16-18	18	25
-6	11/16-16	29	40
-8	13/16-16	41	55
-10	1-14	44	60
-12	1-3/16-12	66	90
-16	1-7/16-12	92	125
-20	1-11/16-12	125	170
-24	2-12	147	200

1. Inspect components for damage or contamination.
2. If O-Ring is not present, install correct O-Ring in face groove 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. 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 the following table.