

Assembly Instructions for SAE J518-1 Code 61 and SAE J518-2 Code 62- Four Screw Split Flange Connections

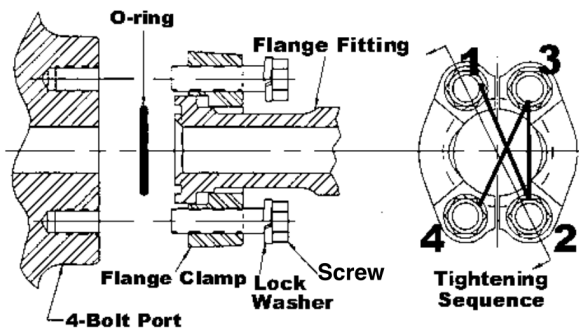


Fig.11 Four Screw Flange Fitting Assembly

1. Inspect components for damage or contamination.
2. Install correct O-Ring in flange groove.
3. Lubricate O-Ring and screw threads
4. Align flange and clamp halves to port.
5. Install screws, hand tighten evenly to seat O-Ring on port face.
6. Gradually tighten screws in equal increments, alternating in a diagonal pattern, to recommended torque listed in the following tables.

Assembly Torque, SAE J518-1 Code 61 Inch Flange Ends

Dash Size	Flange Size	Screw Size ¹	Ft. Lbs.	Nm.
-8	1/2	5/16-18 x 1-1/4	18	24
-12	3/4	3/8-16 x 1-1/4	32	43
-16	1	3/8-16 x 1-1/4	32	43
-20	1-1/4	7/16-14 x 1-1/2	52	70
-24	1-1/2	1/2-13 x 1-1/2	77	105
-32	2	1/2-13 x 1-1/2	77	105

1) Lubricated assembly, Grade 8 Screws.

Assembly Torque, SAE J518-2 Code 62 Inch Flange Ends

Dash Size	Flange Size	Screw Size ¹	Ft. Lbs.	Nm.
-8	1/2	5/16-18 x 1-1/4	24	32
-12	3/4	3/8-16 x 1-1/2	44	60
-16	1	7/16-14 x 1-3/4	68	92
-20	1-1/4	1/2-13 x 1-3/4	111	150
-24	1-1/2	5/8-11 x 2-1/4	217	295
-32	2	3/4-10 x 2-3/4	332	450

1) Lubricated assembly, Grade 8 Screws

Assembly Torque, SAE J518-1 Code 61 Metric Flange Ends

Metric Size	Flange Size	Screw Size ¹	Ft. Lbs.	Nm.
13	1/2	M8 x 25	24	32
19	3/4	M10 x 30	52	70
25	1	M10 x 30	52	70
32	1-1/4	M10 x 30	52	70
38	1-1/2	M12 x 35	96	130
51	2	M12 x 35	96	130
64	2-1/2	M12 x 40	96	130

1) Lubricated assembly, Class 10.9 Screws.

Assembly Torque, SAE J518-2 Code 62 Metric Flange Ends

Metric Size	Flange Size	Screw Size ¹	Ft. Lbs.	Nm.
13	1/2	M8 x 30	24	32
19	3/4	M10 x 35	52	70
25	1	M12 x 45	96	130
32	1-1/4	M12 x 45	96	130
38	1-1/2	M16 x 55	217	295
51	2	M20 x 70	405	550

1) Lubricated assembly, Class 10.9 Screws