

Recommended parallel connection assembly torque

Eaton Aeroquip recommends that a torque wrench be used to assure proper fitting assembly of these connections.

	Dash Size	Thread Size (Inches)	Swivel Nut Torque	
			Ft./Lbs.	Newton Meters
ORS®	-04	$\frac{9}{16}$ -18	10-12	14-16
	-06	$\frac{11}{16}$ -16	18-20	24-27
	-08	$\frac{13}{16}$ -16	32-35	43-47
	-10	1-14	46-50	62-68
	-12	$1\frac{3}{16}$ -12	65-70	88-95
	-16	$1\frac{7}{16}$ -12	92-100	125-136
	-20	$1\frac{11}{16}$ -12	125-140	170-190
	-24	2-12	150-165	204-224

	Dash Size	Thread Size (Inches)	Jam Nut or Straight Fitting Torque	
			Ft./Lbs.	Newton Meters
Straight Thread O-Ring Boss Low Pressure with 37° (SAEJ514)	-03	$\frac{3}{8}$ -24	8-9	12-13
	-04	$\frac{7}{16}$ -20	13-15	18-20
	-05	$\frac{1}{2}$ -20	14-15	19-21
	-06	$\frac{9}{16}$ -18	23-24	32-33
	-08	$\frac{3}{4}$ -16	40-43	55-57
	-10	$\frac{7}{8}$ -14	43-48	59-64
	-12	$1\frac{1}{16}$ -12	68-75	93-101
	-14	$1\frac{3}{16}$ -12	83-90	113-122
	-16	$1\frac{5}{16}$ -12	112-123	152-166
	-20	$1\frac{5}{8}$ -12	146-161	198-218
	-24	$1\frac{7}{8}$ -12	154-170	209-230
	-32	$2\frac{1}{2}$ -12	218-240	296-325

	Dash Size	Thread Size (Inches)	Jam Nut or Straight Fitting Torque	
			Ft./Lbs.	Newton Meters
Straight Thread O-Ring Boss High Pressure with ORS® (J1453)	-03	$\frac{3}{8}$ -24	8-10	11-13
	-04	$\frac{7}{16}$ -20	14-16	20-22
	-05	$\frac{1}{2}$ -20	18-20	24-27
	-06	$\frac{9}{16}$ -18	24-26	33-35
	-08	$\frac{3}{4}$ -16	50-60	68-78
	-10	$\frac{7}{8}$ -14	72-80	98-110
	-12	$1\frac{1}{16}$ -12	125-135	170-183
	-14	$1\frac{3}{16}$ -12	160-180	215-245
	-16	$1\frac{5}{16}$ -12	200-220	270-300
	-20	$1\frac{5}{8}$ -12	210-280	285-380
	-24	$1\frac{7}{8}$ -12	270-360	370-490

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SAE 37° (JIC)	Dash Size	Thread Size (Inches)	Swivel Nut Torque	
			Ft./Lbs.	Newton Meters
	-04	7/16-20	11-12	15-16
	-05	1/2-20	15-16	20-22
	-06	9/16-18	18-20	24-28
	-08	3/4-16	38-42	52-58
	-10	7/8-14	57-62	77-85
	-12	1 1/16-12	79-87	108-119
	-16	1 5/16-12	108-113	148-154
	-20	1 5/8-12	127-133	173-182
	-24	1 7/8-12	158-167	216-227
	-32	2 1/2-12	245-258	334-352

Metric	Thread Size mm	Straight Adapter or Locknut Torque	
		Ft./Lbs.	Newton Meters
	M10 x 1	13-15	18-20
	M12 x 1.5	15-19	20-25
	M14 x 1.5	19-23	25-30
	M16 x 1.5	33-40	45-55
	M18 x 1.5	37-44	50-60
	M20 x 1.5	52-66	70-90
	M22 x 1.5	55-70	75-95
	M26 x 1.5	81-96	110-130
	M27 x 2	96-111	130-150
	M33 x 2	162-184	220-250
	M42 x 2	170-192	230-260
	M48 x 2	258-347	350-470

BSPP **"G" denotes parallel threads, other than ISO 6149. (Port connection only)	Nominal Thread Size Inches**	Straight Adapter or Locknut Torque	
		Ft./Lbs.	Newton Meters
	G 1/8-28	13-15	18-20
	G 1/4-19	19-23	25-30
	G 3/8-19	33-40	45-55
	G 1/2-14	55-70	75-95
	G 3/4-14	103-118	140-160
	G 1-11	162-184	220-250
	G 1 1/4-11	170-192	230-260
	G 1 1/2-11	258-347	350-470

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