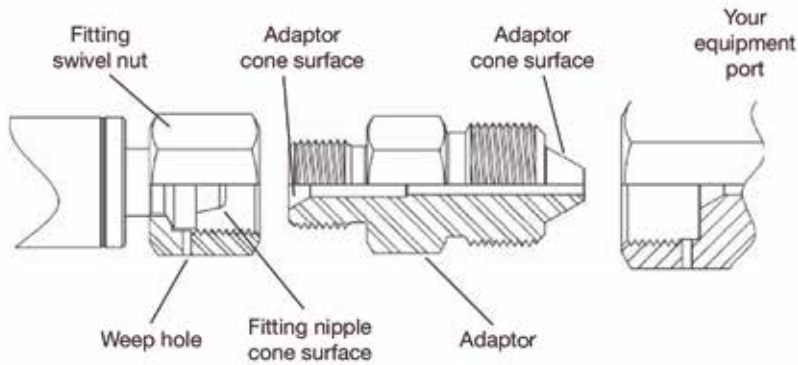


GENERAL ENGINEERING

RECOMMENDED TIGHTENING PROCEDURES

TIGHTENING PROCEDURES

	Connection	Thread Sizes	Tightening Torque	
			ft / lb	M / m
High Pressure	1/4	9/16 - 18	25	34
	3/8	3/4 - 16	50	69
	9/16	1 1/8 - 12	75	103
Medium Pressure	1/4	7/16 - 20	20	28
	3/8	9/16 - 20	30	41
	9/16	13/16 - 16	85	117
	3/4	3/4 NPSM	90	124
	1	1 3/8 - 12	125	173
Type "M" Swivel	A9	9/16 - 18	25 - 30	34 - 41
	A12	3/4 - 16	40 - 50	55 - 69
	A14	7/8 - 14	50 - 60	69 - 83
	A16	1 - 12	75 - 85	103 - 117
	A21	1 5/16 - 12	100 - 120	138 - 166



Leakage at swivel nut-to-adaptor joint

(Seen by leak at weep hole in swivel nut)

1. Reduce system pressure to zero.
2. Unscrew swivel nut and check cone surfaces of adaptor and hose insert.
3. If hose insert is damaged, return hose to Abdex for repair and retest.
4. If cone surfaces look good after cleaning, re-tighten swivel nut. Do not exceed 150% of recommended torque.

Leakage at type "M" adaptor-to-port

(Seen by leak at weep hole in pressure port, or leak at threads for NPT adaptors)

1. Reduce system pressure to zero.
2. Slacken hose swivel nut.
3. Tighten adaptor into port.
4. Re-tighten swivel nut.

Never use the swivel nut to tighten the adaptor into the port.