

Assembly Instructions for Adjustable O-Ring Port Fittings

1. Inspect components for damage or contamination.
2. Back off locknut from washer.
3. Lubricate O-ring and threads with light oil or system fluid, install O-ring in groove on the fitting. See Fig.A6.
4. Screw stud into the O-ring port until the washer fully bottoms out on face of the port. See Fig.A7.
5. Position the fitting as required by backing out (ccw) up to one turn maximum. See Fig.A8.
6. Maintain fitting orientation while tightening locknut to recommended torque listed in Table A4 or A5. See Fig.A9.

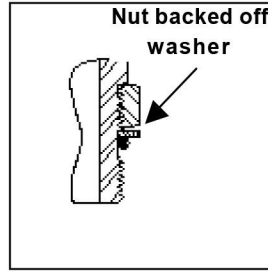


Fig.A6 Back off nut, install lubricated O-ring

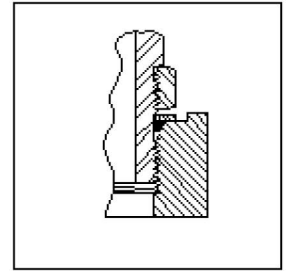


Fig.A7 Screw stud into port until washer bottoms out on port face

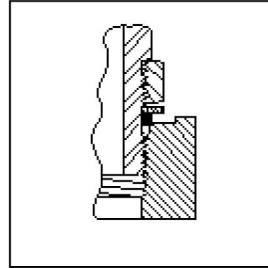


Fig.A8 Orient fitting by backing out up to one turn maximum

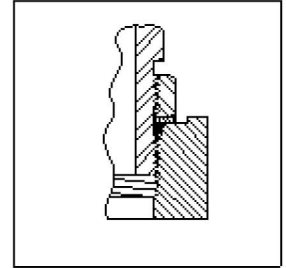


Fig.A9 Maintain fitting orientation while tightening locknut to recommended torque

Table A4. Assembly Torque, SAE J1926-3 Light Duty Stud Ends (Ref. SAE J514 Tube Fittings and Port Plugs)¹

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	40-43	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

¹) Lubricated assembly

Table A5. Assembly Torque, SAE J1926-2 Heavy Duty Stud Ends (Ref. SAE J1453 ORFS Fittings)¹

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	18-20	24-27
-6	9/16-18	24-26	33-35
-8	3/4-16	50-60	68-78
-10	7/8-14	72-80	98-110
-12	1-1/16-12	125-135	170-183
-14	1-3/16-12	170-190	230-260
-16	1-5/16-12	200-220	270-300
-20	1-5/8-12	210-280	285-380
-24	1-7/8-12	270-360	370-490

¹) Lubricated assembly

