

**Assembly Instructions for NPTF Pipe Threads**

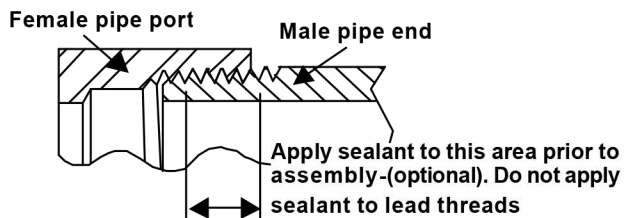


Fig.A10 NPTF Pipe Assembly

**Method A. Installation Torque**

1. Inspect components for damage or contamination.
2. Lubricate or apply compatible sealant to male pipe thread. See Fig.A10.
3. Screw fitting into port until hand tight. For shape fittings, take note of the intended alignment of the mating connectors.
4. For straight fittings, tighten to recommended torque listed in Table A6. For shape fittings, approximately 1/2 turns should be made and then torque to the desired orientation without exceeding maximum recommended torque.

**Method B. Turns from Finger Tight**

Note: Due to the variety of factors which affect the turns method, the values indicated are approximate and should be used only for initial installation, by experienced installation personnel.

1. Inspect components for damage or contamination.
2. Lubricate or apply compatible sealant to male pipe thread.
3. Screw fitting into port and lightly wrench to seat threads.
4. Mark fitting and adjacent surface to indicate initial seating position.
5. For straight fittings, tighten using mean to maximum recommended T.F.F.T. listed in Table A6.
6. For shape fittings, tighten to minimum T.F.F.T., and turn past to desired orientation.
7. Mark final tightening position by extending the existing mark from the fitting to the adjacent surface.

Table A6. Assembly Torque, Adapter Unions and Pipe Fittings. (T.F.F.T. for Tapered Pipe Only) <sup>1</sup>					
Pipe Size	Adapter Unions		Pipe		
	Ft. Lbs. Max.	Nm. Max.	Ft. Lbs. Max.	Nm. Max.	Tapered Pipe T.F.F.T. <sup>2</sup> (Turns)
1/8	13	18	12	16	3/4-1 3/4
1/4	20	27	25	34	3/4-1 3/4
3/8	25	34	40	54	3/4-1 3/4
1/2	47	64	54	73	1/2-1 1/2
3/4	84	114	78	106	1/2-1 1/2
1	129	175	112	152	1/2-1 1/2
1-1/4	152	206	154	209	1/2-1 1/2
1-1/2	152	206	211	286	1/2-1 1/2
2	300	407	300	407	1/2-1 1/2

1) Lubricated assembly.  
 2) Tapered pipe connections use turns from finger tight. Turn past minimum for alignment of shape fittings.

