

ENGINEERING DATA

UNION NUT RECOMMENDED TORQUE VALUES

MN AND MN50 SERIES

IPS SIZE	CAT#	FT. LBS. MIN	FT. LBS MAX
1/8	-0	10	25
1/4	-1	10	25
3/8	-2	12	30
1/2	-3	15	40
3/4	-4	20	50
1"	-5	25	60
1 1/4	-6	30	75
1 1/2	-7	35	90
2"	-8	45	120
2-1/2	-9	60	150

1. THE LISTED TORQUE VALUES SHOULD BE USED FOR TIGHTENING FLAT FACED O-RING SEALED FITTING (FFS) UNION NUTS, MN AND MN50 SERIES ONLY. THEY DO NOT APPLY FOR ASSEMBLIES IN STOCK OR WHEN SHIPPING. HAND TIGHTEN ASSEMBLY IS ACCEPTABLE FOR THESE CONDITIONS.

2. IT IS IMPORTANT, PRIOR TO TORQUE BEING APPLIED TO THE UNION NUT, THAT THE THREADPIECE AND TAILPIECE BE ALIGNED WITH THEIR FACES PARALLEL AND IN COMPLETE CONTACT WITH EACH OTHER. WHEN FITTINGS ARE ALIGNED PROPERLY, THE UNION NUT SHOULD BE ABLE TO BE THREADED WITH LITTLE EFFORT. AFTER HAND TIGHT ASSEMBLY, THE UNION NUTS SHOULD BE TIGHTENED USING THE APPROPRIATE SIZED WRENCH USING A FORCE SPECIFIED ABOVE.

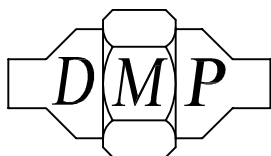
3. DO NOT TORQUE HIGHER THAN THE MAXIMUM VALUES SHOWN

TORQUE VALUES ARE IN ACCORDANCE WITH THE US NAVY "JOINT FLEET MAINTENANCE MANUAL"

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