

83.0 Tightening Torques for Hose Fittings

General

When tightening or loosening hose connections always use two wrenches. This is of particular importance when tightening hose connections since hoses will become stiffer when distorted and will then transmit a larger number of vibrations.

Copper seals, O-rings and threaded connections

should always be lubricated with refrigeration oil. If the connections show any leaks, do not try to eliminate such leaks by tightening beyond specified torque, but loosen the connection again and repair the leak (damaged O-ring or copper seal). If there is no copper seal in the connection, install copper seal.

Tightening Torques in kpm

| Threaded connection | with Cu-seal | without Cu-seal |
|---------------------|-----------------|--------------------|
| 5/8" — 18 UNF | 3.0 ± 0.5 | 4.5 ± 0.5 |
| 3/4" — 16 UNF | 4.5 ± 0.5 | 5.5 ± 0.5 |
| 7/8" — 14 UNF | 6.0 ± 0.5 | 7.0 ± 0.5 |