

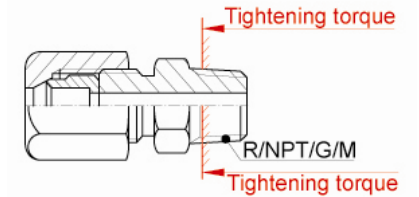
## Tightening torque for male threads

For male threads on SERTO unions we recommend specific tightening torques, which can be found in this chart. Please note that these values apply exclusively to the male threads and are not in any way a recommendation for installations on the nut/compression ferrule side of the union. (As a general assembly instruction, we recommend 1 ¾ turns for all unions.)

### 1. Metal materials (stainless steel, steel, brass)

#### 1.1 Inch threads

Tightening torque in Nm	1/8			1/4			3/8			1/2			3/4			1		1 1/4	
	Inox	Steel	Brass	Inox	Steel	Brass	Inox	Steel	Brass	Inox	Steel	Brass	Inox	Steel	Brass	Inox	Steel	Brass	Steel
<b>R</b>	18	18	8	35	25	12	45	35	20	60	50	30	110	60	30	180	80		100
<b>NPT</b>	25		15	40		25	55		40	110		80	150		90			110	
<b>G O-ring</b>	20		15	50		35	70		50	100		80	120		90				
<b>G edge seal</b>	30	20	20	70	50	50	100	100	80	150	160	100	180	180		220	240		280



#### 1.2 Metric threads

Tightening torque in Nm	M5	M6x0.75	M6	M8x1		M10x1		M12x1.5		M14x1.5		M16x1.5		M18x1.5		M22x1.5		M26x1.5	M33x2
	Brass	Brass	Brass	Inox	Brass	Steel	Brass	Steel	Brass	Steel	Brass	Steel	Brass	Steel	Brass	Steel	Brass	Steel	Steel
<b>M tapered</b>				4	2		5		25		30		50						
<b>M edge seal</b>	4	6	6		9	20	10	25	25	40	30	55	50	80	60	110	80	150	250

### 2. Non-metal materials (PVDF, PA)

#### 2.1 Inch threads

Tightening torque in Nm	1/8		1/4		3/8		1/2	
	PVDF	PA	PVDF	PA	PVDF	PA	PVDF	PA
<b>R</b>	0.5	0.5	2.5	3.5	2.5	3.5	6	8
<b>NPT</b>	1.5	2.0	5	6	5	6		

Tightening torque in Nm	1/8		1/4		3/8		1/2	
	PVDF	PA	PVDF	PA	PVDF	PA	PVDF	PA
<b>G O-ring</b>	1.5	1.5	2.5	2.5	6	6	9	9
<b>G edge seal</b>	2	2	3.5		8		12	