Assembly Torque Values

JIC 37° and SAE 45° Flare Torque Values

SWIVEL NUT TORQUE - JIC 37 FLARE AND 45 FLARE			
Dash Size	Newton Meters	Pound Inches	Flates from Wrench Resistance
-4	15-17	130-150	2
-5	19-22	165-195	2
-6	27-30	235-265	1-1/4
-8	59-65	525-575	1
-10	68-79	600-700	1
-12	107-119	950-1050	1
-16	158-170	1400-1500	1
-20	215-237	1900-2100	1
-24	254-288	2250-2550	1
-32	339-384	3000-3400	1

Note: The hex flats from finger tight method is recommended for 37° and 45° flare fittings. The torque values given are for zinc plated carbon steel components without lubrication.

Seal-Lok® Torque Values

Dash Size	SWIVEL NUT TORQUE - SEAL-LOK Newton Meters	Pound Inches	Flates From Wrench Resistance
-4	24-26	210-230	1-1/2 - 3/4
-6	33-39	295-345	1-1/2 - 3/4
-8	51-57	455-505	1-1/2 - 3/4
-10	81-89	715-785	1-1/2 - 3/4
-12	117-127	1035-1125	1/3 - 1/2
-16	153-173	1350-1530	1/3 - 1/2
-20	180-200	1590-1770	1/3 - 1/2
-24	212-235	1880-2080	1/3 - 1/2
-32	-	-	

Note: The assembly torques listed are higher than the test torques published in SAE J1453.

Torque Conversion Equivelants

Torque Conversion Equivalents Pound Inch - Pound Foot - Newton Meter		
Pound Foot x 12	=	Pound Inch
Pound Foot x 1.356	=	Newton Meter
Newton Meter x 8.850	=	Pound Inch
Newton Meter x 0.737	=	Pound Foot
Pound Inch x .083	=	Pound Foot
Pound Inch x 0.113	=	Newton Meter

The torque values for other materials are as follows:

- Brass fittings and adapters - 65% of the torque value for steel.
- Stainless steel, and monel - use high side of the torque range for steel. Threads to be lubricated for these materials.
- Dissimilar metals - use torque value designated for the lower of the two metals.
- All fittings are dry except as noted above.

The torque values listed above are consistent with the torque values recommended by Parker Tube Fittings Division Technical Service Department ((614) 279-7070 or www.parker.com/tfd).