

# INSTALLATION DATA SHEET

## STEEL PIPE FITTINGS

### Applications:

Water, Oil, Air. Pipe threads must be sealed using approved thread sealant.

### Working Temperature:

-65°F (-54°C) to 250°F (120°C)

### Assembly:

1. Inspect port and fitting to ensure that both are free of contaminants and excessive burrs and nicks.
2. Apply a stripe of an anaerobic liquid pipe sealant around the male threads leaving the first two threads uncovered. If no liquid sealant is available, wrap Teflon tape 1 1/2 to 2 turns in a clockwise direction, viewed from the pipe end, leaving the first two threads uncovered.
3. Screw finger-tight into the port.
4. Wrench-tighten the fitting to the correct Turns Past Finger Tight position. When installing elbows or tees, consider final orientation position as to not exceed the recommended TPFT. A properly assembled fitting's total thread engagement should be 3.5-6 turns.

**CAUTION:** Sealant tape and some pipe sealants are destructive to hydraulic components. Always use extreme caution and follow manufacturer's recommendations for proper application of any sealant in order to prevent contamination.

**CAUTION:** Never back off an installed pipe fitting to achieve proper alignment. Loosening installed pipe fittings will corrupt the seal and contribute to leakage and failure.

### Dash Size NPSM Thread Size (Inches) Turns Past Finger-Tight

-1	1/16-27	1.5 - 3.0
-A	1/8-27	1.5 - 3.0
-B	1/4-18	1.5 - 3.0
-C	3/8-18	1.5 - 3.0
-D	1/2-14	1.5 - 3.0
-E	3/4-14	1.5 - 3.0
-H	1-11 1/2	1 - 2.5
-J	1 1/4-11 1/2	1 - 2.5
-K	1 1/2-11 1/2	1 - 2.5
-M	2-11 1/2	1 - 2.5