

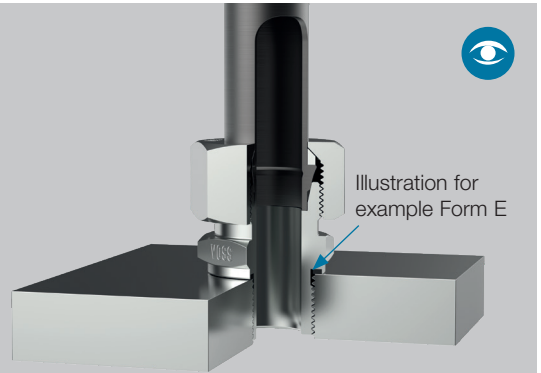
Assembly instructions male stud connectors Form A, B and E

1

Notes

Follow the general information in the catalog before starting assembly and check that the assembly instructions are up to date!

These assembly instructions describe the assembly of male stud connectors Form A, B and E with cylindrical (metric/BSPP) tube thread.



2

Order of assembly



1. Check the male thread and soft-sealing for any damage. Replace components if necessary.

1.1. When using male stud connectors mount the copper sealing ring on the sealing surface.

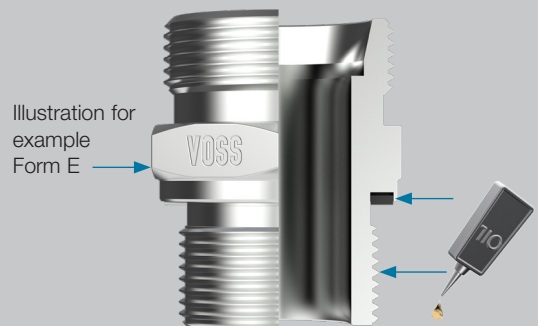
2. Lubricate thread.

2.1. Sealing (flat face) (Form A)/Sealing edge (Form B)
Lightly lubricate the male thread with mineral-oil based hydraulic oil (for example HLP32)!

2.2. Sealing via PEFLEX (Form E)
Lightly lubricate the male thread and soft-sealing with mineral-oil based hydraulic oil (for example HLP32)!

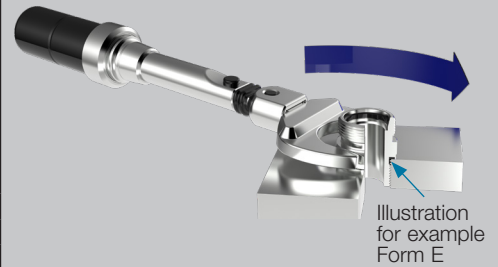
3. Tighten the male stud connector in the threaded hole by hand.

4. Tighten the male stud connector in according to the following table using the torque wrench.



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Male thread size metric	Male stud connector to					
	DIN 3852-1		DIN 3852-1 ISO 9974-3		ISO 9974-2	
	Form A		Form B		Form E	
	Sealing ring e.g. copper sealing ring		Sealing edge		PEFLEX seal Standard NBR	
	Tightening torque Nm -10 %		Tightening torque Nm -10 %		Tightening torque Nm -10 %	
	Series L	Series S	Series L	Series S	Series L	Series S
M 8 x 1			14			
M 10 x 1	20		25		15	
M 12 x 1					25	
M 12 x 1.5	30	30	35	60	25	50
M 14 x 1.5	50	50	55	90	50	60
M 16 x 1.5	90		80	120	70	80
M 18 x 1.5	100	100	100	190	90	90
M 20 x 1.5				280		130
M 22 x 1.5	110		170	300	130	130
M 26 x 1.5	130		230		180	190
M 27 x 2	150			420	180	200
M 33 x 2	350		400	600	230	250
M 42 x 2	550		700	700	330	500
M 48 x 2			900	900	500	600



Male thread size BSPP	Male stud connector to					
	DIN 3852-2		ISO 1179-4		ISO 1179-2	
	Form A		Form B		Form E	
	Sealing ring e.g. copper sealing ring		Sealing edge		PEFLEX seal Standard NBR	
	Tightening torque Nm -10 %		Tightening torque Nm -10 %		Tightening torque Nm -10 %	
	Series L	Series S	Series L	Series S	Series L	Series S
G 1/8 A	20	20	25		20	
G 1/4 A	45	45	55	95	50	60
G 3/8 A	80	80	95	180	80	90
G 1/2 A	90	90	185	160	100	150
G 3/4 A	220	220	250	350	180	200
G 1 A	350	350	400	700	230	250
G 1 1/4 A	400	400	670	850	330	500
G 1 1/2 A	700	700	800	1,000	500	600