

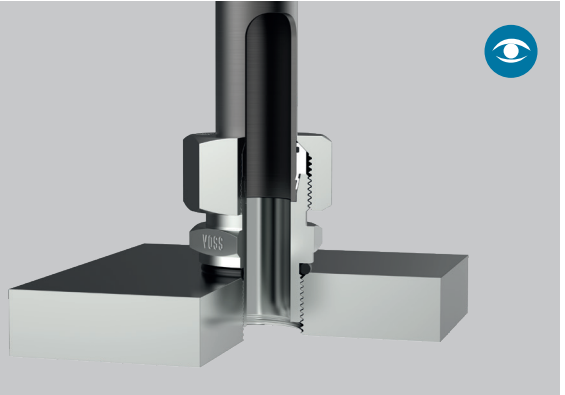
Assembly instructions UN/UNF and ISO 6149 (Form F) male stud connectors

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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 UN/UNF and ISO 6149 (Form F) male stud connectors with cylindrical threads.

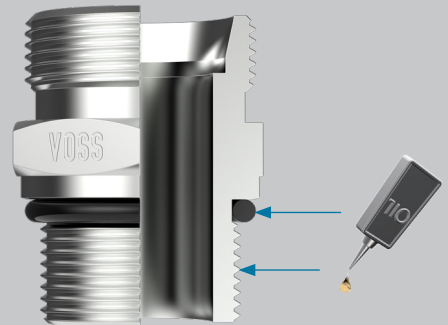


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Order of assembly



1. Check the male thread and soft-sealing for any damage. Exchange components if necessary.
2. 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.



Male thread size UN/UNF	Male stud connector to ISO 11926-2/3 (Form F) O-ring Standard NBR Tightening torque Nm -10 %	
	Series L	Series S
7/16-20 UNF-2A	25	30
1/2-20 UNF-2A	28	45
9/16-18 UNF-2A	30	75
3/4-16 UNF-2A	55	100
7/8-14 UNF-2A	60	160
1 1/16-12 UN-2A	110	270
1 3/16-12 UN-2A	140	
1 5/16-12 UN-2A	165	430
1 5/8-12 UN-2A	220	450
1 7/8-12 UN-2A	260	520

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Male thread size metric	Male stud connector to ISO 6149-2/3 (Form F) O-ring Standard NBR Tightening torque Nm -10 %	
	Series L	Series S
M 10 x 1	15	15
M 12 x 1.5	25	35
M 14 x 1.5	35	40
M 16 x 1.5	40	55
M 18 x 1.5	45	70
M 22 x 1.5	60	100
M 27 x 2	100	170
M 33 x 2	160	310
M 42 x 2	210	330
M 48 x 2	260	420

