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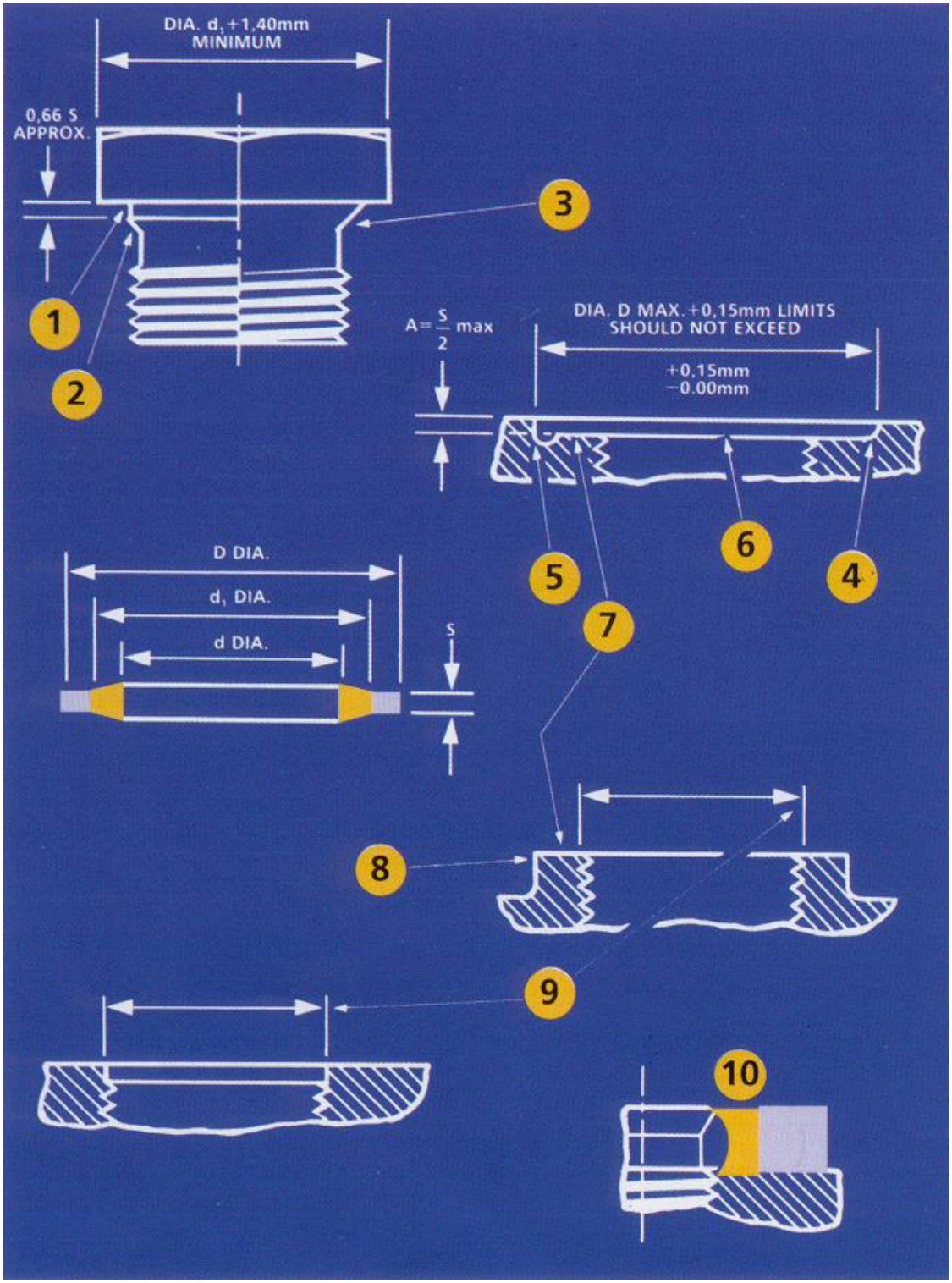
Installation



(1) This Diameter equals basic major thread diameter
(2) Plain shoulder and any form of undercut
(3)Taper neck undercut to bs. 1936 or ags or similar standard. A parallel or semicurcular form width not exceeding s is also acceptable
(4) 0,15 mm max. radius
(5) Alternative if larger corner radius is requrerd
(6) recess eliminatingthe need for special undercut or shoulder in mating part
(7) Face to be normal to thread within 0,08 mm/25 mm run
(8) Boss deameter to be equal to or greater than D dia
(9) the diameter of a chamfer or counterbore for removal of first therad should be concentric with and not exceed the thread diameter
(10) Diagram typical of the assembly as it should appear at any radial section i.e. ring centralised and rubber in full contact with flat faces

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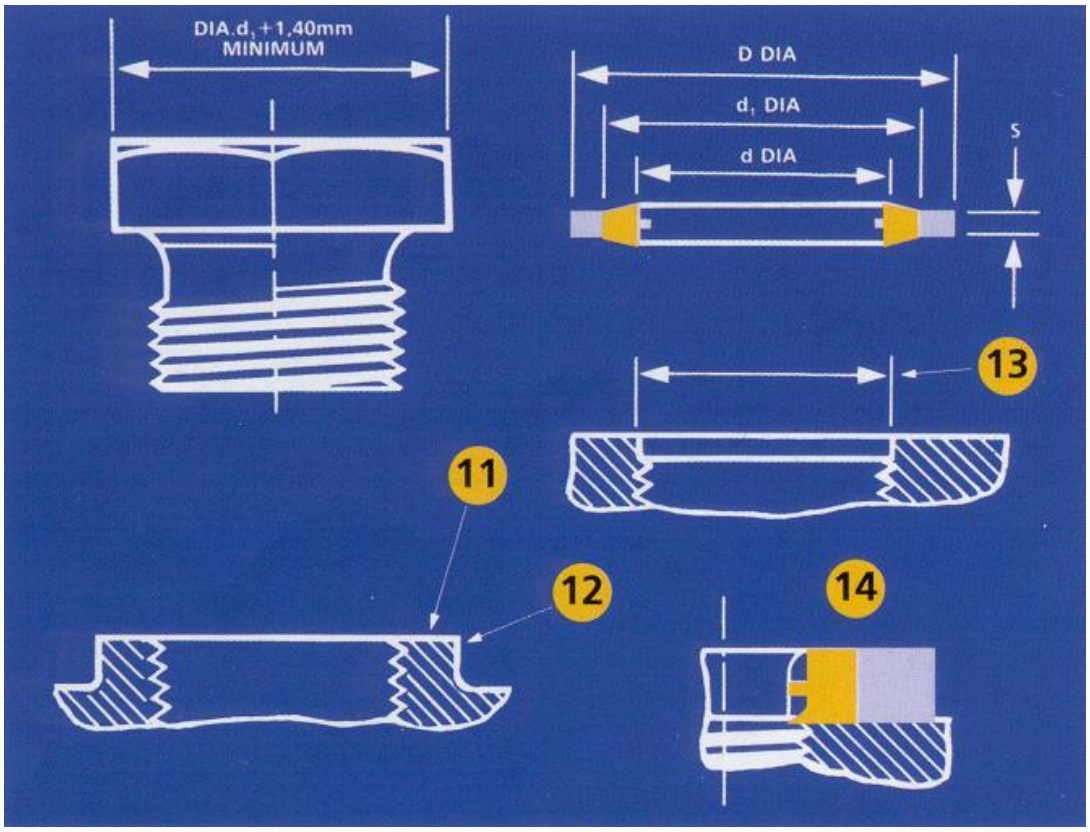
Self centring



(11) Face to be normal to thread within 0,08/25 mm run
(12) Boss deameter to be equal to or greater than D dia
(13) The diameter of a chamfer or counterbore flr removal of first thred should be concentric with and not exceed the thread diameter
(14) Diagram typical or the assembly as it should apear at any radial section i.e. ring centralised and ruber in full contact with flat face.

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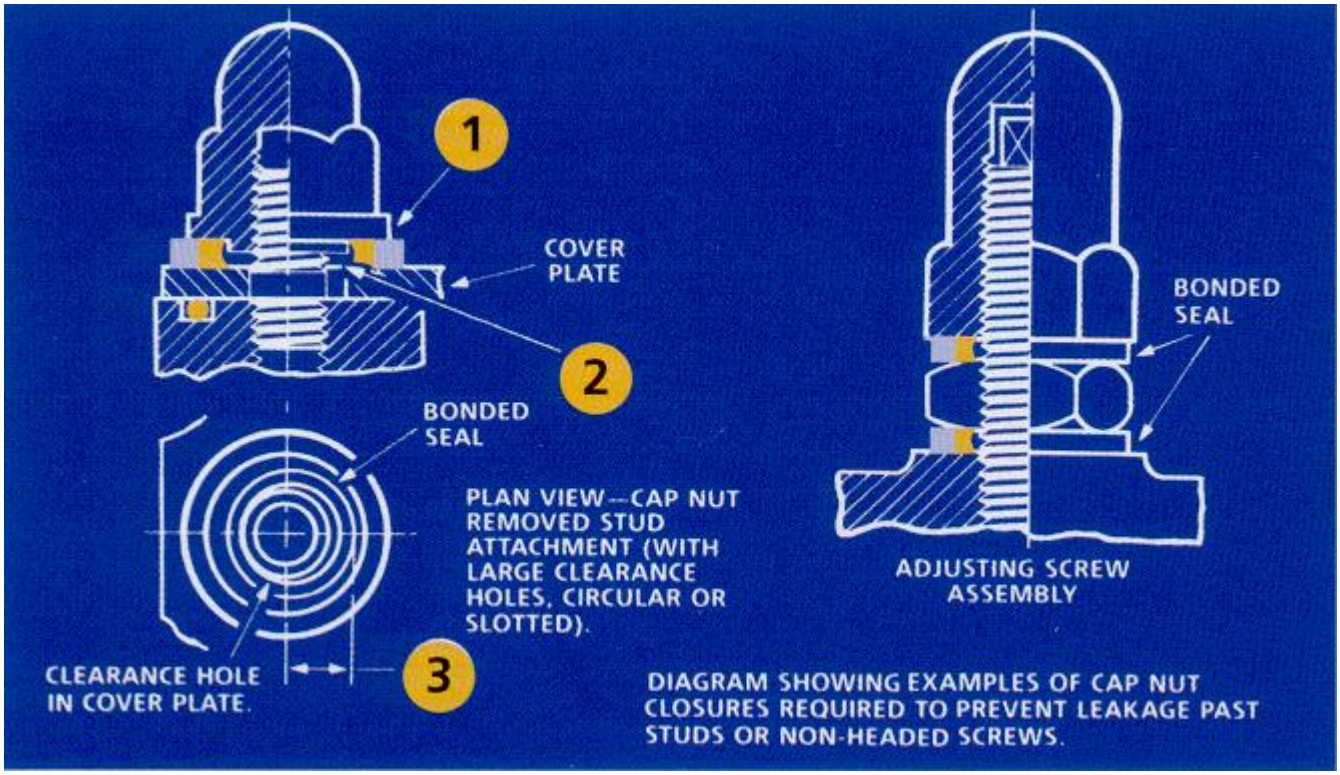
Cap-nut Closures



(1) The flange deameter (or size across flats if the cap nut is machined from hexagon bar)
should not be less than the outside diameter of the rubber ring plus 2,0 mm
(2) The spigot diameter should be equal to the inside diameter of the rubber ring
(min.) minus 0,75 mm and the depth about two thirds metal ring thickness
(3) To be not greater than inside radius of rubber ring - 4,0mm

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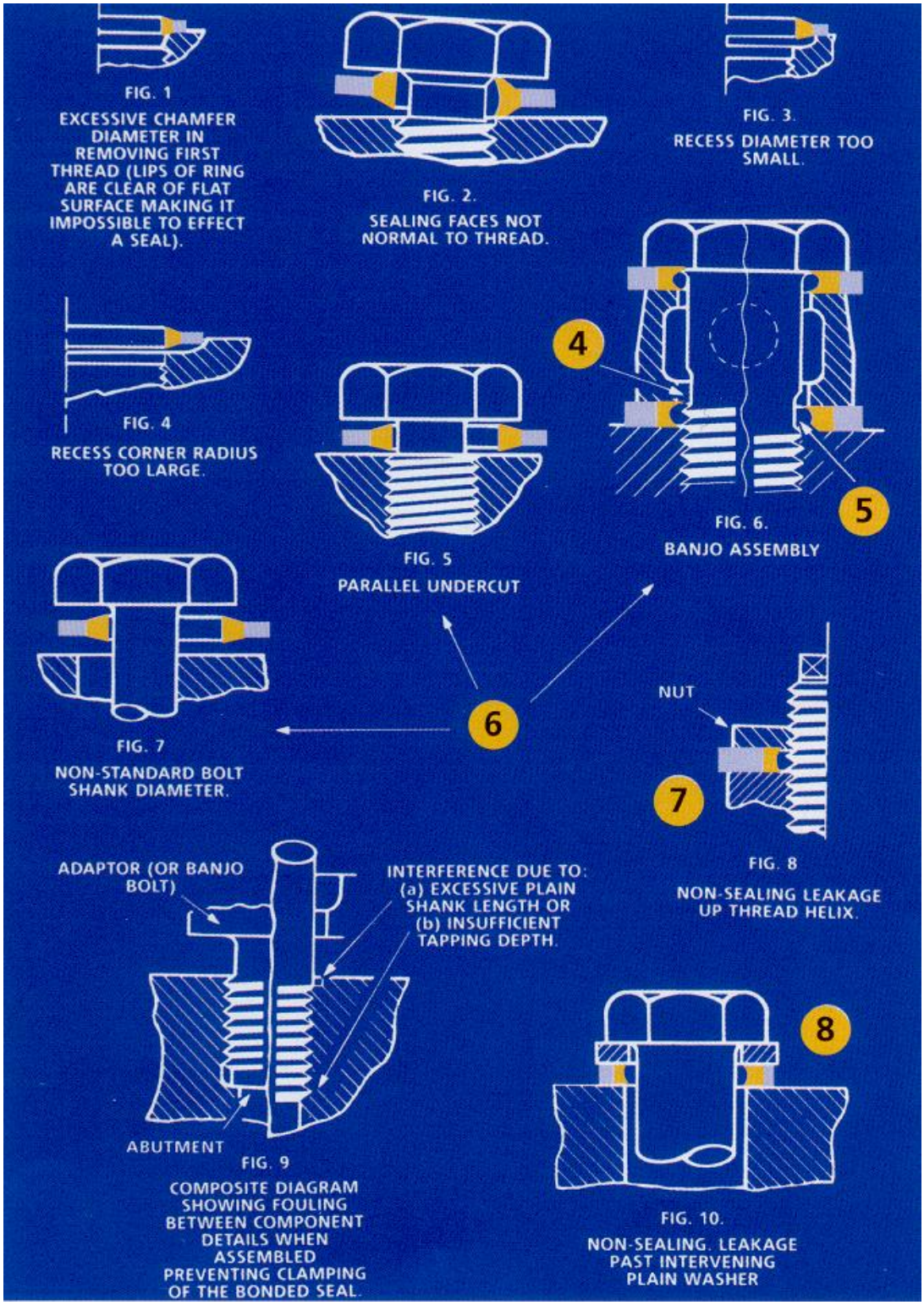
Installations faults



(4) If an undercut is preferred to thread run-out, ensure position is beyond bonded seal as shown thus permitting the thewad to centralise the ring
(5) Avoid having undercut in bolt opposite bonded seal
(6) Figures 5, 6 (in part) and 7 illustrate cases in with (through nonincorporation
on component detalils of mechanical means of centralising) the bonded seal shoulk
be hald central when tightening down to ensure complete circumferential lip contact with the flat surface
(7) In figure 8 or other similar type of assembly, fluid will leak up the thread helic
and past the bonded seal. To obtain a 100% seal the not must be of the cap type
(8) This is incorrect. Fluid will bypass the bonded seal with resultant leakage

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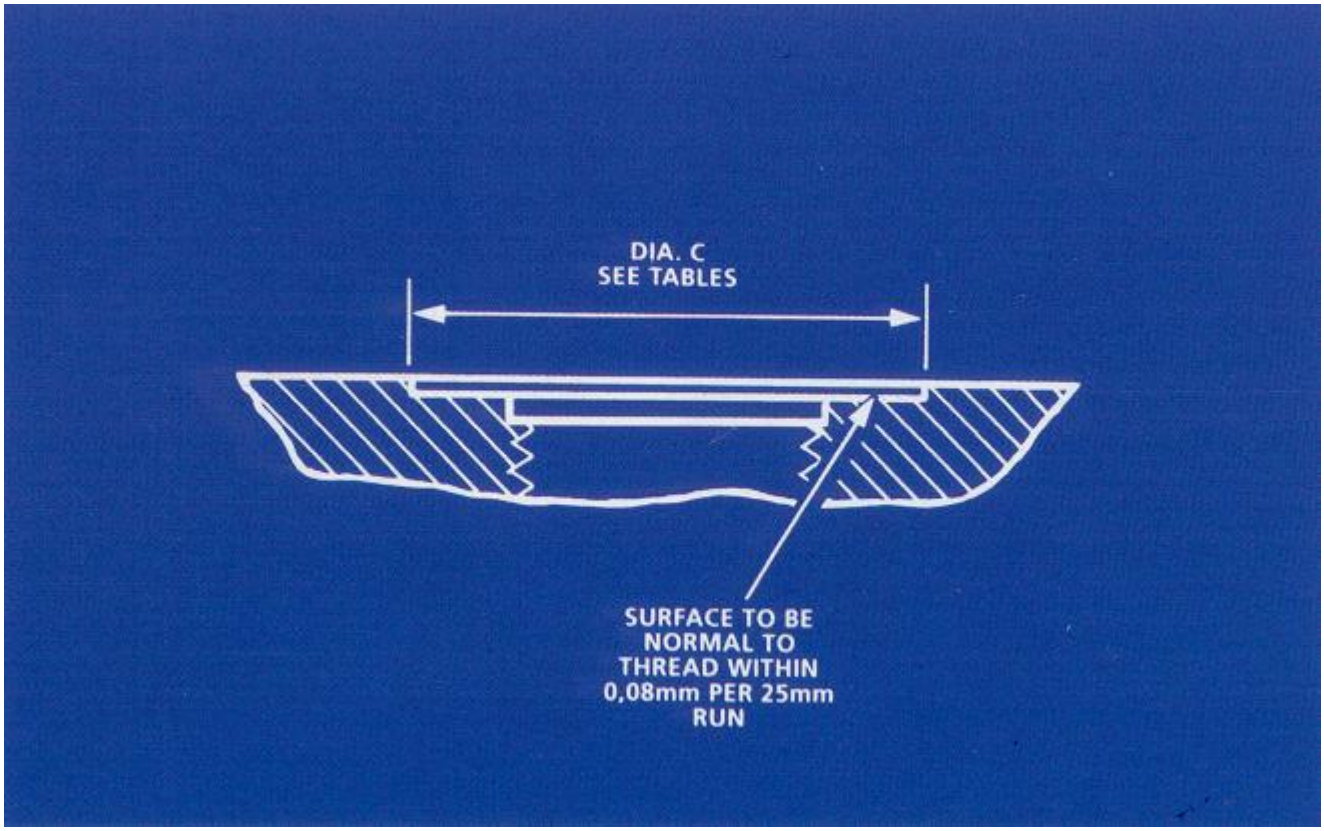
Surface Finish



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Torque Loading

THREAD SIZE			TORQUE REQUIRED (minimum)		FACTOR FOR TANDEM SEALING (eg Banjo Assembly)
Metric	Imperial	BSP	Nm	lbf.in	
Up to 8	5/16		5,3	47	1,6
10	3/8	1/8	7,1	63	
11	7/16		11,8	105	1,3
12	1/2	1/4	15,8	140	
14	9/16	,60x19	22,6	200	
16	5/8	3/8	30,5	270	
18	3/4	,75x14	40,7	360	
20	,823	1/2	56,5	500	1,2
22	7/8	5/8	67,8	600	1,1
24	1		73,4	650	1
27 and above	1,041	3/4	79	700	

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