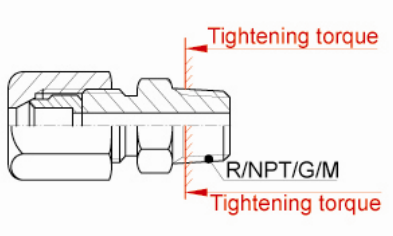
Tightening torque for male threads

For male threads on SERTO unions we recommend specific tightening torques, which can be found in this chart. Please note that these values apply exclusively to the male threads and are not in any way a recommendation for installations on the nut/compression ferrule side of the union. (As a general assembly instruction, we recommend 1 ¾ turns for all unions.)

1. Metal materials (stainless steel, steel, brass)

1.1 Inch threads

Tightening torque in **Nm**	1/8			1/4			3/8			1/2			3/4			1			1 1/4
	Inox	Steel	Brass	Inox	Steel	Brass	Inox	Steel	Brass	Inox	Steel	Brass	Inox	Steel	Brass	Inox	Steel	Brass	Steel
R	18	18	8	35	25	12	45	35	20	60	50	30	110	60	30	180	80		100
NPT	25		15	40		25	55		40	110		80	150		90			110	
G O-ring	20		15	50		35	70		50	100		80	120		90				
G edge seal	30	20	20	70	50	50	100	100	80	150	160	100	180	180		220	240		280



1.2 Metric threads

Tightening torque in **Nm**	M5	M6x0.75	M6	M8x1		M10x1		M12x1.5		M14x1.5		M16x1.5		M18x1.5		M22x1.5		M26x1.5	M33x2
	Brass	Brass	Brass	Inox	Brass	Steel	Brass	Steel	Brass	Steel	Brass	Steel	Brass	Steel	Brass	Steel	Brass	Steel	Steel
M tapered				4	2		5		25		30		50						
M edge seal	4	6	6		9	20	10	25	25	40	30	55	50	80	60	110	80	150	250

2. Non-metal materials (PVDF, PA)

2.1 Inch threads

Tightening torque in **Nm**	1/8		1/4		3/8		1/2	
	PVDF	PA	PVDF	PA	PVDF	PA	PVDF	PA
R	0.5	0.5	2.5	3.5	2.5	3.5	6	8
NPT	1.5	2.0	5	6	5	6		

Tightening torque in **Nm**	1/8		1/4		3/8		1/2	
	PVDF	PA	PVDF	PA	PVDF	PA	PVDF	PA
G O-ring	1.5	1.5	2.5	2.5	6	6	9	9
G edge seal	2	2	3.5		8		12	