Assembly instructions male stud connectors Form A, B and E

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.

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.





Assembly instructions male stud connectors Form A, B and E

| Male | Male stud | d connecto | or to | | | |
|------------|---|------------|-------------------------------|----------|-------------------|----------|
| thread | DIN 3852-1 | | DIN 3852-1 | | ISO 9974-2 | |
| size | | | ISO 9974-3 | | | |
| metric | Form A | | Form B | | Form E | |
| | Sealing ring | | Sealing edge | | PEFLEX seal | |
| | e.g. copper | | | | Standard NBR | |
| | sealing ring Tightening torque Nm –10 % | | | | | |
| | | | Tightening torque Nm –10 % | | Tightening torque | |
| | | | | | | |
| | 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 |

| L | | | | | | | | |
|---|---|--|---|--|--|---|--|--|
| Male | Male stud connector to | | | | | | | |
| thread | DIN 3852-2 | | ISO 1179-4 | | ISO 1179-2 | | | |
| size | | | | | | | | |
| BSPP | Form A | | Form B | | Form E | | | |
| | Sealing ring | | Sealing | | PEFLEX seal | | | |
| | e.g. copper | | edge | | Standard NBR | | | |
| | sealing ring | | Ŭ | | | | | |
| | 0 0 | | | | | | | |
| | Tightening torque | | Tightening torque | | Tightening torque | | | |
| | Nm –10 % | | Nm –10 % | | Nm –10 % | | | |
| | Nm -10 9 | % | Nm -10 9 | % | Nm -10 9 | % | | |
| | Nm –10 Series L | % Series S | Nm –10 ^o Series L | % Series S | Nm –10 9 Series L | % Series S | | |
| G 1/8 A | Nm –10 9 Series L 20 | % Series S 20 | Nm –10 ^o Series L 25 | % Series S | Nm –10 9 Series L 20 | % Series S | | |
| G 1/8 A G 1/4 A | <u>Nm –10 °</u> Series L 20 45 | % Series S 20 45 | <u>Nm –10 °</u> Series L 25 55 | % Series S 95 | Nm –10 9 Series L 20 50 | % Series S 60 | | |
| G 1/8 A G 1/4 A G 3/8 A | Nm -10 ° Series L 20 45 80 | % Series S 20 45 80 | Nm –10 ^o Series L 25 55 95 | % Series S 95 180 | Nm –10 9 Series L 20 50 80 | % Series S 60 90 | | |
| G 1/8 A G 1/4 A G 3/8 A G 1/2 A | Nm -10 9 Series L 20 45 80 90 | % Series S 20 45 80 90 | Nm -10 ° Series L 25 55 95 185 | % Series S 95 180 160 | Nm -10 9 Series L 20 50 80 100 | % Series S 60 90 150 | | |
| G 1/8 A G 1/4 A G 3/8 A G 1/2 A G 3/4 A | Nm -10 ° Series L 20 45 80 90 220 | Series S 20 45 80 90 220 | Nm -10 ° Series L 25 55 95 185 250 | % Series S 95 180 160 350 | Nm -10 9 Series L 20 50 80 100 180 | % Series S 60 90 150 200 | | |
| G 1/8 A G 1/4 A G 3/8 A G 1/2 A G 3/4 A G 1 A | Nm -10 Series L 20 45 80 90 220 350 | % Series S 20 45 80 90 220 350 | Nm -10 ° Series L 25 55 95 185 250 400 | % Series S 95 180 160 350 700 | Nm -10 9 Series L 20 50 80 100 180 230 | % Series S 60 90 150 200 250 | | |
| G 1/8 A G 1/4 A G 3/8 A G 1/2 A G 3/4 A G 1 A G 1 1/4 A | Nm -10 ° Series L 20 45 80 90 220 350 400 | % Series S 20 45 80 90 220 350 400 | Nm -10 ⁶ Series L 25 55 95 185 250 400 670 | % Series S 95 180 160 350 700 850 | Nm -10 9 Series L 20 50 80 100 180 230 330 | % Series S 60 90 150 200 250 500 | | |

