

STEEL PIPE FITTINGS (SPIPE)

Applications:

Water, Oil, Air. Pipe threads must be sealed using approved thread sealant.

Working Temperature:

-65°F (-54°C) to 250°F (120°C)

Assembly:

1. Inspect port and fitting to ensure that both are free of contaminants and excessive burrs and nicks.
2. Apply a stripe of an anaerobic liquid pipe sealant around the male threads leaving the first two threads uncovered. If no liquid sealant is available, wrap Teflon tape 1 1/2 to 2 turns in a clockwise direction, viewed from the pipe end, leaving the first two threads uncovered.
3. Screw finger-tight into the port.
4. Wrench-tighten the fitting to the correct Turns Past Finger Tight position. When installing elbows or tees, consider final orientation position as to not exceed the recommended TPFT. A properly assembled fitting's total thread engagement should be 3.5-6 turns.

CAUTION: Sealant tape and some pipe sealants are destructive to hydraulic components. Always use extreme caution and follow manufacturer's recommendations for proper application of any sealant in order to prevent contamination.

CAUTION: Never back off an installed pipe fitting to achieve proper alignment. Loosening installed pipe fittings will corrupt the seal and contribute to leakage and failure.

Dash Size NPSM Thread Size (Inches) Turns Past Finger-Tight

Dash Size	NPSM Thread Size (Inches)	Turns Past Finger-Tight
-1	1/16-27	1.5 - 3.0
-A	1/8-27	1.5 - 3.0
-B	1/4-18	1.5 - 3.0
-C	3/8-18	1.5 - 3.0
-D	1/2-14	1.5 - 3.0
-E	3/4-14	1.5 - 3.0
-H	1-11 1/2	1 - 2.5
-J	1 1/4-11 1/2	1 - 2.5
-K	1 1/2-11 1/2	1 - 2.5
-M	2-11 1/2	1 - 2.5

