



ACS Hydraulics Pvt. Ltd.

Recommended Fitting And Adapter Installation Torque

SAE J514 37° Flare (JIC)

Dash Size	SIZE	LB.FT		N.M	
	IN	MIN	MAX	MIN	MAX
-4	1/4	11	12	15	16
-5	5/16	14	15	19	21
-6	3/8	18	20	24	28
-8	1/2	36	39	49	53
-10	5/8	57	63	77	85
-12	3/4	79	88	107	119
-16	1	108	113	147	140
-20	1 1/4	127	133	172	181
-24	1 1/2	158	167	215	226
-32	2	245	258	332	350

BSPP

Dash Size	(In)	Lb. ft.	N.m
-2	1/8	15	20
-4	1/4	19	25
-6	3/8	36	49
-8	1/2	44	60
-12	3/4	87	118
-16	1	100	137
-20	1 1/4	123	167
-24	1 1/2	151	206

SAE J1453 O' Ring Face Seal

Dash Size	SIZE	LB.FT		N.M	
	(In)	Min	Max	Min	Max
-4	1/4	10	12	14	16
-6	3/8	18	20	24	27
-8	1/2	32	35	43	47
-10	5/8	46	50	60	68
-12	3/4	65	70	90	95
-14	7/8	65	70	90	95
-16	1	92	100	125	135
-20	1 1/4	125	140	170	190
-24	1 1/2	150	165	200	225

JIS (B8363)

Dash Size	(In)	Lb. ft.	N.m
-4	1/4	19	25
-6	3/8	36	49
-8	1/2	43	59
-10	5/8	87	118
-12	3/4	87	118
-16	1	100	137
-20	1 1/4	123	167
-24	1 1/2	151	206
-32	2	180	245

SAE J518 Code 61 (3000 psi) - Flange Half Bolt

Dash Size	SIZE	LB.FT		N.M	
	(In)	Min	Max	Min	Max
8	1/2	15	19	20	25
-12	3/4	21	29	28	40
-16	1	27	35	37	48
-20	1 1/4	35	46	48	62
-24	1 1/2	46	58	62	79
-32	2	54	66	73	90
-40	2 1/2	79	91	107	124
-48	3	137	149	186	203

METRIC

Thread mm	Lb. ft.	N.m
M12 x 1.5	15	15
M14 x 1.5	19	25
M16 x 1.5	33	45
M18 x 1.5	37	50
M20 x 1.5	52	70
M22 x 1.5	55	75
M24 x 1.5	74	100
M26 x 1.5	81	110
M30 x 2	96	160
M36 x 2	162	220
M42 x 2	170	230
M45 x 2	220	300
M52 x 2	367	500

SAE J518 Code 62 (6000 psi) - Flange Half Bolt

Dash Size	SIZE	LB.FT		N.M	
	(In)	Min	Max	Min	Max
8	1/2	15	19	20	25
-12	3/4	21	29	28	40
-16	1	27	35	37	48
-20	1 1/4	35	46	48	62
-24	1 1/2	46	58	62	79
-32	2	54	66	73	90