

# Engineering Specification PS-115

## Torque For 9/16 Hex Brass Seal Caps on 1/4 Flare Fittings

**PURPOSE:**

Provide a specification that addresses torque requirements for seating 9/16 hex brass seal caps.

**SCOPE:**

This specification applies to 9/16 hex brass seal caps used on S.A.E. type steel or brass flare fittings, either standard drilled or tapped valve core type\*\* through hole and assures refrigerant tight seals\* when properly followed.

**USE:**

Temperature Range:	-40°F to 300°F
Service Pressure:	700 psig Max.
Burst Pressure:	3500 psig Min.

**Torque Recommendations for 9/16 Hex Brass Seal Caps**

Description & Part No.	Flare Type	Material	Torque Seating Values
9/16 Hex Brass Part Number : B16780	Standard Drilled thru Hole	Steel	8 - 12 Ft.-Lbs.
	Tapped for Valve Core	Steel	8 - 12 Ft.-Lbs.
	Standard Drilled Thru Hole	Brass	3 - 5 Ft.-Lbs.
	Tapped for Valve Core	Brass	Not Recommended
9/16 Hex Brass 50541 Part Number: Annealed B16780	Standard Drilled Thru Hole	Steel	5 - 8 Ft.-Lbs.
	Tapped for Valve Core	Steel	5 - 8 Ft.-Lbs.
	Standard Drilled Thru Hole	Brass	3 - 5 Ft.-Lbs.
	Tapped For Valve Core	Brass	Not Recommended
9/16 Hex Brass 80050 Part Number: B16780 W / 80049 Copper Gasket	Standard Drilled Thru Hole	Steel	10 - 14 Ft.-Lbs.
	Tapped for Valve Core	Steel	10 - 14 Ft.-Lbs.
	Standard Drilled Thru Hole	Brass	5 - 8 Ft.-Lbs.
	Tapped for Valve Core	Brass	Not Recommended

**ASSEMBLY NOTES:**

Apply a small coating of refrigerant oil to the flare connector seal face or to the inside of the seal cap sealing surface prior to assembly of and applying torque to any brass seal cap.

\*\* It is not recommended to repeatedly loosen and re-tighten brass seal caps on any valve core flare fittings due to possible "cave in" of hole I.D., resulting in valve core installation and removal difficulties.

\*\* As a general suggestion, it is not recommended to use brass seal caps on brass valve core fittings due to increased possibility of hole "cave in" and resulting difficulties

\*Leak test per Electronic Leak Test, specification PS-105

<p><b>Specification Number:</b> <b>PS- 115</b> (Doc. Control # CDP-047)</p> <p><b>Revision:</b> <b>B</b> (09/11)</p> <p><i>Torque Specifications for 9/16 Hex Brass Seal Caps on 1/4 Flare Fittings</i></p>	 <p><b>Automatic</b> MACHINE PRODUCTS</p> <p>Taunton, MA</p>
---	--

This document is the property of Automatic Machine Products Co. and contains proprietary and confidential information in general and in detail. It shall not be copied or duplicated or its contents revealed to others without the written consent of Automatic Machine Products Co. It is subject to prompt return upon demand.