

Engineering Specification PS-116

Torque For Steel Stem Caps W/Copper Gasket

Purpose:

Provide a specification that addresses torque requirements for steel stem caps with copper gasket installed to insure a refrigerant tight seal.*

Scope:

This specification extends to steel shutoff valves, both o-ring and compression packed type, using steel stem caps with copper gasket installed.

Use:


Temperature Range:	-40°F to + 250°F
Service Pressure:	700 psig Max.
Burst Pressure:	2500 psig Min.

Steel Stem Cap W/Gasket Torque Requirements

Assembly Part Number	Valve Body Size and Shape	Seating Torque
23236-7	3/4 Hex or Square	30 to 35 Ft.-Lbs.
23236-7	7/8 Hex or Square	30 to 35 Ft.-Lbs.
22399-7	1-1/8 Square	30 to 35 Ft.-Lbs.
23053-5	1-3/8 Square	40 to 50 Ft.-Lbs.
12086-0	1-3/4 Square	50 to 60 Ft.-Lbs.

Notes:

1. Prior to applying recommended torque to steel stem cap, apply a small amount of refrigeration oil to the threads and seal face surface to ensure a refrigerant tight seal.*
2. *Leak test per Electronic Leak Test, specification PS-105

<p>Specification Number: PS- 116 (Doc. Control # CDP-048)</p> <p>Revision: C (09/11)</p> <p><i>Torque Specifications for Steel Stem Caps with Copper Gaskets</i></p>	 <p>Automatic MACHINE PRODUCTS</p> <p>Taunton, MA</p>
<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.</p>	