

Engineering Specification PS-117

Torque For Aluminium Hex Seal Cap

PURPOSE:

Provide a specification that addresses torque requirements for aluminium hex seal cap when a refrigerant tight seal* is required.

SCOPE:

This specification applies to 9/16 aluminium hex seal cap (Part Number: 23692) when assembled on SAE steel 1/4 flare fittings of both standard drilled through hole or valve core type.

USE:

Temperature Range:	-40°F to + 300°F
Service Pressure:	700 psig Max.
Burst Pressure:	2500 psig Min.

Aluminium Hex Seal Cap Torque Requirements

1/4 Flare Material	Seating Torque
Steel	6 to 8 Ft.-Lbs.

NOTES

1. Prior to applying recommended torque to an aluminium stem cap, apply a small amount of refrigeration oil to threads and seal face surface to ensure a refrigerant tight seal*.
2. It is not recommended to repeatedly loosen and re-tighten aluminium seal caps on valve core flare fittings due to the potential cave in of hole I.D., resulting in valve core installation and removal difficulties.
3. *Leak test per Electronic Leak Test, specification PS-105.

Specification Number:

PS- 117 (Doc. Control # CDP-049)

Revision:

B (09/11)

*Torque Specifications for 9/16 Aluminium Seal
Caps on 1/4 Flare Fittings*

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