

Engineering Specification PS-127

Torque For 7/8 Hex Brass Stem Cap

Purpose:

Provide a specification that addresses torque requirements for 7/8 hex brass stem cap (P/N's B90403 & B90407) when assembled on shutoff valves requiring a refrigerant tight seal*.

Scope:

This specification extends to 7/8 hex brass stem caps (P/N B90403 & B90407) when assembled on brass packed shutoff valves. This specification covers the application listed in the chart below:

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

Torque Recommendations:

Cap P/N	Body Size & Shape	Recommended Seating Torque
B90403	3/4 Hex or Sq.	20 to 24 Ft.-Lbs.
B90403	7/8 Hex or Sq.	20 to 24 Ft.-Lbs.
B90407	1 Inch Sq.	20 to 24 Ft.-Lbs.
B90407	1 1/8 Sq.	20 to 24 Ft.-Lbs.

Notes:

Prior to applying recommended torque to 7/8 hex brass stem caps, apply a small amount of refrigeration oil to threads and seal face surface to ensure a refrigerant tight seal* and to aid in assembling cap.

2. *Leak test per Electronic Leak Test, specification PS-105.

Specification Number:

PS- 127 (Doc. Control # CDP-059)

Torque Specification for 7/8 Hex Brass Stem Caps

Revision:

B (09/11)

**Automatic**
MACHINE PRODUCTS

Taunton, MA

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.