

# Engineering Specification PS-130

## Torque For Machined Hex Brass Stem Cap W/ Nylon Gasket

**Purpose:**

Provide a specification that addresses torque requirements for machined hex brass stem caps with nylon gaskets assembled on shutoff valves requiring a refrigerant tight seal.\*

**Scope:**

This specification extends to machined hex brass stem cap with nylon gaskets when assembled on brass o-ring style shutoff valves. This specification covers the application listed in the chart below:

Temperature Range:	-40°F to +200°F
Service Pressure:	700 psig Max.
Burst Pressure:	2500 psig Min.


**Torque Recommendations:**

Cap P/N & Size	Nylon Gasket P/N	Body Size & Shape	Recommended Seating Torque
B80163 (3/4" Hex)	80203	11/16" Sq. or 3/4" Hex	8 to 10 Ft. - Lbs.
B80165 (7/8" Hex)	80205	7/8" Sq.	12 to 15 Ft. - Lbs.
B80166 (1" Hex)	80206	1" Sq.	12 to 15 Ft. - Lbs.
B80167 (1 3/16" Hex)	80207	1 1/8" Sq.	15 to 20 Ft. - Lbs.

**Notes:**

1. Prior to applying recommended torque to machined hex brass stem caps with nylon gaskets, 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

<p><b>Specification Number:</b> <b>PS- 130</b> (Doc. Control # CDP-063)</p> <p><b>Revision:</b> <b>B</b> (09/11)</p> <p><i>Torque Specifications for machined Hex Brass Stem Cap w/ Nylon Gasket</i></p>	 <p><b>Automatic</b> MACHINE PRODUCTS</p> <p>Taunton, MA</p>
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