

Engineering Specification PS-134

Torque For Rotary-Lock (R/L) Seal Cap and Seal Plug with Gasket

Purpose:

Provide a specification that addresses torque requirements for R/L seal caps and seal plugs with gaskets, requiring a refrigerant tight seal*.

Scope:

This specification extends to R/L seal caps and plugs with gaskets when assembled on steel or brass shutoff valves and adapters. This specification covers the application listed in the chart below:


Temperature Range:	-40°F to +150°F
Service Pressure:	300 psig
Burst Pressure:	2500 psig

Torque Recommendations:

R/L Thread Size	Seal Cap	Seal Plug	Gasket	Teflon Seal**	Recommended Seating Torque
3/4" - 16**	1016	24874	1001	24590	20 Ft. -Lbs.
1" - 14	24239	27498	22541	24591	40 Ft. -Lbs.
1 1/4" - 12	24240	27499	22770	24592	30 Ft. -Lbs.
1 3/4" - 12	24238	16290	24317	24593	40 Ft. -Lbs.

Torque Recommendations:

1. Prior to applying recommended torque to either seal cap or seal plug, apply refrigeration oil to gasket, as a lubricant to insure a refrigerant tight seal*.
- 2.** Shutoff valves and adapters with 3/4 - 16 thread sizes assembled with a seal cap or seal plug are required to have a Teflon seal installed prior to assembly. It is recommended a Teflon seal be installed for other sizes as well.
3. *Leak test per Electronic Leak Test, specification PS-105.

<p>Specification Number: PS- 134 (Doc. Control # CDP-066)</p> <p>Revision: C (09/11)</p> <p><i>Torque Specification for Rotary-Lock Seal Caps and Seal Plugs with Gaskets</i></p>	 <p>Automatic MACHINE PRODUCTS</p> <p>Taunton, MA</p>
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