

# Engineering Specification PS-136

## Torque and Mounting Recommendations For Steel Base Valves and Adapters

**Purpose:**

Provide a specification that addresses mounting and torque requirements for steel base shutoff valves and adapters.

**Scope:**


This specification extends to hole size and shape, bolt thread size, and provides assembly data that may be utilized when mounting base valves or adapters to base plates or panels.

**Recommended Torque and Mounting Data:**

Valve Body Size & Shape	Hole/Coin Size and Shape	Bolt Thread Size	Length of Thread Engagement	Recommended Torque*
3/4 Hex & Square	7/16 Square	5/16 – 24	5/16	14 - 18 Ft. - Lbs.
7/8 Hex & Square	7/16 Square	5/16 – 24	5/16	14 - 18 Ft. - Lbs.
1 1/8 Square	5/8 Square	3/8 – 24	3/8	25 - 30 Ft. - Lbs.
3/4 Hex & Square	7/16 Square	1/4 – 20	5/16	8 - 10 Ft. - Lbs.
7/8 Hex & Square	7/16 Square	1/4 – 20	5/16	8 - 10 Ft. - Lbs.

**Notes:**

1. It is important to select mounting bolts with ample thread relief under bolt head to avoid interference between incomplete last thread of bolt and lead thread in valve.
2. \*Grade, length and size of mounting bolt will have a definite influence on the ultimate torque strength of threads.
3. Applications other than those listed in the above chart will require comprehensive testing.

<p>Specification Number: <b>PS- 136</b> (Doc. Control # CDP-068)</p> <p>Revision: <b>B</b> (09/11)</p> <p><i>Torque and Mounting Recommendations for Steel Base Valves and Adapters</i></p>	 <p><b>Automatic</b> 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>	