

Engineering Specification PS-138

Torque For Brass Flare Nut Used On Brass Fittings and Single Flared Copper Tubes

Purpose:

Provide a specification that addresses torque requirements for brass shutoff valves that utilize brass flare nuts on standard flare fittings or a combination of flare/sweat fittings requiring a refrigerant tight seal.

Scope:

This specification extends to brass flare nuts when used on brass fittings with single flared copper tubing. This specification covers applicable flare size and recommended torque as shown in chart below:

| Brass Flare Size | Recommended Seating Torque for Brass Flare Nuts |
|------------------|---|
| 1/4 | 8 - 10 Ft. - Lbs. |
| 3/8 | 15 - 18 Ft. - Lbs. |
| 1/2 | 28 - 32 Ft. - Lbs. |
| 5/8 | 38 - 42 Ft. - Lbs. |
| 3/4 | 50 - 55 Ft. - Lbs. |

Notes:

1. Prior to applying recommended torque to brass flare nut, it is highly recommended a small amount of refrigeration oil be applied to the flare threads, flare sealing surface, and copper tubing flared surface to prevent galling of sealing surfaces and aid in providing a refrigerant tight seal.

Specification Number:

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Revision:

B (09/11)

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