

Standard tightening torque values for RAC tubing flared connection

Flare size Nominal outside diameter (according to EN12735-1 & 2)			Minimum wall thickness (mm)	Tightening torque (Nm)
Metric series (mm)	Imperial series			
	(mm)	(inch)		
6			0,8	14 to 18
	6,35	¼	0,8	14 to 18
	7,94	5/16	0,8	33 to 42
8			0,8	33 to 42
	9,52	¾	0,8	33 to 42
10			0,8	33 to 42
12			0,8	50 to 62
	12,7	½	0,8	50 to 62
15			0,8	63 to 77
	15,88	5/8	0,95	63 to 77
18			1,00	90 to 110
	19,06	¾	1,00	90 to 110

NOTE: When making flared joints, care should be taken to ensure that the flare is of the correct size and the torque used to tighten the nut is not excessive. The use of a torque wrench (in combination with an additional adjustable wrench) is mandatory (see also Module "N" figure 84 and 85) Care should be taken not to flare piping that has been work hardened.