

## Threads Assembling Guidance

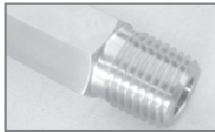
### 1. FITOK thread features

FITOK thread fittings are organized by piping taped thread (NPT, RT) and straight threads (RS,RP, ST, MS, BP, RG). Always use a pipe thread sealant, tape, O ring and gasket to seal.

### 2. Pipe taped male fitting

Pipe taped male fitting always need to use PTFE or thread sealant, and follow the torque to install, the steps by following:

a: clean the inner and outer thread, to make sure clean the dirt or small piece of tape.



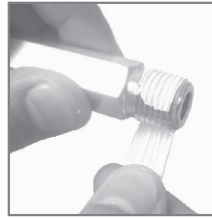
Right



Wrong

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Valves and Fittings

b: from the first round, PTFE should follow the thread direction.



(please following the form on rounding number)

c: make sure the seal PTFE tape is not over the first round, to avoid the broken PTFE into the fluid system.



Right



Wrong

d: cut the extra PTFE tape, and tight the free side with the thread.



e: use hand the assemble the thread at first, then use torque wrench to tight, keep the right direction, to avoid damage the thread (following the torque form below).

f: cut the extra PTFE.

### 3. O ring seal fitting

- 3.1 use finger to assemble the male fitting into female one;
- 3.2 use wrench to tight slowly;
- 3.3: check the O ring, if find any damage, change a new one

### 4. Gasket-Sealing Thread Connectors

4.1 Put the gasket on the bottom of Female-thread or top of Male-thread. (In order to avoid the gasket stuck in the threads, the gasket should put face to the surface, no lean.).

4.2 Screw the Male-thread to the Female-thread and tight by fingers.

4.3 Use the torque wrench tight the the threads, torque strength should follow the catalogue of the gaskets. (Torque strength please refer to the catalogue page Threads torque date sheets).

4.4 Gaskets should change when reinstallation.

### Inspection

1. After the thread connector installed, Helium leak should be take on.
2. The Max leakage range is  $4 \times 10^{-9}$  std  $\text{cm}^3/\text{s}$ .

### Warning

1. Do not untight the nuts, when systems pressure still exists.
2. In order to avoid and leakage or threads stuck, customers must strictly follow the installation instructions to install.
3. Sealant always proper used on taper threads.
4. No experience of installation training person must not instal.

## Appendix

Appendix 1: Corresponding times of turning for Sealing-tape.

Tapered Threads Size	Minimal Sealing-tape turning times
1/16, 1/8	4-5
1/4, 3/8	5-8
1/2, 3/4	8-12
1	12-16
More than 1 Inch	16 or more

Appendix 2: Tapered Threads Torque strength date sheet.

Tapered Threads Size	Max Installation strength (N · m)	Initial Installation strength (N · m)
1/8	8	17
1/4	14	28
3/8	20	51
1/2	35	90
3/4	40	113
1	50	137
1-1/4	60	164
1-1/2	65	175
2	70	186

Appendix 3: Different type gaskets paralld threads Torque strength date sheet.

Gasket Type	Torque strength (N · m)	This table only listed some of Gasket sale paralld threads adapters, This sheet is for reference only. In order to achieve the desired Sealing effect, the installation should be based on the actual installation of the connector standard size, working pressure, Gasket material, working temperature and specific media etc.
CSF-R54	10	
CSF-R58	10	
SSP-R54	25	
SSP-R58	25	
CU-RP6	150	
CU-RP8	150	
CU-RG4	25	
CU-RG8	100	

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