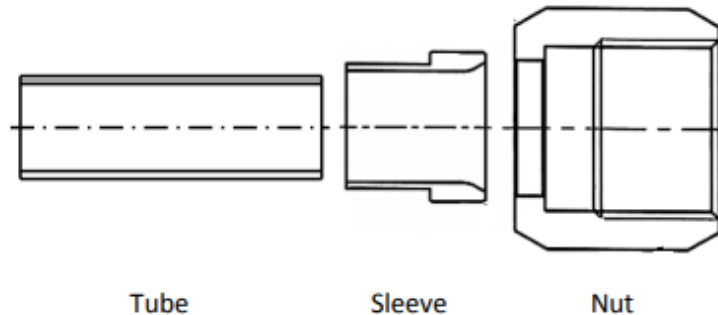


How do you tighten a JIC fitting?

For JIC flare fittings, it is important to assemble the fittings within the designed torque values to be able to achieve the designed pressure as per SAE J514 standards. Under torque and over torque will result in design pressure loss.



Connection Tube and JIC Fitting

Step 1: Check on possible **contamination** or damage on fitting surface and **sealing surface**. Cut the tube according to the length required and flare the tube head to a 37-degree before installation.

Step 2: Apply **lubricant** such as hydraulic fluid onto the threads and the whole surface of the flare.

Step 3: **Insert the nut and sleeve** onto the tube end connection. Align components for hand tightening and turn the flare nut until sealing surface is fully contacted.

Step 4: Check the **tighten torque** value and ensure the sealing is connected as per standard requirement. The fittings and tubing connection shall be carried out without external loads. **Over tightening** may cause deformation of 37-degree flared of the male thread end connection. **Excessive deformation** of the flare will cause in loss of clamping force and hence sealing loss.

*Note: The fittings and tubing connection shall be carried out without external loads. **Over tightening** may cause deformation of 37-degree flared of the male thread end connection. **Excessive deformation** of the flare will cause in loss of clamping force and hence sealing loss.*

Please refer to the table below for JIC's torque assembly pressure:

Tube OD (metric size)	Tube OD (Inch size)	Assembly Torque (Nm)	
		Steel & SS316 Material	Over Torque (Nm) Steel & SS316 Material
6	1/4	15-16	24
8	5/16	19-21	31
10	3/8	24-28	42
12	1/2	49-53	80
16	5/8	77-85	114
20	3/4	107-119	160
25	1	147-154	214
32	1 1/4	172-181	271
38	1 1/2	215-226	339
50	2	332-350	497

Chuan Kok Hardware & Machinery Pte Ltd

Address: 1783 Geylang Bahru #01-02, Kallang Distripark Singapore 339708

Telephone Number: +65 6294 2566

Fax Number: +65 6295 7013

Email Address: info@chuankok.com

Website: www.chuankok.com

Business Registration Number: 198201577Z

Country of Registration: Singapore

Conditions of Use of Catalogue:

The information in the catalogue are not binding and in order to improve distribution, Chuan Kok Hardware & Machinery Pte Ltd reserves the right to make any change including size and pressure ratings considered necessary at any time and without prior notice.

According to the copyright and the civil law, any reproduction (also partial) of figures and texts of this catalogue by means of electronic, mechanical, photocopies, microfilms, recordings or other is forbidden without Chuan Kok Hardware & Machinery Pte Ltd's authorization.

Catalogue Version: 2005