

Parallel Threaded Fittings Installation Instructions

1. Clean And Inspect

Before installation, the threads and o-ring should be inspected. The threads should be clean and burr-free. The o-ring should not be nicked or cut. Such damage could cause the o-ring to fail during use. If the o-ring is suspect, cut it off, being careful not to nick the threads or fitting body. Then, carefully roll the new o-ring over the threads. Inspect it to be sure no damage occurred during replacement.



2. Lubricate

The threads should be lubricated to minimize the chance of galling. Use a small sample of hydraulic system fluid into which the fitting will be installed.



3. Manual Threading

Carefully hand thread the fitting into the port. For straight fittings, turn until the o-ring is completely in the recess and the retaining hex shoulder is in contact with the top of the port.

For adjustable fittings with back-up washers and lock nuts, be certain that the lock nut and washer are all the way back against the beginning of the thread, farthest from the end of the fitting.



4. Alignment (Shapes Only)

Unscrew the fitting up to one turn to align it in the desired final direction. Hold the fitting body secure with a wrench, and with another wrench, firmly seat the back-up washer and locknut snugly against the port.



5. Final Assembly

To "snug up" the assembly, turned the number of hex flats indicated in the following table.



Fitting Size	SAE Thread Size	Hex Flats
2	5/16 - 24	1.5
3	3/8 - 24	1.5
4	7/16 - 20	1.5
5	1/2 - 20	1.5
6	9/16 - 18	1.5
8	3/4 - 16	1.5
10	7/8 - 14	1.5
12	1 1/16 - 12	1.5
14	1 3/16 - 12	1.5
16	1 5/16 - 12	1.5
20	1 5/8 - 12	2.0
24	1 7/8 - 12	2.0
32	2 1/2 - 12	2.0