

Threaded Fitting Installation Guide

Use of Teflon tape is recommended on all plastic pipe threads wrapped 2 to 3 turns around the male thread before assembly.

A simple rule of thumb for installing tapered pipe threads, both metal and plastic, is finger tight plus one to two turns with a wrench. Torque installation values can be determined per application, but due to the variations involved in pipe joints such as dissimilar materials of male and female threads, and internal variations in product wall thickness, a standard torque specification cannot be generically applied. The table below shows the distances and number of turns called for in the standard. A tolerance of plus or minus one turn is allowed, and in practice threads are often routinely cut shorter than the standard specifies. All dimensions are in inches.

American Standard Taper Pipe External Thread

Nominal Size	Actual OD	Threads per Inch	Length of engagement (hand tight)	Effective Thread Length
1/8	0.407	27	0.124 = 3.3 turns	0.260
1/4	0.546	18	0.172 = 3.1 turns	0.401
3/8	.681	18	0.184 = 3.3 turns	0.408
1/2	.850	14	0.248 = 3.4 turns	0.534

Maximum Torque Values

1/8" – 1/4" Thread	3/8" – 1/2" Thread
1.0 ft lbs	2.2 ft lbs
1.5 Nm	3.0 Nm

Over-tightening will cause undue stress and eventual failure. Inspect for leaks after assembly.