



TIGHTENING TORQUE MOMENTS-700 SERIES*

Peripheral Actuator Screws:

Actuator Size	Thread size	Recommended tightening torque [Nm]
2"-3"	M8	20
4"	M10	30
6"-12"	M12	70
16"	M16	120

Actuator Assembly Nuts:

Actuator Size	Thread size	Recommended tightening torque [Nm]
2"	M8	20
3"-4"	7/16" UNC	40
6"-8"	9/16" UNC	75
10"-12"	5/8" UNC	90
16"	1" UNC	180

TIGHTENING TORQUE MOMENTS-400 SERIES*

Valve size	Thread size	Recommended tightening torque [Nm]
2"-2.1/2"	3/8" UNC	18
3"-4"	7/16" UNC	22
6"	5/8" UNC	80
8"-12"	1" UNC	160

*- Refers to tightening with lubricant.

Written by Ohad G.
Product Engineer
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