



# Technical Bulletin

## Proper Installation of O-Ring Straight Thread and SAE (JIC) 37° Flare Fittings and Hoses

This sheet describes procedures to properly install O-Ring straight thread fittings and SAE (JIC) 37° flare fittings and hoses.

- 1 Make sure the threads of all mating components are clean and lightly lubricated with hydraulic oil.
- 2 Thread the components together until finger tight.
- 3 **O-Ring Straight Thread Fittings** –
  - **Straight Fittings** – Tighten the fitting until the nut contacts the port face surface.
  - **45/90° Fittings** – Tighten the fitting until the backup washer contacts the port face surface. Position the fitting by turning out (counterclockwise) up to one turn. Hold the body of the fitting while tightening the locknut until the backup washer contacts the port face surface.

**SAE (JIC) 37° Flare Fittings and Hose Ends** – Use one of the following methods.

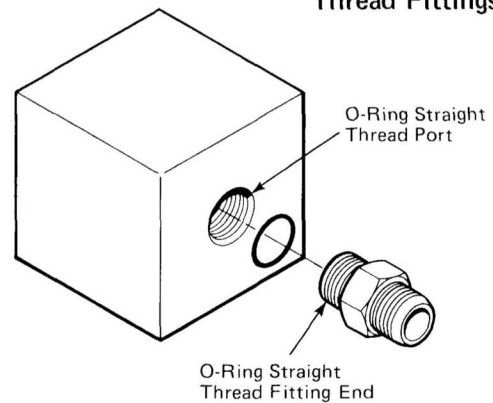
- **Tightening to a torque value** – Tighten the fitting/hose end using the installation torque specifications shown in the chart below. Use a wrench on the hose end body to stop hose rotation while tightening the hose end swivel nut.
- **Tightening using the rotate number of hex flats method** – Make a mark lengthwise on the hose end swivel nut and fitting using a wax pencil or permanent marker. Tighten the fitting/hose end using the rotate number of hex flats specifications shown in the chart below. Use a wrench on the hose end body to stop hose rotation while tighten.

Hose End/ Fitting Size	Installation Torque (in.-lbs.)	Rotate Number of Hex Flats
No. 4	70	2-1/2
No. 6	100	2
No. 8	200	2
No. 10	300	1-1/2 to 2
No. 12	500	1
No. 16	700	3/4 to 1

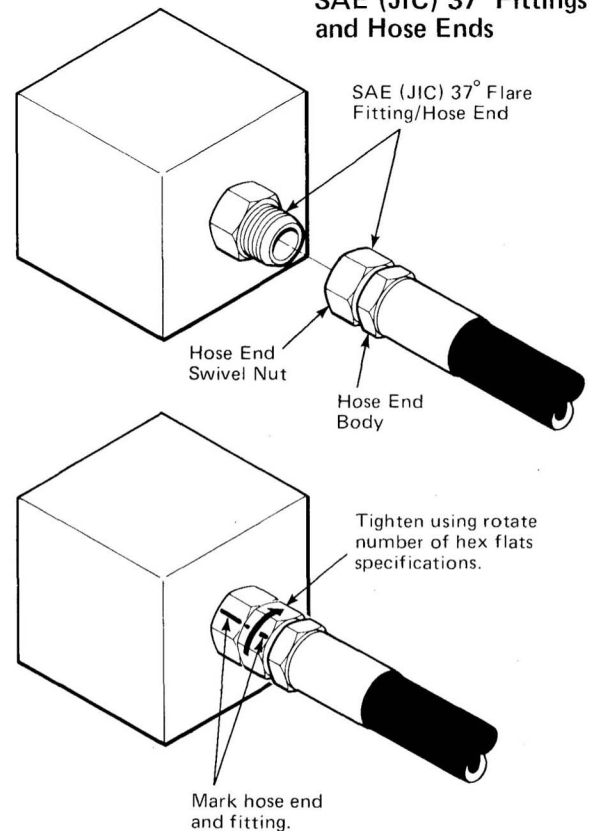
**NOTE:** This information should not be interpreted as the basis for warranty claims unless so designated.

Part No. 204170

O-Ring Straight Thread Fittings



SAE (JIC) 37° Fittings and Hose Ends



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