



Recommended Tightening Torques for PMA Connectors



Tightening torques for PMA polyamide thread fittings to threaded holes or with lock nuts

Metric polyamide thread size	Torque [Nm]	NPT polyamide thread size	Torque [Nm]
M12	1.5	NPT 1/2	4.0
M16	3.0	NPT 3/4	6.0
M20	4.0	NPT 1"	8.0
M25	6.0	NPT 1 1/4	9.0
M32	8.0	NPT 1 1/2	15.0
M40	9.0	NPT 2"	15.0
M50	10.0		
M63	10.0		
			
PG polyamide thread size	Torque [Nm]		
PG07	1.5		
PG09	1.5		
PG11	2.0		
PG13,5	2.5		
PG16	4.0		
PG21	5.0		
PG29	9.0		
PG36	15.0		
PG48	15.0		
			
UNEF polyamide thread size	Torque [Nm]		
1/2-28 UNEF	2.0		
9/16-24 UNEF	3.0		
5/8-24 UNEF	3.0		
11/16-24 UNEF	3.0		
3/4-20 UNEF	4.0		
13/16-20 UNEF	4.0		
7/8-20 UNEF	8.0		
15/16-20 UNEF	8.0		
1-20 UNEF	8.0		
1 1/16-18 UNEF	10.0		
1 3/16-18 UNEF	10.0		
1 1/4-18 UNEF	10.0		
1 5/16-18 UNEF	10.0		
1 3/8-18 UNEF	10.0		
1 7/16-18 UNEF	15.0		
1 5/8-18 UNEF	15.0		
1 3/4-18 UNS	15.0		
2-18 UNS	15.0		
			

Please note: These recommendations are guidelines. Please take into account the influence of the mating thread during assembly. These values are based on measurements under standard climatic conditions (23°C / 50% relative humidity).

The specifications and instructions for our customers in this document reflect the product engineering level at the time of manufacturing. Please consider the valid data sheet release at a time. For questions please contact the PMA customer service. ABB Switzerland, PMA Cable Protection accepts no liability for damages resulting from unprofessional installation or application or misuse for a purpose. This disclaimer also includes damages to third parties. It is the customer's responsibility to check the delivered products and immediately notify ABB Switzerland, PMA Cable Protection of detected faults. It is also the customer's responsibility to test the delivered product on its applicability for the intended purpose. ABB Switzerland, PMA Cable Protection will accept no liability or responsibility for their products if a product or a PMA system is combined or used together with third-party products, i.e. products from other companies than ABB Switzerland, PMA Cable Protection. Jurisdiction in all legal disputes concerning product liability have the courts of the canton of Zurich/Switzerland. Swiss law applies. For more information and the newest data sheet releases go to: www.pma.ch



Recommended Tightening Torques for PMA Connectors



Tightening torques for PMA metal thread fittings to threaded holes or with lock nuts

Metric metal thread size	Torque [Nm]	NPT metal thread size	Torque [Nm]
M12	4.0	NPT 1/2	6.0
M16	4.0	NPT 3/4	8.0
M20	6.0	NPT 1"	10.0
M25	8.0	NPT 1 1/4	15.0
M32	10.0	NPT 1 1/2	15.0
M40	15.0	NPT 2"	15.0
M50	15.0		
M63	15.0		
			
PG metal thread size	Torque [Nm]		
PG07	3.5		
PG09	4.0		
PG11	6.0		
PG13,5	6.0		
PG16	7.0		
PG21	8.0		
PG29	10.0		
PG36	15.0		
PG48	15.0		
			
UNEF metal thread size	Torque [Nm]		
1/2-28 UNEF	4.0		
9/16-24 UNEF	5.0		
5/8-24 UNEF	5.0		
11/16-24 UNEF	5.0		
3/4-20 UNEF	6.0		
13/16-20 UNEF	6.0		
7/8-20 UNEF	10.0		
15/16-20 UNEF	10.0		
1-20 UNEF	10.0		
1 1/16-18 UNEF	10.0		
1 3/16-18 UNEF	10.0		
1 1/4-18 UNEF	10.0		
1 5/16-18 UNEF	10.0		
1 3/8-18 UNEF	10.0		
1 7/16-18 UNEF	15.0		
1 5/8-18 UNEF	15.0		
1 3/4-18 UNS	15.0		
2-18 UNS	15.0		
2 1/4-16 UN	15.0		
			

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Recommended Tightening Torques for PMA Connectors



Tightening torques for nuts and bolts used with PMA conduit clamps, PMA conduit supports and PMA flange fittings

Thread Size	Torque [Nm]
M4	2.0
M5	3.0
M6	4.0
M8	10.0
M10	15.0



Tightening torques for PMA connectors with strain relief elements

Pflitsch strain relief inserts UNI Dicht
 Jacob strain relief inserts PERFECT

[Info No. 13](#)
[Info No. 14](#)



Tightening torques for PMA purely metallic fittings and accessories (e.g. SCA, SWA, MAVI, MONK, JENO, NSNV, NSBIV)

Thread Size	Torque [Nm]	Thread Size	Torque [Nm]	Thread Size	Torque [Nm]
M16	10.0	NPT 1/2	15.0	PG09	15.0
M20	20.0	NPT 3/4	20.0	PG11	15.0
M25	30.0	NPT 1"	30.0	PG13,5	20.0
M32	35.0	NPT 1 1/4	35.0	PG16	30.0
M40	35.0	NPT 1 1/2	40.0	PG21	30.0
M50	40.0	NPT 2"	40.0	PG29	35.0
M63	40.0			PG36	40.0
				PG48	40.0



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