TABLE 14 - ASSEMBLY TORQUE METRIC FOR METRIC TUBE FITTINGS

FITTING SIZE	PORT THREAD SIZE	TORQUE	
		FT-LB	N-M
M10	M10 x 1	17	23
M12	M12 x1.5	24	33
M14	M14 x 1.5	34	46
M16	M16 x 1.5	46	63
M18	M18 x 1.5	61	83
M22	M22 x 1.5	94	127
M27	M27 x 2	139	189
M30	M30 x 2	167	226
M33	M33 x 2	194	263
M42	M42 x 2	265	359
M48	M48 x 2	302	410
M60	M60 x 2	359	487