Air Brake Fitting NPT Thread Installation Instructions

STEPS	DESCRIPTION
1. Prepare the Fittings	Make sure both the male and female NPT fittings are clean and free of debris. Any dirt or debris can interfere with the sealing process.
2. Apply Thread Sealant	Use an appropriate thread sealant on the male threads like LOCTITE 567 Thread Sealant or Teflon tape for sealing NPT threads. When using LOCTITE 567 Thread Sealant, apply a 360º bead to the leading male thread, leaving the first thread free. For bigger threads, apply both on male and female threads. When using Teflon tape, wrap the tape around the male threads in a clockwise direction, overlapping the tape by about half on each wrap.
3. Thread the Fittings	Carefully thread the male fitting into the female fitting by hand. Ensure that the threads align properly and do not cross-thread.
4. Hand Tighten	Using a wrench, hand tighten the fittings until they are snug. Avoid over-tightening, as this can damage the threads or the fittings themselves.
5. Final Tightening	Once the fittings are hand tight, use a wrench to make a final quarter to half turn to fully tighten the fittings. Be cautious not to apply excessive force, as this can also cause damage.
6. Check for Leaks	After tightening, check for leaks by applying soapy water to the connections. Bubbles will form at the site of any leaks. If you detect a leak, you may need to reapply the thread sealant and tighten the fittings further.
7. Test the System	Once you are confident that the fittings are tight and there are no leaks, test the air brake system to ensure proper functionality.

NPT Thread Size	Recommended Torque Setting (ft-lbs)	Recommended Torque Setting (Nm)
1/4 inch	12 - 15	16 - 21
3/8 inch	18 - 25	24 - 34
1/2 inch	25 - 35	34 - 48

These torque settings are guidelines and can vary slightly depending on factors such as the material of the fittings and the specific manufacturer's recommendations. Always refer to the manufacturer's specifications or guidelines for the most accurate torque settings for your particular fittings. Using the correct torque ensures a secure seal without damaging the threads or fittings.