

Recommended Torque

using 13LAH TRI-CLAMP

Update: 26-11-2019



Ferrule size Ø [mm/in]	Recommended torque <u>before</u> SIP * Pressure test at 20°C water temperature								Pressure test <u>after</u> SIP * at 20°C water temperature (without re-torque)							
	25 [½"]	50,5 [1"]	50,5 [1½"]	64 [2"]	64 [2½"]	91 [3"]	119 [4"]	167 [6"]	25 [½"]	50,5 [1"]	50,5 [1½"]	64 [2"]	64 [2½"]	91 [3"]	119 [4"]	167 [6"]
ELASTOMERS	1,5 Nm 10 bar	2 Nm 10 bar	2 Nm 10 bar	2 Nm 10 bar	2 Nm 10 bar	2 Nm 10 bar	2 Nm 10 bar	4 Nm 10 bar	10 bar	10 bar	10 bar	10 bar	10 bar	10 bar	10 bar	10 bar
TRI-BOND	1,5 Nm 10 bar	2 Nm 10 bar	2 Nm 10 bar	3 Nm 10 bar	> 4 Nm No Data	> 4 Nm No Data	No Data	No Data	10 bar	10 bar	10 bar	10 bar	No Data	No Data	No Data	No Data
PTFE ENVELOPE	1,5 Nm 10 bar	3 Nm 10 bar	3 Nm 10 bar	4 Nm 10 bar	> 6 Nm No Data	> 6 Nm No Data	No Data	No Data	10 bar	6 bar	6 bar	6 bar	No Data	No Data	No Data	No Data
PTFE SOLID	1,5 Nm 10 bar	3 Nm 10 bar	3 Nm 10 bar	4 Nm 10 bar	> 6 Nm No Data	> 6 Nm No Data	No Data	No Data	10 bar	10 bar	10 bar	10 bar	No data	No data	No data	No data
STEAM-FLON Type I Ultrapharma	No Data	2 Nm 10 bar	2 Nm 10 bar	4 Nm 10 bar	6 Nm 10 bar	8 Nm 10 bar	No Data	No Data	No Data	10 bar	10 bar	10 bar	10 bar	10 bar	No Data	No Data
STEAM-FLON Type III Ultrapharma	1,5 Nm 10 bar	2 Nm 10 bar	2 Nm 10 bar	4 Nm 10 bar	4 Nm 10 bar	12 Nm 10 bar	18 Nm 10 bar	USE MHP- CLAMP	10 bar	10 bar	10 bar	10 bar	10 bar	10 bar	10 bar	No Data
STEAM-FLON REMOVABLES (screen & orifices)	1,5 Nm 10 bar	4 Nm 10 bar	4 Nm 10 bar	USE MHP- CLAMP	USE MHP- CLAMP	USE MHP- CLAMP	USE MHP- CLAMP	USE MHP- CLAMP	10 bar	10 bar	10 bar	No Data	No Data	No Data	No Data	No Data

* SIP conditions: Temp. 130 - 140° Celcius, pressure 1,8 - 2,2 Bar , 3 - max. 8 hours continues steam per cycle, total hours of steam diversified from min. 3 - max. 50 hours.