

STANDARD GATE-SEAL TORQUES

The following tables are a summary of the gate-seal torque values found in each product line's user manual.

Product Line	Product Size	Torque [ft-lb]	Torque [Nm]
Dura Plus	Deci	25-28	34-38
	Pico	35-40	47-54
	Mega	42-48	57-65

Product Line	Product Size	Torque [ft-lb]	Torque [Nm]
Master Series	Femto Lite	6-7	8-9
	Femto	6-7	8-9
	Pico	12-13	16-18
	Centi	20-22	27-30
	Deci	25-28	34-38
	Hecto	35-40	47-54
Master Series Melt Disk	Centi	10-11	14-15

Product Line	Product Size	Torque [ft-lb]	Torque [Nm]
Summit Series	Deci	6-7	8-9
	Pico	12-13	16-18
	Centi	20-22	27-30

Product Line	Product Size	Torque [ft-lb]	Torque [Nm]
ThinPak	Centi	27-29	37-39
	Deci	34-36	46-49

Product Line	Product Size	Torque [ft-lb]	Torque [Nm]
Fusion	F3000	20	27
	F4000	33	45
	F5000	42	57
	F6000	65	88
	F7000	70	95
	F8000	200	270

Product Line	Product Size	Torque [ft-lb]	Torque [Nm]
Sprint (Vespe)	Centi	22-25	30-34
	Deci	25-28	34-38
Sprint (Colour Change)	Deci	45-50	61-68

Product Line	Product Size	Torque [ft-lb]	Torque [Nm]
Dura	Femto	8-10	11-14
	Pico	12-13	16-18
	Centi	20-22	27-30
	Deci	25-28	34-38
	Hecto	35-40	47-54
	Mega	35-40	47-54
Dura MTT	Centi	10-12	14-16
	Deci	20-22	27-30
Dura Tit Edge	Centi	11-13	15-18
	Deci	11-13	15-18
	Pico	8-10	11-14

OTHER TORQUES

Torque Chart for System Assembly Screws

Metric	Torque [Nm]	Imperial	Torque [ft lbs]
M5	7	#10-32	5
M6	14	1/4-20	10
M8	20	5/16-18	15
M10	40	3/8-16	30
M12	60	1/2-13	45
M16	145	5/8-11	107
M20	285	3/4-10	210

Torque Chart for Plate Assembly Screws

Metric	Max. Torque	Imperial	Min. Torque
M5	9 Nm / 6 ft lbs	#10-32	7 Nm / 5 ft lbs
M6	15 Nm / 11 ft lbs	1/4-20	16 Nm / 12 ft lbs
M8	36 Nm / 27 ft lbs	5/16-18	33 Nm / 24 ft lbs
M10	72 Nm / 53 ft lbs	3/8-16	59 Nm / 44 ft lbs
M12	125 Nm / 92 ft lbs	1/2-13	144 Nm / 106 ft lbs
M16	311 Nm / 229 ft lbs	5/8-11	287 Nm / 212 ft lbs
M20	606 Nm / 447 ft lbs	3/4-10	511 Nm / 377 ft lbs

Torque Chart for Components

Component	Torque
Piston Top (Series 5500, 6500, 6600 and 6700 Valve Actuator)	20-27 Nm (15-20 ft-lbs)