

Argus Model D Pig Valve Assembly Torque Data

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1.0 PURPOSE

This document outlines the required assembly torque for Argus Model D Pig Valves. All torque values are based on using API 7G thread compound (e.g., Jet Lube API-Modified) with a published Friction Factor of 1.0 ($\mu=0.08$). This compound must be applied to bolt and stud threads and contact surfaces under bolt heads and nuts.

2.0 ASSEMBLY TORQUE

Table 1.0: Pig Valve Model D Assembly Torque

	Component	Thread Size	Assembly Torque (ft.-lbs.) (Lubed)	Hytorc Pressure (psi)/ Model	Hytorc Link Number
6" 900	Tailpiece	1 1/4"-8 UN	450	2400 – Stealth 2	6
	Entry Cap	1"-8 UNC	250		
	Stuffing Box	5/8"-11 UNC	100		
	EQ Valve	5/16"-18 UNC	72 (in.-lbs.)		
	Gear Op Adapter Plate	3/4"-10 UNC	60		
	Stuffing Box Adapter Plate	1/2"-13 UNC	60		
6" 1500	Tailpiece	1 3/4"-8 UN	1200	3000 – Stealth 4	8
	Entry Cap	1 1/4"-8 UN	450	2400 – Stealth 2	2
	Stuffing Box	1"-8 UNC	300		
	EQ Valve	1/2"-13 UNC	200 (in.-lbs.)		
	Gear Op Adapter Plate	3/4"-10 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		
8" 150-600	Tailpiece	1 1/4"-8 UN	450	2400 – Stealth 2	6
	Entry Cap	1 1/8"-8 UN	300		
	Stuffing Box	1"-8 UNC	300		
	EQ Valve	5/16"-18 UNC	72 (in.-lbs.)		
	Gear Op Adapter Plate	3/4"-10 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		

Specifications are Subject to Change Without Prior Notice – All Dimensions: inch [mm]

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	Component	Thread Size	Assembly Torque (ft.-lbs.) (Lubed)	Hytorc Pressure (psi)/ Model	Hytorc Link Number
8" 900	Tailpiece	1 1/2"-8 UN	800	4300 – Stealth 2	8
	Entry Cap	1 1/4"-8 UN	450	2400 – Stealth 2	2
	Stuffing Box	1"-8 UNC	300		
	EQ Valve	5/16"-18 UNC	72 (in.-lbs.)		
	Gear Op Adapter Plate	3/4"-10 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		
8" 1500	Tailpiece	2" 1/4-8 UN	2540	3200 – Stealth 8	9
	Entry Cap	1 3/8"-8 UN	600	3200 – Stealth 2	3
	Stuffing Box	1"-8 UNC	300		
	EQ Valve	1/2"-13 UNC	200 (in.-lbs.)		
	Gear Op Adapter Plate	3/4"-10 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		
10" 150-600	Tailpiece	1 1/2"-8 UN	800	4300 – Stealth 2	8
	Entry Cap	1 1/4"-8 UN	450	2400 – Stealth 2	2
	Stuffing Box	1"-8 UNC	300		
	EQ Valve	5/16"-18 UNC	72 (in.-lbs.)		
	Gear Op Adapter Plate	3/4"-10 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		
12" 150-600	Tailpiece	1 5/8"-8 UN	900	4800 – Stealth 2	9
	Entry Cap	1 3/8"-8 UN	600	3200 – Stealth 2	3
	Stuffing Box	1"-8 UNC	300		
	EQ Valve	1/2"-13 UNC	200 (in.-lbs.)		
	Gear Op Adapter Plate	1"-8 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		
12" 900	Tailpiece	2"-8 UN	1740	2200 – Stealth 8	7
	Entry Cap	1 3/8"-8 UN	600	3200 – Stealth 2	3
	Stuffing Box	1"-8 UNC	300		
	EQ Valve	1/2"-13 UNC	200 (in.-lbs.)		
	Gear Op Adapter Plate	3/4"-10 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		

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	Component	Thread Size	Assembly Torque (ft.-lbs.) (Lubed)	Hytorc Pressure (psi)/ Model	Hytorc Link Number
14" 150-600	Tailpiece	1 5/8"-8 UN	900	4800 – Stealth 2	9
	Entry Cap	1 1/2"-8 UN	800	4300 – Stealth 2	8
	Stuffing Box	1"-8 UNC	300		
	Gear Op Adapter Plate	1"-8 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		
16" 150-600	Tailpiece	1 1/2"-8 UN	800	4300 – Stealth 2	8
		1 3/4"-8 UN	1200	3000 – Stealth 4	8
	Entry Cap	1 1/2"-8 UN	800	4300 – Stealth 2	4
	Stuffing Box	1"-8 UNC	300		
	EQ Valve	1/2"-13 UNC	200 (in.-lbs.)		
	Gear Op Adapter Plate	1"-8 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		
18" 150	Tailpiece	1"-8 UNC	180		
	Entry Cap	1"-8 UNC	270		
	Stuffing Box	1"-8 UNC	300		
	Gear Op Adapter Plate	1"-8 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		
20" 150	Tailpiece	1"-8 UNC	180		
	Entry Cap	1"-8 UNC	270		
	Stuffing Box	1"-8 UNC	300		
	Gear Op Adapter Mounting	1"-8 UNC	175		
	Stuffing Box Adapter Plate	3/4"-10 UNC	175		
20" 600	Tailpiece	1 7/8"-8 UN	1400	1800 – Stealth 8	6
	Entry Cap	1 3/4"-8 UN	800	4300 – Stealth 2	5
	Stuffing Box	1"-8 UNC	300		
	Gear Op Adapter Plate	1"-8 UNC	175		
	Stuffing Box Adapter Plate	1"-8 UNC	175		