

Model C, F, and P Pig Valve Assembly Torque Data

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1.0 PURPOSE

This document outlines the required assembly torques for Model F, P, and C Pig Valves.

2.0 SCOPE

Assembly torques are based on using an API 7G thread compound (e.g. *Jet Lube API-Modified*) with a published friction factor of 1.0 ($\mu=.08$). This compound must be applied to bolt and stud threads and contact surfaces under bolt heads and nuts.

3.0 ASSEMBLY TORQUES

Size	Pressure Class	Model	Component	Thread Size	Assembly Torque (Lubed) (ft-lbs)
2"	150-900	F	Trunnion	5/8"-11 UNC	75
			Stuffing Box		
3"	150-900	P	Trunnion	5/8"-11 UNC	75
			Stuffing Box		
4"	150-900	C	Trunnion	5/8"-11 UNC	75
			Stuffing Box		
	1500	P	Trunnion	7/8"-9 UNC	150
			Stuffing Box		
6"	150-600	P	Trunnion	3/4"-10 UNC	100
			Stuffing Box		

4.0 OBSOLETE ASSEMBLY TORQUES

Size	Pressure Class	Model	Component	Thread Size	Assembly Torque (Lubed) (ft-lbs)
4"	150-900	P	Trunnion	3/4"-10 UNC	100
			Stuffing Box		
6"	900	P	Trunnion	5/8"-11 UNC	75
			Stuffing Box		
6"	1500	P	Trunnion	1"-8 UNC	240
			Stuffing Box		
8"	150-900	P	Trunnion	1"-8 UNC	240
			Stuffing Box		
	1500	P	Trunnion	1 1/8"-8 UNC	300
			Stuffing Box		

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

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