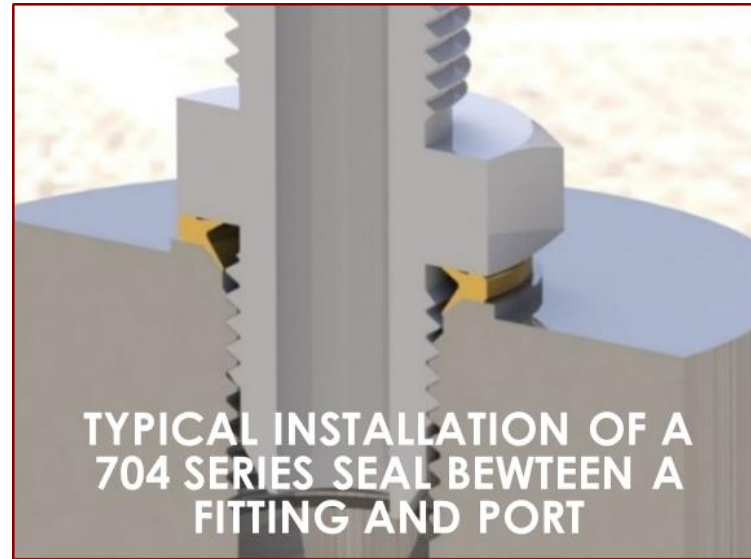


704 SERIES PORT / BOSS (K-SEAL)

(REFERNCE NASA MC 252 SEAL, BOSS, METALLIC)

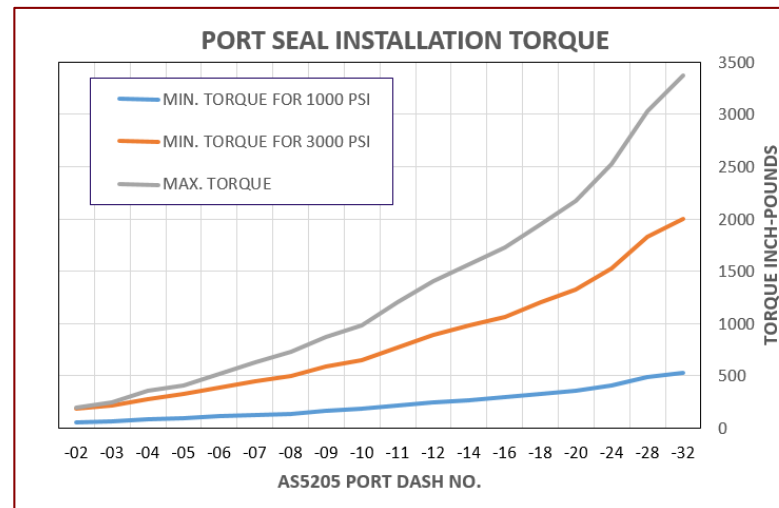
704 PORT SEAL SIZE	MIN. TORQUE FOR 1000 PSI	MIN. TORQUE FOR 3000 PSI	MAX. TORQUE
-02	60	130	200
-03	70	150	250
-04	85	195	355
-05	100	225	410
-06	115	270	520
-07	130	315	625
-08	140	360	730
-09	165	420	870
-10	185	470	980
-11	215	555	1200
-12	245	645	1410
-14	270	710	1570
-16	295	770	1730
-18	330	870	1950
-20	360	970	2170
-24	405	1120	2520
-28	485	1340	3030
-32	525	1480	3370



APPLICATION: AS4395 FITTINGS TO AS5202 PORTS
MEDIA: LIQUID, GAS
MATERIALS: A286, CRES 304
COATINGS: GOLD, TEFLON
SIZES: -2(1/8" LINE) THROUGH -32(2" LINE)
PRESSURE (MAX): A286 SIZES -2 TO -8: 15,000 PSI
 A286 SIZES -10 TO -32: 9,000 PSI
 CRES 304 SIZES -2 TO -8: 5,000 PSI
 CRES 304 SIZES -10 TO -32: 3,000 PSI
MATING FLANGE FINISH: TEFLON 32 R_a CIRCULAR
 SILVER: 16 R_a CIRCULAR
FLANGE AXIAL DEFLECTION: .0005" TOTAL MAX.

704 BOSS SEAL INSTALLATION:

1. Lubricate threads of fitting and boss with compatible lubricant when permissible.
2. Install seal over fitting threads and lightly thread into mating port.
3. Torque to appropriate range. Lubricant usage will affect contact of boss to fitting and sealing effectiveness. Reference MIL-HDBK-60 for torque guidelines.



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