

Aquatherm flange bolt torque and size for connection to flange fittings (not Aquatherm valves)

Nominal Pipe Size	Torque		Bolts		
	N-m	ft-lb	Number	Diameter	Washers
1/2" (20mm)	9	7	4	1/2	Yes
3/4" (25mm)	14	10	4	1/2	Yes
1" (32mm)	20	15	4	1/2	Yes
1-1/4" (40mm)	20	15	4	1/2	Yes
1-1/2" (50 mm)	34	25	4	1/2	Yes
2" (63mm)	41	30	4	5/8	Yes
2-1/2" (75mm)	54	40	4	5/8	Yes
3" (90mm)	54	40	8	5/8	Yes
3-1/2" (110mm)	54	40	8	5/8	Yes
4" (125mm)	54	40	8	5/8	Yes
6" (160mm)	75	55	8	3/4	Yes
8" (200mm)	102	75	8	3/4	Yes
10" (250mm)	122	90	12	7/8	Yes
12" (315mm)	142	105	12	7/8	Yes
14" (355mm)	203	150	12	1	Yes
16" (400mm)	203	150	16	1	Yes
18" (450mm)	237	175	16	1-1/8	Yes
20" (450mm)	237	175	20	1-1/8	Yes
24" (630mm)	305	225	20	1-1/8	Yes

Note: These are typical values for rubber gaskets with lubricated (lightly greased) or plated bolts. for harder gaskets or plain/unplated bolts. Values may be increased by up to 20%

Aquatherm Ball Valve flange bolt torque and size (for connection to Aquatherm ball valves)

Nominal Pipe Size	Torque		Bolts		
	N-m	ft-lb	Number	Diameter	Washers
3" (90mm)	40	29	8	M16 x 60mm	Yes, M16
3-1/2" (110mm)	50	37	8	M16 x 60mm	Yes, M16
4" (125mm)	50	37	8	M16 x 60mm	Yes, M16
6" (160mm)	60	44	8	M20 x 80mm	Yes, M20