

O-Ring Face Seal Torque Values

OFS Torque Values		As the Temperature Rises...
-04 - 10-12	-12 - 65-70	+212° F = Water boils off.
-06 - 18-20	-16 - 92-100	+600° F = Flux starts to bubble.
-08 - 32-35	-20 - 125-140	+800° F = Flux becomes translucent.
-10 - 46-50	-24 - 150-165	+1100° F = Flux thins and becomes clear and dark.
		+1125° F = Silver braze ring melts.
		+1140° F = Silver flows evenly throughout the joint allowing the braze sleeve to drop and be fully seated.
		At this point the metal will take on a dark reddish look.