



CYLINDRICAL STEM THREAD VALVE INSTALLATION INSTRUCTIONS

1. Remove thread protection caps (when present); pay attention not to damage the sealing seats.
2. Take the toroidal O-ring and the venting seal from the bag. Apply the toroidal sealing ring to the valve stem and position it correctly inside the sealing area and repeat the same operation for the venting seal. Pay attention not to damage the rings during positioning operations.
3. If necessary, spread an appropriate lubricant, compatible with the gas, on 3 or 4 threads, the most far from the sealing ring. Use a very small quantity of lubricant and clean any excess away. The lower surface of valve stem must be perfectly clean.
4. Threading on cylinder neck adjoining the sealing area must be free from debris, burrs, notches etc.
5. With the cylinder fixed so as to prevent any rotation, assemble the valve to the cylinder by hand. Pay attention not to damage the sealing ring when it touches the cylinder sealing area.
6. Screw the valve by hand, as tight as possible, then tighten it up by an appropriate tooling.
7. The torque applied must comply with the values shown in Table B. Use an appropriate gauged dynamometric wrench.
8. In order to verify the torque applied during assembling, torque measurement must be taken while unscrewing the valve. The minimum torque needed to start unscrewing the valve must be within the limits specified in Table B. Use an appropriate gauged dynamometric wrench. If hardening sealants are used, the torque must be measured before the sealant hardens.

Table B – Torque to be applied for valve assembling on cylinders

Application	Size of valve parallel stem	Torque Force Nm	
		Min.	Max.
Steel cylinder without welding	1" 1/8 - 12 UNF	100	130
Aluminium-alloy cylinders	1" 1/8 - 12 UNF	95	130