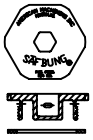
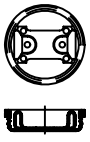
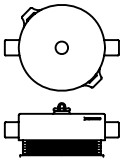
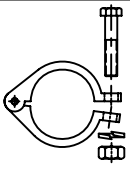
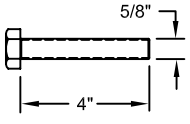
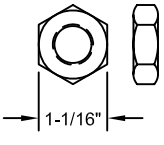
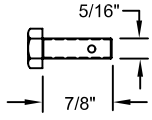
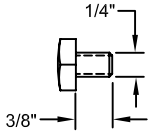
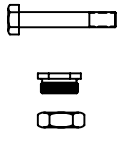
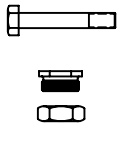
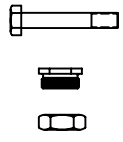
- QUICK REFERENCE GUIDE -
AMI RECOMMENDED COMPONENT TORQUE FOR PORTABLE TANKS

COMPONENT	VISUAL DESCRIPTION	TORQUE SETTING FT/LBS (Nm)	COMMENTS
SAFBUNG™ - 2" bung closure with EPDM or Buna gasket		25 - 30 (33.9 - 40.7)	Refer to AMI drawing 110885-INST
Steel bung closure with gasket		25 - 30 (33.9 - 40.7)	
FUZVENT™ - 3" bung closure with EPDM gasket		15 - 20 (20.3 - 27.1)	Refer to AMI drawing 114452
Fusible Cap - 3" with gasket (Girard type)		25 - 30 (33.9 - 40.7)	
I-Line Clamp - 2" with 1/2" gr5 screw		35 - 40 (47.5 - 54.2)	Used on valve/elbow
Clamp Ring Bolt - stainless or gr5 carbon 5/8"-11 fully threaded screw		40 - 50 (54.2 - 67.8)	Refer to AMS-004 clamp ring installation instructions
Jam Nut for Clamp Ring - stainless, gr5, or gr2 carbon		30 - 40 (40.7 - 54.2)	Refer to AMS-004 clamp ring installation instructions

REVISIONS					
ZONE	REV	DESCRIPTION	DATE	REVISED BY	APPROVED BY

COMPONENT	VISUAL DESCRIPTION	TORQUE SETTING FT/LBS (Nm)	COMMENTS
Retaining Screw - 5/16" for coupling retention		15 - 20 (20.3 - 27.1)	
Retaining Screw - square head set screw for coupling		15 - 20 (20.3 - 27.1)	
Ball Valve assembly screws - AMI 3/8" gr2 3/8" gr5 3/8" stainless steel Packing gland Handle nut		18 - 22 (24.4 - 29.8) 20 - 25 (27.1 - 33.9) 20 - 25 (27.1 - 33.9) 20 - 25 (27.1 - 33.9) 18 - 22 (24.4 - 29.8)	Refer to appropriate valve assembly drawing 111111-INST Tighten screws and packing gland in three (3) steps
Ball Valve assembly screws - Apollo 1-1/2" 5/16" gr2 5/16" gr5 5/16" stainless steel Packing gland Handle nut		20 - 25 (27.1 - 33.9) 25 - 30 (33.9 - 40.7) 25 - 30 (33.9 - 40.7) 30 - 35 (40.7 - 47.5) 18 - 22 (24.4 - 29.8)	Refer to appropriate valve assembly drawing 110579-INST Tighten screws and packing gland in three (3) steps
Ball Valve assembly screws - Apollo 2" 3/8" gr5 3/8" stainless steel Packing gland Handle nut		25 - 30 (33.9 - 40.7) 25 - 30 (33.9 - 40.7) 35 - 40 (47.5 - 54.2) 25 - 30 (33.9 - 40.7)	Refer to appropriate valve assembly drawing 111377-INST Tighten screws and packing gland in three (3) steps

CAUTION: Improper component assembly can create hazardous situations. The above recommendations are intended as a guide only and are based on AMI's field testing and experience using new components. They are intended for use by qualified, trained individuals operating within the confines of applicable standards, regulations, and practices. Other factors, such as ambient temperature, fluids used, frequency of connection/disconnection, and component condition may affect the integrity of tote systems. Users should conduct their own testing to determine feasibility of this information to their own application.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES GENERAL TOLERANCES

FRACTIONS:	.XX DECIMALS:	.XXX DECIMALS:	.XXXX DECIMALS:	ANGLES:
± 1/32	± .010	± .005	± .001	± 1°

PROJECTION

DO NOT SCALE THIS DRAWING
BREAK SHARP EDGES
REMOVE BURRS & FLASH

FINISH: N/A √
SPECIAL FINISH: N/A
DRAWN BY: MCS 04-16-03
CHECKED BY: REICH 04-16-03
APPROVED BY: DATE:

AMERICAN MACHINING, INC.
FENTON, MICHIGAN

DESCRIPTION
TORQUE RECOMMENDATION QUICK REFERENCE GUIDE

SIZE	PART NUMBER	REV
C	114609	–

SCALE: NONE MAT'L: N/A SHEET 1 OF 1