

### 1. Purpose

Guideline for the sealing of fittings, using PTFE tape (specification see note 5).

### 2. Scope

Fittings with NPT thread.

### 3. Current status of the threads

Before sealing the threads must be metallic bright and free of grease.

### 4. Maintenance sequence

- Wrap the thread of the fitting in clockwise direction, beginning from thread end, with 1 ½ to 2 turns of PTFE tape (Fig. 1).
- Screw in the fitting sturdy (Fig. 2).
- Apply with a waterproof marker a longitudinal marking onto any flat of the hexagon. Continue the marking on housing or endcap surface (Fig. 3).
- Tighten further the fitting with a wrench by using the **FFFT** method (= **FLATS FROM FINGER TIGHT**) for the necessary number of flats shown in table 1 (Fig. 4).  
**ATTENTION! NEVER LOWER (UNTIGHTEN) THE PIPE FITTING TO ACHIEVE ANY ADJUSTMENT!**

Among 3 ½ thru 6 thread pitches must be engaged. Any deviations indicates too light tighten or overtighten screw joint or thread beyond allowed tolerance limits.

1) IN CASE OF TOO LIGHT TIGHTEN SCREW JOINT, RETIGHTENING UP TO MAXIMUM ONE TURN IS PERMISSIBLE.

**Table 1**

Thread Size	Number of flats <sup>1)</sup> (FFFT)
1 1/4 – 1 1/2 NPT	1.5 – 2.5
1 1/2 – 1 1/2 NPT	1.5 – 2.5
2 – 1 1/2 NPT	1.5 – 2.5



Fig. 4

### 5. PTFE tape – Specification

- Thread sealing made from clean, sintered PTFE.
- DIN-DVGW-certificated and approved.
- Chemically resistant also against aggressive media.
- Resistant against brittleness and soaking.
- Non-adhesive.
- OPERATING TEMPERATURE RANGE: -60 °C THRU +200 °C (TEMPORARY +260 °C).
- Dimensions (width x thickness): 12 mm x 0,1 mm
- DEUBLIN Order No.: P000329

Printed on FSC certified paper



Fig. 1



Fig. 2

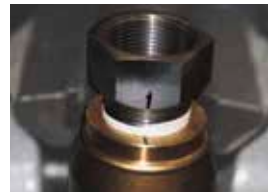


Fig. 3

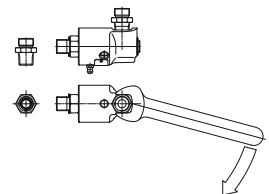


Fig. 5

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