

ASSEMBLY TORQUE VALUE

Amphenol recommends the following assembly torque values for its adaptors while assembling to the connectors. These values are based on the coupling thread strength specified in SAE-AS85049 standard

Connector shell Size	Torque (Inch-Pounds)
8,9	40
3, 10, 10SL, 11	40
7, 12, 12S, 13	40
14, 14S, 15	40
16, 16S, 17	40
18, 19, 27	40
20, 21, 37	80
22, 23	80
24, 25, 61	80
28	100
32	100
36	100
40	120
44	120
48	120

GUIDING SPECIFICATION

As per SAE, AS85049 standard (Old standard is MIL-C-85049).

