SUBJECT: AN FITTINGS

FPE-2023-102
September, 2023

IMPORTANT NOTES:

DO NOT overtighten AN fittings. Damage can occur, resulting in leaks. Always follow recommended torque specs and torquing procedures as given by the manufacturer.

When connecting an AN fitting to an AN adapter, be sure to use a backup wrench to prevent the adapter from overtightening.

If a torque wrench cannot be used on your application, please refer to the alternative torquing method on the next page.

TORQUE SPECS FOR ALUMINUM AN FITTINGS

AN (Army-Navy) Fitting Thread Size Chart				
AN Size	Hose Size	Thread Size	Minimum Torque (in-lbs)	Maximum Torque (in-lbs)
-3	3/16”	3/8-24 SAE	70	105
-4	1/4”	7/16-20 SAE	100	140
-6	3/8”	9/16-18 SAE	150	195
-8	1/2”	3/4-16 SAE	270	350
-10	5/8”	7/8-14 SAE	360	430
-12	3/4”	1-1/16 SAE	460	550
-16	1”	1-5/16 SAE	700	840
-20	1-1/4”	1-5/8 SAE	850	1020

Figure 1

(Fitting outlines are actual size)

ALTERNATIVE METHOD FOR TORQUING ALUMINUM AN FITTINGS:

If a torque wrench cannot be used in your application, you can also properly torque your AN fittings using the flats method.

1. Tighten the nut until it becomes snug, and the fitting is seated.
2. Use a marker to draw a line between the nut and its connection (see Figure 2)
3. Using two wrenches (one for the nut and the other for the connection), tighten the nut to the amount shown in table 1.

Note: Do not exceed the number of hex flat rotations outlined, as damage to the fitting can occur.

AN Fitting Size	# of Hex Flats Rotations
-4	1 ½ to 1 ¾
-6	1 to 1 ½
-8	1 ¼ to 1 ¾
-10	1 ¼ to 1 ¾
-12	1 to 1 ½
-16	¾ to 1
-20	½ to ¾

Table 1

Figure 2: Connection before torquing

Figure 3: Connection with one hex flat rotation