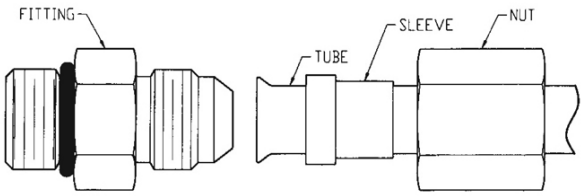
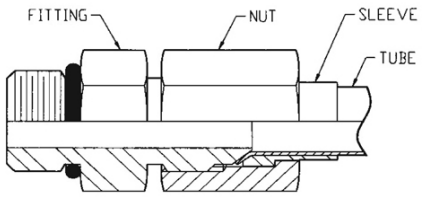
37° JIC Flare Fittings

Components



Assembled



The 37° JIC (Joint Industrial Council) flare is a reliable, straight thread, single-flare design that is used world-wide. It is popular in many applications and environments because it is compact and easy to assemble. It also features high holding power with low torque requirements. The 37° JIC connection consists of three pieces: the nut, the sleeve, and the fitting in a range of sizes from 1/8" up to 2". The sleeve not only absorbs vibration, but acts as a support to the flare during assembly and helps reduce the risk of twisting the tube. Since it is a metal-to-metal seal it can be reliably connected and reconnected multiple times. Because flaring is necessary, it is NOT recommended for thick wall tubing. For assembly instructions see the Male 37° JIC Torque Values chart below. Also see the 37° JIC Swivels page.

37° JIC Torque Values

"Turns Past Hand Tight" Method

Size	Turns	lb-ft min./max.
-02	Not Rated	6-7
-03	Not Rated	8-9
-04	2	11-12
-05	2	14-15
-06	1 1/2	18-20
-08	1 1/2	36-39
-10	1 1/2	57-63
-12	1 1/4	79-88
-14	1	94-103
-16	1	108-113
-20	1	127-133
-24	1	158-167
-32	1	245-258

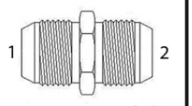
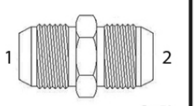
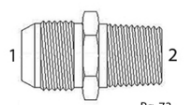
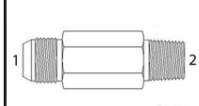
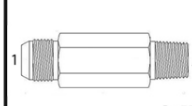
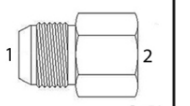
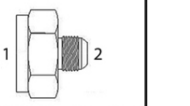
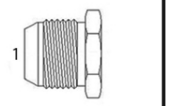
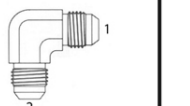
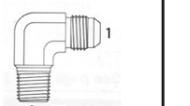
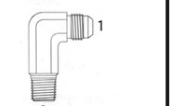
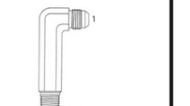
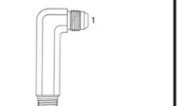
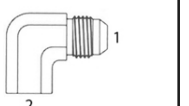
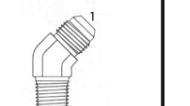
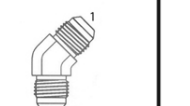
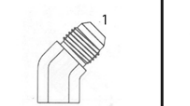
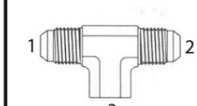
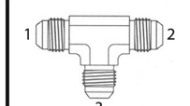
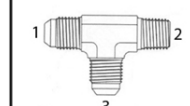
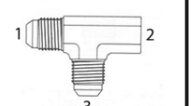
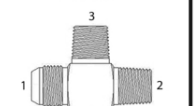
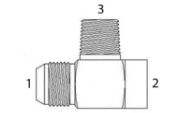
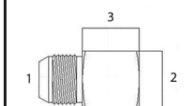
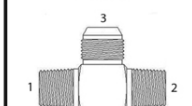
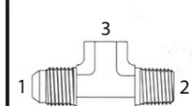
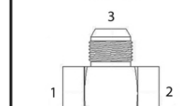
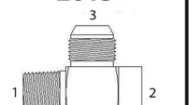
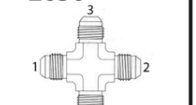
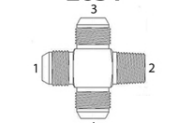
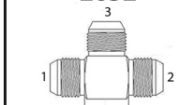
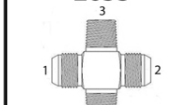
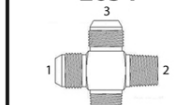
Assembly Steps with a Visual Check

1. With the tube flared, make sure the tubing and threads are clean.
2. Lubricate the threads with 10W hydraulic oil.
3. Hand tighten the nut/sleeve (approx. 30 lb-in).
4. Make alignment marks on the nut and fitting.
5. Proceed to tighten to Turns or lb-ft values.
6. When fully tightened make a 2nd set of alignment marks at the fully tightened position.

This completes a 37° JIC flare connection with visual marks for a quick reference.

Torque values specified are for threads lubricated with 10W hydraulic oil.
Remember sizes -02 through -08 are less tolerant to over-torque abuse.
Over-torque abuse reduces the clamping force resulting in loss of seal and a reduction in flow.

37° JIC Flare Fittings - Visual Identification Chart

2403 (070101)  Pg. 71 MJ-MJ Straight	**2403-LH** (070101)  Pg. 72 MJ-MJ Straight Large Hex	**2404** (070102)  Pg. 73 MJ-MP Straight	**2404-L**  Pg. 74 MJ-MP Straight Long	**2404-LL**  Pg. 75 MJ-MP Straight X-Long	**2405** (070103)  Pg. 76 MJ-FP Straight	**2406** (070123)  FJ-MJ Straight Reducer/Expander Pg. 77
2408 (070109)  Pg. 78 MJ Plug	**2500** (070201)  Pg. 79 MJ-MJ 90°	**2501** (070202)  Pg. 80 MJ-MP 90°	**2501-L** (070101)  Pg. 81 MJ-MP 90° Long	**2501-LL** (070602)  Pg. 82 MJ-MP 90° X-Long	**2501-LLL**  Pg. 82 MJ-MP 90° XX-Long	**2502** (070203)  Pg. 83 MJ-FP 90°
2503 (070302)  Pg. 84 MJ-MP 45°	**2504**  Pg. 85 MJ-MJ 45°	**2505**  Pg. 85 MJ-FP 45°	**2601** (070425)  Pg. 86 MJ-MJ-MP Tee	**2602** (070427)  Pg. 87 MJ-MJ-FP Tee	**2603** (070401)  Pg. 88 MJ-MJ-MJ Tee	**2605** (070424)  Pg. 89 MJ-MP-MJ Tee
2606 (070426)  Pg. 90 MJ-FP-MJ Tee	**2607**  Pg. 90 MJ-MP-MP Tee	**2608**  Pg. 91 MJ-FP-MP Tee	**2609**  Pg. 91 MJ-FP-FP Tee	**2610**  Pg. 91 MP-MP-MJ Tee	**2611**  Pg. 92 MJ-MP-FP Tee	**2612**  Pg. 92 FP-FP-MJ Tee
2613  Pg. 92 MP-FP-MJ Tee	**2650** (070501)  Pg. 93 MJ-MJ-MJ-MJ Cross	**2651**  Pg. 93 MJ-MP-MJ-MJ Cross	**2652**  Pg. 93 MJ-MP-MJ-MJ Cross	**2653**  Pg. 94 MJ-MJ-MP-MP Cross	**2654**  Pg. 94 MJ-MP-MJ-MP Cross	