



## Fastener Torque Specifications

To properly fasten components of our enclosures, determine the fastener size (M5 or M6, typically) and the material of the gasket being compressed (Silicone, EDPM Foam, or Viton). Lubrication is applied to all tapped threads during assembly and reapplication is suggested if component is being reassembled.

### M5 FASTENERS

- |                     |                 |               |
|---------------------|-----------------|---------------|
| • Silicone Gasket:  | 5.5 – 7.0 lb.in | 0.6 – 0.8 N.m |
| • EDPM Foam Gasket: | 2.0 – 3.5 lb.in | 0.2 – 0.4 N.m |
| • Viton Gasket:     | 5.5 – 9.0 lb.in | 0.6 – 1.0 N.m |

### M6 AND ¼ INCH FASTENERS

- |                     |                  |               |
|---------------------|------------------|---------------|
| • Silicone Gasket:  | 7.5 – 9.0 lb.in  | 0.8 – 1.0 N.m |
| • EDPM Foam Gasket: | 2.0 – 3.5 lb.in  | 0.2 – 0.4 N.m |
| • Viton Gasket:     | 7.5 – 11.0 lb.in | 0.8 – 1.2 N.m |

### EXTERNAL ACRYLIC VIEWPORT \*

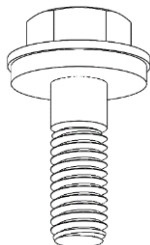
- |                     |                 |               |
|---------------------|-----------------|---------------|
| • Silicone Gasket:  | 3.5 – 5.5 lb.in | 0.4 – 0.6 N.m |
| • EDPM Foam Gasket: | 2.0 – 3.5 lb.in | 0.2 – 0.4 N.m |
| • Viton Gasket:     | 3.5 – 5.5 lb.in | 0.4 – 0.6 N.m |

### BODY WELD STUDS

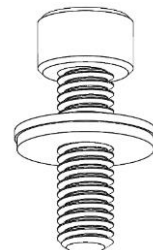
- |                |                  |                |
|----------------|------------------|----------------|
| • M5:          | 15.6 lb.in (MAX) | 1.75 N.m (MAX) |
| • M6 & ¼ Inch: | 26.4 lb.in (MAX) | 3.00 N.m (MAX) |

\* External acrylic viewports are susceptible to cracking around the corners if over-torqued. To meet enclosure IP rating requirements and prevent damage to the viewport, follow these torque specifications.

**Note:** The maximum torque suggested for your application is to prevent over-compression of the gasket which may damage the material and compromise the seal of the enclosure. If you are unsure of the torque you are applying to a fastener, bolt down until the gasket begins to expand from under the head of the fastener then back off one eighth turn.



*APG Custom  
Flanged-Hex Head  
with Gasket*



*Fastener with  
Bonded Sealing  
Washer Gasket*