

TECHNICAL BULLETIN

Review Date: 01/18/2012
Original Date: 06/24/1996
Document ID: NTB-0696-04

NIBCO® Copper Unions

“Ground-Joint” Seal Preparation for Copper/Bronze Unions

- 1.) Make sure the ground-joint area is free of nicks and scratches.
- 2.) Spray the ground-joint area with a silicone spray or beeswax to enhance seating.
- 3.) Recommended torques (for ground-joint seal):
 - ½” (nominal) unions – 35 ft./lbs. (minimum)
 - ¾” (nominal) unions – 60 ft./lbs. (minimum)
 - 1” (nominal) unions – 70 ft./lbs. (minimum)
 - 1 ¼” (nominal) unions – 70 ft./lbs. (minimum)
 - 1 ½” (nominal) unions – 80 ft./lbs. (minimum)
 - 2” (nominal) unions – 80 ft./lbs. (minimum)
- 4.) Make sure alignment of line does not put lateral stress on the ground-joint seal.
- 5.) Make sure that excess solder (droplets) do not reach the ground-joint area.