

## TECHNICAL BULLETIN

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### NIBCO<sup>®</sup> 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.