



# Torque Specifications for Linde Metric Socket-Head Cap Screws

Document No: 916

Rev. 1

Service Bulletin

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**Note:**  
 The torque specifications presented within this Service Bulletin are standard for the metric socket-head cap screws (S.H.C.S.) used on Linde products. The standard torque specifications are to be disregarded **ONLY** when a different torque specification is called out for by a Linde Spare Parts List, a Linde Engineering Drawing, a Linde Engineering Document, or by a Linde Engineer.

Table 1: screws without Loctite:

Dimension		Torque (ft.lb)						
		4.6	4.8	5.8/22H/45H	6.8	8.8	10.9	12.9
Standard Thread	M4	0.7	1.0	1.3	1.5	2.0	2.8	3.4
	M5	1.5	2.0	2.5	3.0	4.1	5.9	7.0
	M6	2.7	3.5	4.4	5.2	7.0	9.6	11.8
	M8	6	8	10	13	17	24	29
	M10	13	17	21	25	34	47	57
	M12	22	30	37	44	59	81	100
	M14	35	46	58	69	92	133	159
	M16	54	74	90	108	144	203	243
	M20	107	140	177	213	284	398	479
	M24	184	243	302	365	487	686	811
	M30	376	498	620	738	996	1364	1659
	M36	649	863	1084	1298	1733	2434	2876
	Fine Pitch Thread	M8 X 1	7	9	12	14	18	26
M10 X 1		15	19	24	29	38	53	70
M10 X 1.25		13	18	22	27	36	50	60
M12 X 1.25		24	32	41	49	65	92	111
M12 X 1.5		23	30	38	46	61	85	103
M14 X 1.5		38	52	64	77	103	144	173
M16 X 1.5		58	77	96	116	155	218	258
M18 X 1.5		85	111	140	170	225	313	376
M20 X 1.5		118	155	195	236	313	443	531
M22 X 1.5		159	210	262	313	420	590	708
M24 X 2		199	266	332	398	531	738	885
M27 X 2		291	387	483	579	774	1106	1328
M30 X 2		398	535	667	800	1069	1512	1844
M36 X 3	686	922	1151	1379	1844	2581	3024	



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Table 2: Screws with loctite:

Dimension		Torque (ft.lb)						
		4.6	4.8	5.8/22H/45H	6.8	8.8	10.9	12.9
Standard Thread	M4	0.8	1.0	1.3	1.6	2.1	3.0	3.6
	M5	1.6	2.2	2.7	3.3	4.4	6.3	7.4
	M6	2.7	3.7	4.6	5.5	7.4	10.3	12.5
	M8	7	9	12	14	18	26	30
	M10	13	18	23	27	36	51	61
	M12	24	32	40	48	63	89	107
	M14	37	49	63	74	100	140	170
	M16	59	77	96	118	155	218	262
	M20	114	151	192	229	302	428	509
	M24	195	262	328	391	524	738	885
	M30	398	535	667	797	1069	1475	1770
	M36	723	959	1195	1438	1918	2729	3171
	Fine Pitch Thread	M8 X 1	7	10	13	15	20	28
M10 X 1		15	20	25	30	41	57	69
M10 X 1.25		14	19	24	29	38	54	65
M12 X 1.25		27	35	44	52	70	100	118
M12 X 1.5		26	33	41	50	66	92	111
M14 X 1.5		41	55	70	81	111	155	184
M16 X 1.5		63	83	103	125	166	232	280
M18 X 1.5		89	118	151	181	240	339	406
M20 X 1.5		125	170	214	254	339	472	568
M22 X 1.5		170	225	280	339	450	634	774
M24 X 2		214	288	361	431	575	811	959
M27 X 2		317	424	531	634	848	1180	1438
M30 X 2		443	590	738	885	1180	1659	1991
M36 X 3	767	1033	1291	1549	2065	2876	3393	



**\*\*\*\*\*ATTENTION\*\*\*\*\***

You have been provided information on conversion, repair and/or service of Linde components. Proper application of the information requires specific training and may require use of specialized tooling and equipment. If you choose to proceed with the conversion, repair and/or service of the Linde component(s) absent the necessary training and/or these specialized tools, you do so at your risk.

Linde Hydraulics Corporation will accept no claim for warranty or other consideration resulting from deficiencies in the conversion, repair and/or service done in accordance with the guidance offered herein when the necessary training has not been conducted and/or required specialized tooling and equipment has not been utilized.

All requests for training must be coordinated through your Linde Account Manager. He can also provide you price and availability of any specialized tooling.

Questions regarding the information provided or this disclaimer should be addressed to the Warranty & Service Department, Linde Hydraulics Corporation.

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