

**1150M**  
**Tier 2**  
**Crawler Dozer**  
*PIN NGC105100 and above*

**SERVICE MANUAL**

**Part number 48080035**

1<sup>st</sup> edition English

April 2017





## **SERVICE MANUAL**

**1150M Power Angle Tilt (PAT) Blade, Long Track (LT) - Tier 2 [NGC105100 - ]**  
**1150M Power Angle Tilt (PAT) Blade, Wide Track (WT) - Tier 2 [NGC105100 - ]**

## Link Product / Engine

Product	Market Product	Engine
1150M Power Angle Tilt (PAT) Blade, Long Track (LT) - Tier 2 [NGC105100 - ]	Middle East Africa	F4HFA613L*E002
1150M Power Angle Tilt (PAT) Blade, Long Track (LT) - Tier 2 [NGC105100 - ]	Latin America	F4HFA613L*E002
1150M Power Angle Tilt (PAT) Blade, Long Track (LT) - Tier 2 [NGC105100 - ]	Asia Pacific	F4HFA613L*E002
1150M Power Angle Tilt (PAT) Blade, Long Track (LT) - Tier 2 [NGC105100 - ]	Australia New Zealand	F4HFA613L*E002
1150M Power Angle Tilt (PAT) Blade, Wide Track (WT) - Tier 2 [NGC105100 - ]	Australia New Zealand	F4HFA613L*E002
1150M Power Angle Tilt (PAT) Blade, Wide Track (WT) - Tier 2 [NGC105100 - ]	Latin America	F4HFA613L*E002
1150M Power Angle Tilt (PAT) Blade, Wide Track (WT) - Tier 2 [NGC105100 - ]	Asia Pacific	F4HFA613L*E002
1150M Power Angle Tilt (PAT) Blade, Wide Track (WT) - Tier 2 [NGC105100 - ]	Middle East Africa	F4HFA613L*E002

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## **INTRODUCTION**



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## INTRODUCTION

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## Foreword - Important notice regarding equipment servicing

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All repair and maintenance work listed in this manual must be carried out only by qualified dealership personnel, strictly complying with the instructions given, and using, whenever possible, the special tools.

Anyone who performs repair and maintenance operations without complying with the procedures provided herein shall be responsible for any subsequent damages.

The manufacturer and all the organizations of its distribution chain, including - without limitation - national, regional, or local dealers, reject any responsibility for damages caused by parts and/or components not approved by the manufacturer, including those used for the servicing or repair of the product manufactured or marketed by the manufacturer. In any case, no warranty is given or attributed on the product manufactured or marketed by the manufacturer in case of damages caused by parts and/or components not approved by the manufacturer.

The manufacturer reserves the right to make improvements in design and changes in specifications at any time without notice and without incurring any obligation to install them on units previously sold. Specifications, descriptions, and illustrative material herein are as accurate as known at time of publication but are subject to change without notice.

In case of questions, refer to your CASE CONSTRUCTION Sales and Service Networks.

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## Safety rules

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### Personal safety





This is the safety alert symbol. It is used to alert you to potential personal injury hazards. Obey all safety messages that follow this symbol to avoid possible death or injury.

Throughout this manual you will find the signal words DANGER, WARNING, and CAUTION followed by special instructions. These precautions are intended for the personal safety of you and those working with you.

Read and understand all the safety messages in this manual before you operate or service the machine.

 DANGER indicates a hazardous situation that, if not avoided, will result in death or serious injury.

 WARNING indicates a hazardous situation that, if not avoided, could result in death or serious injury.

 CAUTION indicates a hazardous situation that, if not avoided, could result in minor or moderate injury.

**FAILURE TO FOLLOW DANGER, WARNING, AND CAUTION MESSAGES COULD RESULT IN DEATH OR SERIOUS INJURY.**

### Machine safety

**NOTICE:** Notice indicates a situation that, if not avoided, could result in machine or property damage.

Throughout this manual you will find the signal word Notice followed by special instructions to prevent machine or property damage. The word Notice is used to address practices not related to personal safety.

### Information

**NOTE:** Note indicates additional information that clarifies steps, procedures, or other information in this manual.

Throughout this manual you will find the word Note followed by additional information about a step, procedure, or other information in the manual. The word Note is not intended to address personal safety or property damage.

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## Safety rules - Personal safety

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### **General maintenance safety**

Keep area used for servicing the machine clean and dry. Clean up spilled fluids.

Service machine on a firm level surface.

Install guards and shields after servicing the machine.

Close all access doors and install all panels after servicing the machine.

Do not attempt to clean, lubricate, clear obstructions or make adjustments to the machine while it is in motion or while the engine is running.

Always make sure working area is clear of tools, parts, other persons and pets before you start operating the machine.

Unsupported hydraulic cylinders can lose pressure and drop the equipment causing a crushing hazard. Do not leave equipment in a raised position while parked or during service, unless securely supported.

Jack or lift the machine only at jack or lift points indicated in this manual.

Incorrect towing procedures can cause accidents. When towing a disabled machine follow the procedure in this manual. Use only rigid tow bars.

Stop the engine, remove key and relieve pressure before disconnecting or connecting fluid lines.

Stop the engine and remove key before disconnecting or connecting electrical connections.

Scalding can result from incorrect removal of coolant caps. Cooling system operates under pressure. Hot coolant can spray out if a cap is removed while the system is hot. Allow system to cool before removing cap. When removing a cap turn it slowly to allow pressure to escape before completely removing the cap.

Replace damaged or worn tubes, hoses, electrical wiring, etc.

Engine, transmission, exhaust components, and hydraulic lines may become hot during operation. Take care when servicing such components. Allow surfaces to cool before handling or disconnecting hot components. Wear protective equipment when appropriate.

When welding, follow the instructions in the manual. Always disconnect the battery before welding on the machine. Always wash your hands after handling battery components.

### **General battery safety**

Always wear eye protection when working with batteries.

Do not create sparks or have open flame near battery.

Ventilate when charging or using in an enclosed area.

Disconnect negative (-) first and reconnect negative (-) last.

When welding on the machine, disconnect both terminals of the battery.

Do not weld, grind, or smoke near a battery.

When using auxiliary batteries or connecting jumper cables to start the engine, use the procedure shown in the operator's manual. Do not short across terminals.

Follow manufacturer's instructions when storing and handling batteries.

Battery post, terminals, and related accessories contain lead and lead compounds. Wash hands after handling. This is a California Proposition 65 warning.

Battery acid causes burns. Batteries contain sulfuric acid. Avoid contact with skin, eyes, or clothing. Antidote (external): Flush with water. Antidote (eyes): flush with water for 15 minutes and seek medical attention immediately. Antidote (internal): Drink large quantities of water or milk. Do not induce vomiting. Seek medical attention immediately.

Keep out of reach of children and other unauthorized persons.

** Air-conditioning system **

The air-conditioning system is under high pressure. Do not disconnect any lines. The release of high pressure can cause serious injury.

The air-conditioning system contains gases that are harmful to the environment when released into the atmosphere. Do not attempt to service or repair the system.

Service, repair, or recharging must be performed only by a trained service technician.

** Personal Protective Equipment (PPE) **

Wear Personal Protective Equipment (PPE) such as hard hat, eye protection, heavy gloves, hearing protection, protective clothing, etc.

** Do Not Operate tag **

Before you start servicing the machine, attach a 'Do Not Operate' warning tag to the machine in an area that will be visible.

## Safety rules - Ecology and the environment

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Soil, air, and water quality is important for all industries and life in general. When legislation does not yet rule the treatment of some of the substances that advanced technology requires, sound judgment should govern the use and disposal of products of a chemical and petrochemical nature.

Familiarize yourself with the relative legislation applicable to your country, and make sure that you understand this legislation. Where no legislation exists, obtain information from suppliers of oils, filters, batteries, fuels, anti-freeze, cleaning agents, etc., with regard to the effect of these substances on man and nature and how to safely store, use, and dispose of these substances.

### Helpful hints

- Avoid the use of cans or other inappropriate pressurized fuel delivery systems to fill tanks. Such delivery systems may cause considerable spillage.
- In general, avoid skin contact with all fuels, oils, acids, solvents, etc. Most of these products contain substances that may be harmful to your health.
- Modern oils contain additives. Do not burn contaminated fuels and or waste oils in ordinary heating systems.
- Avoid spillage when you drain fluids such as used engine coolant mixtures, engine oil, hydraulic fluid, brake fluid, etc. Do not mix drained brake fluids or fuels with lubricants. Store all drained fluids safely until you can dispose of the fluids in a proper way that complies with all local legislation and available resources.
- Do not allow coolant mixtures to get into the soil. Collect and dispose of coolant mixtures properly.
- The air-conditioning system contains gases that should not be released into the atmosphere. Consult an air-conditioning specialist or use a special extractor to recharge the system properly.
- Repair any leaks or defects in the engine cooling system or hydraulic system immediately.
- Do not increase the pressure in a pressurized circuit as this may lead to a component failure.
- Protect hoses during welding. Penetrating weld splatter may burn a hole or weaken hoses, allowing the loss of oils, coolant, etc.

### Battery recycling

Batteries and electric accumulators contain several substances that can have a harmful effect on the environment if the batteries are not properly recycled after use. Improper disposal of batteries can contaminate the soil, groundwater, and waterways. CASE CONSTRUCTION strongly recommends that you return all used batteries to a CASE CONSTRUCTION dealer, who will dispose of the used batteries or recycle the used batteries properly. In some countries, this is a legal requirement.



### Mandatory battery recycling

**NOTE:** The following requirements are mandatory in Brazil.

Batteries are made of lead plates and a sulfuric acid solution. Because batteries contain heavy metals such as lead, CONAMA Resolution 401/2008 requires you to return all used batteries to the battery dealer when you replace any batteries. Do not dispose of batteries in your household garbage.

Points of sale are obliged to:

- Accept the return of your used batteries
- Store the returned batteries in a suitable location
- Send the returned batteries to the battery manufacturer for recycling

## Safety rules - Do not operate tag

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### **▲ WARNING**

**Maintenance hazard!**

**Before you start servicing the machine, attach a DO NOT OPERATE warning tag to the machine in a visible area.**

**Failure to comply could result in death or serious injury.**

W0004A

Attach a DO NOT OPERATE (TAG) to the machine in an area that is clearly visible whenever the machine is not operating properly and/or requires service.

Complete the tag information for the "REASON" the tag is attached by describing the malfunction or service required. Validate the reason for attaching the tag by signing your name in the designated area on the tag.

The tag should only be removed by the person who signed and attached the tag, after validating the repairs or services have been completed.

			
(A)	<div style="background-color: black; color: white; padding: 10px; font-weight: bold; font-size: 1.2em;">DO NOT REMOVE THIS TAG!</div>	<div style="background-color: black; color: white; padding: 10px; font-weight: bold; font-size: 1.5em;">DO NOT OPERATE</div>	(D)
(B)	<p>See Other Side</p> 	<p>REASON</p> <hr/> <hr/> <hr/> <hr/> <hr/> <hr/> <hr/> <hr/>	(E)
(C)	<p>CNH Part Number 87358697</p> <p>Printed in U.S.A.</p>	<p>Signed by</p> <hr/>	(F)
<p><small>87358697 1</small></p>			

### Tag Components

- A. DO NOT REMOVE THIS TAG! - (Warning) The tag should only be removed by the person who signed and attached the tag, after validating the repairs or services have been completed.
- B. See Other Side - (Reference to additional information on opposite side of the tag.)
- C. CNH Part Number - (Request this part number from you Service Parts Dealer to obtain this DO NOT OPERATE tag.)
- D. DO NOT OPERATE - (Warning!)
- E. REASON - (Area for describing malfunction or service required before operation.)
- F. Signed by - (Signature area - to be signed by the person validating the reason for installation of the tag.)

## Torque - Minimum tightening torques for normal assembly

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### METRIC NON-FLANGED HARDWARE

NOM. SIZE	CLASS 8.8 BOLT and CLASS 8 NUT		CLASS 10.9 BOLT and CLASS 10 NUT		LOCKNUT CL.8 W/CL8.8 BOLT	LOCKNUT CL.10 W/CL10.9 BOLT
	UNPLATED	PLATED W/ZnCr	UNPLATED	PLATED W/ZnCr		
M4	2.2 N·m (19 lb in)	2.9 N·m (26 lb in)	3.2 N·m (28 lb in)	4.2 N·m (37 lb in)	2 N·m (18 lb in)	2.9 N·m (26 lb in)
M5	4.5 N·m (40 lb in)	5.9 N·m (52 lb in)	6.4 N·m (57 lb in)	8.5 N·m (75 lb in)	4 N·m (36 lb in)	5.8 N·m (51 lb in)
M6	7.5 N·m (66 lb in)	10 N·m (89 lb in)	11 N·m (96 lb in)	15 N·m (128 lb in)	6.8 N·m (60 lb in)	10 N·m (89 lb in)
M8	18 N·m (163 lb in)	25 N·m (217 lb in)	26 N·m (234 lb in)	35 N·m (311 lb in)	17 N·m (151 lb in)	24 N·m (212 lb in)
M10	37 N·m (27 lb ft)	49 N·m (36 lb ft)	52 N·m (38 lb ft)	70 N·m (51 lb ft)	33 N·m (25 lb ft)	48 N·m (35 lb ft)
M12	64 N·m (47 lb ft)	85 N·m (63 lb ft)	91 N·m (67 lb ft)	121 N·m (90 lb ft)	58 N·m (43 lb ft)	83 N·m (61 lb ft)
M16	158 N·m (116 lb ft)	210 N·m (155 lb ft)	225 N·m (166 lb ft)	301 N·m (222 lb ft)	143 N·m (106 lb ft)	205 N·m (151 lb ft)
M20	319 N·m (235 lb ft)	425 N·m (313 lb ft)	440 N·m (325 lb ft)	587 N·m (433 lb ft)	290 N·m (214 lb ft)	400 N·m (295 lb ft)
M24	551 N·m (410 lb ft)	735 N·m (500 lb ft)	762 N·m (560 lb ft)	1016 N·m (750 lb ft)	501 N·m (370 lb ft)	693 N·m (510 lb ft)

**NOTE:** M4 through M8 hardware torque specifications are shown in pound-inches. M10 through M24 hardware torque specifications are shown in pound-feet.

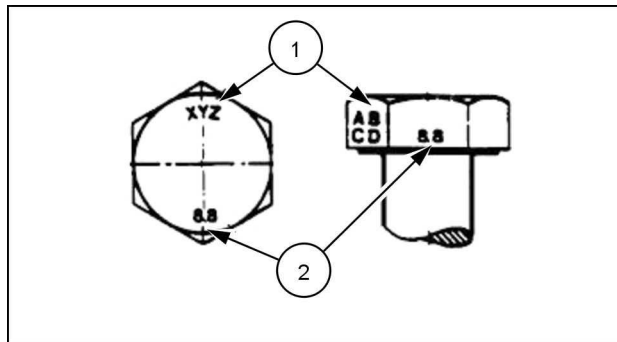


**METRIC FLANGED HARDWARE**

NOM. SIZE	CLASS 8.8 BOLT and CLASS 8 NUT		CLASS 10.9 BOLT and CLASS 10 NUT		LOCKNUT CL.8 W/CL8.8 BOLT	LOCKNUT CL.10 W/CL10.9 BOLT
	UNPLATED	PLATED W/ZnCr	UNPLATED	PLATED W/ZnCr		
M4	2.4 N·m (21 lb in)	3.2 N·m (28 lb in)	3.5 N·m (31 lb in)	4.6 N·m (41 lb in)	2.2 N·m (19 lb in)	3.1 N·m (27 lb in)
M5	4.9 N·m (43 lb in)	6.5 N·m (58 lb in)	7.0 N·m (62 lb in)	9.4 N·m (83 lb in)	4.4 N·m (39 lb in)	6.4 N·m (57 lb in)
M6	8.3 N·m (73 lb in)	11 N·m (96 lb in)	12 N·m (105 lb in)	16 N·m (141 lb in)	7.5 N·m (66 lb in)	11 N·m (96 lb in)
M8	20 N·m (179 lb in)	27 N·m (240 lb in)	29 N·m (257 lb in)	39 N·m (343 lb in)	18 N·m (163 lb in)	27 N·m (240 lb in)
M10	40 N·m (30 lb ft)	54 N·m (40 lb ft)	57 N·m (42 lb ft)	77 N·m (56 lb ft)	37 N·m (27 lb ft)	53 N·m (39 lb ft)
M12	70 N·m (52 lb ft)	93 N·m (69 lb ft)	100 N·m (74 lb ft)	134 N·m (98 lb ft)	63 N·m (47 lb ft)	91 N·m (67 lb ft)
M16	174 N·m (128 lb ft)	231 N·m (171 lb ft)	248 N·m (183 lb ft)	331 N·m (244 lb ft)	158 N·m (116 lb ft)	226 N·m (167 lb ft)
M20	350 N·m (259 lb ft)	467 N·m (345 lb ft)	484 N·m (357 lb ft)	645 N·m (476 lb ft)	318 N·m (235 lb ft)	440 N·m (325 lb ft)
M24	607 N·m (447 lb ft)	809 N·m (597 lb ft)	838 N·m (618 lb ft)	1118 N·m (824 lb ft)	552 N·m (407 lb ft)	

**IDENTIFICATION**

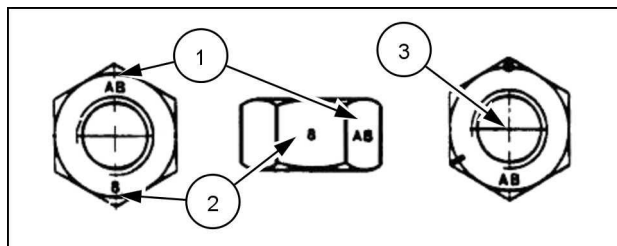
**Metric Hex head and carriage bolts, classes 5.6 and up**



20083680 1

1. Manufacturer's Identification
2. Property Class

**Metric Hex nuts and locknuts, classes 05 and up**



20083681 2

1. Manufacturer's Identification
2. Property Class
3. Clock Marking of Property Class and Manufacturer's Identification (Optional), i.e. marks **60°** apart indicate Class 10 properties, and marks **120°** apart indicate Class 8.

**INCH NON-FLANGED HARDWARE**

NOMINAL SIZE	SAE GRADE 5 BOLT and NUT		SAE GRADE 8 BOLT and NUT		LOCKNUT GrB W/ Gr5 BOLT	LOCKNUT GrC W/ Gr8 BOLT
	UN-PLATED or PLATED SILVER	PLATED W/ZnCr GOLD	UN-PLATED or PLATED SILVER	PLATED W/ZnCr GOLD		
1/4	8 N·m (71 lb in)	11 N·m (97 lb in)	12 N·m (106 lb in)	16 N·m (142 lb in)	8.5 N·m (75 lb in)	12.2 N·m (109 lb in)
5/16	17 N·m (150 lb in)	23 N·m (204 lb in)	24 N·m (212 lb in)	32 N·m (283 lb in)	17.5 N·m (155 lb in)	25 N·m (220 lb in)
3/8	30 N·m (22 lb ft)	40 N·m (30 lb ft)	43 N·m (31 lb ft)	57 N·m (42 lb ft)	31 N·m (23 lb ft)	44 N·m (33 lb ft)
7/16	48 N·m (36 lb ft)	65 N·m (48 lb ft)	68 N·m (50 lb ft)	91 N·m (67 lb ft)	50 N·m (37 lb ft)	71 N·m (53 lb ft)
1/2	74 N·m (54 lb ft)	98 N·m (73 lb ft)	104 N·m (77 lb ft)	139 N·m (103 lb ft)	76 N·m (56 lb ft)	108 N·m (80 lb ft)
9/16	107 N·m (79 lb ft)	142 N·m (105 lb ft)	150 N·m (111 lb ft)	201 N·m (148 lb ft)	111 N·m (82 lb ft)	156 N·m (115 lb ft)
5/8	147 N·m (108 lb ft)	196 N·m (145 lb ft)	208 N·m (153 lb ft)	277 N·m (204 lb ft)	153 N·m (113 lb ft)	215 N·m (159 lb ft)
3/4	261 N·m (193 lb ft)	348 N·m (257 lb ft)	369 N·m (272 lb ft)	491 N·m (362 lb ft)	271 N·m (200 lb ft)	383 N·m (282 lb ft)
7/8	420 N·m (310 lb ft)	561 N·m (413 lb ft)	594 N·m (438 lb ft)	791 N·m (584 lb ft)	437 N·m (323 lb ft)	617 N·m (455 lb ft)
1	630 N·m (465 lb ft)	841 N·m (620 lb ft)	890 N·m (656 lb ft)	1187 N·m (875 lb ft)	654 N·m (483 lb ft)	924 N·m (681 lb ft)

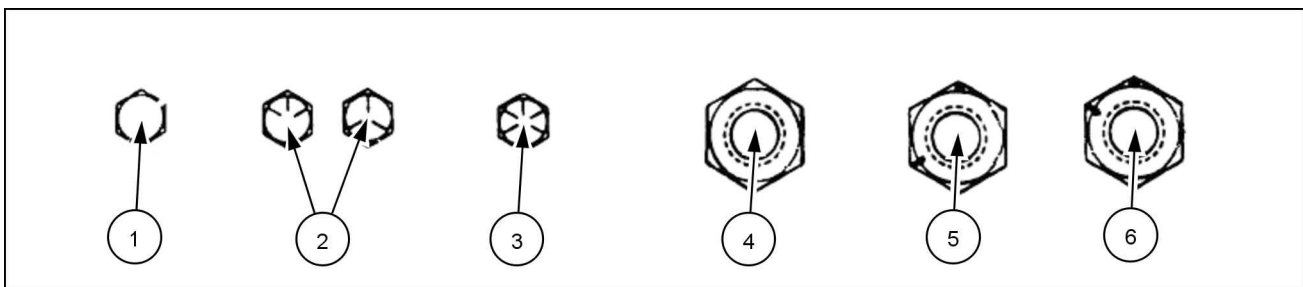
**NOTE:** For Imperial Units, *1/4 in* and *5/16 in* hardware torque specifications are shown in pound-inches. *3/8 in* through *1 in* hardware torque specifications are shown in pound-feet.

**INCH FLANGED HARDWARE**

NOM- INAL SIZE	SAE GRADE 5 BOLT and NUT		SAE GRADE 8 BOLT and NUT		LOCKNUT GrF W/ Gr5 BOLT	LOCKNUT GrG W/ Gr8 BOLT
	UNPLATED or PLATED SILVER	PLATED W/ZnCr GOLD	UNPLATED or PLATED SILVER	PLATED W/ZnCr GOLD		
1/4	9 N·m (80 lb in)	12 N·m (106 lb in)	13 N·m (115 lb in)	17 N·m (150 lb in)	8 N·m (71 lb in)	12 N·m (106 lb in)
5/16	19 N·m (168 lb in)	25 N·m (221 lb in)	26 N·m (230 lb in)	35 N·m (310 lb in)	17 N·m (150 lb in)	24 N·m (212 lb in)
3/8	33 N·m (25 lb ft)	44 N·m (33 lb ft)	47 N·m (35 lb ft)	63 N·m (46 lb ft)	30 N·m (22 lb ft)	43 N·m (32 lb ft)
7/16	53 N·m (39 lb ft)	71 N·m (52 lb ft)	75 N·m (55 lb ft)	100 N·m (74 lb ft)	48 N·m (35 lb ft)	68 N·m (50 lb ft)
1/2	81 N·m (60 lb ft)	108 N·m (80 lb ft)	115 N·m (85 lb ft)	153 N·m (113 lb ft)	74 N·m (55 lb ft)	104 N·m (77 lb ft)
9/16	117 N·m (86 lb ft)	156 N·m (115 lb ft)	165 N·m (122 lb ft)	221 N·m (163 lb ft)	106 N·m (78 lb ft)	157 N·m (116 lb ft)
5/8	162 N·m (119 lb ft)	216 N·m (159 lb ft)	228 N·m (168 lb ft)	304 N·m (225 lb ft)	147 N·m (108 lb ft)	207 N·m (153 lb ft)
3/4	287 N·m (212 lb ft)	383 N·m (282 lb ft)	405 N·m (299 lb ft)	541 N·m (399 lb ft)	261 N·m (193 lb ft)	369 N·m (272 lb ft)
7/8	462 N·m (341 lb ft)	617 N·m (455 lb ft)	653 N·m (482 lb ft)	871 N·m (642 lb ft)	421 N·m (311 lb ft)	594 N·m (438 lb ft)
1	693 N·m (512 lb ft)	925 N·m (682 lb ft)	979 N·m (722 lb ft)	1305 N·m (963 lb ft)	631 N·m (465 lb ft)	890 N·m (656 lb ft)

**IDENTIFICATION**

**Inch Bolts and free-spinning nuts**

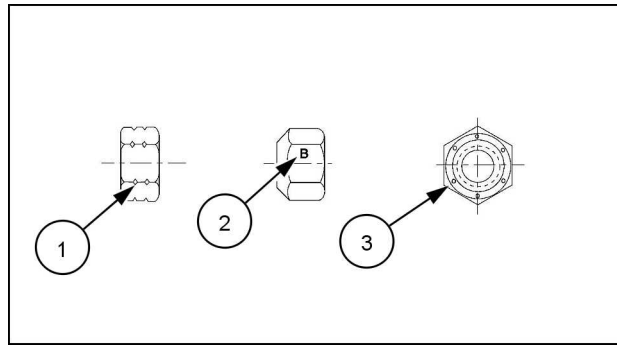


20083682 3

**Grade Marking Examples**

SAE Grade Identification			
1	Grade 2 - No Marks	4	Grade 2 Nut - No Marks
2	Grade 5 - Three Marks	5	Grade 5 Nut - Marks 120° Apart
3	Grade 8 - Five Marks	6	Grade 8 Nut - Marks 60° Apart

**Inch Lock Nuts, All Metal (Three optional methods)**



20090268 4

**Grade Identification**

Grade	Corner Marking Method (1)	Flats Marking Method (2)	Clock Marking Method (3)
Grade A	No Notches	No Mark	No Marks
Grade B	One Circumferential Notch	Letter B	Three Marks
Grade C	Two Circumferential Notches	Letter C	Six Marks

## Torque - Standard torque data for hydraulics

1150M

ANZ --- APAC --- LA --- MEA

**NOTICE:** Hydraulic connections require a minimum assembly torque in order to provide zero leakage at rated pressure with adequate fatigue resistance. Too much torque on a hydraulic connection can lead to leakage or failure.

**NOTICE:** There are several different kinds of parallel thread ports, including those using metric threads, inch threads, and British Standard Pipe Parallel (BSPP) threads. None of these port systems are interchangeable, and using the wrong connector in a port will not provide an adequate seal, even if it is possible to install the part.

**NOTE:** Hand install and hand tighten all connections before using tools to set the torque. This will reduce the possibility of thread damage.

### Torques for Metric O-Ring Boss (ORB) stud ends and port connections

Metric Thread	S-Series (Heavy Duty)		L-Series (Light Duty)	
	Ferrous	Non-Ferrous	Ferrous	Non-Ferrous
M8x1	10.5 N·m (7.7 lb ft)	6.3 N·m (4.6 lb ft)	8.5 N·m (6.3 lb ft)	5 N·m (3.7 lb ft)
M10x1	21 N·m (15.5 lb ft)	12.5 N·m (9.2 lb ft)	15.5 N·m (11.4 lb ft)	9.3 N·m (6.9 lb ft)
M12x1.5	37 N·m (27.3 lb ft)	22 N·m (16.2 lb ft)	27 N·m (19.9 lb ft)	16 N·m (11.8 lb ft)
M14x1.5	47 N·m (34.7 lb ft)	28 N·m (20.7 lb ft)	37 N·m (27.3 lb ft)	22 N·m (16.2 lb ft)
M16x1.5	58 N·m (42.8 lb ft)	35 N·m (25.8 lb ft)	42 N·m (31.0 lb ft)	25 N·m (18.4 lb ft)
M18x1.5	74 N·m (54.6 lb ft)	44 N·m (32.5 lb ft)	47 N·m (34.7 lb ft)	28 N·m (20.7 lb ft)
M22x1.5	105 N·m (77.4 lb ft)	63 N·m (46.5 lb ft)	63 N·m (46.5 lb ft)	38 N·m (28.0 lb ft)
M27x2	178 N·m (131.3 lb ft)	107 N·m (78.9 lb ft)	105 N·m (77.4 lb ft)	63 N·m (46.5 lb ft)
M30x2	225 N·m (166.0 lb ft)	135 N·m (99.6 lb ft)	136 N·m (100.3 lb ft)	82 N·m (60.5 lb ft)
M33x2	325 N·m (239.7 lb ft)	195 N·m (143.8 lb ft)	168 N·m (123.9 lb ft)	101 N·m (74.5 lb ft)
M42x2	345 N·m (254.5 lb ft)	207 N·m (152.7 lb ft)	220 N·m (162.3 lb ft)	132 N·m (97.4 lb ft)
M48x2	440 N·m (324.5 lb ft)	264 N·m (194.7 lb ft)	273 N·m (201.4 lb ft)	164 N·m (121.0 lb ft)
M60x2	525 N·m (387.2 lb ft)	315 N·m (232.3 lb ft)	330 N·m (243.4 lb ft)	198 N·m (146.0 lb ft)

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

### Torques for Metric O-Ring Boss (ORB) port plugs

Metric Thread	Ferrous		Non-Ferrous
	Internal Hex	External Hex	
M8x1	8.5 N·m (6.3 lb ft)	10.5 N·m (7.7 lb ft)	6.3 N·m (4.6 lb ft)
M10x1	16 N·m (11.8 lb ft)	21 N·m (15.5 lb ft)	12.5 N·m (9.2 lb ft)
M12x1.5	23 N·m (17.0 lb ft)	37 N·m (27.3 lb ft)	22 N·m (16.2 lb ft)
M14x1.5	47 N·m (34.7 lb ft)		28 N·m (20.7 lb ft)
M16x1.5	58 N·m (42.8 lb ft)		35 N·m (25.8 lb ft)
M18x1.5	74 N·m (54.6 lb ft)		44 N·m (32.5 lb ft)
M22x1.5	105 N·m (77.4 lb ft)		63 N·m (46.5 lb ft)
M27x2	178 N·m (131.3 lb ft)		107 N·m (78.9 lb ft)
M30x2	225 N·m (166.0 lb ft)		135 N·m (99.6 lb ft)
M33x2	325 N·m (239.7 lb ft)		195 N·m (143.8 lb ft)
M42x2	345 N·m (254.5 lb ft)		207 N·m (152.7 lb ft)
M48x2	440 N·m (324.5 lb ft)		264 N·m (194.7 lb ft)
M60x2	525 N·m (387.2 lb ft)		315 N·m (232.3 lb ft)

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

INTRODUCTION

**Torques for British Standard Pipe Parallel (BSPP) straight-pipe-thread port connections**

BSPP Thread	Metric Tube OD		Ferrous		Non-Ferrous	
	S-Series (Heavy Duty)	L-Series (Light Duty)	S-Series (Heavy Duty)	L-Series (Light Duty)	S-Series (Heavy Duty)	L-Series (Light Duty)
G 1/8 A	—	6 mm	—	21 N·m (15.5 lb ft)	—	12.5 N·m (9.2 lb ft)
G 1/4 A	6 mm	8 mm	63 N·m (46.5 lb ft)	53 N·m (39.1 lb ft)	38 N·m (28.0 lb ft)	32 N·m (23.6 lb ft)
	8 mm	10 mm				
G 3/8 A	10 mm	12 mm	95 N·m (70.1 lb ft)	84 N·m (62.0 lb ft)	57 N·m (42.0 lb ft)	50 N·m (36.9 lb ft)
	12 mm					
G 1/2 A	16 mm	15 mm	136 N·m (100.3 lb ft)	105 N·m (77.4 lb ft)	82 N·m (60.5 lb ft)	63 N·m (46.5 lb ft)
		18 mm				
G 3/4 A	20 mm	22 mm	210 N·m (154.9 lb ft)	210 N·m (154.9 lb ft)	126 N·m (92.9 lb ft)	126 N·m (92.9 lb ft)
G 1 A	25 mm	28 mm	400 N·m (295.0 lb ft)	400 N·m (295.0 lb ft)	240 N·m (177.0 lb ft)	240 N·m (177.0 lb ft)
G 1-1/4 A	30 mm	35 mm	525 N·m (387.2 lb ft)	525 N·m (387.2 lb ft)	315 N·m (232.3 lb ft)	315 N·m (232.3 lb ft)
G 1-1/2 A	38 mm	42 mm	660 N·m (486.8 lb ft)	660 N·m (486.8 lb ft)	396 N·m (292.1 lb ft)	396 N·m (292.1 lb ft)

**NOTE:** Final torque tolerance is +/- 10% of the given torque specification.

INTRODUCTION

**Torques for Metric O-Ring Face Seal (ORFS) ports and stud end connections**

BSP Thread	Metric Tube OD		Ferrous		Non-Ferrous	
	S-Series (Heavy Duty)	L-Series (Light Duty)	S-Series (Heavy Duty)	L-Series (Light Duty)	S-Series (Heavy Duty)	L-Series (Light Duty)
M10x1	—	4 mm	—	21 N·m (15.5 lb ft)	—	12.5 N·m (9.2 lb ft)
M12x1.5	4 mm	6 mm	47 N·m (34.7 lb ft)	32 N·m (23.6 lb ft)	28 N·m (20.7 lb ft)	19 N·m (14.0 lb ft)
M14x1.5	5 mm	7 mm	63 N·m (46.5 lb ft)	53 N·m (39.1 lb ft)	38 N·m (28.0 lb ft)	32 N·m (23.6 lb ft)
M16x1.5	7 mm	9 mm	84 N·m (62.0 lb ft)	63 N·m (46.5 lb ft)	50 N·m (36.9 lb ft)	38 N·m (28.0 lb ft)
M18x1.5	8 mm	11 mm	105 N·m (77.4 lb ft)	84 N·m (62.0 lb ft)	63 N·m (46.5 lb ft)	50 N·m (36.9 lb ft)
M20x1.5	10 mm	—	147 N·m (108.4 lb ft)	—	88 N·m (64.9 lb ft)	—
M22x1.5	12 mm	14 mm	158 N·m (116.5 lb ft)	147 N·m (108.4 lb ft)	95 N·m (70.1 lb ft)	88 N·m (64.9 lb ft)
M26x1.5	—	18 mm	—	210 N·m (154.9 lb ft)	—	126 N·m (92.9 lb ft)
M27x1.2	16 mm	—	210 N·m (154.9 lb ft)	—	126 N·m (92.9 lb ft)	—
M33x2	20 mm	23 mm	400 N·m (295.0 lb ft)	400 N·m (295.0 lb ft)	240 N·m (177.0 lb ft)	240 N·m (177.0 lb ft)
M42x2	25 mm	30 mm	525 N·m (387.2 lb ft)	525 N·m (387.2 lb ft)	315 N·m (232.3 lb ft)	315 N·m (232.3 lb ft)
M48x2	32 mm	36 mm	630 N·m (464.7 lb ft)	630 N·m (464.7 lb ft)	396 N·m (292.1 lb ft)	396 N·m (292.1 lb ft)

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

INTRODUCTION

**Torques for Inch O-Ring Boss (ORB) non-adjustable port and stud end connections**

SAE Dash size	UN/UNF Thread size	Inch Tube OD	S-Series (Heavy Duty)		L-Series (Light Duty)	
			Ferrous	Non-Ferrous	Ferrous	Non-Ferrous
2	5/16-24	3.18 mm (0.125 in) 1/8	—	—	8.5 N·m (6.3 lb ft)	5 N·m (3.7 lb ft)
3	3/8-24	4.76 mm (0.187 in) 3/16	15.5 N·m (11.4 lb ft)	9.3 N·m (6.9 lb ft)	10.5 N·m (7.7 lb ft)	6.3 N·m (4.6 lb ft)
4	7/16-20	6.35 mm (0.25 in) 1/4	37 N·m (27.3 lb ft)	22 N·m (16.2 lb ft)	19 N·m (14.0 lb ft)	11.5 N·m (8.5 lb ft)
5	1/2-20	7.94 mm (0.313 in) 5/16	42 N·m (31.0 lb ft)	25 N·m (18.4 lb ft)	26 N·m (19.2 lb ft)	15.5 N·m (11.4 lb ft)
6	9/16-18	9.52 mm (0.375 in) 3/8	47 N·m (34.7 lb ft)	28 N·m (20.7 lb ft)	32 N·m (23.6 lb ft)	19 N·m (14.0 lb ft)
8	3/4-16	12.7 mm (0.5 in) 1/2	89 N·m (65.6 lb ft)	53 N·m (39.1 lb ft)	53 N·m (39.1 lb ft)	32 N·m (23.6 lb ft)
10	7/8-14	15.88 mm (0.625 in) 5/8	121 N·m (89.2 lb ft)	73 N·m (53.8 lb ft)	63 N·m (46.5 lb ft)	38 N·m (28.0 lb ft)
12	1-1/16-12	19.05 mm (0.75 in) 3/4	178 N·m (131.3 lb ft)	107 N·m (78.9 lb ft)	100 N·m (73.8 lb ft)	60 N·m (44.3 lb ft)
14	1-3/16-12	22.22 mm (0.875 in) 7/8	225 N·m (166.0 lb ft)	135 N·m (99.6 lb ft)	131 N·m (96.6 lb ft)	79 N·m (58.3 lb ft)
16	1-5/16-12	25.4 mm (1.0 in) 1	283 N·m (208.7 lb ft)	170 N·m (125.4 lb ft)	156 N·m (115.1 lb ft)	94 N·m (69.3 lb ft)
20	1-5/8-12	31.75 mm (1.25 in) 1-1/4	300 N·m (221.3 lb ft)	180 N·m (132.8 lb ft)	210 N·m (154.9 lb ft)	126 N·m (92.9 lb ft)
24	1-7/8-12	38.1 mm (1.5 in) 1-1/2	388 N·m (286.2 lb ft)	233 N·m (171.9 lb ft)	220 N·m (162.3 lb ft)	132 N·m (97.4 lb ft)
32	2-1/2-12	50.8 mm (2.0 in) 2	388 N·m (286.2 lb ft)	233 N·m (171.9 lb ft)	315 N·m (232.3 lb ft)	189 N·m (139.4 lb ft)

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.



INTRODUCTION

**Torques for Inch O-Ring Boss (ORB) adjustable stud end and port connections**

SAE Dash size	UN/UNF Thread size	Inch Tube OD	S-Series (Heavy Duty)		L-Series (Light Duty)	
			Ferrous	Non-Ferrous	Ferrous	Non-Ferrous
2	5/16-24	3.18 mm (0.125 in) 1/8	—	—	8.5 N·m (6.3 lb ft)	5 N·m (3.7 lb ft)
3	3/8-24	4.76 mm (0.187 in) 3/16	10.5 N·m (7.7 lb ft)	9.3 N·m (6.9 lb ft)	10.5 N·m (7.7 lb ft)	6.3 N·m (4.6 lb ft)
4	7/16-20	6.35 mm (0.25 in) 1/4	21 N·m (15.5 lb ft)	21 N·m (15.5 lb ft)	19 N·m (14.0 lb ft)	11.5 N·m (8.5 lb ft)
5	1/2-20	7.94 mm (0.313 in) 5/16	42 N·m (31.0 lb ft)	25 N·m (18.4 lb ft)	26 N·m (19.2 lb ft)	15.5 N·m (11.4 lb ft)
6	9/16-18	9.52 mm (0.375 in) 3/8	47 N·m (34.7 lb ft)	28 N·m (20.7 lb ft)	32 N·m (23.6 lb ft)	19 N·m (14.0 lb ft)
8	3/4-16	12.7 mm (0.5 in) 1/2	89 N·m (65.6 lb ft)	53 N·m (39.1 lb ft)	53 N·m (39.1 lb ft)	32 N·m (23.6 lb ft)
10	7/8-14	15.88 mm (0.625 in) 5/8	121 N·m (89.2 lb ft)	73 N·m (53.8 lb ft)	63 N·m (46.5 lb ft)	38 N·m (28.0 lb ft)
12	1-1/16-12	19.05 mm (0.75 in) 3/4	178 N·m (131.3 lb ft)	107 N·m (78.9 lb ft)	100 N·m (73.8 lb ft)	60 N·m (44.3 lb ft)
14	1-3/16-12	22.22 mm (0.875 in) 7/8	225 N·m (166.0 lb ft)	135 N·m (99.6 lb ft)	131 N·m (96.6 lb ft)	79 N·m (58.3 lb ft)
16	1-5/16-12	25.4 mm (1.0 in) 1	285 N·m (210.2 lb ft)	170 N·m (125.4 lb ft)	156 N·m (115.1 lb ft)	94 N·m (69.3 lb ft)
20	1-5/8-12	31.75 mm (1.25 in) 1-1/4	300 N·m (221.3 lb ft)	180 N·m (132.8 lb ft)	210 N·m (154.9 lb ft)	126 N·m (92.9 lb ft)
24	1-7/8-12	38.1 mm (1.5 in) 1-1/2	388 N·m (286.2 lb ft)	233 N·m (171.9 lb ft)	220 N·m (162.3 lb ft)	132 N·m (97.4 lb ft)
32	2-1/2-12	50.8 mm (2.0 in) 2	388 N·m (286.2 lb ft)	233 N·m (171.9 lb ft)	315 N·m (232.3 lb ft)	189 N·m (139.4 lb ft)

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

INTRODUCTION

**Torques for Inch O-Ring Boss (ORB) port plug**

SAE Dash size	UN/UNF Thread size	Ferrous		Non-Ferrous
		Internal Hex	External Hex	
2	5/16-24	7.5 N·m (5.5 lb ft)	12.5 N·m (9.2 lb ft)	7.5 N·m (5.5 lb ft)
3	3/8-24	14.5 N·m (10.7 lb ft)	21 N·m (15.5 lb ft)	12.5 N·m (9.2 lb ft)
4	7/16-20	21 N·m (15.5 lb ft)	37 N·m (27.3 lb ft)	22 N·m (16.2 lb ft)
5	1/2-20	28 N·m (20.7 lb ft)	42 N·m (31.0 lb ft)	25 N·m (18.4 lb ft)
6	9/16-18	47 N·m (34.7 lb ft)	47 N·m (34.7 lb ft)	28 N·m (20.7 lb ft)
8	3/4-16	89 N·m (65.6 lb ft)	89 N·m (65.6 lb ft)	53 N·m (39.1 lb ft)
10	7/8-14	116 N·m (85.6 lb ft)	116 N·m (85.6 lb ft)	70 N·m (51.6 lb ft)
12	1-1/16-12	176 N·m (129.8 lb ft)	176 N·m (129.8 lb ft)	106 N·m (78.2 lb ft)
14	1-3/16-12	247 N·m (182.2 lb ft)	247 N·m (182.2 lb ft)	148 N·m (109.2 lb ft)
16	1-5/16-12	284 N·m (209.5 lb ft)	284 N·m (209.5 lb ft)	170 N·m (125.4 lb ft)
20	1-5/8-12	357 N·m (263.3 lb ft)	357 N·m (263.3 lb ft)	214 N·m (157.8 lb ft)
24	1-7/8-12	441 N·m (325.3 lb ft)	441 N·m (325.3 lb ft)	265 N·m (195.5 lb ft)
32	2-1/2-12	536 N·m (395.3 lb ft)	536 N·m (395.3 lb ft)	322 N·m (237.5 lb ft)

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

INTRODUCTION

**Torques for O-Ring Face Seal (ORFS) hose connectors**

SAE Dash size	UN/UNF Thread size	Tube OD	High/Medium pressure applications (greater than 50 bar (725 psi))	Low pressure applications (less than 50 bar (725 psi))
			Swivel nut torque	
4	9/16–18	6.35 mm (0.25 in) 1/4	27 N·m (19.9 lb ft)	27 N·m (19.9 lb ft)
5	5/8–18	7.94 mm (0.313 in) 5/16	34 N·m (25.1 lb ft)	34 N·m (25.1 lb ft)
6	11/16–16	9.52 mm (0.375 in) 3/8	44 N·m (32.5 lb ft)	44 N·m (32.5 lb ft)
8	13/16–16	12.7 mm (0.5 in) 1/2	65 N·m (47.9 lb ft)	65 N·m (47.9 lb ft)
10	1–14	15.88 mm (0.625 in) 5/8	100 N·m (73.8 lb ft)	100 N·m (73.8 lb ft)
12	1-3/16–12	19.05 mm (0.75 in) 3/4	150 N·m (110.6 lb ft)	131 N·m (96.6 lb ft)
14	1-5/16–12	22.22 mm (0.875 in) 7/8	163 N·m (120.2 lb ft)	131 N·m (96.6 lb ft)
16	1-7/16–12	25.4 mm (1.0 in) 1	210 N·m (154.9 lb ft)	131 N·m (96.6 lb ft)
20	1-11/16–12	31.75 mm (1.25 in) 1-1/4	280 N·m (206.5 lb ft)	178 N·m (131.3 lb ft)
24	2–12	38.1 mm (1.5 in) 1-1/2	375 N·m (276.6 lb ft)	210 N·m (154.9 lb ft)

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

INTRODUCTION

**Torques for four-bolt flange connections (Metric class 10.9)**

<b>Bolt Length</b>	<b>Bolt (SAE Code 61)</b>	<b>Torque (SAE Code 61)</b>	<b>Bolt (SAE Code 62)</b>	<b>Torque (SAE Code 62)</b>
13 mm (0.5 in)	M8x1.25	34 N·m (25.1 lb ft)	M8x1.25	34 N·m (25.1 lb ft)
19 mm (0.75 in)	M10x1.5	74 N·m (54.6 lb ft)	M10x1.5	74 N·m (54.6 lb ft)
25 mm (1.0 in)	M10x1.5	74 N·m (54.6 lb ft)	M12x1.75	137 N·m (101.0 lb ft)
32 mm (1.25 in)	M10x1.5	74 N·m (54.6 lb ft)	M12x1.75	137 N·m (101.0 lb ft)
			M14x1.5	189 N·m (139.4 lb ft)
38 mm (1.5 in)	M12x1.75	137 N·m (101.0 lb ft)	M16x2	310 N·m (228.6 lb ft)
51 mm (2.0 in)	M12x1.75	137 N·m (101.0 lb ft)	M20x2.5	575 N·m (424.1 lb ft)
64 mm (2.5 in)	M12x1.75	137 N·m (101.0 lb ft)	M24x3	575 N·m (424.1 lb ft)
76 mm (3.0 in)	M16x2	310 N·m (228.6 lb ft)	M30x3.5	680 N·m (501.5 lb ft)
89 mm (3.5 in)	M16x2	310 N·m (228.6 lb ft)	—	—
102 mm (4.0 in)	M16x2	310 N·m (228.6 lb ft)	—	—
127 mm (5.0 in)	M16x2	310 N·m (228.6 lb ft)	—	—

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

**Torques for four-bolt flange connections (Metric class 8.8)**

<b>Bolt Length</b>	<b>Bolt (SAE Code 61)</b>	<b>Torque (SAE Code 61)</b>	<b>Bolt (SAE Code 62)</b>	<b>Torque (SAE Code 62)</b>
13 mm (0.5 in)	M8x1.25	29 N·m (21.4 lb ft)	M8x1.25	29 N·m (21.4 lb ft)
19 mm (0.75 in)	M10x1.5	57 N·m (42.0 lb ft)	M10x1.5	57 N·m (42.0 lb ft)
25 mm (1.0 in)	M10x1.5	57 N·m (42.0 lb ft)	M12x1.75	100 N·m (73.8 lb ft)
32 mm (1.25 in)	M10x1.5	57 N·m (42.0 lb ft)	M12x1.75	100 N·m (73.8 lb ft)
			M14x1.5	160 N·m (118.0 lb ft)
38 mm (1.5 in)	M12x1.75	100 N·m (73.8 lb ft)	M16x2	250 N·m (184.4 lb ft)
51 mm (2.0 in)	M12x1.75	100 N·m (73.8 lb ft)	M20x2.5	500 N·m (368.8 lb ft)
64 mm (2.5 in)	M12x1.75	100 N·m (73.8 lb ft)	M24x3	575 N·m (424.1 lb ft)
76 mm (3.0 in)	M16x2	250 N·m (184.4 lb ft)	M30x3.5	680 N·m (501.5 lb ft)
89 mm (3.5 in)	M16x2	250 N·m (184.4 lb ft)	—	—
102 mm (4.0 in)	M16x2	250 N·m (184.4 lb ft)	—	—
127 mm (5.0 in)	M16x2	250 N·m (184.4 lb ft)	—	—

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

INTRODUCTION

**Torques for four-bolt flange connections (Inch grade 8)**

<b>Bolt Length</b>	<b>Bolt (SAE Code 61)</b>	<b>Torque (SAE Code 61)</b>	<b>Bolt (SAE Code 62)</b>	<b>Torque (SAE Code 62)</b>
<b>13 mm (0.5 in)</b>	5/16-18	<b>34 N·m (25.1 lb ft)</b>	5/16-18	<b>34 N·m (25.1 lb ft)</b>
<b>19 mm (0.75 in)</b>	3/8-16	<b>63 N·m (46.5 lb ft)</b>	3/8-16	<b>63 N·m (46.5 lb ft)</b>
<b>25 mm (1.0 in)</b>	3/8-16	<b>63 N·m (46.5 lb ft)</b>	7/16-14	<b>97 N·m (71.5 lb ft)</b>
<b>32 mm (1.25 in)</b>	7/16-14	<b>97 N·m (71.5 lb ft)</b>	1/2-13	<b>158 N·m (116.5 lb ft)</b>
<b>38 mm (1.5 in)</b>	1/2-13	<b>158 N·m (116.5 lb ft)</b>	5/8-11	<b>310 N·m (228.6 lb ft)</b>
<b>51 mm (2.0 in)</b>	1/2-13	<b>158 N·m (116.5 lb ft)</b>	3/4-10	<b>473 N·m (348.9 lb ft)</b>
<b>64 mm (2.5 in)</b>	1/2-13	<b>158 N·m (116.5 lb ft)</b>	—	—
<b>76 mm (3.0 in)</b>	5/8-11	<b>310 N·m (228.6 lb ft)</b>	—	—
<b>89 mm (3.5 in)</b>	5/8-11	<b>310 N·m (228.6 lb ft)</b>	—	—
<b>102 mm (4.0 in)</b>	5/8-11	<b>310 N·m (228.6 lb ft)</b>	—	—
<b>127 mm (5.0 in)</b>	5/8-11	<b>310 N·m (228.6 lb ft)</b>	—	—

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

INTRODUCTION

**Tapered thread connection tightening**

BSPT Thread size	NPTF Thread size	Turns From Finger Tight (TFFT)
1/8–28	1/8–27	2 to 3 full turns
1/4–19	1/4–18	2 to 3 full turns
3/8–19	3/8–18	2 to 3 full turns
1/2–14	1/2–14	2 to 3 full turns
3/4–14	3/4–14	2 to 3 full turns
1–11	1–11-1/2	1-1/2 to 2-1/2 full turns
1-1/4–11	1-1/4–11-1/2	1-1/2 to 2-1/2 full turns
1-1/2–11	1-1/2–11-1/2	1-1/2 to 2-1/2 full turns
2–11	2–11-1/2	1-1/2 to 2-1/2 full turns

**Torques for Banjo-bolt connectors (copper washer style)**

Metric bolt thread	Hex size	Torque
M8x1.25	13 mm (0.5 in)	13 N·m (9.6 lb ft)
M10x1.25	17 mm (0.67 in)	16 N·m (11.8 lb ft)
M12x1.5	17 mm (0.67 in)	40 N·m (29.5 lb ft)
M14x1.5	19 mm (0.75 in)	45 N·m (33.2 lb ft)
M16x1.5	22 mm (0.9 in)	48 N·m (35.4 lb ft)
M18x1.5	24 mm (0.9 in)	50 N·m (36.9 lb ft)
M20x1.5	27 mm (1.1 in)	73 N·m (53.8 lb ft)
M22x1.5	32 mm (1.3 in)	73 N·m (53.8 lb ft)
M24x1.5	32 mm (1.3 in)	73 N·m (53.8 lb ft)

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

**Torques for 37° Flare hose connectors (JIC)**

SAE Dash size	UN/UNF Thread size	Tube OD	Swivel nut torque
2	5/16–24	3.18 mm (0.125 in) 1/8	8.25 N·m (6.1 lb ft)
3	3/8–24	4.76 mm (0.187 in) 3/16	11.5 N·m (8.5 lb ft)
4	7/16–20	6.35 mm (0.25 in) 1/4	15.5 N·m (11.4 lb ft)
5	1/2–20	7.94 mm (0.313 in) 5/16	20 N·m (14.8 lb ft)
6	9/16–18	9.52 mm (0.375 in) 3/8	25 N·m (18.4 lb ft)
8	3/4–16	12.7 mm (0.5 in) 1/2	52 N·m (38.4 lb ft)
10	7/8–14	15.88 mm (0.625 in) 5/8	81 N·m (59.7 lb ft)
12	1-1/16–12	19.05 mm (0.75 in) 3/4	112 N·m (82.6 lb ft)
14	1-3/16–12	22.22 mm (0.875 in) 7/8	133 N·m (98.1 lb ft)
16	1-5/16–12	25.4 mm (1.0 in) 1	155 N·m (114.3 lb ft)
20	1-5/8–12	31.75 mm (1.25 in) 1-1/4	180 N·m (132.8 lb ft)
24	1-7/8–12	38.1 mm (1.5 in) 1-1/2	225 N·m (166.0 lb ft)
32	2-1/2–12	50.8 mm (2.0 in) 2	348 N·m (256.7 lb ft)

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

**Torques for 30° Flare and 60° Cone hose connectors**

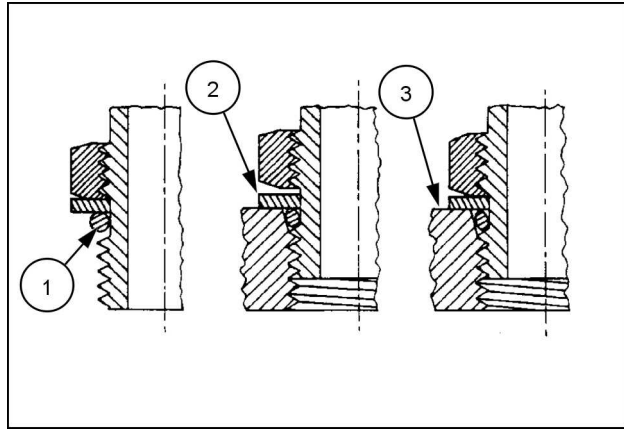
Nominal size	BSPP Thread size	Hex	Swivel nut torque
5, 6, 6.3	G 1/4	17.0 mm (0.7 in)	25 N·m (18.4 lb ft)
8, 9, 10	G 3/8	19.0 mm (0.7 in)	34 N·m (25.1 lb ft)
12, 12.54	G 1/2	22.0 mm (0.9 in)	64 N·m (47.2 lb ft)
15, 16, 19	G 3/4	30.0 mm (1.2 in)	132 N·m (97.4 lb ft)
25	G 1	36.0 mm (1.4 in)	196 N·m (144.6 lb ft)
31.5, 32	G 1-1/4	46.0 mm (1.8 in)	225 N·m (166.0 lb ft)
38	G 1-1/2	50.0 mm (2.0 in)	255 N·m (188.1 lb ft)
50, 51	G 2	65.0 mm (2.6 in)	316 N·m (233.1 lb ft)

**NOTE:** Final torque tolerance +/- 10% of the given torque specification.

## Installation of adjustable O-Ring Bosses (ORB) connectors

Adjustable port connectors are commonly found on shaped connectors, which allow for orientation of the connection. Adjustable port connectors utilize a locknut and back-up washer.

**NOTICE:** Teflon coated O-rings do not require lubrication. For connections which are made into aluminum manifolds or with stainless steel connectors, it may be required to apply a lubricant to prevent galling.



1. Remove protective connector caps only immediately prior to assembly.
2. Inspect the components to ensure that the male and female port threads and sealing surfaces are free of burrs, nicks, and scratches, or any foreign material. Do not use if impurities are found.
3. Make sure the washer (2) is on the fitting before the O-ring (1).
4. Back off the lock nut as far as possible. Make sure that the back-up washer is not loose and it is as far up on the connector as possible.
5. Screw the connector into the port until the back-up washer (2) or the retaining ring contacts the face of the port (3). Light wrenching may be necessary.
6. Unscrew the connector until you achieve the correct angle of the connector. Do not unscrew the connector more than one full turn.

**NOTICE:** Do not over tighten the connector you may damage the washer and increase the possibility of a leak to occur.

7. Using two wrenches, hold the position of the connector and tighten the locknut to the proper torque value. See the torque tables for the proper torque value.

**NOTICE:** Make sure that the O-ring is not pinched and that the washer is seated flat on the face of the port. Do not over tighten and distort the back-up washer.

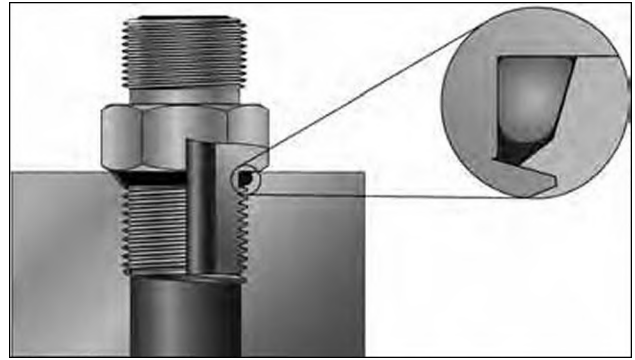
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## Installation of non-adjustable O-Ring Bosses (ORB) connectors

Non-adjustable port connectors are commonly found on straight connectors, which do not require the installer to adjust the orientation of the connection.

**NOTICE:** Teflon coated O-rings do not require lubrication. For connections which are made into aluminum manifolds or with stainless steel connectors, it may be required to apply a lubricant to prevent galling.

1. Remove protective connector caps only immediately prior to assembly.
2. Inspect the components to ensure that the male and female port threads and sealing surfaces are free of burrs, nicks, and scratches, or any foreign material. Do not use if impurities are found.
3. Install the connector by hand.
4. Tighten to the proper torque. See the torque tables for the proper torque value.



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## Installation of tapered thread connectors

1. Remove protective connector caps only immediately prior to assembly.

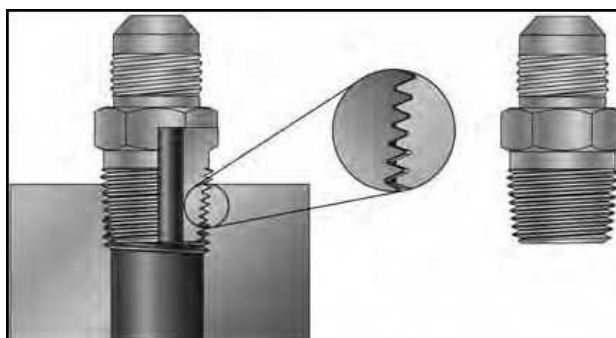
**NOTICE:** Pre-applied sealants, such as **LOCTITE® 503™ VIBRA-SEAL®** and/or powdered PTFE are the preferred sealants for tapered thread connectors. Non-preferred sealant types include PTFE tape, paste sealants, and anaerobic liquids. PTFE tape and paste sealants may contribute to hydraulic system contamination.

2. Inspect the components to ensure that the male and female port threads and sealing surfaces are free of burrs, nicks, and scratches, or any foreign material. Do not use if impurities are found.
3. Apply the sealant/lubricant to the male pipe threads, if not pre-applied. The first one or two threads should not have sealant applied to them to avoid system contamination.

**NOTICE:** If you require a specific orientation of a shaped connector, take into consideration that final position before you proceed with the next steps. Never back off (loosen) tapered thread connectors to achieve alignment you will increase the possibility of leaks.

4. Screw the connector into the port to the finger tight position.
5. Use a wrench to tighten the connector. See the torque table for the proper number of Turns From Finger Tight (TFFT).

**NOTE:** Normally, the total number of threads engaged should be between 3.5 and 6. If more than 6 threads are engaged, this may indicate an over-tightened connection. If fewer than 3.5 threads are engaged, this may indicate an under-tightened connection. For an over-tightened connection, check both threads and replace the part which has out-of-tolerance threads. If the connection is under-tightened, it is acceptable to tighten it further, but no more than one full turn.



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### Installation of flange connectors

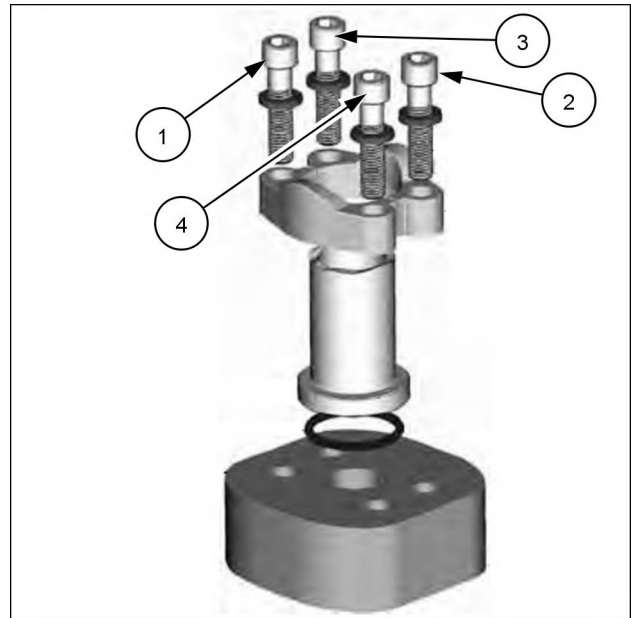
Flange connections typically have four bolts, although some flange connections may have more or fewer. The flange connector consists of four main components:

- A body (flange head)
- An O-ring
- One “captive” or two “split” flange clamps
- Bolts and washers

1. Remove protective connector caps only immediately prior to assembly.
2. Inspect the components to ensure that the male and female port threads and sealing surfaces are free of burrs, nicks, and scratches, or any foreign material. Do not use if impurities are found.
3. Place the O-ring in the groove, the groove will be either on the port side or the flange side.
4. Assemble the flange head and the clamps.
5. Position and hold the flange assembly over the port.
6. Finger tighten the bolt hardware evenly and in a crossing pattern.
7. Tighten the bolt hardware to **60%** of the torque value. Use the same crossing pattern. See the torque tables for the proper torque value.

**NOTE:** For bolt hardware that is not Metric Class 8.8 and 10.9 or Inch Grade 8 see the “Torque - Minimum tightening torques for normal assembly” **Torque - Minimum tightening torques for normal assembly ()**.

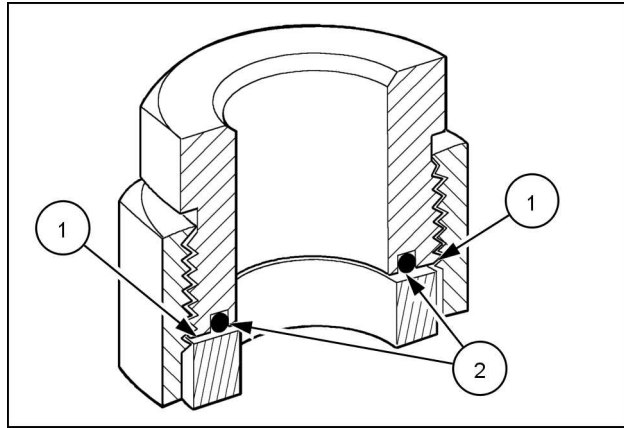
8. Tighten the bolt hardware 1 and 2 to **100%** of the torque value.
9. Tighten the bolt hardware 3 and 4 to **100%** of the torque value.



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## Installation of O-Ring Face Seal (ORFS) connections

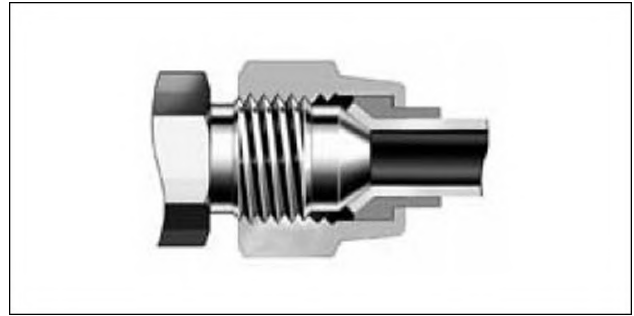
1. Remove protective connector caps only immediately prior to assembly.
2. Inspect the components to ensure that the male and female threads and sealing surfaces are free of burrs, nicks, and scratches, or any foreign material. Do not use if impurities are found.
3. Check that the seal is properly installed in the groove on the male connector. If the seal is not pre-installed on the connector body, it must be installed using an assembly tool:
  - A. Position the O-ring inside the assembly tool, against the plunger.
  - B. Position the tool over the ORFS male end until it is against the bottom of the tool.
  - C. Push the plunger of the tool until the O-ring is fully seated into the groove on the connector.
4. Place the face of the female connector against the face and O-ring of the male connector.
5. Thread the nut completely onto the male connector by hand.
6. Complete steps 1 through 5 for both ends of the hose or tube before continuing.
7. Hand-tighten any clamps that hold the position of the hose or tube.
8. Tighten the ORFS connection to the proper torque value. See the torque tables for the proper torque value.
9. Complete tightening of any clamps that hold the hose or tube only after both end fittings have been fully tightened.



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## Installation of Flare-less Bite type and Flared connections

1. Remove protective connector caps only immediately prior to assembly.
2. Inspect the components to ensure that the male and female threads and sealing surfaces are free of burrs, nicks, and scratches, or any foreign material. Do not use if impurities are found.
3. Place the face of the female connector against the face and O-ring of the male connector.
4. Thread the nut completely onto the male connector by hand.
5. Complete steps 1 through 5 for both ends of the hose or tube before continuing.
6. Hand-tighten any clamps that hold the position of the hose or tube.
7. Tighten the connection to the proper torque value. See the torque tables for the proper torque value.
8. Complete tightening of any clamps that hold the hose or tube only after both end fittings have been fully tightened.



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## Torque - Standard torque data for hydraulic connections

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### General information

- Hydraulic connections require a minimum assembly torque in order to provide zero leakage at rated pressure with adequate fatigue resistance. Over-torquing of a hydraulic connection can also lead to leakage or failure. For some connections, CASE CONSTRUCTION requires a different torque value than is listed in the ISO and SAE standards.
- The torque values in this document should be used whenever possible or applicable.

**NOTICE:** Always follow the instructions in this manual for specific torque values when you service components. The information in this section is for general guidance only when a procedure contains no specific torque value.

### Tolerance

- The tolerance for all torque values is  $\pm 10\%$ . This tolerance must include all assembly variation, not only the torque wrench repeatability.

### Lubrication

Application of grease or other lubricants to hydraulic connectors should be avoided. If clean hydraulic oil is already on the connection, it is not required to remove the oil. Generally, application of grease:

- May cause a significant change in the torque required to properly tighten the connection.
- May reduce the connection's resistance to vibration.
- Excessive grease may displace an elastomer seal during tightening.
- Grease extrusion when connection is tightened may be mistaken for leakage.

CASE CONSTRUCTION products generally use O-Ring Boss (ORB) connectors that have Teflon™-coated O-rings, eliminating the need for O-ring lubrication during installation. For connections which are made into aluminum manifolds or with stainless steel connectors, it may be required to apply a lubricant to prevent galling.

Use of **LOCTITE®** and other thread-locking compounds is prohibited. These compounds:

- May cause a significant change in the torque required to properly tighten the connections.
- Reduce the serviceability of the joint.
- May prevent the O-ring from properly sealing if the compound gets on the O-ring.

**Torque values for metric O-Ring Boss (ORB) port connections**

Metric thread	S-Series *		L-Series **	
	Ferrous N·m (lb ft) ± 10%	Non-Ferrous N·m (lb ft) ± 10%	Ferrous N·m (lb ft) ± 10%	Non-Ferrous N·m (lb ft) ± 10%
M8 x 1	10.5 (7.7)	6.3 (4.6)	8.5 (6.3)	5 (3.7)
M10 x 1	21 (15.5)	12.5 (9.2)	15.5 (11.4)	9.3 (6.9)
M12 x 1.5	37 (27.3)	22 (16.2)	27 (19.9)	16 (11.8)
M14 x 1.5	47 (34.7)	28 (20.7)	37 (27.3)	22 (16.2)
M16 x 1.5	58 (42.8)	35 (25.8)	42 (31)	25 (18.4)
M18 x 1.5	74 (54.6)	44 (32.5)	47 (34.7)	28 (20.7)
M22 x 1.5	105 (77.4)	63 (46.5)	63 (46.5)	38 (28)
M27 x 2	178 (131.3)	107 (78.9)	105 (77.4)	63 (46.5)
M30 x 2	225 (166)	135 (99.6)	136 (100.3)	82 (60.5)
M33 x 2	325 (239.7)	195 (143.8)	168 (123.9)	101 (74.5)
M42 x 2	345 (254.5)	207 (152.7)	220 (162.3)	132 (97.4)
M48 x 2	440 (324.5)	264 (194.7)	273 (201.4)	164 (121)
M60 x 2	525 (387.2)	315 (232.3)	330 (243.4)	198 (146)

\* S-Series connectors are used with O-Ring Face Seals (ORFS).

\*\* L-Series connectors are used with 37° flare.

**Torque values for metric O-Ring Boss (ORB) port plugs**

Metric thread	Ferrous		Non-ferrous
	Internal hex N·m (lb ft) ± 10%	External hex N·m (lb ft) ± 10%	N·m (lb ft) ± 10%
M8 x 1	8.5 (6.3)	10.5 (7.7)	6.3 (4.6)
M10 x 1	16 (11.8)	21 (15.5)	12.5 (9.2)
M12 x 1.5	23 (17)	37 (27.3)	22 (16.2)
M14 x 1.5	47 (34.7)	47 (34.7)	28 (20.7)
M16 x 1.5	58 (42.8)	58 (42.8)	35 (25.8)
M18 x 1.5	74 (54.6)	74 (54.6)	44 (32.5)
M22 x 1.5	105 (77.4)	105 (77.4)	63 (46.5)
M27 x 2	178 (131.3)	178 (131.3)	107 (78.9)
M30 x 2	225 (166)	225 (166)	135 (99.6)
M33 x 2	325 (239.7)	325 (239.7)	195 (143.8)
M42 x 2	345 (254.5)	345 (254.5)	207 (152.7)
M48 x 2	440 (324.5)	440 (324.5)	264 (194.7)
M60 x 2	525 (387.2)	525 (387.2)	315 (232.3)

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**Torque values for port connections (British Standard Pipe Parallel (BSPP) thread ports and stud ends)**

BSPP thread G- Gas; A- medium coarse threads	Metric tube Outside Diameter (OD) mm (in)		Ferrous		Non-Ferrous	
	S-Series *	L-Series **	S-Series N·m (lb ft) ± 10%	L-Series N·m (lb ft) ± 10%	S-Series N·m (lb ft) ± 10%	L-Series N·m (lb ft) ± 10%
G 1/8 A	–	6 (0.236)	–	21 (15.5)	–	12.5 (9.2)
G 1/4 A	6 (0.236) or 8 (0.315)	8 (0.315) or 10 (0.394)	63 (46.5)	53 (39.1)	38 (28)	32 (23.6)
G 3/8 A	10 (0.394) or 12 (0.472)	12 (0.472)	95 (70.1)	84 (62)	57 (42)	50 (36.9)
G 1/2 A	16 (0.630)	15 (0.591) or 18 (0.709)	136 (100.3)	105 (77.4)	82 (60.5)	63 (46.5)
G 3/4 A	20 (0.787)	22 (0.866)	210 (154.9)	210 (154.9)	126 (92.9)	126 (92.9)
G 1 A	25 (0.984)	28 (1.102)	400 (295)	400 (295)	240 (177)	240 (177)
G 1 1/4 A	30 (1.181)	35 (1.378)	525 (387.2)	525 (387.2)	315 (232.3)	315 (232.3)
G 1 1/2 A	38 (1.496)	42 (1.654)	660 (486.8)	660 (486.8)	396 (292.1)	396 (292.1)

\* S-Series connectors are used with O-Ring Face Seals (ORFS).

\*\* L-Series connectors are used with 37° flare.

**Torque values for metric port connections (Metric face-seal ports and stud ends)**

Metric thread	Metric tube Outside Diameter (OD) mm (in)		Ferrous		Non-Ferrous	
	S-Series *	L-Series **	S-Series N·m (lb ft) ± 10%	L-Series N·m (lb ft) ± 10%	S-Series N·m (lb ft) ± 10%	L-Series N·m (lb ft) ± 10%
M10 x 1	–	4 (0.157)	–	21 (15.5)	–	12.5 (9.2)
M12 x 1.5	4 (0.157)	6 (0.236)	47 (34.7)	32 (23.6)	28 (20.7)	19 (14)
M14 x 1.5	5 (0.197)	7 (0.276)	63 (46.5)	53 (39.1)	38 (28)	32 (23.6)
M16 x 1.5	7 (0.276)	9 (0.354)	84 (62)	63 (46.5)	50 (36.9)	38 (28)
M18 x 1.5	8 (0.315)	11 (0.433)	105 (77.4)	84 (62)	63 (46.5)	50 (36.9)
M20 x 1.5	10 (0.394)	–	147 (108.4)	–	88 (64.9)	–
M22 x 1.5	12 (0.472)	14 (0.551)	158 (116.5)	147 (108.4)	95 (70.1)	88 (64.9)
M26 x 1.5	–	18 (0.709)	–	210 (154.9)	–	126 (92.9)
M27 x 1.2	16 (0.630)	–	210 (154.9)	–	126 (92.9)	–
M33 x 2	20 (0.787)	23 (0.906)	400 (295)	400 (295)	240 (177)	240 (177)
M42 x 2	25 (0.984)	30 (1.181)	525 (387.2)	525 (387.2)	315 (232.3)	315 (232.3)
M48 x 2	32 (1.260)	36 (1.417)	630 (464.7)	630 (464.7)	396 (292.1)	396 (292.1)

\* S-Series connectors are used with O-Ring Face Seals (ORFS).

\*\* L-Series connectors are used with 37° flare.

INTRODUCTION

**Torque values for Inch O-Ring Boss (ORB) port non-adjustable connections**

SAE dash size	UN/UNF thread size	Inch tube OD mm (in)	S-Series *		L-Series **	
			Ferrous N·m (lb ft) ± 10%	Non-Ferrous N·m (lb ft) ± 10%	Ferrous N·m (lb ft) ± 10%	Non-Ferrous N·m (lb ft) ± 10%
2	5/16-24	3.18 (0.125)	–	–	8.5 (6.3)	5 (3.7)
3	3/8-24	4.76 (0.187)	15.5 (11.4)	9.3 (6.9)	10.5 (7.7)	6.3 (4.6)
4	7/16-20	6.35 (0.250)	37 (27.3)	22 (16.2)	19 (14)	11.5 (8.5)
5	1/2-20	7.94 (0.313)	42 (31)	25 (18.4)	26 (19.2)	15.5 (11.4)
6	9/16-18	9.52 (0.375)	47 (34.7)	28 (20.7)	32 (23.6)	19 (14)
8	3/4-16	12.7 (0.500)	89 (65.6)	53 (39.1)	53 (39.1)	32 (23.6)
10	7/8-14	15.88 (0.625)	121 (89.2)	73 (53.8)	63 (46.5)	38 (28)
12	1-1/16-12	19.05 (0.750)	178 (131.3)	107 (78.9)	100 (73.8)	60 (44.3)
14	1-3/16-12	22.22 (0.875)	225 (166)	135 (99.6)	131 (96.6)	79 (58.3)
16	1-5/16-12	25.4 (1.000)	283 (208.7)	170 (125.4)	156 (115.1)	94 (69.3)
20	1-5/8-12	31.75 (1.250)	300 (221.3)	180 (132.8)	210 (154.9)	126 (92.9)
24	1-7/8-12	38.1 (1.500)	388 (286.2)	233 (171.9)	220 (162.3)	132 (97.4)
32	2-1/2-12	50.8 (2.000)	388 (286.2)	233 (171.9)	315 (232.3)	189 (139.4)

\* S-Series connectors are used with O-Ring Face Seals (ORFS).

\*\* L-Series connectors are used with 37° flare.

**Torque values for inch O-Ring Boss (ORB) port adjustable connections**

SAE dash size	UN/UNF thread size	Inch tube OD mm (in)	S-Series *		L-Series **	
			Ferrous N·m (lb ft) ± 10%	Non-Ferrous N·m (lb ft) ± 10%	Ferrous N·m (lb ft) ± 10%	Non-Ferrous N·m (lb ft) ± 10%
2	5/16-24	3.18 (0.125)	–	–	8.5 (6.3)	5 (3.7)
3	3/8-24	4.76 (0.187)	10.5 (7.7)	9.3 (6.9)	10.5 (7.7)	6.3 (4.6)
4	7/16-20	6.35 (0.250)	21 (15.5)	21 (15.5)	19 (14)	11.5 (8.5)
5	1/2-20	7.94 (0.313)	42 (31)	25 (18.4)	26 (19.2)	15.5 (11.4)
6	9/16-18	9.52 (0.375)	47 (34.7)	28 (20.7)	32 (23.6)	19 (14)
8	3/4-16	12.7 (0.500)	89 (65.6)	53 (39.1)	53 (39.1)	32 (23.6)
10	7/8-14	15.88 (0.625)	121 (89.2)	73 (53.8)	63 (46.5)	38 (28)
12	1-1/16-12	19.05 (0.750)	178 (131.3)	107 (78.9)	100 (73.8)	60 (44.3)
14	1-3/16-12	22.22 (0.875)	225 (166)	135 (99.6)	131 (96.6)	79 (58.3)
16	1-5/16-12	25.4 (1.000)	285 (210.2)	170 (125.4)	156 (115.1)	94 (69.3)
20	1-5/8-12	31.75 (1.250)	300 (221.3)	180 (132.8)	210 (154.9)	126 (92.9)
24	1-7/8-12	38.1 (1.500)	388 (286.2)	233 (171.9)	220 (162.3)	132 (97.4)
32	2-1/2-12	50.8 (2.000)	388 (286.2)	233 (171.9)	315 (232.3)	189 (139.4)

\* S-Series connectors are used with O-Ring Face Seals (ORFS).

\*\* L-Series connectors are used with 37° flare.



INTRODUCTION

**Torque values for inch O-Ring Boss (ORB) port plugs**

SAE dash size	UN/UNF thread size	Ferrous		Non-Ferrous
		Internal hex N·m (lb ft) ± 10%	External hex N·m (lb ft) ± 10%	N·m (lb ft) ± 10%
2	5/16-24	7.5 (5.5)	12.5 (9.2)	7.5 (5.5)
3	3/8-24	14.5 (10.7)	21 (15.5)	12.5 (9.2)
4	7/16-20	21 (15.5)	37 (27.3)	22 (16.2)
5	1/2-20	28 (20.7)	42 (31)	25 (18.4)
6	9/16-18	47 (34.7)	47 (34.7)	28 (20.7)
8	3/4-16	89 (65.6)	89 (65.6)	53 (39.1)
10	7/8-14	116 (85.6)	116 (85.6)	70 (51.6)
12	1-1/16-12	176 (129.8)	176 (129.8)	106 (78.2)
14	1-3/16-12	247 (182.2)	247 (182.2)	148 (109.2)
16	1-5/16-12	284 (209.5)	284 (209.5)	170 (125.4)
20	1-5/8-12	357 (263.3)	357 (263.3)	214 (157.8)
24	1-7/8-12	441 (325.3)	441 (325.3)	265 (195.5)
32	2-1/2-12	536 (395.3)	536 (395.3)	322 (237.5)

**Torque values for four-bolt flange connections (Metric Screws, Class 10.9)**

Metric size mm	Imperial size in	Screw code 61	Code 61 N·m (lb ft) ± 10%	Screw code 62	Code 62 N·m (lb ft) ± 10%
13	1/2	M8 x 1.25	34 (25.1)	M8 x 1.25	34 (25.1)
19	3/4	M10 x 1.5	74 (54.6)	M10 x 1.5	74 (54.6)
25	1	M10 x 1.5	74 (54.6)	M12 x 1.75	137 (101)
32	1-1/4	M10 x 1.5	74 (54.6)	M12 x 1.75	137 (101)
				M14 x 1.5	189 (139.4)
38	1-1/2	M12 x 1.75	137 (101)	M16 x 2	310 (228.6)
51	2	M12 x 1.75	137 (101)	M20 x 2.5	575 (424.1)
64	2-1/2	M12 x 1.75	137 (101)	M24 x 3	575 (424.1)
76	3	M16 x 2	310 (228.6)	M30 x 3.5	680 (501.5)
89	3-1/2	M16 x 2	310 (228.6)	–	–
102	4	M16 x 2	310 (228.6)	–	–
127	5	M16 x 2	310 (228.6)	–	–

**Torque values for four-bolt flange connections (Metric Screws, Class 8.8)**

Metric size mm	Imperial size in	Screw code 61	Code 61 N·m (lb ft) ± 10%	Screw code 62	Code 62 N·m (lb ft) ± 10%
13	1/2	M8 x 1.25	29 (21.4)	M8 x 1.25	29 (21.4)
19	3/4	M10 x 1.5	57(42)	M10 x 1.5	57(42)
25	1	M10 x 1.5	57(42)	M12 x 1.75	100 (73.8)
32	1-1/4	M10 x 1.5	57(42)	M12 x 1.75	100 (73.8)
				M14 x 1.5	160 (118)
38	1-1/2	M12 x 1.75	100 (73.8)	M16 x 2	250 (184.4)
51	2	M12 x 1.75	100 (73.8)	M20 x 2.5	500 (368.8)
64	2-1/2	M12 x 1.75	100 (73.8)	M24 x 3	575 (424.1)
76	3	M16 x 2	250 (184.4)	M30 x 3.5	680 (501.5)
89	3-1/2	M16 x 2	250 (184.4)	–	–
102	4	M16 x 2	250 (184.4)	–	–
127	5	M16 x 2	250 (184.4)	–	–

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**Torque values for four-bolt flange connections (Inch Screws, Grade 8)**

Metric size mm	Imperial size in	Screw code 61	Code 61 N·m (lb ft) ± 10%	Screw code 62	Code 62 N·m (lb ft) ± 10%
13	1/2	5/16-18	34 (25.1)	5/16-18	34 (25.1)
19	3/4	3/8-16	63 (46.5)	3/8-16	63 (46.5)
25	1	3/8-16	63 (46.5)	7/16-14	97 (71.5)
32	1-1/4	7/16-14	97 (71.5)	1/2-13	158 (116.5)
38	1-1/2	1/2-13	158 (116.5)	5/8-11	310 (228.6)
51	2	1/2-13	158 (116.5)	3/4-10	473 (348.9)
64	2-1/2	1/2-13	158 (116.5)	–	–
76	3	5/8-11	310 (228.6)	–	–
89	3-1/2	5/8-11	310 (228.6)	–	–
102	4	5/8-11	310 (228.6)	–	–
127	5	5/8-11	310 (228.6)	–	–

**Tapered thread connection tightening**

British Standard Pipe Taper (BSPT) thread size (inch)	National Pipe Thread Fuel (NPTF) thread size (inch)	Turns from finger tight
1/8-28	1/8-27	2 - 3
1/4-19	1/4-18	2 - 3
3/8-19	3/8-18	2 - 3
1/2-14	1/2-14	2 - 3
3/4-14	3/4-14	2 - 3
1-11	1-11 1/2	1.5 - 2.5
1-1/4-11	1-1/4-11 1/2	1.5 - 2.5
1-1/2-11	1-1/2-11 1/2	1.5 - 2.5
2-11	2-11 1/2	1.5 - 2.5

**Torque values for banjo bolt connections (Copper washer style)**

Bolt thread (metric)	Hex size (mm)	Torque N·m (lb ft) ± 10%
M8 x 1.25	13	13 (9.6)
M10 x 1.25	17	16 (11.8)
M12 x 1.5	17	40 (29.5)
M14 x 1.5	19	45 (33.2)
M16 x 1.5	22	48 (35.4)
M18 x 1.5	24	50 (36.9)
M20 x 1.5	27	73 (53.8)
M22 x 1.5	32	73 (53.8)
M24 x 1.5	32	73 (53.8)

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**Torque values for O-Ring Face Seals (ORFS) connections**

SAE dash size	UN/UNF thread size	Inch tube OD (mm)	Metric tube OD (mm)	Hex size (mm) (Reference only)	* Swivel nut torque N·m (lb ft) ± 10%	** Swivel nut torque N·m (lb ft) ± 10%
4	9/16-18	6.35	6	17	27 (19.9)	27 (19.9)
5	5/8-18	7.94	8	19	34 (25.1)	34 (25.1)
6	11/16-16	9.52	10	22	44 (32.5)	44 (32.5)
8	13/16-16	12.7	12	24	65 (47.9)	65 (47.9)
10	1-14	15.88	16	30	100 (73.8)	100 (73.8)
12	1-3/16-12	19.05	20	36	150 (110.6)	131 (96.6)
14	1-5/16-12	22.23	22	41	163 (120.2)	131 (96.6)
16	1-7/16-12	25.4	25	41	210 (154.9) ***	131 (96.9)
20	1-11/16-12	31.75	30	50	280 (206.5) ***	178 (131.3)
24	2-12	38.1	38	60	375 (276.6) ***	210 (154.9)

\* High/Medium-pressure applications > 50 bar (725 psi).

\*\* Low-pressure applications < 50 bar (725 psi).

\*\*\* It is recommended to use a four-bolt flange connection instead of O-Ring Face Seals (ORFS) sizes "16" and up.

**Torque values for 37° flare connections - Joint Industry Council (JIC)**

SAE dash size	UN/UNF thread size	Metric tube OD (mm)	Inch tube OD (mm)	Swivel nut torque N·m (lb ft) ± 10%
2	5/16-24	–	3.18	8.25 (6.1)
3	3/8-24	–	4.76	11.5 (8.5)
4	7/16-20	6	6.35	15.5 (11.4)
5	1/2-20	8	7.94	20 (14.8)
6	9/16-18	10	9.52	25 (18.4)
8	3/4-16	12	12.7	52 (38.4)
10	7/8-14	16	15.88	81 (59.7)
12	1-1/16-12	20	19.05	112 (82.6)
14	1-3/16-12	–	22.22	133 (98.1)
16	1-5/16-12	25	25.4	155 (114.3)
20	1-5/8-12	30/32	31.75	180 (132.8)
24	1-7/8-12	38	38.1	225 (166)
32	2-1/2-12	50	50.8	348 (256.7)

**Torque values for 30° flare, 60° cone connections**

Nominal size (mm)	British Standard Pipe Parallel (BSPP) thread size	Hex size (mm)	Swivel nut torque N·m (lb ft) ± 10%
5, 6, 6.3	G 1/4	17	25 (18.4)
8, 9, 10	G 3/8	19	34 (25.1)
12, 12.5	G 1/2	22	64 (47.2)
15, 16, 19	G 3/4	30	132 (97.4)
25	G 1	36	196 (144.6)
31.5, 32	G 1-1/4	46	225 (166)
38	G 1-1/2	50	255 (188.1)
50, 51	G 2	65	316 (223.1)

## Torque - Special torques

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### Ripper

Component	Torque
Ripper mounting bolts	700 – 1260 Nm (515 – 925 lb ft)
Ripper pin retaining and tube cover bolts	145 – 260 Nm (110 – 190 lb ft)

### Hydraulic Pump

Component	Torque
<b>Non PTO pump</b>	
Cover bolts	66 – 80 Nm (50 – 60 lb ft)
<b>PTO type pump</b>	
Air vent	9 Nm (80 lb in)
Pump housing bolts	271 Nm (200 lb ft)
PTO shaft retainer	68 Nm (50 lb ft)
Set screw PTO shaft retainer	9 Nm (80 lb in)
Shaft cover screws	8 – 9 Nm (65 – 75 lb in)

### Fuse and Relay Blocks

Component	Torque
Fuse block mounting	2.7 Nm (24 lb in)
Bussed studs	8.5 Nm (75 lb in)

### Power Relays

Component	Torque
Output studs	5.4 Nm (48 lb in)
Input studs	16.3 Nm (144 lb in)

### Engine Mounts

Component	Torque
Engine mount bolts to chassis	205 – 230 Nm (151 – 170 lb ft)
Rear engine mount brackets to bell housing	118 – 133 Nm (87 – 98 lb ft)
Front engine mount bracket to engine block	118 – 133 Nm (87 – 98 lb ft)
Starter mounting bolts	68 – 77 Nm (50 – 57 lb ft)

### Engine to Pumps Drive Shaft

Component	Torque
Flywheel mount bolts	285 – 305 Nm (210 – 225 lb ft)

### Pumps and Motors

Component	Torque
Pump mount bolts to frame	68 – 81 Nm ( 50 – 60 lb ft)
Motor mount bolts to final drives	250 – 280 N·m (184 – 207 lb ft)
Pump to motor hoses spit flange clamps	90 – 100 Nm ( 66 – 74 lb ft)
Inlet hose clamps	6.5 – 7.6 Nm ( 58 – 68 lb in)

### Rear Frame Cover

Component	Torque
M24 hex bolts	449 – 725 N·m (331 – 535 lb ft)
M16 hex bolts	230 – 371 N·m (170 – 274 lb ft)

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**Track**

Component	Torque
Master link bolts (Use <b>LOCTITE® 242®</b> on master link bolts.)	<b>340.0 – 380.0 N·m (250.8 – 280.3 lb ft)</b>
Standard link shoe bolts	<b>381.0 – 435.0 N·m (281.0 – 320.8 lb ft)</b>

**Final Drives**

Component	Torque
Drive Hub Rolling Torque	<b>8 – 15 N·m (71 – 133 lb in)</b>
Input Shaft Bearing Retainer Plate Mounting Bolts	<b>77 – 87 N·m (57 – 64 lb ft)</b>
Park Brake Housing Plate	<b>77 – 87 N·m (57 – 64 lb ft)</b>
Brake Housing Cover - M20 X 50 12 pnt	<b>650 – 730 N·m (479 – 538 lb ft)</b>
Brake Line Fitting	<b>55 – 60 N·m (41 – 44 lb ft)</b>
Brake Bleeder Fitting	<b>24 – 30 N·m (18 – 22 lb ft)</b>
Counter Shaft Bearing Retainer Plate Mounting Bolts	<b>125 – 150 N·m (92 – 111 lb ft)</b>
Spindle Housing	<b>310 – 380 N·m (229 – 280 lb ft)</b>
Ring Gear Retaining Plate	<b>310 – 380 N·m (229 – 280 lb ft)</b>
Sun Gear Shaft Retaining Plate	<b>125 – 150 N·m (92 – 111 lb ft)</b>
Output Gear Bearing Retainer Plate Mounting Bolts	<b>125 – 150 N·m (92 – 111 lb ft)</b>
Planetary Carrier to Drive Hub	<b>310 – 380 N·m (229 – 280 lb ft)</b>
Final Drive to Frame Mounting Bolts	<b>656 – 725 N·m (484 – 535 lb ft)</b>
Fill Check Plug	<b>24 – 30 N·m (18 – 22 lb ft)</b>
Drain Plug	<b>24 – 30 N·m (18 – 22 lb ft)</b>

**Cab Mounting**

Component	Torque
Support mount bolts	<b>733 – 854 N·m (541 – 630 lb ft)</b>
Brush guard mount bolts (if equipped)	<b>587 – 794 N·m (433 – 586 lb ft)</b>

**Air Conditioning Compressor**

Component	Torque
Compressor rotor shaft nut	<b>15 – 20 Nm ( 11 – 15 lb ft)</b>
Oil filler plug	<b>15 – 24 Nm ( 11 – 18 lb ft)</b>
Dust cover screws	<b>7 – 11 Nm ( 5 – 8 lb ft)</b>

**Lift Cylinder**

Component	Torque
Piston bolt	<b>1820 – 1600 N·m (1342 – 1180 lb ft)</b>
Gland	<b>135 – 542 Nm (100 – 400 lb ft)</b>

**Tilt Cylinder**

Component	Torque
Piston bolt	<b>2160 – 2450 N·m (1593 – 1807 lb ft)</b>
Gland	<b>135 – 542 Nm (100 – 400 lb ft)</b>

**Angle Cylinder**

Component	Torque
Piston bolt	<b>2160 – 2450 N·m (1593 – 1807 lb ft)</b>
Gland	<b>135 – 542 Nm (100 – 400 lb ft)</b>

**Ripper Cylinder**

Component	Torque
Piston bolt	<b>1600 – 1820 N·m (1180 – 1342 lb ft)</b>
Gland	<b>135 – 542 Nm (100 – 400 lb ft)</b>

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### Starter

Component	Torque
Mounting bolts	68 – 77 Nm (50 – 57 lb ft)
Battery terminal nut	17.7 – 24.5 Nm (13 – 18 lb ft)
Solenoid + screw	2.6 – 4.5 Nm (23 – 40 lb in)

### Multifunction valve

Component	Torque
Brake valve	3 – 4 N·m (2 – 3 lb ft)
Brake valve screws	3 – 4 N·m (2 – 3 lb ft)
Cartridge valve	32.6 – 35.4 N·m (24.0 – 26.1 lb ft)
Check valve	150 – 177 N·m (111 – 131 lb ft)

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## Basic instructions - Shop and assembly

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### Shimming

For each adjustment operation, select adjusting shims and measure the adjusting shims individually using a micrometer, then add up the recorded values. Do not rely on measuring the entire shimming set, which may be incorrect, or the rated value shown on each shim.

### Rotating shaft seals

For correct rotating shaft seal installation, proceed as follows:

1. Before assembly, allow the seal to soak in the oil it will be sealing for at least thirty minutes.
2. Thoroughly clean the shaft and check that the working surface on the shaft is not damaged.
3. Position the sealing lip facing the fluid.

**NOTE:** *With hydrodynamic lips, take into consideration the shaft rotation direction and position the grooves so that they will move the fluid towards the inner side of the seal.*

4. Coat the sealing lip with a thin layer of lubricant (use oil rather than grease). Fill the gap between the sealing lip and the dust lip on double lip seals with grease.
5. Insert the seal in its seat and press down using a flat punch or seal installation tool. Do not tap the seal with a hammer or mallet.
6. While you insert the seal, check that the seal is perpendicular to the seat. When the seal settles, make sure that the seal makes contact with the thrust element, if required.
7. To prevent damage to the seal lip on the shaft, position a protective guard during installation operations.

### O-ring seals

Lubricate the O-ring seals before you insert them in the seats. This will prevent the O-ring seals from overturning and twisting, which would jeopardize sealing efficiency.

### Sealing compounds

Apply a sealing compound on the mating surfaces when specified by the procedure. Before you apply the sealing compound, prepare the surfaces as directed by the product container.

### Spare parts

Only use CNH Original Parts or CASE CONSTRUCTION Original Parts.

Only genuine spare parts guarantee the same quality, duration, and safety as original parts, as they are the same parts that are assembled during standard production. Only CNH Original Parts or CASE CONSTRUCTION Original Parts can offer this guarantee.

When ordering spare parts, always provide the following information:

- Machine model (commercial name) and Product Identification Number (PIN)
- Part number of the ordered part, which can be found in the parts catalog

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## Protecting the electronic and/or electrical systems during charging and welding

To avoid damage to the electronic and/or electrical systems, always observe the following practices:

1. Never make or break any of the charging circuit connections when the engine is running, including the battery connections.
2. Never short any of the charging components to ground.
3. Always disconnect the ground cable from the battery before arc welding on the machine or on any machine attachment.
  - Position the welder ground clamp as close to the welding area as possible.
  - If you weld in close proximity to a computer module, then you should remove the module from the machine.
  - Never allow welding cables to lie on, near, or across any electrical wiring or electronic component while you weld.
4. Always disconnect the negative cable from the battery when charging the battery in the machine with a battery charger.

**NOTICE:** *If you must weld on the unit, you must disconnect the battery ground cable from the machine battery. The electronic monitoring system and charging system will be damaged if this is not done.*

5. Remove the battery ground cable. Reconnect the cable when you complete welding.

### **⚠ WARNING**

**Battery acid causes burns. Batteries contain sulfuric acid.**

**Avoid contact with skin, eyes or clothing. Antidote (external): Flush with water. Antidote (eyes): flush with water for 15 minutes and seek medical attention immediately. Antidote (internal): Drink large quantities of water or milk. Do not induce vomiting. Seek medical attention immediately. Failure to comply could result in death or serious injury.**

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## Special tools

The special tools that CASE CONSTRUCTION suggests and illustrate in this manual have been specifically researched and designed for use with CASE CONSTRUCTION machines. The special tools are essential for reliable repair operations. The special tools are accurately built and rigorously tested to offer efficient and long-lasting operation.

By using these tools, repair personnel will benefit from:

- Operating in optimal technical conditions
- Obtaining the best results
- Saving time and effort
- Working in safe conditions



## Engine cooling system - Basic instructions

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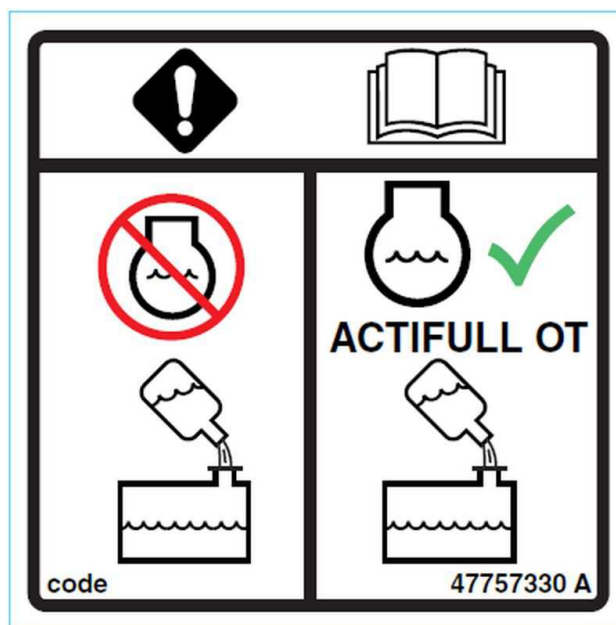
Depending on the date of manufacture, your cooling system may be equipped with conventional ethylene glycol coolant such as **CNH XHD HEAVY DUTY COOLANT / ANTI-FREEZE** or an Organic Acid Technology (OAT) coolant solution such as **CASE AKCELA ACTIFULL™ OT EXTENDED LIFE COOLANT**. You can easily identify **CASE AKCELA ACTIFULL™ OT EXTENDED LIFE COOLANT** by its yellow color. You should never mix the coolant types.

The coolant solution used must meet the following CNH Industrial material specifications for either coolant type:

- **MAT3624** for OAT coolant
- **MAT3620** for conventional coolant

The decal shown is located near the fill point of the cooling system whenever the factory fill is **CASE AKCELA ACTIFULL™ OT EXTENDED LIFE COOLANT**. This decal is available in three different sizes. See the table below for the associated part numbers.

CNH Industrial part number	Size
47757330	50 mm x 50 mm
47757331	75 mm x 75 mm
47757332	100 mm x 100 mm



47757330 1

**NOTICE:** NEVER mix OAT coolant with conventional coolant. Under no circumstances should you top off a cooling system with only water. You can use a refractometer to check the concentration level. You should not use Supplemental Coolant Additives (SCA) when using **CASE AKCELA ACTIFULL™ OT EXTENDED LIFE COOLANT**. Change the coolant solution at the recommended change interval.

If you need to change a machine from conventional coolant to OAT coolant or vice versa, you should follow the “Changing coolant types” procedure below to attain the full benefit of the coolant.

### Changing coolant types

To change coolant from OAT coolant to conventional coolant (or vice versa):

1. Empty the engine cooling system by draining the coolant into a suitable container.
2. Fill the system with clean water.
3. Start the engine and run the engine for at least **30 min.**

**NOTE:** Make sure that you activate the heating system (if equipped) to circulate fluid through the heater core.

4. Repeat Steps 1 to 3 for a total of two washes.
5. Fill the system with conventional coolant (or OAT coolant).
6. Operate the engine until it is warm. Inspect the machine for leaks.
7. If you are changing to OAT coolant, then attach the decal (CNH Industrial part number 47757330) to indicate the use of OAT coolant in the cooling system.

You may notice the older version of the OAT decal (CNH Industrial part number 47488993) on some applications.

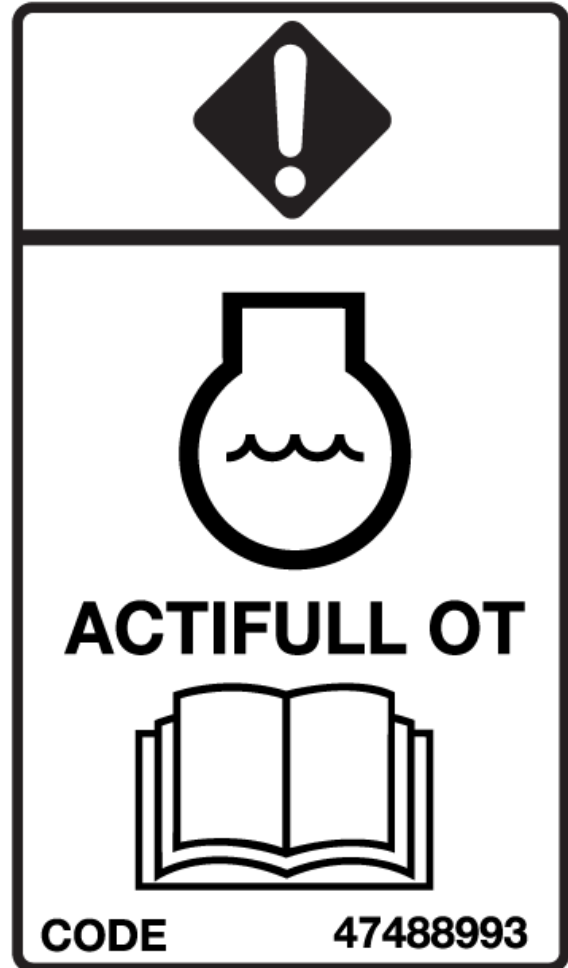
### Definitions

Conventional coolant:

A coolant that relies on inorganic inhibitors such as silicates, nitrites, and phosphates for corrosion and cavitation protection.

Organic Acid Technology (OAT) coolant:

A coolant that relies on inhibitors such as organic acid salts for corrosion and cavitation protection.



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