



TECHNICAL BULLETIN

Torque Reference Guide

2022

The Following charts are list of metric nut sizes that ICS Wear Group uses in the construction of Mill Master Pumps. Please cross reference the corresponding torque chart to the required bolt, stud, and screw charts below.

M# Bolt – Size	Torque (+/- 10%) - Nm
M12	25
M16	50
M20	90
M24	150
M27	220
M30	300
M33	400
M36	520
M42	850
M48	1200
M64	1500

The following are charts of ICS Mill Master Bolts, Studs and Screws.

Adjusting Bolt		
Bolt	Frame Size	Nut
B	B	M12
C	C	M16
D	D	M20
E	E	M24
F	F	M30
G	G	M36
S	ST	M30
T	T	M42
H	H	M64
U	U	M64

Clamp Bolt (Barrel Bolt)		
Bolt	Frame Size	Nut
B	B	M12
C	C	M20
D	D	M24
E	E	M30
F	F	M30
G	G	M36
T	T	M42
H	H	M64

End Cover Screws		
Bolt	Frame Size	Nut
B	B	M10
C	C	M10
D	D	M12
E	E	M12
F	F	M16
G	G	M20
S	ST	M16
T	T	M20
H	H	M24

Frame Plate Liner Studs		
Bolt	Frame Size	Nut
B	B	M10
C	C	M12
D	D	M12
E	E	M16
F	F	M16
G	G	M20
H	TU	M24

**** These are the most common sizes pumps on the market, please ask if you see a Size not listed ****

Throat Bush Studs		
Bolt	Pump Size	Nut
C	C	M12
D	D	M12
G8	G	M20
G10	FM, G & ST	M12
G12	FM, G & ST	M16
H	H	M16

Frame Plate Stud		
Bolt	Pump Size	Nut
B	B	M12
C	C	M16
D	D	M20
E	E	M24
F	F	M30
G	G & ST	M42
TU	TU	M64
H		M64

Gland Bolt		
Bolt	Pump Size	Nut
B	B	M10
C	C	M10
D	D	M12
E	E	M16
F	F	M20
G	G	M20
R	SL	M16
H	H & TU	M20

**** These are the most common sizes pumps on the market, please ask if you see a Size not listed ****

Cover Plate Bolt		
Bolt	Pump Size	Nut
B	B	M20
C	C	M20
D	D	M24
E	E	M30
F	F	M30
G8	ST	M48
G10	FM, G & ST	M42
G12	FM, G & ST	M48
H	H	M64

**** These are the most common sizes pumps on the market, please ask if you see a Size not listed ****