

TIGHTENING TORQUE REFERENCE CHART FOR SAE AND METRIC BOLTS

NL = Not Lubricated
L = Lubricated
1 lbs ft = 1.356 N*m



HEX KEY INTERCHANGE

SAE

Metric

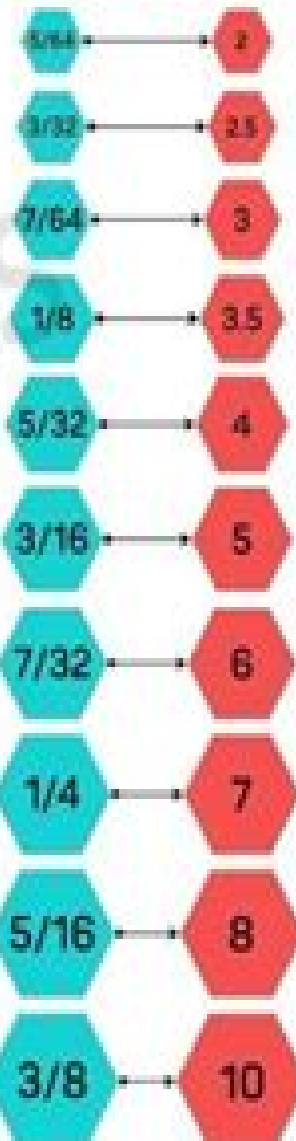
TIGHTENING TORQUE FOR SAE BOLTS (30% of yield strength S_y) in lbs ft

MATERIAL	UNC	1/4"-20	5/16"-18	3/8"-16	7/16"-14	1 1/2"-12	9/16"-12	5/8"-11	3/4"-10	1 1/8"-8	1 3/8"-7	1 5/8"-6	1 3/4"-6	1 5/2"-6
GRADE 1	NL	4	8	14	22	34	45	68	100	194	291	492	581	762
	L	3	6	10	17	26	37	51	90	145	218	309	436	759
GRADE 2	NL	6	12	22	35	54	78	107	191	194	291	492	581	762
	L	5	9	17	27	40	58	81	143	145	218	309	436	759
GRADE 5/8.2	NL	10	20	36	57	87	126	173	308	496	743	1053	1486	2589
	L	7	15	27	43	65	94	130	239	372	557	790	1114	1939
GRADE 8	NL	14	28	50	81	123	177	245	435	700	1050	1488	2100	2752
	L	10	21	38	60	92	133	184	326	525	787	1116	1575	2084

MATERIAL	UNF	1/4"-28	5/16"-24	3/8"-24	7/16"-20	1 1/2"-20	9/16"-18	5/8"-16	3/4"-16	1 1/8"-14	1 3/8"-12	1 5/8"-12	1 3/4"-12	1 5/2"-12
GRADE 1	NL	4	9	16	25	38	55	77	104	214	325	482	644	868
	L	3	7	12	19	29	41	58	101	180	245	347	483	651
GRADE 2	NL	7	14	25	39	61	87	122	213	214	326	482	644	868
	L	5	10	19	30	46	66	91	159	180	245	347	483	651
GRADE 5/1.2	NL	11	22	40	64	98	140	196	343	547	834	1181	1648	2217
	L	8	17	30	48	74	105	147	257	410	625	886	1234	1683
GRADE 8	NL	16	31	57	90	139	198	277	485	773	1178	1689	2325	3133
	L	12	24	43	68	104	148	208	364	583	884	1251	1744	2350

TIGHTENING TORQUE FOR METRIC BOLTS (30% of yield strength S_y) in lbs ft

MATERIAL	ST. PITCH	M6-1	M8-1.25	M10-1.5	M12-1.75	M14-2	M16-2	M18-2.5	M20-2.5	M22-2.5	M24-3	M27-3	M30-3.5	M33-3.5	M36-4
CLASS 4.6	NL	3	9	16	29	46	71	98	139	189	240	351	477	649	833
	L	3	6	12	21	34	53	74	104	142	180	263	357	486	629
CLASS 8.8	NL	8	22	44	76	122	190	262	370	509	640	896	1271	1730	2221
	L	7	17	33	57	91	142	197	278	378	480	702	953	1287	1666
CLASS 10.9	NL	15	32	64	112	179	279	385	544	739	940	1375	1887	2540	3283
	L	10	24	48	84	134	209	289	408	555	705	1031	1400	1905	2447
CLASS 12.9	NL	16	38	75	131	209	326	451	636	865	1100	1609	2195	2973	3878
	L	12	29	56	98	157	245	338	477	649	825	1207	1639	2230	2883
MATERIAL	FINE PITCH	M6-0.75	M8-1	M10-1	M12-1.25	M14-1.5	M16-1.5	M18-1.5	M20-1.5	M22-1.5	M24-1.5	M27-1.5	M30-1.5	M33-1.5	M36-1.5
CLASS 4.6	NL	4	9	16	21	30	38	70	154	207	273	393	545	733	958
	L	3	7	14	23	37	57	83	116	156	204	295	409	550	719
CLASS 8.8	NL	10	24	49	83	132	202	294	411	553	727	1048	1455	1954	2556
	L	7	18	37	63	99	151	220	308	415	545	789	1091	1466	1917
CLASS 10.9	NL	15	35	72	123	194	296	431	603	813	1088	1539	2136	2870	3754
	L	11	26	54	92	146	222	323	453	610	801	1155	1602	2152	2815
CLASS 12.9	NL	17	41	84	143	227	347	505	708	951	1249	1822	2500	3358	4383
	L	12	31	63	108	170	260	379	530	719	937	1351	1875	2519	3295



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United States. War Department



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Cooled, 12-cylinder, Assembly; Models AVDS-1790-2M (2815-856-4996), AVDS-1790-2A and AVDS-1790-2AM (2815-856-9005). ,1989 *LS Gen IV Engines 2005 - Present* Mike Mavrigian,2018-08-15 p p1

margin 0 0px 0 0px 0 0px 0 0px font 12 0px Arial The GM LS Gen IV engine dominates the high performance V 8 market and is the most popular powerplant for engine swap projects In stock trim the Gen IV engines produce class leading horsepower The Gen IV s rectangular port heads flow far more air fuel than the Gen III cathedral port heads However with the right combination of modification procedures and performance parts you can unlock the performance potential of the Gen IV engines and reach almost any performance target Engine building and LS expert Mike Mavrigian guides readers through the best products and modification procedures to achieve maximum performance for a variety of applications To make more horsepower you need to flow more air and fuel into the engine therefore how to select the industry leading aftermarket heads and port the stock heads for superior performance are comprehensively covered The cam controls all major timing events in the engine so determining the best cam for your engine package and performance goals is revealed But these are just a few aspects of high performance Gen IV engine building Installing nitrous oxide or supercharger systems and bolting on cold air intakes aftermarket ignition controls headers and exhaust system parts are all covered in detail The foundation of any engine build is the block and crucial guidance for modifying stock blocks and aftermarket block upgrade advice is provided Crankshafts pistons and rods valvetrain oiling systems intakes and fuel injection cooling systems are all covered so you can build a complete high performance package Muscle car owners LS engine builders and many enthusiasts have migrated to the Gen IV engine platform so clear concise and informative content for transforming these stock engines into top performers for a variety of applications is essential A massive amount of aftermarket parts is available and this provides guidance and instructions for extracting top performance from these engines If you re searching for an authoritative source for the best components and modifications to create the ultimate high performance packages then you ve found it *Piping and Pipelines Assessment Guide* Keith Escoe,2006-04-10 Whether it s called fixed equipment at ExxonMobil stationary equipment at Shell or static equipment in Europe this type of equipment is the bread and butter of any process plant Used in the petrochemical industry pharmaceutical industry food processing industry paper industry and the manufacturing process industries stationary equipment must be kept operational and reliable for companies to maintain production and for employees to be safe from accidents This series the most comprehensive of its kind uses real life examples and time tested rules of thumb to guide the mechanical engineer through issues of reliability and fitness for service This volume on piping and pipeline assessment is the only handbook that the mechanical or pipeline engineer needs to assess pipes and pipelines for reliability and fitness for service Provides essential insight to make informed decisions on when to run alter repair monitor or replace equipment How to perform these type of assessments and calculations on pipelines is a hot issue in the petrochemical industry at this time There is very little information on the market right now for pipers and pipeliners with

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