



TIGHTENING TORQUE REFERENCE CHART FOR SAE AND METRIC BOLTS

NL = Not Lubricated

L = Lubricated

1 lbs ft = 1.356 N·M



Grade 1, 5 (UNS 5.8)
Tensile: 60,000 psi

Grade 2
Tensile: 70,000 psi

Grade 5
Tensile: 100,000 psi

Grade 8
Tensile: 150,000 psi

Grade 10.9
Tensile: 120,000 psi

Grade 12.9
Tensile: 140,000 psi

TIGHTENING TORQUE FOR SAE BOLTS (80% of yield strength S_y) in lbs ft

MATERIAL	UNC	1/4"-20	5/16"-18	3/8"-16	7/16"-14	1/2"-13	9/16"-12	5/8"-11	3/4"-10	7/8"-9	1"-8	1 1/8"-7	1 1/4"-7	1 3/8"-6	1 1/2"-5
GRADE 1	NL	4	8	14	22	34	49	68	100	154	291	412	581	762	1092
	L	3	6	10	17	26	37	51	80	145	278	399	436	570	758
GRADE 2	NL	6	12	22	35	54	78	107	161	254	492	681	881	1162	1702
	L	5	9	17	27	40	58	81	143	218	436	609	836	1107	1658
GRADE 5/5.2	NL	10	20	36	57	87	126	173	268	406	743	1053	1486	1948	2886
	L	7	15	27	43	65	94	130	231	372	687	990	1374	1821	2658
GRADE 8	NL	14	28	50	81	123	177	245	435	700	1350	1988	2700	3752	5554
	L	10	21	38	60	92	133	184	326	525	987	1416	1975	2764	4040

TIGHTENING TORQUE FOR METRIC BOLTS (80% 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	M20-3	M22-3	M24-3	M27-3	M30-3.5	M33-3.5	M36-4
CLASS 4.6	NL	3	8	16	29	46	71	98	139	189	240	351	477	649	803
	L	3	6	12	21	34	53	74	104	142	180	263	357	486	625
CLASS 8.8	NL	9	22	44	76	122	190	262	370	503	640	936	1271	1730	2321
	L	7	17	33	57	91	142	197	278	378	480	702	953	1297	1698
CLASS 10.9	NL	13	32	64	112	178	279	385	544	739	940	1375	1860	2540	3263
	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	1608	2185	2973	3853
	L	12	29	56	96	157	245	338	477	649	825	1207	1639	2230	2893
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	18	31	50	76	100	154	207	273	393	545	733	958
	L	3	7	14	23	37	57	83	116	156	204	295	409	550	718
CLASS 8.8	NL	10	24	48	83	132	202	284	411	553	737	1048	1455	1954	2556
	L	7	18	37	63	99	151	220	328	445	595	858	1181	1588	2075
CLASS 10.9	NL	15	35	72	123	194	286	431	639	873	1158	1688	2330	3152	4155
	L	11	26	54	92	148	222	323	483	670	891	1285	1752	2362	3085
CLASS 12.9	NL	17	41	84	143	227	347	506	736	995	1349	1952	2690	3638	4783
	L	13	31	63	108	170	260	379	530	713	937	1351	1875	2519	3295

WRENCH INTERCHANGE

SAE	Metric
1/4"	6
5/16"	8
3/8"	10
1/2"	12
5/8"	16
3/4"	19
1"	25
1 1/8"	30
1 1/4"	36
1 3/8"	42
1 1/2"	48
1 3/4"	54
2"	60
2 1/4"	66
2 3/4"	72
3"	78
3 1/2"	84
4"	90
4 1/2"	96
5"	102
5 1/2"	108
6"	114
6 1/2"	120
7"	126
7 1/2"	132
8"	138
8 1/2"	144
9"	150
9 1/2"	156
10"	162
10 1/2"	168
11"	174
11 1/2"	180
12"	186
12 1/2"	192
13"	198
13 1/2"	204
14"	210
14 1/2"	216
15"	222
15 1/2"	228
16"	234
16 1/2"	240
17"	246
17 1/2"	252
18"	258
18 1/2"	264
19"	270
19 1/2"	276
20"	282
20 1/2"	288
21"	294
21 1/2"	300
22"	306
22 1/2"	312
23"	318
23 1/2"	324
24"	330
24 1/2"	336
25"	342
25 1/2"	348
26"	354
26 1/2"	360
27"	366
27 1/2"	372
28"	378
28 1/2"	384
29"	390
29 1/2"	396
30"	402
30 1/2"	408
31"	414
31 1/2"	420
32"	426
32 1/2"	432
33"	438
33 1/2"	444
34"	450
34 1/2"	456
35"	462
35 1/2"	468
36"	474
36 1/2"	480
37"	486
37 1/2"	492
38"	498
38 1/2"	504
39"	510
39 1/2"	516
40"	522
40 1/2"	528
41"	534
41 1/2"	540
42"	546
42 1/2"	552
43"	558
43 1/2"	564
44"	570
44 1/2"	576
45"	582
45 1/2"	588
46"	594
46 1/2"	600
47"	606
47 1/2"	612
48"	618
48 1/2"	624
49"	630
49 1/2"	636
50"	642
50 1/2"	648
51"	654
51 1/2"	660
52"	666
52 1/2"	672
53"	678
53 1/2"	684
54"	690
54 1/2"	696
55"	702
55 1/2"	708
56"	714
56 1/2"	720
57"	726
57 1/2"	732
58"	738
58 1/2"	744
59"	750
59 1/2"	756
60"	762
60 1/2"	768
61"	774
61 1/2"	780
62"	786
62 1/2"	792
63"	798
63 1/2"	804
64"	810
64 1/2"	816
65"	822
65 1/2"	828
66"	834
66 1/2"	840
67"	846
67 1/2"	852
68"	858
68 1/2"	864
69"	870
69 1/2"	876
70"	882
70 1/2"	888
71"	894
71 1/2"	900
72"	906
72 1/2"	912
73"	918
73 1/2"	924
74"	930
74 1/2"	936
75"	942
75 1/2"	948
76"	954
76 1/2"	960
77"	966
77 1/2"	972
78"	978
78 1/2"	984
79"	990
79 1/2"	996
80"	1002
80 1/2"	1008
81"	1014
81 1/2"	1020
82"	1026
82 1/2"	1032
83"	1038
83 1/2"	1044
84"	1050
84 1/2"	1056
85"	1062
85 1/2"	1068
86"	1074
86 1/2"	1080
87"	1086
87 1/2"	1092
88"	1098
88 1/2"	1104
89"	1110
89 1/2"	1116
90"	1122
90 1/2"	1128
91"	1134
91 1/2"	1140
92"	1146
92 1/2"	1152
93"	1158
93 1/2"	1164
94"	1170
94 1/2"	1176
95"	1182
95 1/2"	1188
96"	1194
96 1/2"	1200
97"	1206
97 1/2"	1212
98"	1218
98 1/2"	1224
99"	1230
99 1/2"	1236
100"	1242
100 1/2"	1248
101"	1254
101 1/2"	1260
102"	1266
102 1/2"	1272
103"	1278
103 1/2"	1284
104"	1290
104 1/2"	1296
105"	1302
105 1/2"	1308
106"	1314
106 1/2"	1320
107"	1326
107 1/2"	1332
108"	1338
108 1/2"	1344
109"	1350
109 1/2"	1356
110"	1362
110 1/2"	1368
111"	1374
111 1/2"	1380
112"	1386
112 1/2"	1392
113"	1398
113 1/2"	1404
114"	1410
114 1/2"	1416
115"	1422
115 1/2"	1428
116"	1434
116 1/2"	1440
117"	1446
117 1/2"	1452
118"	1458
118 1/2"	1464
119"	1470
119 1/2"	1476
120"	1482
120 1/2"	1488
121"	1494
121 1/2"	1500
122"	1506
122 1/2"	1512
123"	1518
123 1/2"	1524
124"	1530
124 1/2"	1536
125"	1542
125 1/2"	1548
126"	1554
126 1/2"	1560
127"	1566
127 1/2"	1572
128"	1578
128 1/2"	1584
129"	1590
129 1/2"	1596
130"	1602
130 1/2"	1608
131"	1614
131 1/2"	1620
132"	1626
132 1/2"	1632
133"	1638
133 1/2"	1644
134"	1650
134 1/2"	1656
135"	1662
135 1/2"	1668
136"	1674
136 1/2"	1680
137"	1686
137 1/2"	1692
138"	1698
138 1/2"	1704
139"	1710
139 1/2"	1716
140"	1722
140 1/2"	1728
141"	1734
141 1/2"	1740
142"	1746
142 1/2"	1752
143"	1758
143 1/2"	1764
144"	1770
144 1/2"	1776
145"	1782
145 1/2"	1788
146"	1794
146 1/2"	1800
147"	1806
147 1/2"	1812
148"	1818
148 1/2"	1824
149"	1830
149 1/2"	1836
150"	1842
150 1/2"	1848
151"	1854
151 1/2"	1860
152"	1866
152 1/2"	1872
153"	1878
153 1/2"	1884
154"	1890

Torque Guide For Bolts

Sabine Zange

A red circular graphic with a gradient, appearing as a stylized arrow or a light effect, positioned to the right of the author's name.

Torque Guide For Bolts:

The Overlanding Vehicle Builder's Guide Don Alexander, 2024-03-15 What is overlanding Wikipedia states Overlanding is self reliant overland travel to remote destinations where the journey is the principal goal Typically but not exclusively it is accomplished with mechanized off road capable transport from bicycles to trucks where the principal form of lodging is camping It often lasts for extended periods of time months to years and spans international boundaries Overlanding did not originate in America and it is a little different here You would be hard pressed to find a bicycle out in the desert and most people don't stay out there quite that long However the spirit of the activity is the same Do you want to give overlanding a try Great You will need some gear In *The Overlanding Vehicle Builder's Guide* veteran racer off roader and journalist Don Alexander provides a terrific overview of what to consider when building your overlanding rig This includes the planned duration of the trip the number of people in your party how far off the beaten path you want to go and the creature comforts you require Understanding those wants and needs shapes what gear you need for the best experience Covered are the strengths and weaknesses of the types of vehicles themselves modifications to the vehicles to make them more capable accessories lighting camping gear food and water storage etc and equipment for trail mishaps and recovery Driving techniques and trail rules and etiquette are also included If you are ready to build a rig or just want to know more about the hobby this book is a great guide to help you get started *Technical Manual* United States Department of the Army, 1954

Machinist Guide David B Smith, 2015-04-15 This is a Machinist Notebook Reference guide Revised Apr 11 2015 Written for machinists by a journeymen machinist in a real shop environment With tables charts illustration drawing and Sketches for machinist gunsmith auto industries With work sheets for none standard threading and gear cutting It also has simple illustration on how to make a few simple tooling and aids in the shop information for machinist As listed Three wire Major Diameter worm DP and MOD Using a Dividing Head How use a Compound Indexing How to make the Smith Compound indexer Rebound Ball Hardness Tester Grinding Lathe Tools bits Speeds and lubrication Rebound Ball Hardness Tester Hardness Chart Roughness Finish Compactor Scale Over the wire dimensions inch bolts in mm Index Table for 40 tooth worm 2 to 540 Compound Indexing on 40 tooth worm 51 250 teeth Index Table for 72 tooth worm Index Table for 90 tooth worm 2 230 Gear cutting and blanks This is book with written for fast reading NOT NOVEL for reading for slow reading

Operator's, Organizational, Direct Support, General Support, and Depot Maintenance Manual (including Repair Parts Information and Supplemental Operating, Maintenance, and Repair Parts Instructions) for Roller, Pneumatic Tired Variable Pressure, Self-propelled (CCE) Hyster Model C530A, NSN 3805-01-013-3630, 1983 , **High Performance Fasteners and Plumbing** Mike Mavrigian, 2008-01-02 The essential reference guide for choosing the right fastener and plumbing for any automotive high performance custom or racing application This user friendly guide explains high performance fasteners plumbing and all the other hardware used by racers rodders restorers and all other auto enthusiasts Subjects include hose

sizes fittings materials routing and installation tips heat shielding brake fuel coolant and oil lines as well as fastener technology such as thread sizing clamping loads bolt stretch and fastener styles **Fundamentals of Mobile Heavy Equipment** Owen C. Duffy, Gus Wright, Scott A. Heard, 2017-09-27 Fundamentals of Mobile Heavy Equipment provides students with a thorough introduction to the diagnosis repair and maintenance of off road mobile heavy equipment With comprehensive up to date coverage of the latest technology in the field it addresses the equipment used in construction agricultural forestry and mining industries *Zinn & the Art of Road Bike Maintenance* Lennard Zinn, 2023-10-24 Zinn all bottom bracket systems cone and cup through press fit all brake systems including caliper V brake cantilever and disc all headset stem handlebar and fork systems wheelbuilding for all bikes including cyclocross and disc brake wheels special sections on cyclocross throughout including troubleshooting maintenance service repair and equipment selection updated and expanded torque tables complete illustration index and complete subject index **MotorBoating** , 1975-11 [Direct and General Support Maintenance Manual](#) , 1971 **Zinn & the Art of Mountain Bike Maintenance 6th edition** Lennard Zinn, 2023-10-24 From basic repairs like how to fix a flat to advanced overhauls of drivetrains and brakes Lennard Zinn s clearly illustrated guide makes every bike repair and maintenance job easy for everyone Lennard Zinn is the world s leading expert on bike maintenance and repair His friendly step by step guide explains the tools and parts you ll need and how to know you ve done the job right The book s interior is easy to read even in a dimly lit garage or workshop Hundreds of hand drawn illustrations and exploded parts diagrams show just the right level of detail to lead you through every mountain bike repair task This smartly organized guide shows how to repair new and old mountain bikes from top to bottom In over 500 pages and more than 750 illustrations Zinn s guide includes simple instructions for hundreds of mountain bike maintenance and repair jobs Basics How to fix a flat tire lube a bicycle chain adjust the brakes Emergency repairs How to fix a broken chain tighten loose spokes repair a bent derailleur Easy shifting How to adjust shifters derailleurs and cables for clean and smooth shifting Wheels How to true a wheel install a new tire change a cassette replace broken spokes build your own wheels Overhauls How to service and replace pedals chains and chainrings saddles handlebars stems headsets forks bottom brackets New tech How to maintain 1x speed systems electronic and wireless shifters Troubleshooting How to figure out what s wrong with any bike and fix it Zinn all bottom bracket systems all brake systems all headset stem handlebar and fork systems wheelbuilding for all bikes updated and expanded torque tables complete indexes of all illustrations and topics covered Whether you re riding a classic Stumpjumper or a carbon fiber race machine Zinn has got you covered **Direct Support and General Support Maintenance Manual** , 1990 [Field and Depot Maintenance Manual](#) , 1992 **Technical Manual** United States. War Department, 1948 [DS and GS Maintenance Manual](#) United States. Department of the Army, 1965 *Direct Support, General Support and Depot Maintenance Manual, Including Repair Parts and Special Tools Lists for Engine, with Container, Turbosupercharged, Diesel, Fuel Injection, 90-degree "V" Type, Air*

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

regard to pipe and pipeline fitness for service **Direct and General Support Maintenance Manual for Transmission Assembly, Automatic, Model TX 200-2A, Allison Division, GM, 2520-860-7342, Transmission Assembly, Automatic, Model TX 200-2B, Allison Division, GM, 2520-964-9207, Transmission Assembly, Automatic, Model TX 200-6, Allison Division, GM, 2520-045-3108 ,1969** *Donny'S Unauthorized Technical Guide to Harley-Davidson, 1936 to Present* Donny Petersen,2016-10-29 Donny Petersen feels honored to share the wealth of his motorcycle knowledge and technical expertise He offers the real deal in understanding the Harley Davidson He gives workable solutions for whatever ails the 1957 to 1985 H D Ironhead Sportster Graphics pictures and charts guide the reader on a sure footed journey to a thorough understanding Donny intersperses the technical explanations with entertaining true stories of the hard core lifestyle of these years including The Wild One Easyriders the Birth of Hog Willie G Steppenwolf Evil Knevil the reviled AMF 1%ers and who could forget Elvis Presley Petersens insight makes technical issues understandable even for the novice This is the eighth volume of twelve of Donnys technical series Petersen is the dean of motorcycle technology Donny examines the theory design and mechanical aspects of the Ironhead Sportster Donny has ridden hundreds of Harleys across four continents doing all of his own roadside repairs He has acquired his practical knowledge the hard way Donny Petersen has the privilege of sharing his technical secrets with easy understanding He will walk you through detailed mechanical procedures concerning the power train electrical fuel delivery ignition and the gear head favorite subject of oil and lubrication

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Torque Guide For Bolts Introduction

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