

TIGHTENING TORQUE REFERENCE CHART FOR SAE AND METRIC BOLTS

NL = Not Lubricated

L = Lubricated

1 lbs ft = 1.356 N·m



TIGHTENING TORQUE FOR SAE BOLTS 80% OF YIELD STRENGTH (A) IN LBS-FT

MATERIAL	UNC	5/16"-20	3/8"-16	1/2"-13	5/8"-11	3/4"-10	7/8"-9	1 1/8"-8	1 1/4"-7	1 3/8"-6	1 1/2"-5	1 3/4"-4 1/2	1 7/8"-4	2"-4
GRADE 1	NL	4	8	14	22	34	48	68	120	194	291	412	581	762
	L	3	6	10	15	23	33	47	80	134	200	278	390	512
GRADE 2	NL	5	10	17	27	40	58	83	143	240	359	506	702	915
	L	4	8	13	20	30	43	62	107	180	271	375	512	675
GRADE 5/2	NL	10	20	36	57	87	128	185	308	496	743	1053	1486	2006
	L	7	15	27	43	65	95	138	231	373	557	790	1095	1458
GRADE 8	NL	14	28	50	81	120	177	245	405	706	1050	1488	2100	2792
	L	10	21	38	60	90	132	185	308	540	810	1150	1600	2140

TIGHTENING TORQUE FOR METRIC BOLTS 80% OF YIELD STRENGTH (A) IN N·m

MATERIAL	ST. PITCH	M6-1	M8-1.25	M10-1.25	M12-1.25	M14-2	M16-2	M18-2.5	M20-2.5	M22-2	M24-3	M27-2	M30-2.5	M33-3	M36-4
CLASS 4.8	NL	3	8	15	26	40	71	98	139	189	240	351	477	648	833
	L	3	7	12	21	34	53	74	105	142	180	263	357	486	633
CLASS 8.8	NL	5	12	22	38	60	105	145	208	283	360	536	721	976	1271
	L	4	10	18	30	48	81	113	160	218	278	408	553	750	996
CLASS 10.9	NL	10	24	44	75	120	208	290	408	553	705	1020	1380	1860	2447
	L	7	17	32	54	88	151	208	290	383	495	735	996	1330	1758
CLASS 12.9	NL	16	38	70	120	190	326	451	636	865	1100	1600	2185	2975	3918
	L	12	29	54	90	145	245	338	477	649	825	1207	1639	2200	2903

SAE to Metric

1/8"	3
1/4"	6
3/8"	9
1/2"	12
5/8"	16
3/4"	19
7/8"	22
1"	25
1 1/8"	28
1 1/4"	31
1 3/8"	34
1 1/2"	37
1 3/4"	40
2"	43

Torque Settings In The Conrod Bolts For 2e

Sebastian Brünink



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