

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

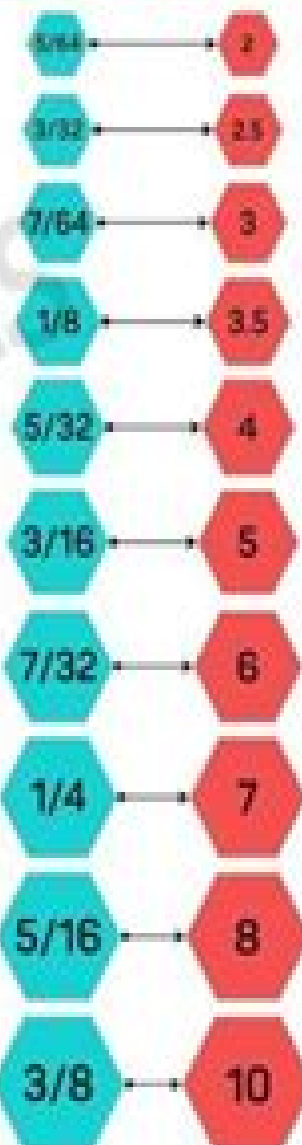
MATERIAL	UNC	1/4"-20	5/16"-18	3/8"-16	7/16"-14	1 1/2"-12	9/16"-12	5/8"-11	3/4"-10	1 1/8"-8	1 3/8"-7	1 5/8"-6	1 3/4"-6	1 1/2"-6
GRADE 1	NL	4	8	14	22	34	45	68	100	194	291	492	581	762
	L	3	6	10	17	26	37	51	90	145	218	309	436	572
GRADE 2	NL	6	12	22	35	54	78	107	191	394	492	581	762	1012
	L	5	9	17	27	40	58	81	143	145	218	309	436	572
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	231	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 1/2"-12
GRADE 1	NL	4	9	16	25	38	55	77	104	214	325	482	644	808
	L	3	7	12	19	29	41	58	101	160	245	347	483	601
GRADE 2	NL	7	14	25	39	61	87	122	213	214	326	482	644	808
	L	5	10	19	30	46	65	91	159	160	245	347	483	601
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	1682
GRADE 8	NL	16	31	57	90	139	198	277	485	773	1178	1669	2325	3103
	L	12	24	43	68	104	148	208	364	580	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	M36-4
CLASS 4.6	NL	3	9	16	29	46	71	98	139	199	240	351	477	649
	L	3	6	12	21	34	53	74	104	142	180	263	357	486
CLASS 8.8	NL	8	22	44	76	122	190	262	370	509	640	896	1271	1730
	L	7	17	33	57	91	142	197	278	378	480	702	953	1297
CLASS 10.9	NL	15	32	64	112	179	279	385	544	739	940	1375	1867	2540
	L	10	24	48	84	134	209	289	408	555	705	1031	1400	1905
CLASS 12.9	NL	16	38	75	131	209	326	451	636	865	1100	1609	2195	2973
	L	12	29	56	98	157	245	338	477	649	825	1207	1639	2230

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	M36-1.5
CLASS 4.6	NL	4	9	16	21	30	38	70	154	207	273	393	545	733
	L	3	7	14	23	37	57	83	116	156	204	295	409	550
CLASS 8.8	NL	10	24	49	83	132	202	294	411	553	727	1048	1455	2054
	L	7	18	37	63	99	151	220	308	415	545	799	1091	1486
CLASS 10.9	NL	15	35	72	123	194	296	431	603	813	1068	1539	2136	2970
	L	11	26	54	92	146	222	323	453	610	801	1155	1602	2215
CLASS 12.9	NL	17	41	84	143	227	347	505	708	951	1249	1822	2500	3358
	L	12	31	63	108	170	260	379	530	719	937	1351	1875	2579



Torque Guide For Metric Bolts

Dennis Parks



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Machinist Guide David B Smith, 2015-04-15 This is a Machinist Notebook Reference guide Revised Apr 11 2015 Written for machinists by a journeyman 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 ,

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Index of Specifications and Standards , Chilton's Repair & Tune-up Guide, Champ, Arrow, Sapporo, 1977-81 , 1981

Handbook of Bolts and Bolted Joints Sayed A. Nassar, John H. Bickford, 2025-03-20 Presenting time tested standards

as well as validated emerging knowledge on threaded fasteners and bolted joints this updated edition covers how to design select parts and materials control assembly processes predict behavior and solve on the job problems This handbook examines key issues affecting bolting in the automotive pressure vessel petrochemical aerospace energy and structural steel industries The editors have successfully created a useful rather than scholarly handbook with chapters written in a straightforward how to manner Theory is discussed only when necessary and the handbook's logical organization and thorough index enhance its usefulness Handbook of Bolts and Bolted Joints Second Edition includes updated chapters solved numerical examples and case studies This new edition is an essential handbook for professionals researchers and students in all fields in which threaded joints are used including automotive aerospace structural chemical and naval and ocean engineering as well as agricultural equipment wind turbines and medical devices

Illustrated Theatre Production Guide John Ramsey Holloway, 2014-06-20 Illustrated Theatre Production Guide delivers a step by step approach to the most prevalent and established theatre production practices focusing on essential issues related to the construction of wooden fabric plastic and metal scenery used on the stage A must have resource for both the community theatre worker who must be a jack of all trades and the student who needs to learn the fundamentals on his or her own it covers the necessities in great detail without bogging you down Offering techniques and best practice methods from an experienced industry expert it will allow you to create a foundation on which to build a successful and resourceful career behind the scenes in theatre production This third edition has been completely restructured to more effectively lead you through the basics of stagecraft Through detailed lessons and hundreds of drawings author John Holloway offers you solutions to the problems that you'll face every day in a production from rigging to knot tying New to this edition are guides to jobs in theatre construction documentation and video projection methods with expanded information on Thrust Theatres lighting audio and video practices This book is suitable for Stagecraft courses in university Theatre programs as well as for professional theatre technicians

The Essential Guide to Motorcycle Maintenance Mark Zimmerman, 2016-12-15 Popular motorcycle journalist and author Mark Zimmerman brings a comfortable conversational tone to his easy to understand explanations of how motorcycles work and how to maintain them and fix them when they don't This practical tutorial covers all brands and styles of bikes making it a perfect companion to the owner's service manual whether you need to use the step by step instructions for basic maintenance techniques to wrench on your bike yourself or just want to learn enough to become an informed customer at your local motorcycle service department This book includes more than 500 color photos and a thorough index to make it an especially user friendly reference for home motorcycle mechanics of all skill levels

Chilton's Repair & Tune-up Guide, Pinto, Bobcat, 1971-80 Chilton Book Company, Chilton, 1981 This book outlines procedures for servicing and repairing vehicles using safe effective methods

Illustrated Theatre Production Guide Emeritus Professor of English John Holloway, John Holloway, 2013-03-20 Completely expanded and remodeled new edition of this unique look at theatrical

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