

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	130	195	278	390	512
GRADE 2	NL	5	10	17	27	40	58	83	143	240	359	506	702	925
	L	4	8	13	20	30	43	62	107	180	271	375	510	675
GRADE 5 & 8	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	2732
	L	10	21	38	60	90	132	185	308	540	810	1155	1605	2145

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	130	195	278	390	512
GRADE 2	NL	5	10	17	27	40	58	83	143	240	359	506	702	925
	L	4	8	13	20	30	43	62	107	180	271	375	510	675
GRADE 5 & 8	NL	11	22	40	64	98	140	198	343	547	834	1181	1645	2209
	L	8	17	30	48	74	107	150	257	405	625	885	1235	1685
GRADE 8	NL	16	31	57	90	138	198	277	465	773	1178	1688	2325	3133
	L	12	24	43	68	104	148	208	349	580	881	1251	1744	2383

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

MATERIAL	FINE 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	46	71	98	139	189	240	351	477	648	833
	L	2	5	10	17	30	46	64	90	120	150	225	300	405	522
CLASS 8.8	NL	5	12	22	38	66	102	140	198	267	340	510	687	924	1197
	L	3	7	13	22	38	57	79	110	147	189	279	375	504	657
CLASS 10.9	NL	10	24	44	76	132	199	278	389	520	660	990	1320	1764	2292
	L	7	17	30	51	88	132	183	258	340	429	644	855	1134	1476
CLASS 12.9	NL	16	38	68	116	202	306	420	588	786	990	1485	1980	2664	3456
	L	12	28	50	84	148	222	306	429	576	729	1098	1452	1932	2520

MATERIAL	FINE PITCH	M6-1.75	M8-1	M10-1.25	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 4.8	NL	4	9	16	27	46	70	97	134	180	231	345	462	621	804
	L	3	7	13	22	37	55	76	105	141	183	274	363	492	636
CLASS 8.8	NL	10	24	44	76	132	199	278	389	520	660	990	1320	1764	2292
	L	7	17	30	51	88	132	183	258	340	429	644	855	1134	1476
CLASS 10.9	NL	15	35	62	106	187	282	390	537	720	924	1386	1848	2484	3204
	L	11	26	46	78	136	204	282	390	513	660	990	1320	1764	2292
CLASS 12.9	NL	17	41	74	126	222	336	462	636	855	1098	1647	2196	2934	3816
	L	13	31	55	93	166	250	342	474	636	819	1227	1638	2184	2856

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"	46

Torque Settings In The Conrod Bolts For 2e

**Larry Warren, Mark Christman, John
Harold Haynes**



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