

# 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

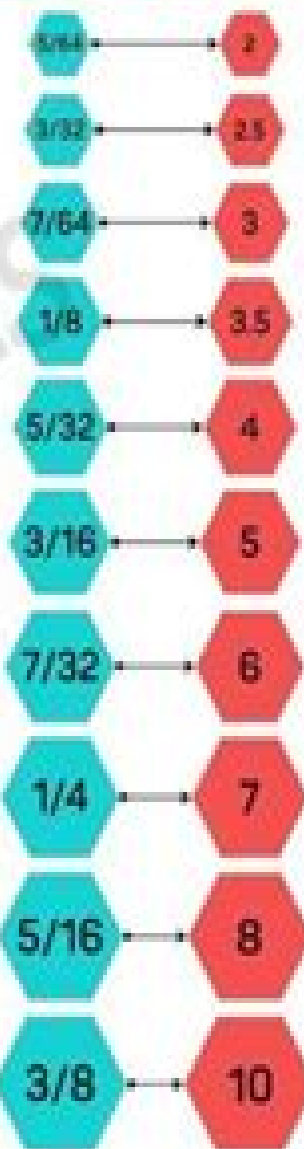
MATERIAL	UNC	1/4"-20	5/16"-18	3/8"-16	7/16"-14	1 1/2"-12	1 3/8"-12	1 1/4"-12	1 1/8"-12	1 1/4"-10	1 3/8"-10	1 1/2"-8	1 3/4"-8	1 5/8"-8	1 7/8"-6
GRADE 1	NL	4	8	14	22	34	45	68	100	194	291	492	581	762	1012
	L	3	6	10	17	26	37	51	90	145	218	309	436	572	759
GRADE 2	NL	6	12	22	35	54	78	107	191	194	291	492	581	762	1012
	L	5	9	17	27	40	58	81	143	145	218	309	436	572	759
GRADE 5/8.2	NL	10	20	36	57	87	126	173	308	496	743	1053	1486	1948	2589
	L	7	15	27	43	65	94	130	231	372	557	790	1114	1481	1939
GRADE 8	NL	14	28	50	81	123	177	245	435	700	1050	1488	2100	2752	3654
	L	10	21	38	60	92	133	184	326	525	787	1116	1575	2064	2740

MATERIAL	UNF	1/4"-28	5/16"-24	3/8"-24	7/16"-20	1 1/2"-20	1 3/8"-18	1 1/4"-18	1 1/8"-18	1 1/4"-16	1 3/8"-16	1 1/2"-14	1 3/4"-14	1 5/8"-14	1 7/8"-12
GRADE 1	NL	4	9	16	25	38	55	77	104	214	325	482	644	868	1108
	L	3	7	12	19	29	41	58	101	180	245	347	483	651	854
GRADE 2	NL	7	14	25	39	61	87	122	213	214	326	482	644	868	1108
	L	5	10	19	30	48	69	91	159	180	245	347	483	651	854
GRADE 5/1.2	NL	11	22	40	64	98	140	196	343	547	834	1181	1645	2217	2909
	L	8	17	30	48	74	105	147	257	410	625	886	1234	1683	2182
GRADE 8	NL	16	31	57	90	139	198	277	485	773	1178	1689	2325	3133	4111
	L	12	24	43	68	104	148	208	364	583	884	1251	1744	2350	3083

### 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	8	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	18	31	50	76	110	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	1068	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	1361	1875	2519	3285



# Bolt Torque Guide

**United States. Department of the  
Army**

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the text box.

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*Donny's Unauthorized Technical Guide to Harley-Davidson, 1936 to Present* Donny Petersen, 2010-03-01 Donny is the Winner of the 2012 International Book Awards Donny Petersen has been educating motorcycle enthusiasts about Harley Davidson bikes for years Now he has combined all his knowledge into a twelve volume series masterpiece and this third book is one that every rider will treasure Petersen who has studied privately with Harley Davidson engineers and has spent thirty six years working on motorcycles is sharing all of his secrets As the founder of Toronto's Heavy Duty Cycles in 1974 North America's premier motorcycle shop the dean of motorcycle technology teaches about the theory design and mechanical aspects of Harleys In this third volume discover 1 How to identify the Evolution models 2 Why the Evolution models are better 3 Everything you need to know about engines 4 Troubleshooting every facet of the Evolution And so much more The Harley Davidson Evolution The Japanese had more than quality Their arsenal included acceleration and speed combining with good braking and handling They could design tool up and build a new motorcycle in a mere eighteen months The flavor of the day could easily be accomplished with this organizational skill and dexterity On top of this they had lower prices The Gang of 13 took over a failing company or did they By 1982 Harley Davidson sales went into a tailspin with plunging production The USA was in a deep recession Adding to the perfect storm was the flood of Asian imports that many believe were being sold in the U S below their manufactured costs Whether this was true or not how did a small country a half world away manufacture a quality product that was faster handled better and was less expensive Furthermore these import

motorcycles were more functional Well of course they did because USA motorcycle manufacturing offered old clunker styling that was slower did not handle well and broke down all the time And for all of this Harley Davidson s cost more Insulting if one thinks about it It is not that the Evolution was that good relative to their competitors because in my opinion it was not However the Evolution was stellar relative to what went before I was a loyal Shovelhead rider necessarily becoming a mechanic along the way I like the rest of my ilk would never consider riding any other product I did not care that a Honda might be functionally better less expensive and not require my newfound mechanical skills Honda simply did not give what my psyche craved Importantly H D dropped its lackadaisical attitude towards copyright infringement particularly with knock off products Harley Davidson became extremely aggressive against the counterfeiting of their trademarks It licensed use of its logos with all manner merchandise that was embraced by mainstream America followed by the world including the Japanese H D then saw the birth of HOG the most successful marketing and loyalty campaign in the annals of corporate sustenance The world embraced this pasteurized version of the outlaw subculture You might meet the nicest people on a Honda but Harley riders are all about cool They adapt a pseudo outlaw lifestyle that emulates freedom and individualism They spend much of their time adopting one charity or another to prove they really aren t bad Many charities benefitted greatly during the Harley boom Can these riders be contesting the Honda mantra of niceness The previous owners AMF deserve much credit for the success of Harley Davidson They gave the Gang of 13 a platform from which to launch These new guys were brighter than bright They put a management team together that knew no bounds in success I am sure that Marketing 101 in every business school teaches and will continue to teach their brilliant story Harley Davidson became the epitome of American manufacturing and marketing the darling of capitalism at its finest Think about it How could a rusty old manufacturer whose time had drifted by reach such pinnacles of success Well H D had a little help along the way with two main sociological factors 1 The post World War II baby boom the aging bulge in American demographics looking for adventure and whatever safely came their way 2 A generation that worked hard raised families and then looked back at what they had missed in their youth Harley Davidson embodied the freedom and adventure they lacked Harley Davidson was granted two decades in which to plan a lasting and viable future It sought to be the motorcycle of mainstream America The world would follow This venerable company almost pulled it off The Motor Company updated technology both in their manufacturing venue and in the product itself H D balanced on a near impossible fulcrum maintaining tradition on one side and complying with environmental dictates on the other The Evolution s successor the air cooled Twin Cam introduced in 1999 with great success H D continued to grow and prosper I have always viewed the Twin Cam as a transitional model embracing the past but leading into a future of overhead cams and water jackets The new H D V Rod s technological marvels are a wonderful attempt but as much as the Factory hoped mainstream Harley riders did not take the bait en masse After all they had their psychological needs These attempts did not prevent dark clouds from appearing on the horizon 1 Inexorably

the post World War II baby boom s bulge has grown older losing interest in reclaiming youth with interests shifting elsewhere Who is to take over this downsizing market Who will be left to support the Motor Company in the style it has become accustomed 2 In my humble opinion the masters of marketing did not fill the coming void of consumers I think H D is good at pretty much everything except lowering prices for the incoming generations Nor have they developed affordable and desirable product lines for the youth Certainly the Factory began to enjoy economies of scale in manufacturing I for one do not think they have used their profits wisely for continued prosperity Will I continue to ride a Harley at age 62 Sure I will but I was riding them before they became cool I am not a dentist looking for a safe walk on the wild side or a movie star acquiring the in bauble of the day The Evolution motorcycle saved the Hog s bacon but a new savior is now required

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States. Office of Education, Walter J. Brooking, 1970      *Organizational Maintenance Manual for Truck Chassis, for Direct Support Section, Topographic Support System (TSS)*, NSN 2320-01-113-3616 , 1987

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