

# 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	1070
	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	1070
	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	1208
	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	1208
	L	5	10	19	30	46	65	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	2929
	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	625
CLASS 8.8	NL	8	22	44	76	122	190	262	370	503	640	896	1271	1730	2221
	L	7	17	33	57	91	142	197	278	378	480	702	953	1287	1655
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	16	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	1351	1875	2519	3285

5/16" → 2

3/32" → 2.5

7/64" → 3

1/8" → 3.5

5/32" → 4

3/16" → 5

7/32" → 6

1/4" → 7

5/16" → 8

3/8" → 10

# Bolt Torque Chart Metric 316

**Sabine Zange**

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located to the right of the name bar.

## **Bolt Torque Chart Metric 316:**

**Introduction to the Design and Behavior of Bolted Joints** John H. Bickford, Michael Oliver, 2022-12-30 The fully updated Fifth Edition of John H Bickford's classic work updated by Michael Oliver provides a practical detailed guide for the design threaded bolted joints the tightening of threaded joints and the latest design procedures for long term life New sections on materials threads and their strength have been added and coverage of FEA for design analysis is now included Referencing the latest standards this new edition combines fastener materials explanation of how fasteners are made and how fasteners fit together supplementing the basic design coverage included in previous versions of this authoritative text Introduction to the Design and Behavior of Bolted Joints Non Gasketed Joints will be of interest to engineers involved in the design and testing of bolted joints **Sweet's Industrial Construction and Renovation File**, 1992 **Sweet's General Building & Renovation**, 1999 **Gearheads** Stock Drive Products (Firm)., 2004 *Index of Specifications and Standards*,

**Construction Calculations Manual** Sidney M Levy, 2011-09-19 Construction Calculations is a manual that provides end users with a comprehensive guide for many of the formulas mathematical vectors and conversion factors that are commonly encountered during the design and construction stages of a construction project It offers readers detailed calculations applications and examples needed in site work cost estimation piping and pipefitting and project management The book also serves as a refresher course for some of the formulas and concepts of geometry and trigonometry The book is divided into sections that present the common components of construction The first section of the books starts with a refresher discussion of unit and systems measurement its origin and evolution the standards of length mass and capacity terminology and tables and notes of metric U S and British units of measurements The following concepts are presented and discussed throughout the book Conversion tables and formulas including the Metric Conversion Law and conversion factors for builders and design professionals Calculations and formulas of geometry trigonometry and physics in construction Rudiments of excavation classification use of material measurement and payment Soil classification and morphology including its physicochemical properties Formulas and calculations needed for soil tests and evaluations and for the design of retaining structures Calculations relating to concrete and masonry Calculations of the size weight of structural steel and other metals Mechanical properties of wood and processing of wood products Calculations relating to sound and thermal transmission Interior finishes plumbing and HVAC calculations Electrical formulas and calculations Construction managers and engineers architects contractors and beginners in engineering architecture and construction will find this practical guide useful for managing all aspects of construction Work in and convert between building dimensions including metric Built in right angle solutions Areas volumes square ups Complete stair layouts Roof rafter and framing solutions Circle arcs circumference segments

**GEARHEADS**, 2002 **Drafting Fundamentals** Cecil Howard Jensen, Frederick Harry Sextus Mason, 1982 *Truck and Trailer Systems (PB)* Mike Thomas, 2013-10-22 The most complete visual guide to servicing medium and heavy duty truck

systems Written by an expert with decades of experience as an automotive and diesel technician and instructor Truck and Trailer Systems offers comprehensive information on medium and heavy duty truck service The book begins by discussing the trucking industry professional certifications safety tools and measuring equipment Then each system is thoroughly covered from electrical and lighting to brakes and transmissions Factory procedures from the most common manufacturers for diagnosis and repair are presented along with annotated photos and diagrams This practical authoritative resource is essential for those starting out in the field as well as experienced professionals in need of a detailed on the job reference Chapters include Objectives Notes Cautions Service tips Photos and diagrams Chapter reviews Truck and Trailer Systems covers Industry safety Basic electrical Magnetism Batteries Starting system Charging system Lighting and wiring Computer systems Mobile heating ventilation and air conditioning systems Tires wheels and wheel end systems Frames and suspensions Steering systems Trailers and fifth wheels Hydraulic brake systems Air brake foundation brakes Air brake air systems Antilock brake systems Drive lines Clutches Drive axles Single and twin countershaft manual transmissions Automated manual transmissions Automatic transmissions Allison transmission overhaul PMI Auxiliary power units

**Fundamentals of Engineering Drawing** Cecil Howard Jensen, Jay D. Helsel, 1979 Thomas Register of American Manufacturers, 2002 This basic source for identification of U S manufacturers is arranged by product in a large multi volume set Includes Products services Company profiles and Catalog file

**To Advance the Concept of Aesthetics and Constructability in the Design of Noise Barrier Walls Through the Design of Models, Prototypes, Plans and Specifications of the Bhavnani Design** Ed Dauenheimer, 1999

**The Engineering Designer**, 1978 How Everything Works Louis A. Bloomfield, 2007-08-28 By explaining the physics behind ordinary objects this book unravels the mysteries of how things work Using familiar examples from everyday life and modern technology this book explains the seemingly inexplicable phenomena we encounter all around us As it examines everything from roller coasters to radio musical instruments to makeup and knuckleballs to nuclear weapons How Everything Works provides the answers to such questions as why the sky is blue why metal is a problem in microwave ovens and why some clothes require dry cleaning With fascinating and fun real life examples that provide the answers to scores of questions How Everything Works is nothing short of a user s manual to our everyday world

AID Small Business Circular; Trade Opportunities for American Suppliers United States. Agency for International Development. Office of Small Business, 1963

**FRC Technical Abstracts** Fasteners Research Council, 1965

**NASA-Wide Fastener Technical Interchange Meeting (TIM)**, 1995

**Make No Mistake!** C. Martin Hinckley, 2001-09-30 With C Martin Hinckley s new book Make No Mistake An Outcome Based Approach to Mistake Proofing that vision can become a reality If you work for a company that emphasizes traditional quality control methods it s unlikely that you ve seen defects eliminated despite your substantial efforts Make No Mistake clarifies the reasons why such traditional methods fail and shows how world class quality can be achieved at a minimal cost through

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*California Manufacturers Register* ,1976      Thomas Register of American Manufacturers and Thomas Register Catalog File ,2002 Vols for 1970 71 includes manufacturers catalogs

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