

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 1/8-9	1 1/8-7	1 1/8-6	1 1/2-6
GRADE 1	NL	4	8	14	22	34	45	68	100	194	201	492	581	1012
	L	3	6	10	17	26	37	51	90	145	218	309	436	759
GRADE 2	NL	6	12	22	35	54	78	107	191	194	291	492	581	1012
	L	5	9	17	27	40	58	81	143	145	218	309	436	759
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	3654
	L	10	21	38	60	92	133	184	326	525	787	1116	1575	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 1/8-14	1 1/4-12	1 1/8-12	1 1/8-10	1 1/8-8	1 1/2-8
GRADE 1	NL	4	9	16	25	38	55	77	104	214	325	482	644	1028
	L	3	7	12	19	29	41	58	101	160	245	347	483	854
GRADE 2	NL	7	14	25	39	61	87	122	213	214	326	492	644	1028
	L	5	10	19	30	46	66	91	159	160	245	347	483	854
GRADE 5/8.2	NL	11	22	40	64	98	140	196	343	547	834	1181	1645	2929
	L	8	17	30	48	74	105	147	257	410	625	886	1234	2182
GRADE 8	NL	16	31	57	90	139	198	277	485	773	1178	1669	2325	4111
	L	12	24	43	68	104	148	208	364	580	884	1251	1744	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	M36-4
CLASS 4.6	NL	3	9	16	29	46	71	98	139	199	240	351	477	833
	L	3	6	12	21	34	53	74	104	142	180	263	357	625
CLASS 8.8	NL	8	22	44	76	122	190	262	370	509	640	896	1271	2221
	L	7	17	33	57	91	142	197	278	378	480	702	953	1666
CLASS 10.9	NL	15	32	64	112	179	279	385	544	739	940	1375	1887	3363
	L	10	24	48	84	134	209	289	408	555	705	1031	1400	2447
CLASS 12.9	NL	16	38	75	131	209	326	451	636	865	1100	1609	2195	3878
	L	12	29	56	98	157	245	338	477	649	825	1207	1639	2863

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	958
	L	3	7	14	23	37	57	83	116	156	204	295	409	719
CLASS 8.8	NL	10	24	49	83	132	202	294	411	553	727	1048	1455	2556
	L	7	18	37	63	99	151	220	308	415	545	799	1091	1897
CLASS 10.9	NL	15	35	72	123	194	296	431	603	813	1068	1539	2136	3754
	L	11	26	54	92	146	222	323	453	610	801	1155	1602	2815
CLASS 12.9	NL	17	41	84	143	227	347	505	708	951	1249	1822	2500	4363
	L	12	31	63	108	170	260	379	530	719	937	1351	1875	3295

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 Guide

William Carroll

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

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