

# 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	1-12	1 1/8-12	1 1/4-11	1 3/8-10	1 1/2-9	1 5/8-8	1 3/4-7	1 7/8-6	2-5
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	294	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	1194	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	1-20	1 1/8-18	1 1/4-16	1 3/8-14	1 1/2-12	1 5/8-10	1 3/4-9	1 7/8-8	2-7
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	651
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	651
GRADE 5/8.2	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	1689	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	8	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	78	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	18	31	50	76	110	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	1954
	L	7	18	37	63	99	151	220	308	415	545	799	1091	1466
CLASS 10.9	NL	15	35	72	123	194	296	431	603	813	1068	1539	2136	2870
	L	11	26	54	92	146	222	323	453	610	801	1155	1602	2152
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	1361	1875	2519

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

**Donny Petersen**

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.

## **Bolt Torque Guide:**

**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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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

**Technical Manual** United States. War Department,1948      **Fundamentals of Medium/Heavy Duty Commercial Vehicle Systems** Owen C. Duffy,Gus Wright,2015-07-13 Based on the 2014 National Automotive Technicians Education Foundation NATEF Medium Heavy Truck Tasks Lists and ASE Certification Test Series for truck and bus specialists Fundamentals of Medium Heavy Duty Commercial Vehicle Systems is designed to address these and other international training standards The text offers comprehensive coverage of every NATEF task with clarity and precision in a concise format that ensures student comprehension and encourages critical thinking Fundamentals of Medium Heavy Duty Commercial Vehicle Systems describes safe and effective diagnostic repair and maintenance procedures for today s medium and heavy vehicle chassis systems including the most current relevant and practical coverage of Automated transmissions Braking system technology used in vehicle stability collision avoidance and new stopping distance standards Hybrid drive powertrains Advanced battery technologies On board vehicle networks and integrated chassis electrical control system Automatic transmission drive shafts and drive axles Charging starting vehicle instrumentation and chassis electrical systems On board diagnostic systems electronic signal processing and sensor operation Steering suspension frames hitching and air conditioning systems Environmental and fuel efficiency technologies Additional features include Up to date NATEF coverage Support of ASE certification test preparation for medium heavy truck and bus test series A clear accessible writing style Reinforcement of concepts learned Application to real world practice A wealth of photographs illustrations and step by step explanations with visual summaries      **Technical Manual** United States Department of the Army,1950      Garage and Workshop Gear Guide Tom Benford,2006      **General Motors Diesel, Series 71, Maintenance and Overhaul Manual for Three, Four, and Six Cylinder Industrial Units, Form 6SE-61** United States. Department of the Army,1954

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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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