

# 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	7/8"-14	1 1/2"-12	2"-12	2 1/2"-12	3"-10	3 1/2"-9	4"-8	5"-8	5 1/2"-7	6"-7	6 1/2"-6	7"-6
GRADE 1	NL	4	8	14	22	34	48	68	100	134	201	292	452	581	762	1012
	L	3	6	10	17	26	37	51	90	145	218	309	436	572	759	1012
GRADE 2	NL	6	12	22	35	54	78	107	191	294	452	681	981	1386	1948	2589
	L	5	9	17	27	40	58	81	143	145	218	309	436	572	759	1012
GRADE 5/8.2	NL	10	20	38	57	87	126	173	308	486	743	1053	1486	1948	2589	3454
	L	7	15	27	43	65	94	130	239	372	557	790	1114	1481	1939	2589
GRADE 8	NL	14	28	50	81	123	177	246	435	700	1050	1488	2100	2752	3654	4854
	L	10	21	38	60	90	133	184	326	525	787	1116	1575	2084	2740	3654
MATERIAL	UNF	1/4"-28	5/16"-24	3/8"-24	7/8"-20	1 1/2"-12	2"-12	2 1/2"-12	3"-10	3 1/2"-9	4"-8	5"-8	5 1/2"-7	6"-7	6 1/2"-6	7"-6
GRADE 1	NL	4	9	16	25	38	55	77	104	214	325	482	644	868	1038	1308
	L	3	7	12	19	29	41	58	101	160	245	347	483	651	854	1054
GRADE 2	NL	7	14	25	39	61	97	132	213	314	482	644	868	1038	1308	1678
	L	5	10	19	30	48	75	91	159	160	245	347	483	651	854	1054
GRADE 5/8.2	NL	11	22	40	64	98	140	196	343	547	834	1181	1648	2217	2929	3829
	L	8	17	30	48	74	105	147	257	410	625	886	1234	1683	2182	2882
GRADE 8	NL	16	31	57	90	139	198	277	485	773	1178	1689	2325	3133	4111	5311
	L	12	24	43	68	104	148	208	364	580	884	1251	1744	2350	3083	4083

### 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	549	833
	L	3	6	12	21	34	53	74	104	142	180	263	357	486	629
CLASS 8.8	NL	8	22	44	78	122	190	262	370	509	640	896	1271	1730	2221
	L	7	17	33	57	91	142	197	278	378	480	702	953	1297	1658
CLASS 10.9	NL	15	32	64	112	179	279	385	544	739	940	1375	1867	2540	3263
	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	2893
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	25	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	2558
	L	7	18	37	63	99	151	220	308	415	545	799	1091	1466	1917
CLASS 10.9	NL	15	35	72	123	194	296	431	603	813	1088	1529	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	1802	2500	3358	4383
	L	13	31	63	108	170	260	379	530	719	937	1351	1875	2519	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

**United States. War Department**

A red circular graphic with a gradient, appearing as a stylized arrow or a partial circle, located to the right of the 'United States. War Department' text.

## **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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**Direct Support and General Support Maintenance Manual** , 1989

**Camaro Restoration Guide, 1967-1969** Jason Scott, 1997      *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      *Chilton's Repair & Tune-up Guide, Pontiac Mid-size, 1974-83* , 1989      *Technical Manual* United States. War Department, 1948      **Truck service manual** , 1984      ,      *Chassis, Truck, M44, M44A1, M44A2, M45, M45A1, M45A2, M45A2G, M45C, M45G, M46, M46A1, M46A1C, M46A2C, M46C, M57, M58; Instrument Repair Shop, Truck Mounted ... Truck, Cargo ... Truck, Dump ... Truck, Maintenance ... Truck, Pipeline Construction ... Truck, Tank ... Truck, Tractor ...*

*Truck, Van ... Truck, Wrecker, Light, M60* ,1992      *Chilton's Repair & Tune-up Guide, Volvo 1970-83* ,1983      Chilton's Ford 1968 to 1979 Repair & Tune-up Guide Chilton Book Company,1979      Chilton's Repair & Tune-up Guide, Datsun 1200, 210, Nissan Sentra, 1973-84 ,1984      Chilton's Repair & Tune-up Guide, Datsun, 1973 to 1980 Chilton Book Company,1980  
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web apr 8 2023 i am writing to formally request a change in my current shift schedule due to some personal circumstances that have recently emerged as you are aware i am currently working the night shift 10 pm to 6 am at the department name however due to unforeseen family obligations i am finding it increasingly challenging to maintain this

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web request a change the my work schedule by communication address your contact to the law person or department create eimen email title that clear states to intent hail the person or business mention your name job top and your team or department mention previous schedule and your new schedule

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web to email protected subject request to change schedule dear employer s name i m your name a job title working on your department team i would same to requests a change to my schedule from current schedule to desired schedule for the next 3 months such my mother passed away i m now responsible for taking care of my father

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web may 19 2020 respected sir madam i am name of the employee working as name of the position in your esteemed company i am writing this letter to request a change in my shift schedule my current working hours are mention the timings

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