

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 3/4-8	1 7/8-7	2-6	2 1/4-5	2 3/4-4
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	294	492	581	762	1012	1302
	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	2084	2740
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 3/4-11	1 7/8-10	2-9	2 1/4-8	2 3/4-7
GRADE 1	NL	4	9	16	25	38	55	77	104	214	325	482	648	868	1108
	L	3	7	12	19	29	41	58	101	160	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	46	66	91	159	160	245	347	483	651	854
GRADE 5/8.2	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	580	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	9	16	29	46	71	98	139	199	240	351	477	549	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	509	640	896	1271	1730	2221
	L	7	17	33	57	91	142	197	278	378	480	702	953	1297	1655
CLASS 10.9	NL	15	32	64	112	179	279	385	544	739	940	1375	1887	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	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	16	21	30	38	70	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	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 Chart Metric 316

John H. Bickford, Michael Oliver

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

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Table of Contents Bolt Torque Chart Metric 316

1. Understanding the eBook Bolt Torque Chart Metric 316
 - The Rise of Digital Reading Bolt Torque Chart Metric 316
 - Advantages of eBooks Over Traditional Books
2. Identifying Bolt Torque Chart Metric 316
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Bolt Torque Chart Metric 316
 - User-Friendly Interface
4. Exploring eBook Recommendations from Bolt Torque Chart Metric 316
 - Personalized Recommendations
 - Bolt Torque Chart Metric 316 User Reviews and Ratings
 - Bolt Torque Chart Metric 316 and Bestseller Lists

5. Accessing Bolt Torque Chart Metric 316 Free and Paid eBooks
 - Bolt Torque Chart Metric 316 Public Domain eBooks
 - Bolt Torque Chart Metric 316 eBook Subscription Services
 - Bolt Torque Chart Metric 316 Budget-Friendly Options
6. Navigating Bolt Torque Chart Metric 316 eBook Formats
 - ePub, PDF, MOBI, and More
 - Bolt Torque Chart Metric 316 Compatibility with Devices
 - Bolt Torque Chart Metric 316 Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Bolt Torque Chart Metric 316
 - Highlighting and Note-Taking Bolt Torque Chart Metric 316
 - Interactive Elements Bolt Torque Chart Metric 316
8. Staying Engaged with Bolt Torque Chart Metric 316
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Bolt Torque Chart Metric 316
9. Balancing eBooks and Physical Books Bolt Torque Chart Metric 316
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Bolt Torque Chart Metric 316
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Bolt Torque Chart Metric 316
 - Setting Reading Goals Bolt Torque Chart Metric 316
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Bolt Torque Chart Metric 316
 - Fact-Checking eBook Content of Bolt Torque Chart Metric 316
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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