

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 (50% of yield strength S_y) in lbs ft

MATERIAL	UNC	1/4"-20	5/16"-18	3/8"-16	7/16"-14	1/2"-13	9/16"-12	5/8"-11	3/4"-10	7/8"-9	1"-8	1 1/8"-7	1 3/8"-6	1 5/8"-5	1 3/4"-4
GRADE 1	NL	4	8	14	22	34	48	68	100	154	201	452	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	452	581	762	1012	1312
	L	5	9	17	27	40	58	81	143	145	218	309	436	572	759
GRADE 5/8.2	NL	10	20	38	57	87	126	173	308	486	743	1053	1486	1948	2589
	L	7	15	27	43	65	94	130	239	372	557	790	1114	1481	1939
GRADE 8	NL	14	28	50	81	123	177	246	435	700	1050	1488	2100	2752	3654
	L	10	21	38	60	90	133	184	326	525	787	1116	1575	2084	2740
MATERIAL	UNF	1/4"-28	5/16"-34	3/8"-34	7/16"-27	1/2"-23	5/8"-20	3/4"-18	7/8"-14	1"-12	1 1/8"-10	1 3/8"-8	1 5/8"-6	1 3/4"-5	1 1/2"-4
GRADE 1	NL	4	9	16	25	38	55	77	104	214	325	482	644	868	1028
	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	328	482	644	868	1028
	L	5	10	19	30	48	69	91	159	180	245	347	483	651	854
GRADE 5/8.2	NL	11	22	40	64	98	140	196	343	547	834	1181	1648	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	580	884	1251	1744	2350	3083

TIGHTENING TORQUE FOR METRIC BOLTS (50% 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	20	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	1287	1658
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	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	2558
	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	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

Léo Pomar

A red circular graphic with a gradient, appearing as a semi-circle or a partial circle, located on the right side of the slide, partially overlapping the light blue bar.

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