

## Recommended Assembly Torque Values \*

(Steel Hex. Head Bolts)

Size	BSW		UNC				UNF			
	Grade 2		Grade 5		Grade 8		Grade 5		Grade 8	
	Nm	lb ft	Nm	lb ft	Nm	lb ft	Nm	lb ft	Nm	lb ft
1/4"	4	3	10	7	14	10	11	8	16	12
5/16"	8	6	20	15	29	21	23	17	31	23
3/8"	16	12	37	27	52	38	41	30	58	43
7/16"	26	19	58	43	82	60	65	48	91	67
1/2"	38	28	90	66	125	92	101	74	141	104
5/8"	75	55	177	130	249	183	204	150	282	207
3/4"	133	98	313	230	442	325	354	260	494	363
7/8"	204	150	503	370	711	523	558	410	785	577
1"	313	230	762	560	1068	785	830	610	1168	859
<b>1" UNS</b>							<b>848</b>	<b>625</b>	<b>1197</b>	<b>883</b>
1-1/8"	435	320	934	689	1514	1116	1046	772	1697	1252
1-1/4"	612	450	1317	971	2135	1575	1458	1075	2365	1744
1-3/8"			1727	1274	2799	2065	1965	1449	3187	2351
1-1/2"	1061	780	2291	1690	3715	2740	2578	1901	4180	3083

### Notes

1. Values given represent the torque required to induce a tension in the bolt corresponding to approximately 65% of its proof load.

2. Values given are applicable to plain finish (uncoated) fasteners only. Torque settings for fasteners with zinc, galvanised, or other surface treatments, will vary due to differences in frictional coefficients.

\* This table is recommended for use as a guide only. While all care has been taken with its preparation, no responsibility is accepted for the absolute accuracy of the data provided.