

## Recommended Assembly Torque Values \*

(Imperial Socket Heads) All Class 12.9 material

	Socket Cap Screw				Low Head Cap Screws		Flat Head (Countersunk)				Button Head				Shoulder Screws		Grub Screws	
	UNC		UNF		UNC		UNC		UNF		UNC		UNF		UNC		UNC	
Size	Nm	lb ft	Nm	lb ft	Nm	lb ft	Nm	lb ft	Nm	lb ft	Nm	lb ft	Nm	lb ft	Nm	lb ft	Nm	lb ft
#0			0.3	0.22					0.18	0.13			0.18	0.13			0.109	0.08
#1	0.52	0.38	0.54	0.4			0.29	0.21	0.29	0.21	0.29	0.21	0.29	0.21			0.2	0.15
#2	0.86	0.63	0.91	0.67			0.52	0.38	0.52	0.38	0.52	0.38	0.52	0.38			0.2	0.15
#3	1.25	0.92	1.36	1			0.79	0.58	0.79	0.58	0.8	0.58	0.79	0.58			0.6	0.42
#4	1.81	1.33	2.04	1.5	0.57	0.42	0.91	0.67	0.91	0.67	0.9	0.67	1.02	0.75			0.6	0.42
#5	3	2	2.72	2	1.07	0.79	1.36	1	1.47	1.08	1.4	1	1.36	1			1.1	0.83
#6	3	2.5	3.85	2.83	1.07	0.79	1.7	1.25	1.93	1.42	1.81	1.33	2	1			1.1	0.83
#8	6	4.58	6.57	4.83	2.2	1.62	3.4	2.5	3.51	2.58	3.4	2.5	3	3			2	2
#10	9	6.58	10.2	7.5	3.79	2.79	4.53	3.33	5.1	3.75	5.1	3.75	5	4			4	3
1/4"	23	17	26	19	9	6	11	8	12	9	11	8	12	9	6	4	10	7
5/16"	48	35	52	38	18	13	23	17	24	18	23	17	24	18	14	10	19	14
3/8"	84	62	95	70	31	23	39	29	45	33	39	29	45	33	30	22	33	24
7/16"	136	100	148	109	49	36	64	47	71	52							49	36
1/2"	204	150	234	172	69	51	97	71	113	83	97	71	113	83	53	39	71	52
9/16"	287	211	325	239			136	100	154	113							71	52
5/8"	385	283	431	317	150	110	193	142	215	158	193	142	204	150	131	96	139	102
3/4"	680	500	764	562			340	250	363	267					227	167	272	200
7/8"	936	688	1043	767			567	417	612	450							408	300
1	1414	1040	1469	1080			907	667									567	417
1-1/4"	2829	2080	3142	2310			1541	1133									1088	800
1-1/2"	4930	3625	5549	4080													1282	943

### Notes

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

