

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 3/4"-6	8"-5
GRADE 1	NL	4	8	14	22	34	45	68	100	194	291	492	581	762	1012	1512
	L	3	6	10	17	26	37	51	90	145	218	309	436	572	759	1102
GRADE 2	NL	6	12	22	35	54	78	107	191	294	492	581	762	1012	1512	2202
	L	5	9	17	27	40	58	81	143	145	218	309	436	572	759	1102
GRADE 5/8.2	NL	10	20	36	57	87	126	173	308	496	743	1053	1486	1948	2589	3854
	L	7	15	27	43	65	94	130	231	372	557	790	1114	1481	1939	2854
GRADE 8	NL	14	28	50	81	123	177	245	435	700	1050	1488	2100	2752	3654	5454
	L	10	21	38	60	92	133	184	326	525	787	1116	1575	2084	2740	4040

MATERIAL	UNF	1/4"-28	5/16"-24	3/8"-24	7/8"-20	1 1/2"-18	2"-18	2 1/2"-16	3"-14	3 1/2"-14	4"-12	5"-12	5 1/2"-11	6"-11	6 3/4"-10	8"-9
GRADE 1	NL	4	9	16	25	38	55	77	104	214	325	482	644	868	1028	1528
	L	3	7	12	19	29	41	58	101	160	245	347	483	651	854	1254
GRADE 2	NL	7	14	25	39	61	87	122	213	214	326	482	644	868	1028	1528
	L	5	10	19	30	46	65	91	159	160	245	347	483	651	854	1254
GRADE 5/8.2	NL	11	22	40	64	98	140	196	343	547	834	1181	1645	2217	2929	4329
	L	8	17	30	48	74	105	147	257	410	625	886	1234	1683	2182	3282
GRADE 8	NL	16	31	57	90	139	198	277	485	773	1178	1689	2325	3133	4111	6111
	L	12	24	43	68	104	148	208	364	580	884	1251	1744	2350	3083	4583

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	199	240	351	477	649	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	1666
CLASS 10.9	NL	15	32	64	112	179	279	385	544	739	940	1375	1887	2540	3283
	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	2556
	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	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

Nitronic 50 Lubricated Torque Values

Lawrence J. Korb



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