

# 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 1/2"-12	1 3/8"-12	1 1/4"-12	1 1/8"-12	1 1/4"-10	1 3/8"-9	1 1/2"-8	1 3/4"-7	1 5/8"-6	1 1/2"-6
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	194	291	492	581	762	1012
	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	2064	2740

MATERIAL	UNF	1/4"-28	5/16"-24	3/8"-24	7/16"-20	1 1/2"-20	1 3/8"-18	1 1/4"-18	1 1/8"-16	1 1/4"-14	1 3/8"-12	1 1/2"-12	1 3/4"-10	1 5/8"-10	1 1/2"-10
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	160	245	347	483	651	854
GRADE 2	NL	7	14	25	39	61	87	122	213	214	326	482	644	868	1028
	L	5	10	19	30	46	65	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	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 (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	16	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

# Nitronic 50 Lubricated Torque Values

**John Bickford**



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web the judging criteria contests also have an element of competition that requires the sponsor or agency to set clear contest judging criteria so participants know how their entries will be judged this criteria will also tell the judging body what to look for and how to assign value or rank entries

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