

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	1/2-13	9/16-12	5/8-11	3/4-10	7/8-9	1-8	1 1/8-7	1 1/4-7	1 3/8-6	1 1/2-6
GRADE 1	NL	4	8	14	22	34	48	68	100	134	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	194	291	452	581	762	1012
	L	5	9	17	27	40	58	81	143	145	218	309	436	572	759
GRADE 5/1.2	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	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	5/16-24	3/8-24	7/16-20	1/2-20	5/8-18	3/4-16	7/8-14	1-14	1 1/8-12	1 1/4-12	1 3/8-12	1 1/2-12	
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	326	452	644	868	1028
	L	5	10	19	30	46	66	91	159	180	245	347	483	651	854
GRADE 5/1.2	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	1669	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	9	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	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	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	16	27	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	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

M Walker



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Machinist Guide David B Smith, 2015-04-15 This is a Machinist Notebook Reference guide Revised Apr 11 2015 Written for machinists by a journeymen machinist in a real shop environment With tables charts illustration drawing and Sketches for machinist gunsmith auto industries With work sheets for none standard threading and gear cutting It also has simple illustration on how to make a few simple tooling and aids in the shop information for machinist As listed Three wire Major Diameter worm DP and MOD Using a Dividing Head How use a Compound Indexing How to make the Smith Compound indexer Rebound Ball Hardness Tester Grinding Lathe Tools bits Speeds and lubrication Rebound Ball Hardness Tester Hardness Chart Roughness Finish Compactor Scale Over the wire dimensions inch bolts in mm Index Table for 40 tooth worm 2 to 540 Compound Indexing on 40 tooth worm 51 250 teeth Index Table for 72 tooth worm Index Table for 90 tooth worm 2 230 Gear cutting and blanks This is book with written for fast reading NOT NOVEL for reading for slow reading

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Chevrolet V8 Performance Guide William Carroll,1971 A complete list of the original factory issue parts for every 1955 1971 Chevrolet V8 engine including oil coolers high rise manifolds and special cams This fine book has been known as the Stocker s Bible for decades

Fundamentals of Medium/Heavy Duty Commercial Vehicle Systems Owen C. Duffy,Gus Wright,2015-07-13 Based on the 2014 National Automotive Technicians Education Foundation NATEF Medium Heavy Truck Tasks Lists and ASE Certification Test Series for truck and bus specialists Fundamentals of Medium Heavy Duty Commercial Vehicle Systems is designed to address these and other international training standards The text offers comprehensive coverage of every NATEF task with clarity and precision in a concise format that ensures student comprehension and encourages critical thinking Fundamentals of Medium Heavy Duty Commercial Vehicle Systems describes safe and effective diagnostic repair and maintenance procedures for today s medium and heavy vehicle chassis systems including the most current relevant and practical coverage of Automated transmissions Braking system technology used in vehicle stability collision avoidance and new stopping distance standards Hybrid drive powertrains Advanced battery technologies On board vehicle networks and integrated chassis electrical control system Automatic transmission drive shafts and drive axles Charging starting vehicle instrumentation and chassis electrical systems On board diagnostic systems electronic signal processing and sensor operation Steering suspension frames hitching and air conditioning systems Environmental and fuel efficiency technologies Additional features include Up to date NATEF coverage Support of ASE certification test preparation for medium heavy truck and bus test series A clear accessible writing style Reinforcement of concepts learned Application to real world practice A wealth of photographs illustrations and step by step explanations with visual summaries

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