



RECOMMENDED ASSEMBLY TORQUES

BSW Mild Steel Bolts & Screws

Diameter	Threads Per Inch (TPI)	Bolt Tension Corresponding to 65% of Proof Load	Recommended Assembly Torque
		lbf	lbft
1/4"	20	736	3
5/16"	18	1208	6
3/8"	16	1786	11
7/16"	14	2451	18
1/2"	12	3176	26
5/8"	11	5206	54
3/4"	10	7705	96
7/8"	9	10641	155
1"	8	13943	232
1.1/8"	7	17566	329
1.1/4"	7	22473	468
1.1/2"	6	32334	808

To convert kN to lbf; Multiply Kn by 224.809
To convert Nm to lbft; Multiply Nm by 0.737562

Surface Condition Torque Adjustment Factors	
Plain Steel, as supplied	x 1.0
Plain Steel, degreased	x 2.0
Zinc Plated, as supplied	x 1.0
Zinc Plated, lightly oiled	x 0.9
Galvanised, degreased	x 2.1
Galvanised, lightly oiled	x 1.1
Heavily greased	x 0.7

