



## RECOMMENDED ASSEMBLY TORQUES

### Class 10.9 ISO Metric Coarse Pitch Bolts and Screws

Class 10.9 ISO Metric Coarse Pitch Bolts and Screws		Bolt Tension Corresponding to 65% of Proof Load	Recommended Assembly Torque
Diameter	Pitch (mm)	kN	Nm
M5	0.80	7.67	8
M6	1.00	10.9	13
M8	1.25	19.8	32
M10	1.50	31.3	63
M12	1.75	45.5	109
M14	2.00	62.1	174
M16	2.00	84.5	270
M18	2.50	103	371
M20	2.50	132	528
M22	2.50	164	722
M24	3.00	190	914
M27	3.00	248	1339
M30	3.50	303	1817
M33	3.50	371	2449
M36	4.00	441	3173
M39	4.00	527	4110

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

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

