



RECOMMENDED ASSEMBLY TORQUES

Class 8.8 ISO Metric Coarse Pitch Bolts and Screws

| Class 8.8 ISO Metric Coarse Pitch Bolts and Screws | | Bolt Tension Corresponding to 65% of Proof Load | Recommended Assembly Torque |
|--|------------|---|-----------------------------|
| Diameter | Pitch (mm) | kN | Nm |
| M1.6 | 0.35 | 0.48 | 0.15 |
| M2 | 0.40 | 0.78 | 0.31 |
| M2.5 | 0.45 | 1.28 | 0.64 |
| M3 | 0.50 | 1.9 | 1.1 |
| M4 | 0.70 | 3.32 | 2.7 |
| M5 | 0.80 | 5.35 | 5 |
| M6 | 1.00 | 7.54 | 9 |
| M8 | 1.25 | 13.8 | 22 |
| M10 | 1.50 | 21.9 | 44 |
| M12 | 1.75 | 31.8 | 77 |
| M14 | 2.00 | 43.4 | 122 |
| M16 | 2.00 | 59.2 | 190 |
| M18 | 2.50 | 74.8 | 269 |
| M20 | 2.50 | 95.6 | 372 |
| M22 | 2.50 | 118 | 519 |
| M24 | 3.00 | 138 | 640 |
| M27 | 3.00 | 179 | 967 |
| M30 | 3.50 | 219 | 1314 |
| M33 | 3.50 | 270 | 1782 |
| M36 | 4.00 | 319 | 2297 |
| M39 | 4.00 | 380 | 2970 |
| M42 | 4.50 | 437 | 3671 |
| M48 | 5.00 | 573 | 5500 |
| M56 | 5.50 | 792 | 8870 |
| M64 | 6.00 | 1045 | 13376 |

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 |

