

TIGHTENING TORQUE

METRIC HEX BOLTS

RECOMMENDED TIGHTENING TORQUE (Nm)

DIAMETER	PITCH (mm)	CLASS 4.6			CLASS 8.8			CLASS 10.9		
		PLAIN	ZINC	HDG	PLAIN	ZINC	HDG	PLAIN	ZINC	HDG
M3	0.50	0.441	0.308	0.925	1.139	0.797	2.391	1.630	1.141	3.423
M3.5	0.60	0.696	0.487	1.462	1.793	1.255	3.765	2.562	1.793	5.379
M4	0.70	1.030	0.721	2.162	2.652	1.856	5.569	3.791	2.654	7.961
M5	0.80	2.080	1.456	4.368	5.350	3.745	11.23	7.670	5.369	16.11
M6	1.00	3.526	2.468	7.404	9.048	6.334	19.00	13.03	9.118	27.35
M7	1.00	5.915	4.141	12.42	15.29	10.70	32.10	21.84	15.29	45.86
M8	1.25	8.570	5.999	18.00	22.05	15.43	46.30	31.62	22.13	66.39
M10	1.50	16.90	11.83	35.49	43.81	30.67	92.00	62.53	43.77	131.3
M12	1.75	29.64	20.75	62.24	76.28	53.40	160.20	109.2	76.44	229.3
M14	2.00	47.14	33.00	98.99	121.4	84.98	254.93	173.8	121.7	365.0
M16	2.00	73.42	51.40	154.2	189.3	132.5	397.5	270.4	189.3	567.8
M18	2.50	101.1	70.76	212.3	269.1	188.4	565.1	372.1	260.4	781.3
M20	2.50	143.3	100.3	300.8	382.2	267.5	802.6	527.8	369.5	1108
M22	2.50	195.1	136.5	409.6	520.5	364.4	1093	720.7	504.5	1514
M24	3.00	247.7	173.4	520.2	661.4	463.0	1389	914.2	639.9	1920
M27	3.00	361.5	253.1	759.2	965.3	675.7	2027	1337	936.1	2808
M30	3.50	491.4	344.0	1032	1314	920.0	2760	1817	1272	3817
M33	3.50	669.2	468.5	1405	1785	1249	3748	2471	1730	5189
M36	4.00	861.1	602.8	1808	2293	1605	4816	3173	2221	6663
M39	4.00	1115	780.8	2342	2971	2080	6239	4107	2875	8624

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