

TIGHTENING TORQUE

UNC/UNF HEX BOLTS

UNC - RECOMMENDED TIGHTENING TORQUE (lbft)

DIAMETER	TPI	GRADE 5		GRADE 8	
		PLAIN	ZINC	PLAIN	ZINC
1/4	20	7.313	5.119	10.29	7.204
5/16	18	15.82	11.07	22.39	15.68
3/8	16	26.81	18.77	37.78	26.45
7/16	14	42.89	30.03	60.67	42.47
1/2	13	65.54	45.88	92.08	64.46
9/16	12	94.45	66.12	132.8	92.99
5/8	11	130.0	91.00	183.5	128.4
3/4	10	230.8	161.5	325.8	228.1
7/8	9	372.5	260.8	525.1	367.6
1	8	557.9	390.5	787.6	551.3
1-1/8	7	688.6	482.0	1116	781.5
1-1/4	7	970.9	679.7	1575	1102
1-3/8	6	1274	891.5	2065	1445
1-1/2	6	1690	1183	2740	1918

UNF - RECOMMENDED TIGHTENING TORQUE (lbft)

DIAMETER	TPI	GRADE 5		GRADE 8	
		PLAIN	ZINC	PLAIN	ZINC
1/4	28	8.396	5.877	11.78	8.247
5/16	24	17.42	12.19	24.71	17.29
3/8	24	30.27	21.19	42.66	29.86
7/16	20	47.87	33.51	67.30	47.11
1/2	20	73.67	51.57	104.0	72.80
9/16	18	105.4	73.80	148.7	104.1
5/8	18	147.6	103.3	203.8	142.7
3/4	16	257.6	180.3	364.0	254.8
7/8	14	410.4	287.3	579.2	405.4
1	12	611.0	427.7	862.3	603.6
1-1/8	12	771.5	540.0	1252	876.2
1-1/4	12	1075	752.6	1744	1221
1-3/8	12	1449	1015	2351	1645
1-1/2	12	1901	1331	3083	2158

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