

# TIGHTENING TORQUE

## UNC/UNF THREADED RODS

### 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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