



RECOMMENDED ASSEMBLY TORQUES

Class 4.6 ISO Metric Coarse Pitch Bolts & Screws

Diameter	Pitch	Bolt Tension Corresponding to 65% of Proof Load	Recommended Assembly Torque
		kN	Nm
M1.6	0.35	0.19	0.06
M2	0.40	0.31	0.12
M2.5	0.45	0.50	0.25
M3	0.50	0.73	0.44
M4	0.70	1.29	1.00
M5	0.80	2.08	2.1
M6	1.00	2.94	3.5
M8	1.25	5.34	8.5
M10	1.5	8.45	17
M12	1.75	12.4	30
M14	2.00	16.8	47
M16	2.00	22.9	73
M18	2.5	28.1	101
M20	2.5	35.8	143
M22	2.5	44.3	195
M24	3.00	51.6	248
M27	3.00	67.0	362
M30	3.50	81.9	491
M33	3.50	101	669
M36	4.00	120	864
M39	4.00	143	1115
M42	4.50	164	1378
M48	5.00	215	2064
M56	5.50	298	3338
M64	6.00	393	5030

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