



RECOMMENDED ASSEMBLY TORQUES

Class 8.8 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	0.48	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	1.5	21.9	44
M12	1.75	31.8	77
M14	2.00	43.4	122
M16	2.00	59.2	190
M18	2.5	74.8	269
M20	2.5	95.6	372
M22	2.5	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 lbf: 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