

INDUSTRIALBOLTING

SAMPLE TORQUE CHART SHOWING FACTORS AFFECTING TOURQUE

Pre-load Stress @ 50% Minimum Yield

Thread Type UNC

| ****TORQUE IN FT/LBS**** | | S.A.E. Grade 6 45K p.s.i. | | | S.A.E. Grade 8 60K p.s.i. | | |
|--------------------------|----------|---------------------------------|----------------|---------|---------------------------------|----------------|---------|
| Stud Diameter | Nut Size | Dry | Machine Oil | Moly DS | Dry | Machine Oil | Moly DS |
| 1 | 1 5/8 | 533 | 361 | 172 | 800 | 542 | 258 |
| 1 1/4 | 2 | 1023 | 693 | 330 | 1534 | 1040 | 495 |
| 1 1/2 | 2 3/8 | 1817 | 1231 | 586 | 2725 | 1846 | 879 |
| 1 3/4 | 2 3/4 | 2905 | 1968 | 937 | 4357 | 2952 | 1406 |
| 2 | 3 1/8 | 4334 | 2936 | 1398 | 6501 | 4404 | 2097 |
| 2 1/4 | 3 1/2 | 6169 | 4179 | 1990 | 9254 | 6268 | 2985 |
| 2 1/2 | 3 7/8 | 8457 | 5729 | 2728 | 12686 | 8593 | 4092 |
| 2 3/4 | 4 1/4 | 10180 | 6896 | 3264 | 15271 | 10345 | 4928 |
| 3 | 4 5/8 | 13522 | 9160 | 4362 | 20283 | 13740 | 6543 |
| 3 1/4 | 5 | 16786 | 11372 | 5415 | 25180 | 17057 | 8122 |
| 3 1/2 | 5 3/8 | 20953 | 14194 | 6759 | 31429 | 21291 | 10138 |
| 3 3/4 | 5 3/4 | 25761 | 17451 | 6310 | 38642 | 28176 | 12465 |
| 4 | 6 1/8 | 31248 | 21168 | 10080 | 46872 | 31752 | 15120 |

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SALES / RENTALS / REPAIRS / CALIBRATIONS