



INDUSTRIAL BOLTING



50% MIN. YIELD STRENGTH - B7 STUD				TORQUE FOR SPECIFIED LUBRICANT (ft-lb)						
BOLT SIZE & THREAD PITCH	HEX NUT SIZE	MIN YIELD STRESS (PSI)	BOLT TENSION (LBS)	MOLYBDENUM DISULFIDE K=.06	MOLYLEAD OXIDE/ GRAPHITE K=.085	COPPER GRAPH. K=.10	NICKEL GRAPH. K=.110	API SA2 K=.117	MACHINE OIL K=.150	DRY STEEL K= 40
3/4 x 10	1-1/4"	106,000	23,415	88	124	146	161	171	220	585
7/8 x 9	1-7/16"	106,000	31,870	139	198	232	256	272	349	930
1 x 8	1-5/8"	106,000	41,628	208	295	347	382	406	520	1,388
1-1/8 x 8	1-13/16"	106,000	52,683	296	420	494	543	578	741	1,976
1-1/4 x 8	2"	106,000	65,041	407	576	678	745	793	1,016	2,710
1-3/8 x 8	2-3/16"	106,000	78,700	541	767	902	992	1,056	1,353	3,607
1-1/2 x 8	2-3/8"	106,000	93,659	702	995	1,171	1,288	1,370	1,756	4,683
1-5/8 x 8	2-9/16"	106,000	109,919	893	1,265	1,488	1,637	1,742	2,233	5,954
1-3/4 x 8	2-3/4"	106,000	127,480	1,115	1,580	1,859	2,045	2,175	2,789	7,436
1-7/8 x 8	2-15/16"	106,000	146,342	1,372	1,944	2,287	2,515	2,675	3,430	9,146
2 x 8	3-1/8"	106,000	166,505	1,665	2,359	2,775	3,053	3,247	4,163	11,100
2-1/8 x 8	3-5/16"	106,000	187,958	1,997	2,829	3,329	3,661	3,894	4,993	13,314
2-1/4 x 8	3-1/2"	106,000	210,733	2,371	3,359	3,951	4,346	4,623	5,927	15,805
2-3/8 x 8	3-11/16"	106,000	234,798	2,788	3,950	4,647	5,112	5,437	6,971	18,588
2-1/2 x 8	3-7/8"	106,000	260,164	3,252	4,607	5,420	5,962	6,341	8,130	21,680
2-3/4 x 8	4-1/4"	95,000	282,130	3,879	5,496	6,465	7,112	7,565	9,698	25,862
3 x 8	4-5/8"	95,000	335,759	5,036	7,135	8,394	9,233	9,821	12,591	33,576
3-1/4 x 8	5"	95,000	394,050	6,403	9,071	10,672	11,739	12,486	16,008	42,689
3-1/2 x 8	5-3/8"	95,000	457,005	7,998	11,330	13,329	14,662	15,595	19,994	53,317
3-3/4 x 8	5-3/4"	95,000	524,623	9,837	13,935	16,394	18,034	19,162	24,592	65,578
4 x 8	6-1/8"	95,000	596,904	11,938	16,912	19,897	21,886	23,279	29,845	79,587
4-1/4 x 8	6-1/2"	75,000	631,986	11,305	16,015	18,841	20,725	22,044	28,262	75,365
4-1/2 x 8	6-7/8"	75,000	596,413	13,419	19,011	22,365	24,602	26,168	33,548	89,462
4-3/4 x 8	7-1/4"	75,000	664,522	15,782	22,358	26,304	28,934	30,776	39,456	105,216
5 x 8	7-5/8"	75,000	736,313	18,408	26,078	30,680	33,748	35,895	46,020	122,719
5-1/4 x 8	8"	75,000	811,785	21,309	30,188	35,516	39,067	41,553	53,273	142,062
5-1/2 x 8	8-3/8"	75,000	890,938	24,501	34,709	40,835	44,918	47,777	61,252	163,339
5-3/4 x 8	8-3/4"	75,000	973,773	27,996	39,661	46,860	51,328	54,592	69,990	186,640
6 x 8	9-1/8"	75,000	1,060,290	31,809	45,062	53,015	58,316	62,027	79,522	212,058

*** Chart of torque value guidelines for ASTM A193 Grade B7 with stud stress equal to 50% of minimum yield strength.

NOTE: These are guidelines only. Refer to manufacturers specs or Engineering Department.