



RECOMMENDED ASSEMBLY TORQUES

SAE Grade 5 Bolts and Screws - UNF Thread

SAE Grade 5 Bolts and Screws - UNF Thread		Bolt Tension Corresponding to 65% of Proof Load	Recommended Assembly Torque
Diameter	Threads Per Inch (TPI)	lbf	lbft
1/4	28	2010	8
5/16	24	3180	17
3/8	24	4840	30
7/16	20	6560	48
1/2	20	8840	74
9/16	18	11240	105
5/8	18	14170	148
3/4	16	20600	258
7/8	14	28100	410
1	12	36600	610
1.1/8	12	41100	771
1.1/4	12	51600	1075
1.3/8	12	63200	1448
1.1/2	12	76000	1900

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

