



## RECOMMENDED ASSEMBLY TORQUES

### SAE Grade 8 Bolts and Screws - UNF Thread

SAE Grade 8 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	2820	12
5/16	24	4510	23
3/8	24	6820	43
7/16	20	9230	67
1/2	20	12480	104
9/16	18	15860	149
5/8	18	19950	208
3/4	16	29120	364
7/8	14	39700	549
1	12	51700	862
1.1/8	12	66700	1241
1.1/4	12	83700	1744
1.3/8	12	102500	2349
1.1/2	12	123300	3083

### SAE Grade 5 and 8 Bolts and Screws - 1" SAE

SAE Grade 5 and 8 Bolts and Screws - 1" SAE		Bolt Tension Corresponding to 65% of Proof Load	Recommended Assembly Torque
Diameter	Threads Per Inch (TPI)	lbf	lbft
Grade 5	14	37500	625
Grade 8	14	53000	883

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

