TECHNICAL



Socket Head Recommended Tightening Torque

Stainless Steel

STAINLESS SOCKET HEAD BOLTS - RECOMMENDED TIGHTENING TORQUE (Nm)					
Nominal	Pitch	Stress Area	Class	Class	Class
Size	(mm)	(mm^2)	50	70	80
M3	0.50	5.03	0.4	0.9	1.2
M4	0.70	8.78	1.0	2.1	2.7
M5	0.80	14.20	1.9	4.2	5.5
M6	1.00	20.10	3.3	7.1	9.4
M8	1.25	36.60	8.0	17.1	22.8
M10	1.50	58.00	15.8	33.9	45.2
M12	1.75	84.30	27.6	59.2	78.9
M14	2.00	115.00	44.0	94.2	125.6
M16	2.00	157.00	68.6	147.0	195.9
M18	2.50	192.00	94.3	202.2	269.6
M20	2.50	245.00	133.8	286.7	382.2
M22	2.50	303.00	182.0	390.0	519.9
M24	3.00	353.00	231.3	495.6	660.8
M27	3.00	459.00	338.3	725.0	966.7
M30	3.50	561.00	459.5	984.6	1312.7
M33	3.50	694.00	625.2	1339.8	1786.4
M36	4.00	817.00	802.9	1720.6	2294.1
M39	4.00	976.00	1039.1	2226.7	2969.0



Note:
The tightening torque values given in the above table serve only as a guide. A k factor of 0.2 has been used which assumes threads are burr free and a good quality lubricant (molybdenum disulphate MoS2) is used. Stainless fasteners that are not lubricated or coated often seize and can exhibit k factors in excess of 0.35.
Note that these figures are based on the first tightening of single assemblies in isolation.

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