

Stainless Steel Allthread Tightening Torque

Stainless Steel

Hex Bolt Yield Stress

STAINLESS ALLTHREAD - RECOMMENDED TIGHTENING TORQUE (Nm)						
Nominal Size	Pitch mm	Stress Area mm²	Class 50	Class 70	Class 80	Neptune Rod™
M3	0.50	5.03	0.4	0.9	1.2	1.2
M4	0.70	8.78	1.0	2.1	2.7	2.7
M5	0.8	14.20	1.9	4.2	5.5	5.5
M6	1.00	20.10	3.3	7.1	9.4	9.4
M8	1.25	36.60	8.0	17.1	22.8	22.8
M10	1.50	58.00	15.8	33.9	45.2	45.2
M12	1.75	84.30	27.6	59.2	78.9	78.9
M14	2.00	115.00	44.0	94.2	125.6	125.6
M16	2.00	157.00	68.6	147.0	195.9	195.9
M18	2.50	192.00	94.3	202.2	269.6	269.6
M20	2.50	245.00	133.8	286.7	382.2	382.2
M22	2.50	303.00	182.0	390.0	519.9	519.9
M24	3.00	353.00	231.3	495.6	660.8	660.8
M27	3.00	459.00	338.3	725.0	966.7	966.7
M30	3.50	561.00	459.5	984.6	1312.7	1312.7
M33	3.50	694.00	625.2	1339.8	1786.4	1786.4
M36	4.00	817.00	802.9	1720.6	2294.1	2294.1
M39	4.00	976.00	1039.1	2226.7	2969.0	2969.0



k Factor = 0.2

The induced load is calculated at 65% yield stress

A k factor of 0.2 has been used which assumes threads are burr free and a good quality lubricant (molybdenum disulphate MoS_2) is used. Stainless fasteners that are not lubricated or coated often seize and can exhibit k factors in excess of 0.35