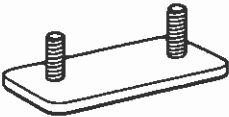

STANDARD BOLT TIGHTENING TORQUE

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STANDARD BOLT TIGHTENING TORQUE B-2

STANDARD BOLT TIGHTENING TORQUE

HOW TO DETERMINE BOLT STRENGTH

	Mark	Class		Mark	Class
Hexagon head bolt	 Bolt head No. 4— 5— 6— 7—	4T 5T 6T 7T	Stud bolt	 No mark	4T
	 No mark	4T			
Hexagon flange bolt w/washer hexagon bolt	 No mark	4T		 Grooved	6T
Hexagon head bolt	 Two protruding lines	5T	Welded bolt		4T
Hexagon flange bolt w/washer hexagon bolt	 Two protruding lines	6T			
Hexagon head bolt	 Three protruding lines	7T			

SPECIFIED TORQUE FOR STANDARD BOLTS

Class	Diameter mm	Pitch mm	Tightening torque					
			Hexagon head bolt			Hexagon flange bolt		
			kg-cm	ft-lb	N-m	kg-cm	ft-lb	N-m
4T	6	1	55	48 in.-lb	5.4	60	52 in.-lb	5.9
	8	1.25	130	9	13	145	10	14
	10	1.25	260	19	25	290	21	28
	12	1.25	480	35	47	540	39	53
	14	1.5	760	55	75	850	61	83
	16	1.5	1,150	83	113	—		
5T	6	1	65	56 in.-lb	6.4	—		
	8	1.25	160	12	16	—		
	10	1.25	330	24	32	—		
	12	1.25	600	43	59	—		
	14	1.5	930	67	91	—		
	16	1.5	1,400	101	137	—		
6T	6	1	80	69 in.-lb	7.8	90	78 in.-lb	8.8
	8	1.25	195	14	19	215	16	21
	10	1.25	400	29	39	440	32	43
	12	1.25	730	53	72	810	59	79
	14	1.5	—			1,250	90	123
7T	6	1	110	8	11	120	9	12
	8	1.25	260	19	25	290	21	28
	10	1.25	530	38	52	590	43	58
	12	1.25	970	70	95	1,050	76	103
	14	1.5	1,500	108	147	1,700	123	167
	16	1.5	2,300	166	226	—		