

# TORQUE

Proper torque (or tightening) depends on many factors including: surface texture, finish, and lubrication. These values are only a guideline.

## CAP SCREWS

DIAMETER COARSE	GRADE 2		GRADE 5		GRADE 8	
	DRY FT/LBS	LUB FT/LBS	DRY FT/LBS	LUB FT/LBS	DRY FT/LBS	LUB FT/LBS
1/4-20	5.5	4.2	8	6.3	12	9
5/16-18	11	8	17	13	24	18
3/8-16	20	15	30	23	45	35
7/16-14	32	24	50	35	70	50
1/2-13	50	35	75	55	110	80
9/16-12	70	55	110	80	150	110
5/8-11	100	75	150	110	210	160
3/4-10	175	130	260	200	390	280
7/8-9	170	125	430	320	600	450
1-8	250	190	640	480	910	680

DIAMETER COARSE	18-8 SS	316 SS	BRASS
	INCH/LBS	INCH/LBS	INCH/LBS
1/4-20	75.2	78.8	61.5
5/16-18	132	138	107
3/8-16	236	247	192
7/16-14	376	393	317
1/2-13	517	542	422
9/16-12	682	713	558
5/8-11	1110	1160	907
3/4-10	1530	1582	1249
7/8-9	2328	2430	1905
1-8	3440	3595	2815

DIAMETER FINE	GRADE 2		GRADE 5		GRADE 8	
	DRY FT/LBS	LUB FT/LBS	DRY FT/LBS	LUB FT/LBS	DRY FT/LBS	LUB FT/LBS
1/4-28	6.3	4.7	10	7.2	14	10
5/16-24	12	9	19	14	27	20
3/8-24	23	17	35	25	50	35
7/16-20	36	27	55	40	80	60
1/2-20	55	40	85	65	120	90
9/16-18	80	60	120	90	170	130
5/8-18	110	85	170	130	240	180
3/4-16	200	140	300	220	420	310
7/8-14	180	140	470	350	670	500
1-14	280	210	720	540	1020	760

DIAMETER FINE	18-8 SS	316 SS	BRASS
	INCH/LBS	INCH/LBS	INCH/LBS
1/4-28	94	99	77
5/16-24	142	147	116
3/8-24	259	271	212
7/16-20	400	418	327
1/2-20	541	565	443
9/16-18	752	787	615
5/8-18	1244	1301	1016
3/4-16	1490	1558	1220
7/8-14	2318	2420	1895
1-14	3110	3250	2545

## ALLOY SOCKET PRODUCTS

SOCKET CAP SCREWS			FLAT HEAD		BUTTON HEAD		LOW HEAD	SHOULDER SCREWS
NOMINAL SIZE	TORQUE FT/LBS		TORQUE INCH LBS		TORQUE INCH LBS		TORQUE INCH LBS	TORQUE INCH LBS
	COARSE	FINE	COARSE	FINE	COARSE	FINE	COARSE	COARSE
1/4	17	19	100	110	100	110	78	50
5/16	35	38	200	220	200	220	156	125
3/8	62	70	350	400	350	400	273	265
7/16	100	109	560	625	--	--	--	--
1/2	1510	172	850	1000	850	1000	615	470
5/8	283	317	1700	1900	1700	1800	1315	1150
3/4	500	562	3000	3200	--	--	--	2000
7/8	688	767	5000	5400	--	--	--	--
1	1040	1080	8000	7600	--	--	--	4000



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