

GENERAL TIGHTENING TORQUE FOR BOLTS, NUTS AND TAPERLOCK STUDS

The following charts give the standard torque values for bolts, nuts and taperlock studs of SAE Grade 5 or better quality. Exceptions are given in other sections of the Service Manual where needed.



THREAD DIAMETER		STANDARD TORQUE	
inches	millimeters	lb. ft.	N-m *
Standard thread 		Use these torques for bolts and nuts with standard threads (conversions are approximate).	
1/8	6.35	9 ± 3	12 ± 4
5/16	7.94	18 ± 5	25 ± 7
3/8	9.53	32 ± 5	45 ± 7
7/16	11.11	50 ± 10	70 ± 15
1/2	12.70	75 ± 10	100 ± 15
5/8	14.29	110 ± 15	150 ± 20
3/4	19.05	150 ± 20	200 ± 25
7/8	22.23	265 ± 35	360 ± 60
1	25.40	420 ± 60	570 ± 80
1 1/8	29.58	640 ± 80	875 ± 100
1 1/4	31.75	800 ± 100	1100 ± 150
1 3/8	34.93	1000 ± 120	1350 ± 175
1 1/2	38.10	1200 ± 150	1600 ± 200
		1500 ± 200	2000 ± 275
Use these torques for bolts and nuts on hydraulic valve bodies.			
5/16	7.94	13 ± 2	20 ± 3
3/8	9.53	24 ± 2	35 ± 3
7/16	11.11	39 ± 2	50 ± 3
1/2	12.70	60 ± 3	80 ± 4
5/8	15.88	118 ± 4	160 ± 6
Taperlock stud 		Use these torques for studs with Taperlock threads.	
1/8	6.35	5 ± 2	7 ± 3
5/16	7.94	10 ± 3	15 ± 5
3/8	9.53	20 ± 3	30 ± 5
7/16	11.11	30 ± 5	40 ± 10
1/2	12.70	40 ± 5	55 ± 10
5/8	14.29	60 ± 10	80 ± 15
3/4	19.05	75 ± 10	100 ± 15
7/8	22.23	110 ± 15	150 ± 20
1	25.40	170 ± 20	230 ± 30
1 1/8	29.58	260 ± 30	350 ± 40
1 1/4	31.75	320 ± 30	400 ± 40
1 3/8	34.93	400 ± 40	550 ± 50
1 1/2	38.10	480 ± 40	650 ± 50
		550 ± 50	750 ± 70

* 1 newton meter (N-m) is approximately the same as 0.1 mkg.

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