Recommended Assembly Torques
Stainless Steel Class 70
ISO Metric Coarse Pitch Bolts and Screws

Diameter	Pitch (mm)	Recommended Assembly Torque Nm
M3	0.50	0.90
M4	0.70	2
M5	0.80	4.10
M6	1.00	7
M8	1.25	17
M10	1.50	33
M12	1.75	57
M14	2.00	91
M16	2.00	140
M20	2.50	273
M24	3.00	472
M27	3.00	682
M30	3.50	930
M36	4.00	1620

To convert kN to lbft - Multiply kN by 224.809
To convert Nm to lbft - Multiply Nm by 0.737562

In the absence of site specific torque values or engineering calculations, the chart above can be used as a guide to the maximum safe torque for a particular size/grade fastener.

- Information refers to flat burr-free surfaces lubricated with good quality lubricant such as MOLYBOND®
- The nominal induced load in joints tightened to these torque values is calculated as 65% of the load at the permanent set limit but in practice, the value can be expected to vary between 50% and 80% of the load at the permanent set limit.
- Calculations assume a coefficient friction of 0.16, which requires good quality lubricant such as MOLYBOND®
- Even slight variations from normal test conditions can produce wide variations in friction. Accordingly when friction coefficients are used in design calculations due allowance or factors of safety should be considered and in critical cases, specific tests conducted to provide actual coefficients for material, geometry, site conditions and/or lubricant combinations.