






TORQUE TABLE

IOS 898-1



Metric Bolt Torque Table Estimated with clamp load as 75% of proof load as specified in ISO 898-1						
Property Class	8.8 		10.9 		12.9 Socket Head Cap Screw 	
Minimum Tensile Strength MPa	M6 - M16: 800 M20 - M30: 830		1040		1220	
Nominal Size and Thread Pitch	Bolt Torque Specs in Foot Pounds or (Inch Pounds)					
	Dry	Lubed	Dry	Lubed	Dry	Lubed
M5 x 0.80	(54)	(41)	(78)	(59)	(91)	(68)
M6 x 1.00	(92)	(69)	(133)	(99)	(156)	(116)
M7 x 1.00	(156)	(116)	(222)	(167)	(260)	(195)
M8 x 1.25	(225)	(169)	(333)	(242)	(377)	(284)
M10 x 1.50	37	28	53	40	62	47
M12 x 1.75	65	49	93	69	108	81
M14 x 2.00	104	78	148	111	173	130
M16 x 2.00	161	121	230	172	269	202
M18 x 2.50	222	167	318	238	372	279
M20 x 2.50	314	235	449	337	525	394
M22 x 2.50	428	321	613	460	716	537
M24 x 3.00	543	407	776	582	908	681
M27 x 3.00	796	597	1139	854	1331	998
M30 x 3.50	1079	809	1543	1158	1804	1353
M33 x 3.50	1468	1101	2101	1576	2455	1842
M36 x 4.00	1886	1415	2699	2024	3154	2366

Lubed means cleaned dry bolts lubricated with a standard medium viscosity machine oil. Lubricate all contact areas of the bolts and washers. Lubricating the bolts is the suggested method.