

ELECTRICAL CONNECTION

BOLT TORQUE SETTINGS



RECOMMENDED ASSEMBLY TORQUES

Class 4.6 ISO Metric Coarse Pitch Bolt and Screws		Bolt Tension Corresponding to 65% of Proof Load	Recommended Assembly Torque
Diameter	Pitch (mm)	kN	Nm
M1.6	0.35	0.19	0.06
M2	0.40	0.31	0.12
M2.5	0.45	0.50	0.25
M3	0.50	0.73	0.44
M4	0.70	1.29	1
M5	0.80	2.08	2.1
M6	1.00	2.94	3.5
M8	1.25	5.34	8.5
M10	1.50	8.45	17
M12	1.75	12.4	30
M14	2.00	16.8	47
M16	2.00	22.9	73
M18	2.50	28.1	101
M20	2.50	35.8	143
M22	2.50	44.3	195
M24	3.00	51.6	248
M27	3.00	67	362
M30	3.50	81.9	491
M33	3.50	101	669
M36	4.00	120	864
M39	4.00	143	1115
M42	4.50	164	1378
M48	5.00	215	2064
M56	5.50	298	3338
M64	6.00	393	5030

Surface Condition Torque Adjustment Factors

Plain steel, as supplied	x 1.0
Plain steel, degreased	x 2.0
Zinc plated, as supplied	x 1.0
Zinc plated, lightly oiled	x 0.9
Galvanised, degreased	x 2.1
Galvanised, lightly oiled	x 1.1
Heavily greased	x 0.7

To convert kN to lbf - multiply Kn by 224.809
To convert Nm to lbft - multiply Nm by 0.737562

ELECTRICAL CONNECTION

BOLT TORQUE SETTINGS



RECOMMENDED ASSEMBLY TORQUES

Class 8.8 ISO Metric Coarse Pitch Bolt and Screws		Bolt Tension Corresponding to 65% of Proof Load	Recommended Assembly Torque
Diameter	Pitch (mm)	kN	Nm
M1.6	0.35	0.48	0.15
M2	0.40	0.78	0.31
M2.5	0.45	1.28	0.64
M3	0.50	1.9	1.1
M4	0.70	3.32	2.7
M5	0.80	5.35	5
M6	1.00	7.54	9
M8	1.25	13.8	22
M10	1.50	21.9	44
M12	1.75	31.8	77
M14	2.00	43.4	122
M16	2.00	59.2	190
M18	2.50	74.8	269
M20	2.50	95.6	372
M22	2.50	118	519
M24	3.00	138	640
M27	3.00	179	967
M30	3.50	219	1314
M33	3.50	270	1782
M36	4.00	319	2297
M39	4.00	380	2970
M42	4.50	437	3671
M48	5.00	573	5500
M56	5.50	792	8870
M64	6.00	1045	13376

Surface Condition Torque Adjustment Factors

Plain steel, as supplied	x 1.0
Plain steel, degreased	x 2.0
Zinc plated, as supplied	x 1.0
Zinc plated, lightly oiled	x 0.9
Galvanised, degreased	x 2.1
Galvanised, lightly oiled	x 1.1
Heavily greased	x 0.7

To convert kN to lbf - multiply Kn by 224.809
To convert Nm to lbft - multiply Nm by 0.737562