

Hex Bolts

Tensile / Yield / Shear Strength
Tightening Torque



HEX BOLTS - RECOMMENDED TIGHTENING TORQUE CLASS 8.8

Size	Pitch (mm)	Stress Area (mm ²)	Core Area (mm ²)	Tensile Strength (kN)	Proof Strength (kN)	Shear Strength (kN)	Recommended Tightening Torque		
							Plain (Nm)	Zinc (Nm)	HDG (Nm)
M6	1.00	20.1	17.9	16.1	11.7	8.6	9.1	6.4	19.1
M8	1.25	36.6	32.8	29.3	21.2	15.7	22.1	15.5	46.4
M10	1.50	58.0	52.3	46.4	33.6	25.1	43.7	30.6	91.8
M12	1.75	84.3	76.2	67.4	48.9	36.6	76.3	53.4	160.2
M14	2.00	115.0	104.7	92.0	66.7	50.3	121.4	85.0	254.9
M16	2.00	157.0	144.0	125.6	91.1	69.1	189.4	132.6	397.8
M18	2.50	192.0	175.0	159.4	115.2	84.0	269.6	188.7	566.1
M20	2.50	245.0	225.0	203.3	147.0	108.0	382.0	268.0	803.0
M22	2.50	303.0	281.0	251.5	181.8	134.9	520.0	364.0	1092.0
M24	3.00	353.0	324.0	293.0	211.8	155.5	661.0	463.0	1388.0
M27	3.00	459.0	427.0	381.0	275.4	205.0	967.0	677.0	2030.0
M30	3.50	561.0	519.0	465.6	336.6	249.1	1313.0	919.0	2757.0
M33	3.50	694.0	647.0	576.0	416.4	310.6	1786.0	1250.0	3751.0
M36	4.00	817.0	759.0	678.1	490.2	364.3	2294.0	1606.0	4818.0
M39	4.00	976.0	912.0	810.1	585.6	437.8	2969.0	2078.0	6235.0
M42	4.50	1120.0	1050.0	929.6	672.0	504.0	3670.0	2568.0	7705.0
M48	5.00	1470.0	1380.0	1220.1	882.0	662.4	5504.0	3853.0	11558.0
M56	5.50	2030.0	1910.0	1684.9	1218.0	916.8	8867.0	6207.0	18621.0
M64	6.00	2680.0	2520.0	2224.4	1608.0	1209.6	13379.0	9365.0	28095.0

Note:

The tightening torque values given in the above table serve only as a guide. A k factor of 0.2 has been used which assumes threads are plain finish, burr free with a light oil coating. It should be noted that these figures are based on the first tightening of single assemblies in isolation.

Please refer to AS4100 for correct tightening methods of AS1252, as the above figures do not apply.