

Bolt Torque - Tension Relationship Chart

(for Selected Inch-Series Fasteners)

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Bolt Size (inches)	Threads Per Inch	Bolt Thread Tensile Stress Area (sq. in.)	Fastener Coating	Bolt Torque / Clamp Load	Bolt Clamp Loads & Torques listed below are based on Bolt Material Pre-Load Stress of 10,000 & 25,000 psi... regardless of fastener specification		Fastener Specification			
							SAE J429-Grade 2	SAE J429-Grade 5	SAE J429-Grade 8	ASTM A574 Socket Head Cap Screw
					10,000 psi	25,000 psi	55,000 psi proof strength (1/4" - 3/4")	85,000 psi proof strength (1/4" - 1")	120,000 psi proof strength (1/4" - 1.5")	140,000 psi proof strength (#0 - 1/2")
							33,000 psi proof strength (7/8" - 1.5")	74,000 psi proof strength (1 - 1 1/8" - 1.5")		135,000 psi proof strength (over 1/2" - 2")
Bolt Clamp Loads & Torques listed below Based on Bolt Pre-load Stress of 75% of Proof Strength										
1/4 UNC	20	0.0318		Clamp Load (Lb)	318	796	1,313	2,029	2,864	3,341
			Lubricated	Torque (in-lb)	12	30	49	76	107	125
			Zinc Plated		14	36	59	91	129	150
			Plain - Dry		16	40	66	101	143	167
1/4 UNF	28	0.0364		Clamp Load (Lb)	364	909	1,500	2,319	3,274	3,819
			Lubricated	Torque (in-lb)	14	34	56	87	123	143
			Zinc Plated		16	41	68	104	147	172
			Plain - Dry		18	45	75	116	164	191
5/16 UNC	18	0.0524		Clamp Load (Lb)	524	1,311	2,163	3,342	4,719	5,505
			Lubricated	Torque (in-lb)	25	61	101	157	221	258
			Zinc Plated		29	74	122	188	265	310
			Plain - Dry		33	82	135	209	295	344
5/16 UNF	24	0.0581		Clamp Load (Lb)	581	1,452	2,395	3,702	5,226	6,097
			Lubricated	Torque (in-lb)	27	68	112	174	245	286
			Zinc Plated		33	82	135	208	294	343
			Plain - Dry		36	91	150	231	327	381

Nitronic 50 Lubricated Torque Values

Jiyuan Zhang



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Handbook of Bolts and Bolted Joints John Bickford, 1998-04-28 Presenting time tested standard as well as reliable emerging knowledge on threaded fasteners and joints this book covers how to select parts and materials predict behavior control assembly processes and solve on the job problems It examines key issues affecting bolting in the automotive pressure vessel petrochemical aerospace and structural steel industries The editors have successfully created a useful rather than scholarly handbook with chapters written in a straightforward how to do it manner Theory is discussed only when necessary and the handbook s logical organization and thorough index enhances its usefulness **Fusion Technology** ,1986

Metals Handbook: Corrosion ASM International. Handbook Committee, 1978 *Corrosion* Lawrence J. Korb, 1991 Provides an in depth review of a number of processes recently introduced or that have come into acceptance such as radial rotary orbital precision powder and isothermal hot die forging Plus superplastic sheet forming and abrasive waterjet and laser cutting Contents include Forging Equipment and Dies Forging Processes Forging of Carbon Alloy Stainless Steels and Heat Resistant Alloys Forging of Nonferrous Metals Cold Heading and Cold Extrusion Other Bulk Forming Processes Evaluation of Workability Computer Aided Process Design for Bulk Forming Blanking and Piercing of Steel Sheet Strip and Plate Tooling and Lubrication for Forming Sheet Strip and Plate Forming Processes for Sheet Strip and Plate Forming of Stainless Steel and Heat Resistant Alloys Forming of Nonferrous Sheet Materials and much more **Thomas Register of American Manufacturers** ,2003 Vols for 1970 71 includes manufacturers catalogs *Professional Engineer* ,1979

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