



SOKO® Range Tightening Torque

Metric Recommended Tightening Torque

Torque Nm: Metric SOKO® products

Size	Socket Head		Low Head		Countersunk Head		Button Head		Socket Set Screw (Grub)		Shoulder Screw	
	Plain (Nm)	Zinc Plated (Nm)	Plain (Nm)	Zinc Plated (Nm)	Plain (Nm)	Zinc Plated (Nm)	Plain (Nm)	Zinc Plated (Nm)	Plain (Nm)	Zinc Plated (Nm)	Plain (Nm)	Zinc Plated (Nm)
M1.6	0.30	0.21							0.08	0.06		
M2	0.60	0.42							0.15	0.11		
M2.5	1.20	0.84							0.42	0.29		
M3	2.0	1.4			1.4	1.0	1.2	0.84	0.80	0.56		
M4	5.0	3.5	4.0	2.8			3.4	2.4	2.2	1.5	2.8	2.0
M5	10.0	7.0	8.0	5.6	6.8	4.8	5.5	3.9	4.6	3.2		
M6	16.0	11.2	13.0	9.1	11.0	7.7	10.0	7.0	7.8	5.5	7.0	4.9
M8	39.0	27.3	32.0	22.4	28.0	19.6	24.0	16.8	18.0	12.6	12.0	8.4
M10	77.0	53.9	64.0	44.8	55.0	38.5	47.0	32.9	36.0	25.2	29.0	20.3
M12	135.0	94.5	110.0	77.0	95.0	66.5	82.0	57.4	60.0	42.0	57.0	39.9
M14	215.0	150.5			150.0	105.0			62.0	43.4		
M16	330.0	231.0			237.0	165.9			150.0	105.0	100.0	70.0
M18	455.0	318.5										
M20	650.0	455.0			480.0	336.0			300.0	210.0	240.0	168.0
M22	870.0	609.0										
M24	1100.0	770.0			640.0	448.0			475.0	332.5	470.0	329.0
M27	1650.0	1155.0										
M30	2250.0	1575.0										
M36	3850.0	2695.0										
M42	6270.0	4389.0										

Note:

The tightening torque values given in the above table serve only as a guide. A k factor of 0.2 has been used for threads with plain finish, burr free with a light oil coating. A k factor of 0.14 has been used for zinc plated. It should be noted that these figures are based on the first tightening of single assemblies in isolation.

Please refer to our engineering team for more detailed systems of determining the correct tension in fasteners rather than just using the above guide, which is very general in nature. It does not take into account the many variables that effect friction in real world applications and hence tension in the fastener.

Bolt Tension | Anti-Vibration | Product Reliability | Traceability

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