



SOKO® Range Tightening Torque Class 10.9

Metric Recommended Tightening Torque

Class	10.9		010.9		010.9	
	Socket Head		Button Head		Countersunk Head	
						
Size	Plain (Nm)	Zinc Plated (Nm)	Plain (Nm)	Zinc Plated (Nm)	Plain (Nm)	Zinc Plated (Nm)
M3	1.6	1.1	1.1	0.8	1.1	0.8
M4	3.8	2.7	2.5	1.8	2.5	1.8
M5	7.7	5.4	5.1	3.6	5.1	3.6
M6	13.0	9.1	8.7	6.1	8.7	6.1
M8	31.6	22.1	21.1	14.8	21.1	14.8
M10	62.6	43.8	41.8	29.2	41.8	29.2
M12	109.2	76.4	72.8	51.0	72.8	51.0
M16	271.0	189.7	180.9	126.6	180.9	126.6
M20	528.7	370.1	352.8	247.0	352.8	247.0
M24	914.1	639.9	610.0	427.0	610.0	427.0

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. Note that these figures are based on the first tightening of single assemblies in isolation.

For reduced head class 010.9, clamp load is calculated for 360MPa bolt stress.

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 affect friction in real-world applications and hence tension in the fastener.

Bolt Tension | Anti-Vibration | Product Reliability | Traceability