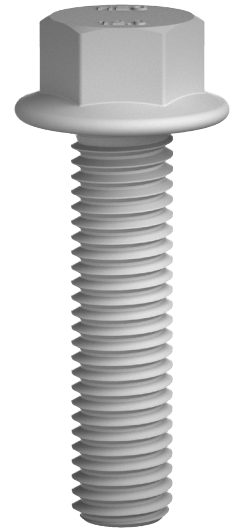




Tightening Torque D-LOK® Bolts

Plain and Zinc Flake

D-LOK® Bolts - RECOMMENDED TIGHTENING TORQUE (Nm)					
Nominal	UTS	Yield	Clamp Load	Plain	Zinc Flake
	Min.	Min.			
mm	kN	kN	kN	Nm	Nm
M5	17.3	15.6	11.7	11.7	9.9
M6	24.5	22.1	16.6	19.9	16.9
M8	44.6	40.3	30.2	48.4	41.1
M10	70.8	63.8	47.9	95.7	81.3
M12	102.8	92.7	69.5	167.0	142.0
M14	140.0	126.5	94.9	266.0	226.0
M16	191.5	172.5	129.4	414.0	352.0
M20	299.0	270.0	202.5	810.0	689.0



Note:

1. The tightening torque values are given as a guide only and are based on first tightening of single assemblies in isolation.
2. Clamp load is calculated for 75% of yield stress
3. Nut factors (k) used for calculation on installation torque: Plain 0.2; Zinc Flake = 0.17;

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