



## Stainless Steel Allthread Tightening Torque

# Stainless Steel

Hex Bolt Yield Stress

### STAINLESS ALLTHREAD - RECOMMENDED TIGHTENING TORQUE (Nm)

Nominal Size	Pitch mm	Stress Area mm <sup>2</sup>	Class 50	Class 70	Class 80	Neptune Rod™
M3	0.50	5.03	0.4	0.9	1.2	1.2
M4	0.70	8.78	1.0	2.1	2.7	2.7
M5	0.8	14.20	1.9	4.2	5.5	5.5
M6	1.00	20.10	3.3	7.1	9.4	9.4
M8	1.25	36.60	8.0	17.1	22.8	22.8
M10	1.50	58.00	15.8	33.9	45.2	45.2
M12	1.75	84.30	27.6	59.2	78.9	78.9
M14	2.00	115.00	44.0	94.2	125.6	125.6
M16	2.00	157.00	68.6	147.0	195.9	195.9
M18	2.50	192.00	94.3	202.2	269.6	269.6
M20	2.50	245.00	133.8	286.7	382.2	382.2
M22	2.50	303.00	182.0	390.0	519.9	519.9
M24	3.00	353.00	231.3	495.6	660.8	660.8
M27	3.00	459.00	338.3	725.0	966.7	966.7
M30	3.50	561.00	459.5	984.6	1312.7	1312.7
M33	3.50	694.00	625.2	1339.8	1786.4	1786.4
M36	4.00	817.00	802.9	1720.6	2294.1	2294.1
M39	4.00	976.00	1039.1	2226.7	2969.0	2969.0



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 burr free and a good quality lubricant (molybdenum disulphate MoS2) is used. Stainless fasteners that are not lubricant or coated often seize and can exhibit k factors in excess of 0.35.

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