



SOKO® Range Tightening Torque Grade ASTM A574

UNF Recommended Tightening Torque

	Socket Head 1960 Series		Countersunk Head		Button Head		Socket Set Screw (Grub)	
								
Size	Plain (Lb-Ft)	Zinc Plated (Lb-Ft)	Plain (Lb-Ft)	Zinc Plated (Lb-Ft)	Plain (Lb-Ft)	Zinc Plated (Lb-Ft)	Plain (Lb-Ft)	Zinc Plated (Lb-Ft)
#0	0.22	0.15	0.12	0.09	0.12	0.09	0.08	0.06
#1	0.40	0.28	0.21	0.15	0.21	0.15	0.15	0.10
#2	0.67	0.47	0.37	0.26	0.37	0.26	0.15	0.10
#3	1.0	0.70	0.58	0.41	0.58	0.41	0.42	0.29
#4	1.5	1.0	0.67	0.47	0.67	0.47	0.42	0.29
#5	2.0	1.4	1.1	0.76	1.1	0.76	0.83	0.58
#6	3.0	2.0	1.3	0.93	1.3	0.93	0.83	0.58
#8	4.8	3.4	2.5	1.7	2.5	1.7	1.7	1.2
#10	7.5	5.2	3.7	2.6	3.7	2.6	3.0	2.1
1/4"	19.0	13.3	9.2	6.4	9.2	6.4	7.2	5.1
5/16"	38.0	26.6	18.3	12.8	18.3	12.8	13.7	9.6
3/8"	70.0	49.0	33.3	23.3	33.3	23.3	24.2	16.9
7/16"	109.0	76.3	52.1	36.5	52.1	36.5	35.8	25.1
1/2"	172.0	120.4	83.3	58.3	83.3	58.3	51.7	36.2
9/16"	239.1	167.4	113.3	79.3	113.3	79.3	51.7	36.2
5/8"	317.0	221.9	150.0	105.0	150.0	105.0	102.1	71.5
3/4"	562.0	393.4	266.7	186.7	266.7	186.7	200.0	140.0
7/8"	767.0	536.9	450.0	315.0	450.0	315.0	300.0	210.0
1"	1080.0	756.0					416.7	291.7

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.

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 account for the many variables that affect friction in real-world applications and hence tension in the fastener.

Bolt Tension | Anti-Vibration | Product Reliability | Traceability

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