

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 1 of 1

Tightening Torques - Aluminium

DSE191

TIGHTENING TORQUES (IN ALUMINIUM ALLOY)

Recommended Tightening Torques for A2-70 Screws and Bolts Fitted into Tapped Holes in Aluminium

Thread Size	Tightening Torque /Nm			
	Loctite or Bare		TufLok Only	
	Minimum	Maximum	Minimum	Maximum
M1.6	0.105	0.14		
M2	0.2175	0.29	0.4175	0.49
M2.5	0.45	0.6	0.9	1.05
M3	0.75	1	1.45	1.7
M4	1.8375	2.45	2.7375	3.35
M5	3.705	4.94	5.305	6.54
M6	6.2625	8.35	9.2625	11.35
M8	15.3	20.4	21.3	26.4
M10	30.3	40.4	39.8	49.9
M12	52.8	70.4	65.8	83.4
M16	131.25	175	150.25	194
M20	264.75	353	308.75	397
M24	457.5	610	517.5	670
M30	909.75	1213	989.75	1293
M36	1587.75	2117		
M39	2065.5	2742		

Notes

1. The torque figures are based on a theoretical bolt load equal to 60% of the proof load of the bolt or screw material
2. Recommended length of engagement = 2 x diameter (minimum)
3. Recommended torque settings are for ideal conditions. Inspection will be necessary to ensure that lock washers are compressed and screws are tight
4. In the event of any doubt as to the tightness of the screw, consult engineering
5. This Engineering Instruction should be referred to on assembly drawings.

Issue	01	02	03	04	05	06	07	08
DCR	7135	32833						