

DEK STANDARD ENGINEERING INSTRUCTION

Title

Page 1 of 1

Tightening Torques - Steel

DSE192

TIGHTENING TORQUES (IN STEEL)

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

Thread Size	Tightening Torque /Nm			
	Loctite or Bare		TufLok Only	
	Minimum	Maximum	Minimum	Maximum
M1.6	0.119	0.17		
M2	0.245	0.35	0.445	0.55
M2.5	0.518	0.74	0.968	1.19
M3	0.98	1.4	1.68	2.1
M4	2.31	3.3	3.21	4.2
M5	4.62	6.6	6.22	8.2
M6	7.77	11.1	10.77	14.1
M8	18.97	27.1	24.97	33.1
M10	37.8	54	47.3	63.5
M12	65.8	94	78.8	107
M16	163.1	233	182.1	252
M20	329	470	373	514
M24	569.8	814	629.8	874
M30	1132.6	1618	1212.6	1698
M36	1975.4	2822		
M39	2559.9	3657		

Notes

1. The torque figures are based on a theoretical bolt load equal to 80% of the proof load of the bolt or screw material
2. Recommended length of engagement = 1.5 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						