

TIGHTENING TORQUE LOADS FOR HT BOLTS

Torques to be applied unless specified.

In Newton Metres

Diameter mm	Pitch mm	Class 6.8 UTS 600, YP 480 MPa	Class 8.8 UTS 800, YP 640 MPa	Class 10.9 UTS 1000, YP 900 MPa	Class 12.9 UTS 1200, YP 1080 MPa
8	1.25	12	16	22	26
10	1.50	23	31	43	52
12	1.75	40	53	75	90
14	2	64	85	120	144
16	2	99	132	186	223
18	2.5	137	183	258	309
20	2.5	194	259	364	437
22	2.5	266	354	498	598
24	3	334	445	597	717
27	3	492	627	881	1057
30	3.5	638	851	1196	1436
33	3.5	865	1153	1622	1946
36	4	1114	1485	2089	2507
39	4	1441	1921	2702	3242
42	4.5	1785	2380	3346	4015
45	4.5	2223	2964	4168	5002
48	5	2687	3583	5040	6047