

ATI TIGHTENING TORQUE GUIDE FOR TIE RODS (100K STRESS PROOF)

COARSE THREAD

BOLT DIA.	TORQUE FT-LBS AT 100,000 PSI
1/4-20	6
5/16-18	11
3/8-16	19
7/16-14	29
1/2-13	44
9/16-12	62
5/8-11	85
3/4-10	146
7/8-9	231
1-8	328
1-1/8-7	488

FINE THREAD

BOLT DIA.	TORQUE FT-LBS AT 100,000 PSI
1/4-28	8
5/16-24	13
3/8-24	21
7/16-20	32
1/2-20	47
9/16-18	65
5/8-18	88
3/4-16	152
7/8-14	241
1-14	347
1-1/8-12	498