

ATI TIGHTENING TORQUE GUIDE (SAE GRADE 8 FASTENERS)

COARSE THREAD

BOLT DIA.	CLAMP LOAD LBS.	PLAIN (FT-LBS)	PLATED (FT-LBS)
1/4-20	2,850	12	9
5/16-18	4,725	25	18
3/8-16	6,975	44	33
7/16-14	9,600	70	52
1/2-13	12,750	106	80
9/16-12	16,350	153	115
5/8-11	20,325	212	159
3/4-10	30,075	376	282
7/8-9	41,550	606	454
1-8	54,525	909	682
1-1/8-7	68,700	1288	966
1-1/4-7	87,225	1817	1363
1-3/8-6	103,950	2382	1787
1-1/2-6	126,450	3163	2371

FINE THREAD

BOLT DIA.	CLAMP LOAD LBS.	PLAIN (FT-LBS)	PLATED (FT-LBS)
1/4-28	3,263	14	10
5/16-24	5,113	27	20
3/8-24	7,875	49	37
7/16-20	10,650	78	58
1/2-20	14,400	120	90
9/16-18	18,300	172	129
5/8-18	23,025	240	180
3/4-16	33,600	420	315
7/8-2014	45,825	668	501
1-12	59,700	995	746
1-14	61,125	1019	764
1-1/8-12	77,025	1444	1083
1-1/4-12	96,600	2012	1509
1-3/8-12	118,350	2712	2034
1-1/2-12	142,275	3557	2668

NOTE: WHEN USING STAT-O SEALS OR THREAD SEALS USE THE FOLLOWING CHARTS.

COARSE THREAD

BOLT DIA.	CLAMP LOAD LBS.	PLAIN (FT-LBS)	PLATED (FT-LBS)
1/4-20	2,850	12	9
5/16-18	4,725	25	18
3/8-16	6,975	44	33
7/16-14	9,600	70	52
1/2-13	12,750	106	80
9/16-12	16,350	153	115
5/8-11	20,325	212	159
3/4-10	30,075	376	282
7/8-9	41,550	606	454
1-8	54,525	909	682
1-1/8-7	68,700	1288	966
1-1/4-7	87,225	1817	1363
1-3/8-6	103,950	2382	1787
1-1/2-6	126,450	3163	2371

FINE THREAD

BOLT DIA.	CLAMP LOAD LBS.	PLAIN (FT-LBS)	PLATED (FT-LBS)
1/4-28	3,263	14	10
5/16-24	5,113	27	20
3/8-24	7,875	49	37
7/16-20	10,650	78	58
1/2-20	14,400	120	90
9/16-18	18,300	172	129
5/8-18	23,025	240	180
3/4-16	33,600	420	315
7/8-2014	45,825	668	501
1-12	59,700	995	746
1-14	61,125	1019	764
1-1/8-12	77,025	1444	1083
1-1/4-12	96,600	2012	1509
1-3/8-12	118,350	2712	2034
1-1/2-12	142,275	3557	2668