PORTLAND BOLT & MANUFACTURING COMPANY

Suggested Starting Torque Values

ASTM A307

Bolt Size	TPI	Proof Load (lbs)	Clamp Load (lbs)	Tightening Torque (ft lbs)		
				Waxed	Galv	Plain
1/4	20	1145	859	2	4	4
5/16	18	1886	1415	4	9	7
3/8	16	2790	2093	7	16	13
7/16	14	3827	2870	10	26	21
1/2	13	5108	3831	16	40	32
9/16	12	6552	4914	23	58	46
5/8	11	8136	6102	32	79	64
3/4	10	12024	9018	56	141	113
7/8	9	15200	11400	83	208	166
1	8	20000	15000	125	313	250
1 1/8	7	25200	18900	177	443	354
1 1/4	7	32000	24000	250	625	500
1 3/8	6	38100	28575	327	819	655
1 1/2	6	46400	34800	435	1088	870
1 3/4	5	68400	51300	748	1870	1496
2	4½	90000	67500	1125	2813	2250
2 1/4	4½	117000	87750	1645	4113	3291
2 1/2	4	144000	108000	2250	5625	4500
2 3/4	4	177480	133110	3050	7626	6101
3	4	214920	161190	4030	10074	8060
3 1/4	4	255600	191700	5192	12980	10384
3 1/2	4	299880	224910	6560	16400	13120
3 3/4	4	347760	260820	8151	20377	16301
4	4	398880	299160	9972	24930	19944

SAE Grade 2

Bolt Size	TPI	Proof Load (lbs)	Clamp Load (lbs)	Tightening Torque (ft lbs)		
				Waxed	Galv	Plain
1/4	20	1750	1313	3	7	5
5/16	18	2900	2175	6	14	11
3/8	16	4250	3188	10	25	20
7/16	14	5850	4388	16	40	32
1/2	13	7800	5850	24	61	49
9/16	12	10000	7500	35	88	70
5/8	11	12400	9300	48	121	97
3/4	10	18400	13800	86	216	173
7/8	9	15200	11400	83	208	166
1	8	20000	15000	125	313	250
1 1/8	7	25200	18900	177	443	354
1 1/4	7	32000	24000	250	625	500
1 3/8	6	38100	28575	327	819	655
1 1/2	6	46400	34800	435	1088	870

ASTM A325 / ASTM A449 / SAE Grade 5

Bolt Size	TPI	Proof Load (lbs)	Clamp Load (lbs)	Tightening Torque (ft lbs)		
				Waxed	Galv	Plain
1/4	20	2700	2025	4	11	8
5/16	18	4450	3338	9	22	17
3/8	16	6600	4950	15	39	31
7/16	14	9050	6788	25	62	49
1/2	13	12050	9038	38	94	75
9/16	12	15450	11588	54	136	109
5/8	11	19200	14400	75	188	150
3/4	10	28400	21300	133	333	266
7/8	9	39250	29438	215	537	429
1	8	51500	38625	322	805	644
1 1/8	7	56450	42338	397	992	794
1 1/4	7	71700	53775	560	1400	1120
1 3/8	6	85450	64088	734	1836	1469
1 1/2	6	104000	78000	975	2438	1950
1 3/4	5	104500	78375	1143	2857	2286
2	4½	137500	103125	1719	4297	3438
2 1/4	4½	178750	134063	2514	6284	5027
2 1/2	4	220000	165000	3438	8594	6875
2 3/4	4	271150	203363	4660	11651	9321
3	4	328350	246263	6157	15391	12313

ASTM A193 B7

Bolt Size	TPI	Proof Load (lbs)	Clamp Load (lbs)	Tightening Torque (ft lbs)		
				Waxed	Galv	Plain
1/4	20	3350	2513	5	13	10
5/16	18	5500	4125	11	27	21
3/8	16	8150	6113	19	48	38
7/16	14	11150	8363	30	76	61
1/2	13	14900	11175	47	116	93
9/16	12	19100	14325	67	168	134
5/8	11	23750	17813	93	232	186
3/4	10	35050	25288	164	411	329
7/8	9	48500	36375	265	663	530
1	8	63650	47738	398	995	796
1 1/8	7	80100	60075	563	1408	1126
1 1/4	7	101750	76313	795	1987	1590
1 3/8	6	121300	90975	1042	2606	2085
1 1/2	6	147550	110663	1383	3458	2767
1 3/4	5	199500	149625	2182	5455	4364
2	4½	262500	196875	3281	8203	6563
2 1/4	4½	341250	255938	4799	11997	9598
2 1/2	4	420000	315000	6563	16406	13125
2 3/4	4	468500	351263	8050	20124	16100
3	4	567150	425363	10634	26585	21268
3 1/4	4	674500	505875	13701	34252	27402
3 1/2	4	791350	593513	17311	43277	34622
3 3/4	4	917700	688275	21509	53771	43017
4	4	1052600	789450	26315	65788	52630

ASTM A354-BD / ASTM A490 / SAE Grade 8

Bolt Size	TPI	Proof Load (lbs)	Clamp Load (lbs)	Tightening Torque	
				Waxed	Plain
1/4	20	3800	2850	6	12
5/16	18	6300	4725	12	25
3/8	16	9300	6975	22	44
7/16	14	12750	9563	35	70
1/2	13	17050	12788	53	107
9/16	12	21850	16388	77	154
5/8	11	27100	20325	106	212
3/4	10	40100	30075	188	376
7/8	9	55450	41588	303	606
1	8	72700	54525	454	909
1 1/8	7	91550	68663	644	1287
1 1/4	7	120000	90000	938	1875
1 3/8	6	138600	103950	1191	2382
1 1/2	6	168600	126450	1581	3161
1 3/4	5	228000	171000	2494	4988
2	4½	300000	225000	3750	7500
2 1/4	4½	390000	292500	5484	10969
2 1/2	4	480000	360000	7500	15000
2 3/4	4	517650	388238	8897	17794
3	4	626850	470138	11753	23507
3 1/4	4	745500	559125	15143	30286
3 1/2	4	874650	655988	19133	38266
3 3/4	4	1014300	760725	23773	47545
4	4	1052600	789450	26315	52630

Notes:

1. Values calculated using industry accepted formula T = KDP where T = Torque, K = torque coefficient (dimensionless), D = nominal diameter (inches), P = bolt clamp load, lb.
2. K values: **waxed** (e.g. pressure wax as supplied on high strength nuts) = .10, hot dip **galv**anized = .25, and **plain** non-plated bolts (as received) = .20.
3. Torque has been converted into ft/lbs by dividing the result of the formula by 12
4. All calculation are for Coarse Thread Series (UNC).
5. Grade 2 calculations only cover fasteners 1/4"-3/4" in diameter up to 6" long; for longer fasteners the torque is reduced significantly.
6. Clamp loads are based on 75% of the minimum proof loads for each grade and size.
7. Proof load, stress area, yield strength, and other data is based on IFI 7th Edition (2003) Technical Data N-68, SAE J429, ASTM A307, A325, A354, A449, and A490.