

## Socket Screw Seating Torque Value Guidelines

PROPERTY CLASS VALUES IN Nm

| Diameter | ISO 4735<br>DIN912<br>Socket Cap<br>Screws |      | DIN 7984<br>Low Head<br>Socket Cap<br>Screws | ISO 10642<br>DIN 7991<br>Socket Csk<br>Screws |      | ISO 7380<br>Socket<br>Button Head<br>Screws |      | ISO 7379<br>Socket Head<br>Shoulder<br>Screws |
|----------|--|------|--|---|------|---|------|---|
|          | 10.9                                       | 12.9 | 10.9   | 10.9  | 12.9 | 10.9  | 12.9 | 12.9  |
|          |  |      |  |   |      |   |      |   |
| M1.6     | 0.25                                       | 0.30 |  |   |      |   |      |   |
| M2       | 0.5  | 0.63 |  |   |      |   |      |   |
| M2.5     | 1.03                                       | 1.27 |  |   |      |   |      |   |
| M3       | 1.83                                       | 2.20 | 1.15   | 1.15  | 1.35 | 1.15  | 1.35 |   |
| M4       | 4.27                                       | 4.83 | 2.7  | 2.70  | 3.10 | 3.70  | 3.10 |   |
| M5       | 8.64                                       | 10.0 | 5.4  | 5.40  | 6.10 | 5.40  | 6.10 |   |
| M6       | 14.7                                       | 16.8 | 9.15   | 9.15  | 10.5 | 9.15  | 10.5 | 5.6   |
| M8       | 35.6                                       | 41.0 | 22   | 22.0  | 26.0 | 22.0  | 26.0 | 9.6   |
| M10      | 70.6                                       | 81.0 | 44   | 44.0  | 52.0 | 44.0  | 52.0 | 25  |
| M12      | 123  | 142  | 77   | 77.0  | 90.0 | 77.0  | 90.0 | 51  |
| M14      | 195  | 226  | 122  | 122   | 143  |   |      |   |
| M16      | 305  | 350  | 190  | 190   | 225  | 190   | 225  | 92  |
| M18      | 420  | 485  | 262  |   |      |   |      |   |
| M20      | 596  | 685  | 371  | 370   | 440  |   |      | 245   |
| M22      | 811  | 930  |  |   |      |   |      |   |
| M24      | 1031                                       | 1180 |  |   |      |   |      |   |
| M27      | 1508                                       | 1730 |  |   |      |   |      |   |
| M30      | 2048                                       | 2380 |  |   |      |   |      |   |
| M33      | 2787                                       | 3262 |  |   |      |   |      |   |
| M36      | 3580                                       | 4190 |  |   |      |   |      |   |
| M39      | 4633                                       | 5420 |  |   |      |   |      |   |

THE ABOVE FIGURES ARE GENERAL GUIDELINES ONLY