

TORQUE ESTIMATING CHART

ASTM A193, GRADE "B7" STUDS | LUBRICANT: MOLY PASTE | NUT FACTORS (K): 0.14, 0.18 or 0.20

TORQUE VALUES CALCULATED USING MECHANICAL ENGINEERING "SHORT FORMULA":

$$T = K (\text{Nut Factor}) \times \text{Clamp Load (Lbs)} \times \frac{D (\text{Bolt Diameter - Inches})}{12}$$

12

Stud Diameter (Inches)	Nut Size (ATF)	Torque Values (Ft-Lbs)								
		40% Yield			50% Yield			60% Yield		
		K=.14	K=.18	K=.20	K=.14	K=.18	K=.20	K=.14	K=.18	K=.20
1/2	7/8	35	45	50	43	56	62	52	67	75
5/8	1-1/16	69	89	99	87	111	124	104	134	148
3/4	1-1/4	123	158	175	153	197	219	184	237	263
7/8	1-7/16	198	255	283	248	318	354	297	382	424
1	1-5/8	297	382	424	371	477	530	445	573	636
1-1/8	1-13/16	435	560	622	544	700	778	653	840	933
1-1/4	2	613	788	875	766	984	1,094	919	1,181	1,313
1-3/8	2-3/16	831	1,068	1,187	1,038	1,335	1,483	1,245	1,602	1,780
1-1/2	2-3/8	1,097	1,410	1,567	1,371	1,762	1,958	1,645	2,115	2,350
1-5/8	2-9/16	1,417	1,822	2,025	1,772	2,278	2,531	2,126	2,733	3,037
1-3/4	2-3/4	1,784	2,293	2,548	2,230	2,867	3,185	2,675	3,440	3,822
1-7/8	2-15/16	2,214	2,847	3,163	2,768	3,559	3,954	3,321	4,270	4,745
2	3-1/8	2,715	3,490	3,878	3,393	4,090	4,848	4,072	5,235	5,817
2-1/4	3-1/2	3,925	5,046	5,607	4,906	6,308	7,009	5,887	7,569	8,411
2-1/2	3-7/8	4,921	6,327	7,030	6,151	7,909	8,788	7,382	9,491	10,545
2-3/4	4-1/4	6,620	8,512	9,457	8,275	10,639	11,822	9,930	12,767	14,186
3	4-5/8	8,658	11,132	12,369	10,823	13,915	15,461	12,987	16,698	18,554
3-1/4	5	11,080	14,246	15,829	13,850	17,807	19,786	16,620	21,369	23,743
3-1/2	5-3/8	13,903	17,875	19,861	17,379	22,344	24,827	20,854	26,813	29,792
3-3/4	5-3/4	17,190	22,102	24,558	21,488	27,627	30,697	25,785	33,153	36,836
4	6-1/8	20,943	26,927	29,919	26,179	33,659	37,398	31,415	40,390	44,878

Material Yield Strength:

1/2" - 2-1/4" Diameter Studs: 105,000 PSI

2-1/2" - 4" Diameter Studs: 95,000 PSI

Number of Threads:

1/2" Diameter Studs: 13 TPI 7/8" Diameter Studs: 9 TPI

5/8" Diameter Studs: 11 TPI 1" - 4" Diameter Studs: 8 TPI

3/4" Diameter Studs: 10 TPI

The K Factor is an experimentally determined constant that relates the torque applied to the load induced in the fastener. This factor is affected by the condition of the fastener, the lubricant used and the condition of the flange.

For example, the 0.18 K Factor listed above is based on the following conditions:

1. New condition of flanges, studs and nuts.
2. Thorough application of lubricant on all mating surfaces of flange, nut and stud.
3. Use of hardened steel washers.

