

TIGHTENING TORQUE OF STANDARD BOLTS

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PFP:00000

Description

To ESM

BAS00027

This vehicle has both new standard based on ISO* and previous standard bolts/nuts. There are some differences between these two types of bolts/nuts; shape of the head, grade of strength, hexagonal width across flats and the standard tightening torque.

- For guidance in discriminating, refer to [GI-4, " Tightening Torque Table \(New Standard Included\)"](#) .
- The new standard machine screws and tapping screws have a head of ISO standard torx recess.
- If the tightening torque is not described in the description or figure, refer to [GI-4, " Tightening Torque Table \(New Standard Included\)"](#) .

*ISO: International Organization for Standardization

Tightening Torque Table (New Standard Included)

BAS00028

CAUTION:

- The special parts are excluded.
- The bolts/nuts in these tables have a strength (discrimination) number/symbol assigned to the head or the like. As to the relation between the strength grade in these tables and the strength (discrimination) number/symbol, refer to "DISCRIMINATION OF BOLTS AND NUTS".

PREVIOUS STANDARD

Grade (Strength grade)	Bolt size	Bolt diameter mm	Hexagonal width across flats mm	Pitch mm	Tightening torque (Without lubricant)							
					Hexagon head bolt				Hexagon flange bolt			
					N·m	kg·m	ft·lb	in·lb	N·m	kg·m	ft·lb	in·lb
4T	M6	6.0	10	1.0	5.5	0.56	4	49	7	0.71	5	62
	M8	8.0	12	1.25	13.5	1.4	10	—	17	1.7	13	—
				1.0	13.5	1.4	10	—	17	1.7	13	—
	M10	10.0	14	1.5	28	2.9	21	—	35	3.6	26	—
				1.25	28	2.9	21	—	35	3.6	26	—
	M12	12.0	17	1.75	45	4.6	33	—	55	5.6	41	—
				1.25	45	4.6	33	—	65	6.6	48	—
M14	14.0	19	1.5	80	8.2	59	—	100	10	74	—	
7T	M6	6.0	10	1.0	9	0.92	7	80	11	1.1	8	97
	M8	8.0	12	1.25	22	2.2	16	—	28	2.9	21	—
				1.0	22	2.2	16	—	28	2.9	21	—
	M10	10.0	14	1.5	45	4.6	33	—	55	5.6	41	—
				1.25	45	4.6	33	—	55	5.6	41	—
	M12	12.0	17	1.75	80	8.2	59	—	100	10	74	—
				1.25	80	8.2	59	—	100	10	74	—
M14	14.0	19	1.5	130	13	96	—	170	17	125	—	
9T	M6	6.0	10	1.0	11	1.1	8	—	13.5	1.4	10	—
	M8	8.0	12	1.25	28	2.9	21	—	35	3.6	26	—
				1.0	28	2.9	21	—	35	3.6	26	—
	M10	10.0	14	1.5	55	5.6	41	—	80	8.2	59	—
				1.25	55	5.6	41	—	80	8.2	59	—
	M12	12.0	17	1.75	100	10	74	—	130	13	96	—
				1.25	100	10	74	—	130	13	96	—
M14	14.0	19	1.5	170	17	125	—	210	21	155	—	

CAUTION:

The parts with aluminum or the cast iron washer surface/screw surface are excluded.

TIGHTENING TORQUE OF STANDARD BOLTS

NEW STANDARD BASED ON ISO

Grade (Strength grade)	Bolt size	Bolt diameter mm	Hexagonal width across flats mm	Pitch mm	Tightening torque							
					Hexagon head bolt				Hexagon flange bolt			
					N·m	kg·m	ft-lb	in-lb	N·m	kg·m	ft-lb	in-lb
4.8 (Without lubricant)	M6	6.0	10	1.0	5.5	0.56	4	49	7	0.71	5	62
	M8	8.0	13	1.25	13.5	1.4	10	—	17	1.7	13	—
				1.0	13.5	1.4	10	—	17	1.7	13	—
	M10	10.0	16	1.5	28	2.9	21	—	35	3.6	26	—
				1.25	28	2.9	21	—	35	3.6	26	—
	M12	12.0	18	1.75	45	4.6	33	—	55	5.6	41	—
				1.25	45	4.6	33	—	65	6.6	48	—
4.8 (With lubricant)	M6	6.0	10	1.0	4	0.41	3	35	5.5	0.56	4	49
	M8	8.0	13	1.25	11	1.1	8	—	13.5	1.4	10	—
				1.0	11	1.1	8	—	13.5	1.4	10	—
	M10	10.0	16	1.5	22	2.2	16	—	28	2.9	21	—
				1.25	22	2.2	16	—	28	2.9	21	—
	M12	12.0	18	1.75	35	3.6	26	—	45	4.6	33	—
				1.25	35	3.6	26	—	45	4.6	33	—
8.8 (With lubricant)	M6	6.0	10	1.0	8	0.82	6	71	10	1.0	7	89
	M8	8.0	13	1.25	21	2.1	15	—	25	2.6	18	—
				1.0	21	2.1	15	—	25	2.6	18	—
	M10	10.0	16	1.5	40	4.1	30	—	50	5.1	37	—
				1.25	40	4.1	30	—	50	5.1	37	—
	M12	12.0	18	1.75	70	7.1	52	—	85	8.7	63	—
				1.25	70	7.1	52	—	85	8.7	63	—
10.9 (With lubricant)	M6	6.0	10	1.0	10	1.0	7	89	12	1.2	9	106
	M8	8.0	13	1.25	27	2.8	20	—	32	3.3	24	—
				1.0	27	2.8	20	—	32	3.3	24	—
	M10	10.0	16	1.5	55	5.6	41	—	62	6.3	46	—
				1.25	55	5.6	41	—	62	6.3	46	—
	M12	12.0	18	1.75	95	9.7	70	—	105	11	77	—
				1.25	95	9.7	70	—	105	11	77	—
10.9 (With lubricant)	M14	14.0	21	1.5	160	16	118	—	180	18	133	—

CAUTION:

1. Use tightening torque with lubricant for the new standard bolts/nuts in principle. Friction coefficient stabilizer is applied to the new standard bolts/nuts.
2. However, use tightening torque without lubricant for the following cases. Friction coefficient stabilizer is not applied to the following bolts/nuts.
 - Grade 4.8, M6 size bolt, Conical spring washer installed
 - Paint removing nut (Size M6 and M8) for fixing with weld bolt

TIGHTENING TORQUE OF STANDARD BOLTS

DISCRIMINATION OF BOLTS AND NUTS

GI

BOLTS

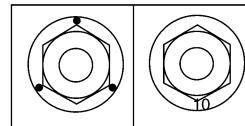
	Grade (Strength)	Discrimination	
Previous standard	4T (392N/mm ²)		 (No number/ symbol)
	7T (686N/mm ²)		
	9T (883N/mm ²)		
New Standard	4.8 (420N/mm ²)		 (No number/ symbol)
	8.8 (800N/mm ²)		
	10.9 (1040N/mm ²)		

NUTS

	Grade (Proof load stress)	Discrimination		
Previous standard	7N (686N/mm ²)	 (No number/ symbol)		
	9N (883N/mm ²)			
New Standard	8 (800N/mm ²)			 (No number/ symbol)
	10 (1040N/mm ²)			

NOTICE:

- A number is assigned on the side of the nuts in some cases.
- A number or symbol is assigned on the upper surface of the flange for the nut with flange.



MACHINE SCREWS AND TAPPING SCREWS

Shape of the head :

Cross recess for the previous standard

Torx recess for the new standard

Screw size	Screw diameter	Torx size
M4	4.0	T20
M5	5.0	T20
M6	6.0	T30

NOTICE:

Use torx size T20 (united with M4 screw) for M5 screw although ISO standard specifies T25.

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