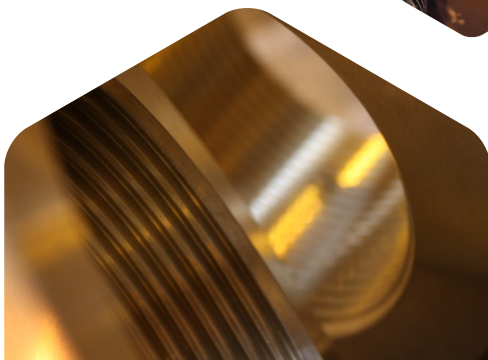
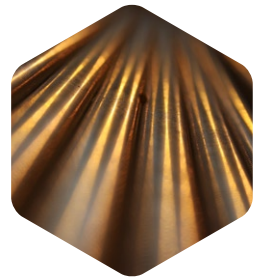


TORQUE FOR IMPERIAL FASTENERS

BOLT SIZE (INS)	MINIMUM YIELD STRENGTH PS.I	BOLT TENSION (LBS)	MOLYBDENUM DISULFIDE BASED U=0.06	MOLYBDENUM LEAD OXIDE & GRAPHITE U=0.085	COPPER & GRAPHITE U=0.110	NICKEL & GRAPHITE BASED U=0.110	API SAE2 U=0.117	MACHINE OIL U=0.150	DRY STEEL U=0.400
1/4	106000	24856	146	192	220	239	252	314	783
3/8	106000	34293	231	305	350	381	402	501	1250
1	106000	44981	343	455	522	568	598	746	1865
1 1/8	106000	58622	491	655	753	819	865	1081	2792
1 1/4	106000	74068	676	906	1044	1135	1201	1505	3808
1 3/8	106000	91316	902	1214	1400	1526	1613	2026	5149
1 1/2	106000	110369	1172	1583	1830	1995	2110	2654	6772
1 5/8	106000	131226	1499	2034	2355	2568	2717	3423	8764
1 3/4	106000	153888	1873	2548	2953	3221	3410	4301	11043
1 7/8	106000	178353	2304	3142	3643	3977	4213	5317	13865
2	106000	204621	2796	3821	4434	4844	5131	6482	16719
2 1/8	106000	232694	3353	4591	5333	5827	6173	7805	20171
2 1/4	106000	262571	3980	5457	6343	6934	7347	9297	24067
2 3/8	106000	294252	4680	6426	7475	8173	8662	10963	28434
2 1/2	106000	327737	5457	7504	8733	9552	10125	12827	33300
2 3/4	95000	362012	6567	9054	10546	11542	12237	15519	40384
3	95000	434028	8522	11774	13724	15025	15935	20226	52738
3 1/4	95000	512574	10829	14987	17483	19146	20310	25799	63181
3 1/2	95000	597647	13518	18739	21871	23958	25420	32311	84511
3 3/4	95000	689249	16619	23068	26937	29495	31322	39834	104322
4	95000	787381	20161	28017	32731	33074	38073	48444	127008
4 1/4	75000	704242	19069	26548	31027	34014	36103	45956	120604
4 1/2	75000	932023	22644	31532	36865	40419	42909	54641	143518
4 3/4	75000	884957	26621	37103	43392	47583	50518	64354	169163
5	75000	983046	31039	43294	50646	55548	58979	75153	197694
5 1/4	75000	1086288	35920	50137	58668	64354	68334	87100	229265
5 1/2	75000	1194686	41287	57666	67493	74045	78630	100248	264029
5 3/4	75000	1308237	47165	65913	77162	84661	89911	114659	302141
6	75000	1426942	53574	74911	87713	96247	102221	130386	343753



FIGURES SHOWN ABOVE ARE TO BE USED AS A GUIDE ONLY.