



SOKO® Range Tightening Torque Class 8.8

Metric Recommended Tightening Torque

Class	8.8		08.8		08.8	
	Socket Head		Button Head		Countersunk Head	
						
Size	Plain (Nm)	Zinc Plated (Nm)	Plain (Nm)	Zinc Plated (Nm)	Plain (Nm)	Zinc Plated (Nm)
M3	1.1	0.8	0.8	0.5	0.8	0.5
M4	2.6	1.9	1.8	1.2	1.8	1.2
M5	5.4	3.7	3.6	2.5	3.6	2.5
M6	9.1	6.4	6.0	4.2	6.0	4.2
M8	22.1	15.5	14.6	10.2	14.6	10.2
M10	43.7	30.6	29.0	20.3	29.0	20.3
M12	76.3	53.4	50.6	35.4	50.6	35.4
M16	189.4	132.6	125.6	87.9	125.6	87.9
M20	382.2	267.5	254.8	178.4	254.8	178.4
M24	660.8	462.6	440.5	308.4	440.5	308.4

Note:

The tightening torque values given in the above table serve only as a guide. A k factor of 0.2 has been used for threads with plain finish, burr-free with a light oil coating. A k factor of 0.14 has been used for zinc plated. Note these figures are based on the first tightening of single assemblies in isolation.

For reduced head class 08.8, clamp load is calculated for 250MPa for ≤M16 and 260MPa for >M16 bolt stress.

Please refer to our engineering team for more detailed systems of determining the correct tension in fasteners rather than just using the above guide, which is very general in nature. It does not take into account the many variables that affect friction in real-world applications and hence tension in the fastener.

Bolt Tension | Anti-Vibration | Product Reliability | Traceability