

DCI Bolt Tightening Torque Recommendations

Improperly or inadequately pre-tensioned bolting can lead to the loading applied to the bolts not being held into place. DCI recommends following the chart to avoid reduced equipment service life, or damage and failure. These values have been based on lubrication of bolt threads with anti-seize. Remember these values are only recommendations and other factors such as dry threads, damaged threads, and friction can play a factor in applying the correct pre-tension in a bolt and DCI, Inc. can not be held accountable for these factors. *The following chart has been compiled to be used for bolting of all DCI equipment unless otherwise specified elsewhere.*

Bolt Size	SAE Grade 5 Low Carbon Steel Bolts	18-8 / 316 Stainless Steel Bolts
	(ft.-lbs.)	(ft.-lbs.)
1/4"-20	5.4	6.3
1/4"-28	7.5	7.8
5/16"-18	10.8	10.8
5/16"-24	11.6	11.8
3/8"-16	17.7	19.7
3/8"-24	19.3	21.6
7/16"-14	28.2	31.3
7/16"-20	30.1	33.3
1/2"-13	38.8	43.1
1/2"-20	40.6	45.1
9/16"-12	51.1	56.8
9/16"-18	55.7	62.7
5/8"-11	83.3	92.5
5/8"-18	95.0	103.7
3/4"-10	104.9	127.5
3/4"-16	102.5	124.2
7/8"-9	159.9	194.0
7/8"-14	159.3	193.2
1"-8	236.0	286.7
1"-14	213.5	259.2
1 1/8"-7	340.0	413.0
1 1/8"-12	322.0	390.0
1 1/4"-7	432.0	523.0
1 1/4"-12	396.0	480.0
1 1/2"-6	732.0	888.0
1 1/2"-12	579.0	703.0

DCI Wingnuts have been designed to apply the proper torque to the bolt when an average human being applies a "hand-tight" force to the wingnut with hands (creating 30-40 ft-lbs). No bars or extensions are to be used.