



GREAT LAKES HYDRAULICS LLC

PNEUMATIC AND HYDRAULIC BOLTING EQUIPMENT

Torque and tension solutions for industry

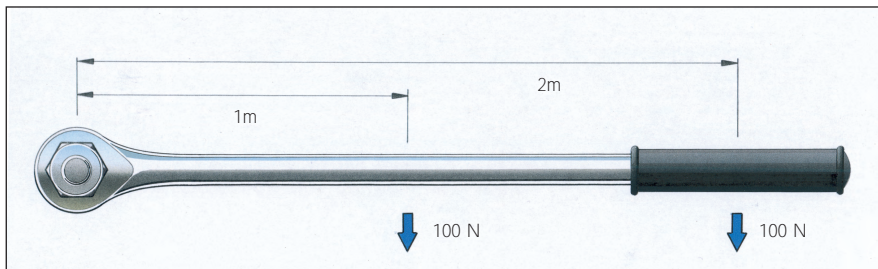
What is Torque?

Torque is any force or system of forces that tends to cause rotation about an axis.

Measurement of Torque

Imagine someone tightening a bolt using a socket attached to a meter long bar. If they apply 10 kg of force (kgf) perpendicular to the bar they will produce a torque of 10 kgf.m at the axis (the centre of the bolt).

However, under the S.I. system of measurement, force is expressed in Newtons (N) rather than kgf. The conversion between kgf and N is x 9.807 so the person is applying 98.07 N.m of torque.



Torque = Force x Distance

Example 1: Distance = 1 m, Force = 100 N, Torque = 100 N.m.

Example 2: Distance = 2 m, Force = 100 N, Torque = 200 N.m.

Example 3: Distance = 1 ft, Force = 100 lbf, Torque = 100 lbf.ft (or 100 ft.lb)

The Importance of Torque Control

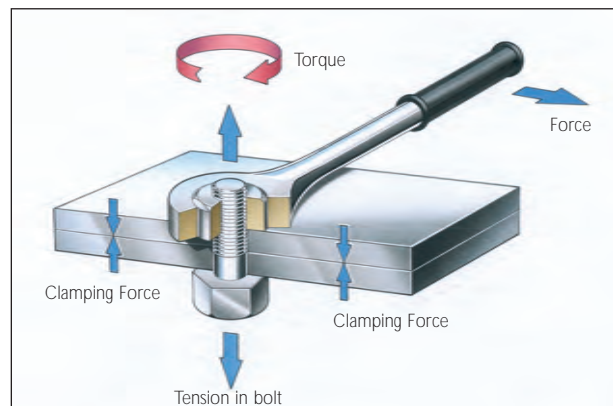
Although many methods exist to join two or more parts together, the ease of assembly and disassembly provided by threaded fasteners make them the ideal choice for many applications.

The object of a threaded fastener is to clamp parts together with a tension greater than the external forces tending to separate them. The bolt then remains under constant stress and is immune from fatigue. However, if the initial tension is too low, varying loads act on the bolt and it will quickly fail. If the initial tension is too high, the tightening process may cause bolt failure. Reliability therefore depends upon correct initial tension. The most practical way of ensuring this is by specifying and controlling the tightening torque.

Bolt Tension

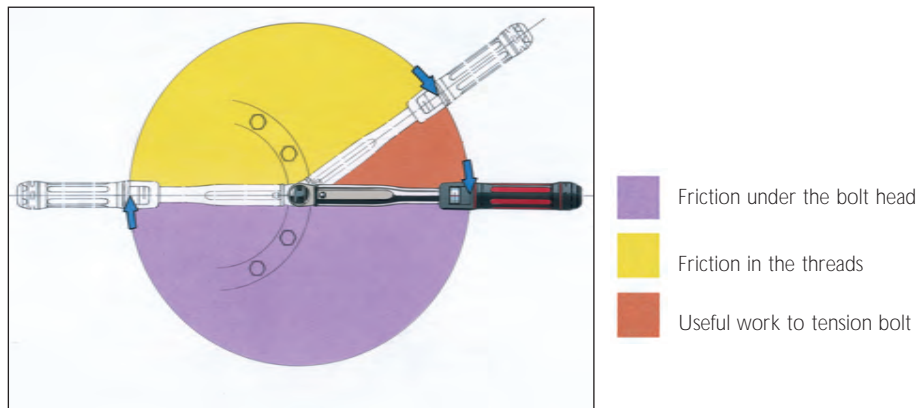
When an assembly is clamped by tightening a nut and bolt, the induced tension causes the bolt to stretch. An equal force acts to compress the parts which are thus clamped.

The proof load of a bolt, normally established by test, is the load which just starts to induce permanent set – also known as the yield point. Typically bolts are tightened to between 75% and 90% of yield.



Friction in the Bolted Joint

When a threaded fastener is tightened, the induced tension results in friction under the head of the bolt and in the threads. It is generally accepted that as much as 50% of the applied torque is expended in overcoming friction between the bolt head and the abutting surface and another 30% to 40% is lost to friction in the threads. As little as 10% of the applied torque results in useful work to tension the bolt.



Given that up to 90% of the applied torque will be lost to friction, it follows that any changes in the coefficient of friction resulting from differences in surface finish, surface condition and lubrication can have a dramatic effect on the torque versus tension relationship. Some general points can be made:

- Most torque tightened joints do not use washers because their use can result in relative motion between the nut and washer or the washer and joint surface during tightening. This has the effect of changing the friction radius and hence affects the torque-tension relationship. Where a larger bearing face is required then flange nuts or bolts can be used. If washers are to be used, hard washers with a good fit to the shank of the bolt give lower and more consistent friction and are generally to be preferred.
- Degreasing fasteners of the film of oil usually present on them as supplied will decrease the tension for a given torque and may result in shear of the fastener before the desired tension is achieved.
- Super lubricants formulated from graphite, molybdenum disulphide and waxes result in minimal friction. Unless allowance is made in the specified tightening torque, the induced tension may be excessive causing the bolt to yield and fail. However, used in a controlled manner, these lubricants serve a useful purpose in reducing the torque to produce the desired tension meaning that a lower capacity tightening tool can be used.
- For reasons of appearance or corrosion resistance, fasteners may be plated. These treatments affect the coefficient of friction and therefore the torque versus tension relationship.
- Friction is often deliberately introduced into the fastener to reduce the possibility of loosening due to vibration. Devices such as lock-nuts must be taken into account when establishing the correct tightening torque.

As a rough guide, the calculated tightening torque should be multiplied by the factor from the table opposite according to surface treatment and lubrication.

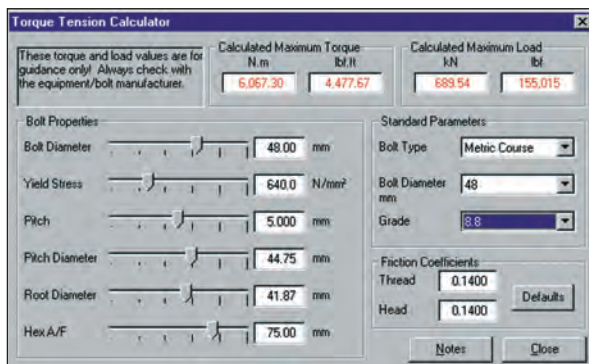
		Surface condition of bolt			
		Untreated	Zinc	Cadmium	Phosphate
Surface condition of nut	Untreated	1.00	1.00	0.80	0.90
	Zinc	1.15	1.20	1.35	1.15
	Cadmium	0.85	0.90	1.20	1.00
	Phosphate and oil	0.70	0.65	0.70	0.75
	Zinc with wax	0.60	0.55	0.65	0.55

Tightening to Yield

Bolts tightened to yield provide consistently higher preloads from smaller diameter bolts. The reduced fastener stiffness reduces the fatigue loading to which the bolt is subjected under repeated external load reversals, e.g. cylinder heads and connecting rods.

In theory, a bolt tightened to its yield point will provide the strongest and most fatigue-resistant joint possible, within the physical limitations of the bolt material and manufacturing process.

Down side of this method is the cost of the sophisticated equipment necessary to determine when the bolt goes into yield.



The screenshot shows the 'Torque Tension Calculator' window. It features a warning at the top: 'These torque and load values are for guidance only! Always check with the equipment/bolt manufacturer.' Below this, it displays 'Calculated Maximum Torque' in N.m (6,067.30) and lbf.ft (4,477.67), and 'Calculated Maximum Load' in kN (689.54) and lbf (155,015). The interface is divided into 'Bolt Properties' and 'Standard Parameters'. Bolt Properties includes fields for Bolt Diameter (48.00 mm), Yield Stress (640.0 N/mm²), Pitch (5.000 mm), Pitch Diameter (44.75 mm), Root Diameter (41.87 mm), and Hex A/F (75.00 mm). Standard Parameters includes Bolt Type (Metric Course), Bolt Diameter (48 mm), Grade (8.8), and Friction Coefficients (Thread: 0.1400, Head: 0.1400). There are 'Notes' and 'Close' buttons at the bottom.

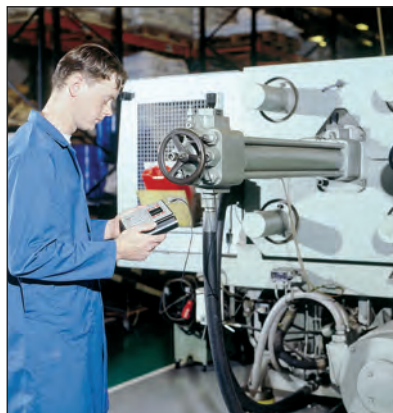
Torque Tension Calculator

For further information and guidance on establishing the correct tightening torque for a fastener, see Norbar's web site, www.norbar.com.

When Torque Doesn't Equal Tight

As we have established, it is the tension in a fastener rather than the torque that is the critical factor. Torque is an indirect means of establishing tension but, in a correctly engineered joint and with a controlled tightening process, it is a satisfactory method under the majority of circumstances.

However, in joints that are highly critical due to safety or the cost and implications of machine down-time, a more direct means of establishing tension is needed. Various methods exist including several types of load indicating bolt or washer. However, one of the most versatile methods is to measure the extension of the bolt due to the tightening process using ultrasound and this is exactly what Norbar's USM-3 does. For full details of this instrument see Norbar's web site: www.norbar.com.





Recommended Maximum Torque Values

The information supplied here is intended to be an acceptable guide for normal conditions. For critical applications, further information and research will be necessary. The following basic assumptions have been made:

- Bolts are new, standard finish, uncoated and not lubricated (other than the normal protective oil film).
- The load will be 90% of the bolt yield strength.
- The coefficient of friction is 0.14.
- The final tightening sequence is achieved smoothly and slowly.

If lubrication is to be applied to the nut/bolt, multiply the recommended torque by the appropriate factor shown in the table on page 7. Alternatively, use the Torque/Tension Calculator on the Norbar website which enables fastener and friction conditions to be modified with ease.

	Bolt Grade									 mm
	3.6	4.6	5.6	5.8	6.8	8.8	9.8	10.9	12.9	
	Torque in N.m									
M 1.6	0.05	0.07	0.09	0.11	0.14	0.18	0.21	0.26	0.31	3.2
M 2	0.11	0.14	0.18	0.24	0.28	0.38	0.42	0.53	0.63	4
M 2.5	0.22	0.29	0.36	0.48	0.58	0.78	0.87	1.09	1.31	5
M 3	0.38	0.51	0.63	0.84	1.01	1.35	1.52	1.9	2.27	5.5
M 4	0.71	0.95	1.19	1.59	1.91	2.54	2.86	3.57	4.29	7
M 5	1.71	2.28	2.85	3.8	4.56	6.09	6.85	8.56	10.3	8
M 6	2.94	3.92	4.91	6.54	7.85	10.5	11.8	14.7	17.7	10
M 8	7.11	9.48	11.9	15.8	19	25.3	28.4	35.5	42.7	13
M 10	14.3	19.1	23.8	31.8	38.1	50.8	57.2	71.5	85.8	17
M 12	24.4	32.6	40.7	54.3	65.1	86.9	97.7	122	147	19
M 14	39	52	65	86.6	104	139	156	195	234	22
M 16	59.9	79.9	99.8	133	160	213	240	299	359	24
M 18	82.5	110	138	183	220	293	330	413	495	27
M 20	117	156	195	260	312	416	468	585	702	30
M 22	158	211	264	352	422	563	634	792	950	32
M 24	202	270	337	449	539	719	809	1011	1213	36
M 27	298	398	497	663	795	1060	1193	1491	1789	41
M 30	405	540	675	900	1080	1440	1620	2025	2430	46
M 33	550	734	917	1223	1467	1956	2201	2751	3301	50
M 36	708	944	1180	1573	1888	2517	2832	3540	4248	55
M 39	919	1226	1532	2043	2452	3269	3678	4597	5517	60
M 42	1139	1518	1898	2530	3036	4049	4555	5693	6832	65
M 45	1425	1900	2375	3167	3800	5067	5701	7126	8551	70
M 48	1716	2288	2860	3813	4576	6101	6864	8580	10296	75
M 52	2210	2947	3684	4912	5895	7859	8842	11052	13263	80
M 56	2737	3650	4562	6083	7300	9733	10950	13687	16425	85
M 60	3404	4538	5673	7564	9076	12102	13614	17018	20422	90
M 64	4100	5466	6833	9110	10932	14576	16398	20498	24597	95
M 68	4963	6617	8271	11029	13234	17646	19851	24814	29777	100

Torque Conversion Factors

Units to be converted	S.I. Units		Imperial Units			Metric Units	
	cN.m	N.m	ozf.in	lbf.in	lbf.ft	kgf.cm	kgf.m
1 cN.m =	1	0.01	1.416	0.088	0.007	0.102	0.001
1 N.m =	100	1	141.6	8.851	0.738	10.20	0.102
1 ozf.in =	0.706	0.007	1	0.0625	0.005	0.072	0.0007
1 lbf.in =	11.3	0.113	16	1	0.083	1.152	0.0115
1 lbf.ft =	135.6	1.356	192	12	1	13.83	0.138
1 kgf.cm =	9.807	0.098	13.89	0.868	0.072	1	0.01
1 kgf.m =	980.7	9.807	1389	86.8	7.233	100	1



See our "Torque Unit Converter" on the Norbar website and "apps" for iPhone and Android smart phones.

Force

lbf x 4.45 = N
N x 0.225 = lbf

Flow

l/s x 2.119 = cu.ft/min
cu.ft/min x 0.472 = l/s

Pressure

lbf/in² x 0.069 = bar
bar x 14.504 = lbf/in²

Power

hp x 0.746 = kW
kW = $\frac{\text{N.m} \times \text{rev/min}}{9546}$

Formulae

Accepted formulae relating torque and tension, based on many tests are:-

$$M = \frac{P \times D}{60}$$

M = torque lbf.ft
P = bolt tension lbf
D = bolt dia.ins

or for metric sizes:-

$$M = \frac{P \times D}{5000}$$

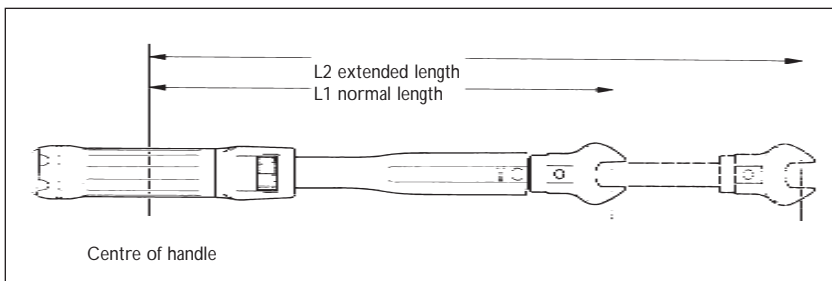
M = torque N.m
P = bolt tension Newtons
D = bolt dia. mm

These formulae may be used for bolts outside the range of the tables,

Formula for Calculating the Effect of Torque Wrench Extensions

$$M1 = M2 \times L1/L2$$

Where L1 is the normal length and L2 is the extended length, M1 is the set torque and M2 the actual torque applied to the nut.



Example

The required torque on the fastener is 130 N.m (M2) but what do you set on the torque wrench scale?

$$L1 = 500 \quad L2 = 650$$

(units of length not important, this is a ratio)

$$M1 = 130 \times 500/650$$

$$M1 = 100$$