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PREMIER SCREW & REPETITION COMPANY

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RECOMMENDED TIGHTENING TORQUE & BOLT TENSIONS FOR AEROTIGHT® NUTS

Note: The data quoted below gives approximate tensions and recommended tightening torques for self colour, lightly oiled nuts, applied to self colour bolts. Any changes in assembly conditions will require readjustment of these recommendations.

4.6/4.8 Grade Bolts			8.8 Grade Bolts	
Size	75% Proof Load	Tightening Torque	75% Proof Load	Tightening Torque
	(N)	(Nm)	(N)	(Nm)
Metric	M3	1165	2330	1.40
	M4	2030	4060	3.25
	M5	3290	6580	6.57
	M6	4660	9330	11.18
	M8	9070	16940	27.12
	M10	13400	26800	53.57
	M12	19500	39140	93.5
	M16	36300	72600	232
	M20	56800	113600	454

Registered in England under 3824556
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"Precision Components of the Highest Quality"

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