

elongations of standard bolts (international standard threads) subjected to the tightening torques and bolt tensions recommended in the table on the opposite page

The following elongations have been calculated subject to the same conditions as were applied in preparing the table on the opposite page, i. e.: use of three-fourths of the elastic limit of bolts, for a coefficient of friction of 0.12, corresponding to bolts which are mounted greased, and carefully manufactured from the standpoint of condition of the surfaces and the geometric standards used in production.

To obtain the elongations representing the elastic limit of bolts, multiply the following elongations by 1.33.

	Soft Steel Bolts AFNOR RATING C 20 Breaking Stress : 45 kg/mm ² Elastic Limit : 25 kg/mm ²	Semi-Hard Steel Bolts AFNOR RATING C35 Breaking Stress : 65 kg/mm ² Elastic Limit : 32 kg/mm ²	Hard Steel Bolts AFNOR RATING C45 Breaking Stress : 75 kg/mm ² Elastic Limit : 38 kg/mm ²	Heat treated Hard Steel Bolts AFNOR RATING C45 Breaking Stress : 90 kg/mm ² Elastic Limit : 65 kg/mm ²	Heat treat. Nickel Chrome Steel Bol. AFNOR RATING 16 N.C. 6 Breaking Stress : 130 kg/mm ² Elastic Limit : 90 kg/mm ²
Elongations of the threaded part (machine-made and rolled bolts). Elongations indicated for a threaded part 100 mm on length, whatever the diameter of the bolt. A_1	mm 0,09	mm 0,12	• mm 0,14	mm 0,24	mm 0,34
Average elongations of the smooth part of machine-made bolts. Elongations indicated for a smooth part 100 mm in length, whatever the diameter of the bolt. A_2	0,06	0,08	• 0,09	0,16	0,22
Average elongations of the smooth part of rolled bolts. Elongations indicated for a smooth part 100 mm in length, whatever the diameter of the bolt. A_3	0,07	0,09	• 0,11	0,18	0,25

calculating the elongation of a bolt subjected to a given tightening torque

The elongations are proportional to the tightening torques; they vary according to the quality of the steel and according to the section of the bolt (that is why the elongations indicated above differ, depending on whether the part is threaded or smooth, machine-made or rolled); furthermore, they are proportional to the length of the bolt (the values indicated above are for 100 millimeters). To ascertain the elongation of a bolt as an absolute value, you need only compute two successive rules of three for the threaded part and the smooth part, and add together the two values obtained.

Example : A diameter 12 IS bolt of hard steel, untreated. Length of the useful threaded part $f = 25$ mm.
Length of the smooth part under the bolt head $e = 30$ mm.

A - ELONGATION OF THE THREADED PART

Machine-made or rolled bolt (cf. line A_1).

The table indicates, for 4.2 mkg and for a threaded part 100 mm in length, an elongation of 0.14 mm (cf. black dots above).

At a torque of 3 mkg and for a threaded part 100 mm in length, the elongation would be $\frac{0.14 \times 3}{4.2} = 0.10$ mm.

At a torque of 3 mkg and for a threaded part 25 mm in length, the elongation would be $\frac{0.10 \times 25}{100} = 0.025$ mm.

B - ELONGATION OF THE SMOOTH PART

a) Machine-made bolt (cf. line A_2).

The table indicates, for 4.2 mkg and for a smooth part 100 mm in length, an elongation of 0.09 mm (cf. black dots above).

At a torque of 3 mkg and for a smooth part 100 mm in length, the elongation would be $\frac{0.09 \times 3}{4.2} = 0.064$ mm.

At a torque of 3 mkg and for a smooth part 30 mm in length, the elongation would be $\frac{0.064 \times 30}{100} = 0.0193$ mm.

b) Rolled bolt (cf. line A_3).

The table indicates, for 4.2 mkg and for a smooth part 100 mm in length, an elongation of 0.11 mm (cf. black dots above).

At a torque of 3 mkg and for a smooth part 100 mm in length, the elongation would be $\frac{0.11 \times 3}{4.2} = 0.078$ mm.

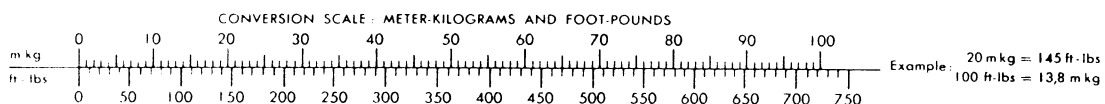
At a torque of 3 mkg and for a smooth part 30 mm in length, the elongation would be $\frac{0.078 \times 30}{100} = 0.0235$ mm.

The bolt and screw tightening torque indications shown in these tables are the result of calculations and tests carried out by the Engineering Bureau of the FACOM Company.
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C - TOTAL ELONGATION

a) Machine-made bolt - At a tightening torque of 3 mkg, the diameter 12 IS bolt ($f = 25$, $e = 30$) of untreated hard steel would have a total elongation of $0.025 + 0.0193 = 0.044$ mm.

b) Rolled bolt - At a tightening torque of 3 mkg, the diameter 12 IS bolt ($f = 25$, $e = 30$) of untreated hard steel would have a total elongation of $0.025 + 0.0235 = 0.048$ mm.



T5 2 - torque tables

Table of tightening torques recommended for standard bolts and screws.

tightening torque and bolt tension recommended for standard bolts (international standard threads)

The tightening torques and bolt tension indications listed below are based on use of 75 % of the elastic limit of bolts for a coefficient of friction of 0.12, corresponding to bolts which are **mountend greased**, and carefully manufactured from the standpoint of condition of the surfaces and the geometric standards used in production. These loads are an exact indication of the **normal** tightening twist which can be applied to bolts, and may be used to determine the practical amount of tightening torque, in terms of the torque wrench being used. To determine the tightening torque and bolt tension which represents the elastic limit of bolts, multiply the figures in the table below by 1.33.

Torque Capacity of FACOM Torque Wrenches										Standard Bolt Dimensions (I.S. Threads)		TYPE OF BOLTS									
												Soft Steel Bolts AFNOR Rating C20 Breaking Stress : 45 kg/mm ² Elastic Limit : 25 kg/mm ²		Semi-Hard Steel Bolts AFNOR Rating C35 Breaking Stress : 65 kg/mm ² Elastic Limit : 32 kg/mm ²		Hard Steel Bolts AFNOR Rating C45 Breaking Stress : 75 kg/mm ² Elastic Limit : 38 kg/mm ²		Heat Treated Hard Steel Bolts AFNOR Rating C45 Breaking Stress : 90 kg/mm ² Elastic Limit : 65 kg/mm ²		Heat Treated Nickel Chrome Steel Bolts AFNOR Rating I6NC6 Breaking Stress : 130 kg/mm ² Elastic Limit : 90 kg/mm ²	
R 200	J 200	S 200	S 203	S 203 with S 214	S 203 with S 214	K 214	K 200	M 200	Bolt Diameter	Thread Pitch	Bolt Head Dimensions Across Flats	Recommended Tightening Torque	Bolt Tension Developed	Recommended Tightening Torque	Bolt Tension Developed	Recommended Tightening Torque	Bolt Tension Developed	Recommended Tightening Torque	Bolt Tension Developed	Recommended Tightening Torque	Bolt Tension Developed
0 to 2 mkg	0 to 10 mkg	0 to 25 mkg	0 to 20 mkg	0 to 40 mkg	0 to 60 mkg	0 to 80 mkg	0 to 250 mkg		in mm	P in 1/100 mm	A in mm	C in mkg	T in kg	C in mkg	T in kg	C in mkg	T in kg	C in mkg	T in kg	C in mkg	T in kg
									4	75	7	0,09	128	0,12	164	0,14	194	0,23	340	0,33	460
									5	90	8	0,17	206	0,22	265	0,27	315	0,46	535	0,63	740
									6	100	10	0,32	310	0,41	400	0,49	470	0,84	805	1,16	1 120
									7	100	12	0,55	456	0,71	585	0,84	690	1,45	1 180	2,00	1 640
									8	125	14	0,80	575	1,03	740	1,22	870	2,10	1 500	2,90	2 060
									9	125	16	1,20	770	1,54	990	1,82	1 170	3,10	2 000	4,30	2 760
									10	150	17	1,58	915	2,03	1 170	2,40	1 390	4,10	2 380	5,70	3 300
									11	150	19	2,20	1 170	2,80	1 500	3,35	1 780	5,70	3 050	7,90	4 200
									12	175	21	2,77	1 330	3,55	1 700	4,20	2 020	7,20	3 450	10,00	4 800
									14	200	23	4,35	1 840	5,55	2 350	6,60	2 790	11,30	4 800	15,60	6 600
									16	200	26	6,80	2 550	8,70	3 250	10,40	3 880	17,70	6 600	24,50	9 200
									18	250	29	9,30	3 070	11,90	3 950	14,20	4 670	24,20	8 000	33,50	11 000
									20	250	32	13,20	3 980	16,90	5 100	20,00	6 000	34,50	10 400	47,50	14 300
									22	250	35	18,00	5 050	23,00	6 450	27,40	7 700	47,00	13 100	65,00	18 200
									24	300	38	22,60	5 800	29,00	7 400	34,40	8 800	59,00	15 100	81,00	20 800
									27	300	42	33,50	7 650	43,00	9 800	51,00	11 600	87,00	19 900	120,00	27 500
									30	350	46	45,00	9 200	57,50	11 800	68,50	14 000	117,00	24 000	162,00	33 000
									33	350	50	61,00	11 500	78,00	14 800	93,00	17 500	159,00	30 000	220,00	41 500
									36	400	54	80,00	13 500	102,00	17 300	122,00	20 500	208,00	35 000	288,00	48 500
									39	400	58	102,00	16 500	130,00	21 000	155,00	25 000	265,00	43 000	356,00	59 000
									42	450	63	126,00	18 800	152,00	24 000	194,00	28 500	330,00	48 700	460,00	67 500
									45	450	67	158,00	22 000	202,00	28 200	240,00	33 500	410,00	57 300	570,00	79 500
									48	500	71	190,00	24 700	242,00	31 600	286,00	37 600	490,00	64 200	675,00	89 000
									52	500	77	245,00	29 900	313,00	38 000	372,00	45 300	635,00	77 500	880,00	107 000

computing the tension developed by a given torque and, conversely, computing the torque needed to develop a given tension

Whatever the type of bolt used and for a given bolt diameter, there is a definite ratio between the tension developed and the tightening torque applied. A simple rule of three will give us the tension in terms of the torque, using the figures in the table which correspond to the bolt diameter.

Example : Diameter 12 IS. bolt of hard untreated steel.

The table indicates for 4 mkg 2 a bolt tension of 2020 kg (see black dotted figures above).

The bolt tension developed by applying 3 mkg of torque would be $\frac{2020 \times 3}{4} = 1440$ kg.

Conversely, the torque which would produce a bolt tension of 1500 kg would be $\frac{4,2 \times 1500}{2,020} = 3,12$ mkg.

