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### **BOLT TORQUES**

<b>BOLT DIAMETER (mm)</b>	<b>TORQUE (Nm)</b>
10	40
12	67
14	104
16	151
18	211
20	284
22	372
25	534
30	895
35	1384
36	1499
40	2019
45	2816
50	3794
55	4967

**Notes:**

1. It is recommended that the contractor applies the above torque to the bolts again after the pipeline has been in operation 24 to 48 hours.
2. It is recommended that the use of a gasket and its material is subject to agreement as stated in DIN 16963 Part 4 Table 5 Materials.

*Please note*

1. *The above table is a guideline only and the torque actually applied will be adjusted by the influence of other factors including, inter alia:*
  - a. *The grade of steel used in the manufacture of the nut, bolt and washer*
  - b. *The use, or not, of a gasket*
  - c. *The type of material of the gasket*
  - d. *The ambient temperature at the time of torqueing the flange*
  - e. *The procedure used to revisit and re-torque the bolts*