

American National Standard Flange SPECIFICATIONS				Torque Chart for ASTM A193 Grade B7 Studs In Ft./Lbs At 50% Of Yield Add .04 to the u to = K factor					
1500 lb				Moly Lube u=0.085 K=.0125	Nickel Lube u=0.110 K=.150	Copper Lube u=0.100 K=.140	Machine Oil u=0.160 K=.200	Dry Torque u=0.400 K=.440	Tool Model
PIPE SIZE	BOLT DIA.	# OF BOLTS	HEAVY HEX A/F						
1/2"	3/4"	4	1-1/4"	137	165	154	219	483	Versa-1
3/4"	3/4"	4	1-1/4"	137	165	154	219	483	Versa-1
1"	7/8"	4	1-7/16"	221	265	247	353	777	Versa-1
1-1/4"	7/8"	4	1-7/16"	221	265	247	353	777	Versa-1
1-1/2"	1"	4	1-5/8"	331	397	371	530	1165	Versa-1
2"	7/8"	8	1-7/16"	221	365	247	353	777	Versa-1
2-1/2"	1"	8	1-5/8"	331	397	371	530	1165	Versa-1
3"	1-1/8"	8	1-13/16"	486	583	544	778	1711	Stealth-2
N/A	N/A	N/A	N/A						
4"	1-1/4"	8	2"	683	820	765	1093	2404	Stealth-2
5"	1-1/2"	8	2-3/8"	1223	14668	1370	1957	4306	Stealth-4
6"	1-3/8"	12	2-3/16"	927	1112	1038	1483	3263	Stealth-4
8"	1-5/8"	12	2-9/16"	2207	2648	2472	3531	7768	Stealth-4
10"	1-7/8"	12	2-15/16"	2474	2969	2771	3959	8709	Stealth-8
12"	2"	16	3-1/8"	3029	3635	3392	4846	10662	Stealth-8
14"	2-1/4"	16	3-1/2"	4375	5250	4900	7000	15400	Stealth-14
16"	2-1/2"	16	3-7/8"	5492	6590	6151	8787	19332	Stealth-14
18"	2-3/4"	16	4-1/4"	7378	8854	8263	11805	25971	Stealth-22
20"	3"	16	4-5/8"	9653	11584	10811	15445	33978	Stealth-36
24"	3-1/2"	16	5-3/8"	15514	18617	17376	24823	54611	Stealth-36

This spread sheet is to be used as a guide. all results should be analyzed against actual field results to establish their validity.