

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					
2500 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"	1"	4	1-5/8"	331	397	371	530	1165	Versa-1
1-1/2"	1-1/8"	4	1-13/16"	486	583	544	778	1711	Stealth-2
2"	1"	8	1-5/8"	331	397	371	530	1165	Versa-1
2-1/2"	1-1/8"	8	1-13/16"	486	583	544	778	1711	Stealth-2
3"	1-1/4"	8	2"	683	820	765	1093	2404	Stealth-2
N/A	N/A	N/A	N/A						
4"	1-1/2"	8	2-3/8"	1223	1468	1370	1957	4306	Stealth-4
5"	1-3/4"	8	2-3/4"	1992	2390	2231	3187	7011	Stealth-4
6"	2"	8	3-1/8"	3029	3635	3392	4846	10662	Stealth-8
8"	2"	12	3-1/8"	3029	5088	3392	4846	10662	Stealth-8
10"	2-1/2"	12	3-7/8"	5492	6590	6151	8787	19332	Stealth-14
12"	2-3/4"	12	4-1/4"	7378	8854	8263	11805	25971	Stealth-22
14"	N/A	N/A	N/A						
16"	N/A	N/A	N/A						
18"	N/A	N/A	N/A						
20"	N/A	N/A	N/A						
24"	N/A	N/A	N/A						

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