

**Recommended Torques for Inch Series Huck 360**

		3/8"	1/2"	5/8"	3/4"	7/8"	1"	1 1/8"	1 3/8"
Target Clamp	Lbf.	8000	15000	24000	35000	49000	64000	80000	121000
	KN	36	67	107	156	218	285	356	538
Recommended Torque when Turning Nut	ft. lbs.	45	110	215	365	585	890	1265	2275
	Nm	60	145	290	495	795	1210	1720	3085

**Recommended Torques for Metric Series Huck 360**

		10mm	12mm	14mm	16mm	18mm	20mm	22mm	24mm	27mm	30mm	36mm	42mm
Target Clamp	Lbf.	9500	13800	18900	25700	31500	40200	49600	57800	75300	91800	133800	183500
	KN	42	61	84	114	140	179	221	257	335	408	595	816
Recommended Torque when Turning Nut	ft. lbs.	55	95	150	230	325	450	605	765	1145	1490	2670	4295
	Nm	75	130	200	310	440	610	820	1040	1550	2020	3620	5825

Notes:

The torque numbers in this table are meant to generate a target clamp load equal to 70% of the Huck 360s ultimate tensile strength.

These torque numbers were calculated for turning the nut against a hardened steel washer or against a clean smooth hardened steel surface with no additional lubrication.

These torque numbers are a reference starting point and may need to be adjusted up or down in order to achieve the target clamp load. Some causes that can contribute to the need for adjustments are: variations in surface texture of application, turning bolt instead of nut, residual lubrication on the application surface, and surface contamination.

The best way to determine the correct torque is under conditions similar to the end user's application and environmental conditions.