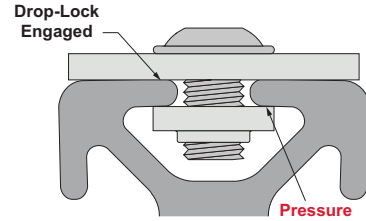


Torque Specifications

The tables below show the amount of torque in foot-lbs. and newton meters required to activate the 2 degree drop-lock feature for t-slotted profiles. Nut and bolt combination is preloaded when tightened to the minimum torque rating.



Fractional T-slotted Profiles

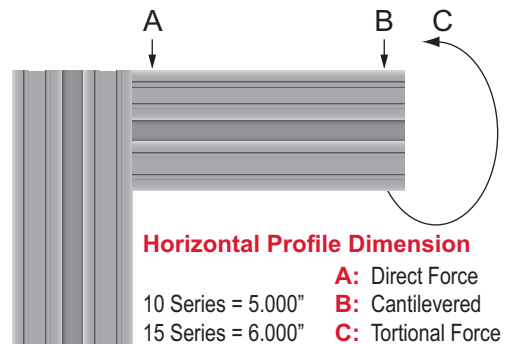
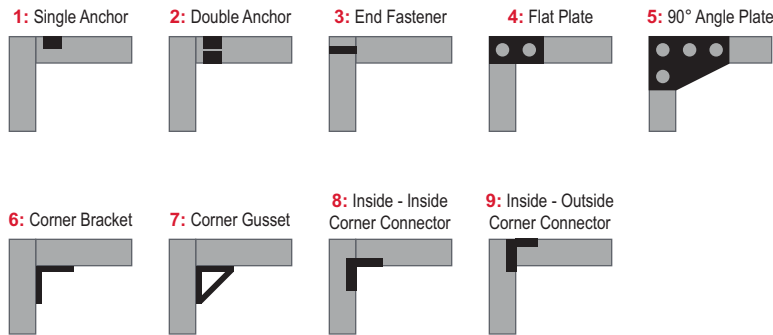
Part Number	Fastener Description	Tested Profile	Minimum Torque Ft.-lbs.	Maximum Torque Ft.-lbs.
3320	5/16-18 x 11/16 Flanged BHSCS & Economy T-Nut	1515	10.00	15.00
3325	5/16-18 x 3/4 Economy T-Slot Stud, Washer & Hex Nut	1515	25.00	30.00
3360	15 Series Anchor Fastener Assembly	1515-Lite	10.00	20.00
3380	15 Series End Fastener Assembly	1515-Lite	10.00	22.00
3321	1/4-20 x 1/2 Flanged BHSCS & Economy T-Nut	1010	4.00	6.00
3395	10 Series Anchor Fastener Assembly	1010	3.00	17.00
3381	10 Series End Fastener Assembly	1010	4.00	17.00

Metric T-slotted Profiles

Part Number	Fastener Description	Tested Profile	Minimum Torque Newton Meters	Maximum Torque Newton Meters
75-3422	M8 x 16mm BHSCS & Economy T-Nut	40-4040	13	20
75-3500	M8 x 20mm Economy T-Slot Stud, Washer & Hex Nut	40-4040	40	54
40-3897	40 Series Anchor Fastener Assembly	40-4040-Lite	13	37
40-3891	40 Series End Fastener Assembly	40-4040-Lite	13	29
75-3404	M6 x 10mm BHSCS & Economy T-Nut	25-2525	5	8
25-3896	25 Series Anchor Fastener Assembly	25-2525	4	23
25-3895	25 Series End Fastener Assembly	25-2525	5	23

The estimated torque calculations in this chart are offered as a guide only. Use of this content by anyone is the sole responsibility of that person and they assume all risk. Due to many variables that affect the torque-tension relationship like human error, surface texture, and lubrication the only way to determine the correct torque is through experimentation under actual joint and assembly conditions.

Fastener Application Test



Fastener	1010 Profile			1515-Lite Profile			1515 Profile		
	A (lbs)	B (lbs)	C (Inch-lbs)	A (lbs)	B (lbs)	C (Inch-lbs)	A (lbs)	B (lbs)	C (Inch-lbs)
1	500	250	180	950	625	540	950	1,000	700
2	900	250	260	1,200	700	1,150	1,200	1,200	2,000
3	450	200	325	1,000	500	680	1,000	820	1,150
4	175	50	400	225	200	1,000	225	200	1,100
5	175	50	500	250	200	1,120	250	200	1,260
6	325	75	180	375	225	500	575	225	500
7	325	220	260	375	750	500	575	750	500
8	—	—	—	50	50	50	—	—	—
9	—	—	—	240	220	240	—	—	—