



FOUNDED 1890

# ROYERSFORD™

## FOUNDRY AND MACHINE CO., INC.

### Tightening Torque for Royersford Foundry Products

Bolt Tightening Torque for Royersford Foundry Journal Bearings & Clamp Couplings		
Bolt Size	Dry Torque	Wet Torque
	lb. in.	lb. in.
1/4-20	66	49
Bolt Size	lb. ft.	lb. ft.
5/16-18	11	8
3/8-16	20	15
1/2-13	50	35
5/8-11	100	75
3/4-10	175	130
7/8-9	165	125
1-8	250	190
1 1/8-7	350	270
1 1/4-7	500	380
1 3/8-6	660	490

Socket Set Screw Tightening Torque for Royersford Foundry Shaft Collars, Rigid Sleeve Couplings & Type 'E' Drive Collars	
Size	Torque (lb. in.)
#8-32	20
#10-24	36
1/4-20	87
5/16-18	165
3/8-16	290
1/2-13	620
5/8-11	1325
3/4-10	2400

Socket Set Screw Tightening Torque for Royersford Foundry R2000 Drive Collars	
Size	Torque (lb. in.)
3/8-24	250
1/2-20	620
5/8-18	1325