



**Bolt Torque Values for ASME B16.5 Series A Class 150# Flat Flanges  
with A193 Grade B7 Bolts**

For Full Face Homogenous Elastomeric Gaskets

Nominal Pipe Size (in)	# of Bolt Holes (in)	Size of Bolts (in)	Minimum Torque (ft. lbs.)	<70 durometer	>70 durometer
				Shore A	Shore A
				Preferred Torque (ft. lbs.)	Preferred Torque (ft. lbs.)
0.50	4	0.50	9	14	19
0.75	4	0.50	12	17	23
1.00	4	0.50	14	21	28
1.25	4	0.50	16	24	32
1.50	4	0.50	19	28	37
2.00	4	0.63	33	49	66
2.50	4	0.63	45	67	90
3.00	4	0.63	49	73	97
3.50	8	0.63	30	45	60
4.00	8	0.63	33	49	66
5.00	8	0.75	41	61	82
6.00	8	0.75	46	69	92
8.00	8	0.75	66	99	132
10.0	12	0.88	64	96	128
12.0	12	0.88	93	140	186
14.0	12	1.00	134	201	268
16.0	16	1.00	120	181	241
18.0	16	1.13	132	198	264
20.0	20	1.13	124	187	249
24.0	20	1.25	173	260	347

NOTE 1: This torque table applies for 1/16" and 1/8" thick homogenous elastomeric gaskets. The pressure rating of the material may vary depending on the grade.

NOTE 2: The above-mentioned torque values are based on the maximum bolt stress of 60,000 psi. Bolt yield should be at least 80,000 psi.

NOTE 3: This table does not take flange strength into consideration. We recommend consulting the flange manufacturer to confirm the suitability of the above-mentioned values.

NOTE 4: Apply torque in increments. When the gasket extends past the O.D. of the flange by 1/4" to 3/8", stop tightening.