



APE SERVICE BULLETIN

DEEP FOUNDATION SOLUTIONS

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#50 RECOMMENDED BOLT TIGHTENING TORQUE “LUBRICATED SHCS” Socket Head Cap Screws

When installing any APE equipment or parts apply lubricant and use APE standard **Anti-Seize** torque specs.

See Tightening Torque Spec below. Failure to follow tightening torque spec can result in under / over tightening fasteners, leading to equipment failure or personal injury.



COARSE THREADS

FINE THREADS

| Nominal Screw Size | Nominal Socket Size | Tightening Torque (ft-lbs) |
|--------------------|---------------------|----------------------------|
| #10-24 | 5/32 | 6 |
| .25-20 | 3/16 | 10 |
| .31-18 | 1/4 | 22 |
| .38-16 | 5/16 | 38 |
| .44-14 | 3/8 | 61 |
| .50-13 | 3/8 | 93 |
| .63-11 | 1/2 | 179 |
| .75-10 | 5/8 | 317 |
| .88-9 | 3/4 | 511 |
| 1.00-8 | 3/4 | 767 |
| 1.25-7 | 7/8 | 1,533 |
| 1.50-6 | 1 | 2,668 |

| Nominal Screw Size | Nominal Socket Size | Tightening Torque (ft-lbs) |
|--------------------|---------------------|----------------------------|
| #10-32 | 5/32 | 6 |
| .25-28 | 3/16 | 12 |
| .31-24 | 1/4 | 24 |
| .38-24 | 5/16 | 43 |
| .44-20 | 3/8 | 68 |
| .50-20 | 3/8 | 105 |
| .63-18 | 1/2 | 202 |
| .75-16 | 5/8 | 354 |
| .88-14 | 3/4 | 564 |
| 1.00-12 | 3/4 | 860 |
| 1.25-12 | 7/8 | 1,697 |
| 1.50-12 | 1 | 3,001 |

RECOMMENDED ANTI-SEIZE LUBRICANT

BENEFITS & FEATURES

- **Excellent Anti-Seize** Prevents seizing causing by galling, galvanic action, fretting, fusion, pitting, thread distortion, breakage, rust, and corrosions.
- **Water Resistant** Provides long term protection with just one application, outdoors or indoors, even in the damp areas or against salt spray. Will not wash off.
- **Wide Temperature Range** Coating withstands temperatures of -65 Degree F to 2100 Degree F. (-54 C to 1100 C)
- **Stable Coating** Will not harden or fuse to metal, cake, evaporate or separate
- **Compatible with many materials** Can be used as an anti-seize on the threads of steel, stainless steel, steel alloy, cast iron, aluminum, copper brass, and titanium parts and reduces friction and wear on plastic.
- **Environmentally Desirable** Past contains no lead compounds traditionally found in this type of product.



WARNING: USING OTHER TYPES OF ANTI-SEIZE NOT RECOMMENDED BY APE CAN LEAD TO EQUIPMENT FAILURE OR PERSONAL INJURY. WARRANTY WILL BE VOIDED AND FEES MAY APPLY.



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