

**MAKE-UP TORQUE RECOMMENDED
FOR ROCK BIT PINS**

| API PIN SIZE Inches | RECOMMENDED TORQUE Ft.-Lbs | m-kg |
|------------------------|-------------------------------|---------------|
| 2 3/8 | 3,000 - 3,500 | 410 - 480 |
| 2 7/8 | 6,000 - 7,000 | 830 - 970 |
| 3 1/2 | 7,000 - 9,000 | 970 - 1,240 |
| 4 1/2 | 12,000 - 16,000 | 1,660 - 2,210 |
| 6 5/8 | 28,000 - 32,000 | 3,870 - 4,420 |
| 7 5/8 | 34,000 - 40,000 | 4,700 - 5,530 |
| 8 5/8 | 40,000 - 60,000 | 5,530 - 8,300 |



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