

# Make Up Torque

**Table 10: 2°, 3° and 4° Conventional Lock Housing Make-up Torque**

Motor Size	Torque	
	(lb-ft)	(N-m)
2 7/8"	4,000	5,400
3 1/8"	4,500	6,100
3 3/4"	5,300	7,200
4 3/4"	11,300	15,000
6 1/4"	23,000	31,000
6 3/4"	28,000	38,000
7 3/4"	43,000	58,000
9 5/8"	68,000	92,000
11 1/4"	80,000	108,000

**Table 11: 2.38° and 3° HEMIDRIL-rated Lock Housing Make-up Torque**

Motor Size	Torque	
	(lb-ft)	(N-m)
5" (2.38° only)	11,000	15,000
5" (3° only)	14,000	19,000
6 1/2"	26,000	35,000
7"	28,000	38,000
8"	50,000	68,000
9 5/8"	68,000	92,000

The following table shows the available bend settings for the 2°, 2.38°, 3°, and 4° adjustable housings.

**Table 12: Adjustable Housing Bend Settings**

2 Degree	3 Degree	4 Degree	2.38 Degree
0.00	0.00	0.00	0.00
0.26	0.39	0.35	0.39
0.52	0.78	0.69	0.78
0.77	1.15	1.04	1.15
1.00	1.50	1.37	1.50
1.22	1.83	1.69	1.83
1.41	2.12	2.00	2.12
1.59	2.38	2.29	2.25
1.73	2.60	2.57	2.38
1.85	2.77	2.83	
1.93	2.89	3.06	
1.98	2.97	3.28	
2.00	3.00	3.46	
		3.63	
		3.76	
		3.86	
		3.94	
		3.98	
		4.00	