

Schraubenanzugsmomente mit Toleranz
Tightening torques with tolerance
Couples de serrage des vis avec Tolerance

| Abmessung | geölt, oiled, huile $\mu = 0,08$ | | MOS ₂ $\mu = 0,1$ | | geölt, oiled, huile $\mu = 0,12$ | |
|------------|----------------------------------|-----------|------------------------------|-----------|----------------------------------|-----------|
| Dimension | 8.8 | 10.9 | 8.8 | 10.9 | 8.8 | 10.9 |
| | Nm | Nm | Nm | Nm | Nm | Nm |
| M4 | 2,0 +0,2 | 2,8 +0,4 | 2,2 +0,3 | 3,2 +0,4 | 2,5 +0,3 | 3,7 +0,4 |
| M5 | 3,9 +0,4 | 5,6 +0,7 | 4,5 +0,5 | 6,4 +0,7 | 5,0 +0,5 | 7,3 +0,8 |
| M6 | 6,6 +0,8 | 10 +0,9 | 7,6 +0,9 | 11 +1 | 8,5 +1 | 13 +1 |
| M8 | 16 +2 | 23 +3 | 18 +2 | 26 +3 | 21 +2 | 30 +4 |
| M8 x 1 | 17 +2 | 25 +3 | 19 +2 | 27 +3 | 22 +2 | 32 +4 |
| M10 | 32 +4 | 46 +6 | 36 +4 | 51 +6 | 41 +5 | 60 +8 |
| M10 x 1 | 35 +4 | 51 +6 | 41 +4 | 57 +6 | 47 +5 | 68 +8 |
| M10 x 1,25 | 33 +4 | 50 +5 | 40 +3 | 55 +5 | 44 +5 | 65 +7 |
| M12 | 55 +6 | 81 +9 | 65 +6 | 90 +10 | 70 +9 | 100 +14 |
| M12 x 1,25 | 58 +7 | 86 +10 | 68 +8 | 95 +12 | 78 +9 | 110 +15 |
| M12 x 1,5 | 57 +6 | 84 +9 | 65 +8 | 93 +10 | 75 +8 | 110 +12 |
| M14 | 87 +10 | 130 +15 | 105 +9 | 145 +15 | 110 +15 | 165 +20 |
| M14 x 1,5 | 93 +10 | 135 +15 | 110 +11 | 155 +15 | 120 +15 | 180 +20 |
| M16 | 130 +15 | 195 +20 | 155 +16 | 220 +20 | 175 +20 | 250 +30 |
| M16 x 1,5 | 140 +15 | 200 +25 | 160 +18 | 225 +25 | 185 +20 | 270 +30 |
| M18 | 190 +20 | 270 +30 | 215 +20 | 300 +30 | 250 +30 | 350 +40 |
| M18 x 1,5 | 210 +20 | 300 +30 | 240 +25 | 335 +35 | 280 +30 | 395 +45 |
| M20 | 270 +30 | 380 +40 | 305 +30 | 425 +45 | 350 +40 | 505 +55 |
| M20 x 1,5 | 290 +30 | 410 +50 | 330 +35 | 460 +50 | 385 +45 | 560 +60 |
| M22 | 360 +40 | 510 +60 | 405 +45 | 570 +60 | 480 +50 | 675 +75 |
| M22 x 1,5 | 390 +40 | 550 +60 | 430 +50 | 610 +70 | 520 +60 | 740 +80 |
| M24 | 460 +50 | 660 +70 | 520 +60 | 730 +80 | 600 +70 | 865 +95 |
| M24 x 2 | 490 +50 | 700 +80 | 560 +60 | 780 +90 | 660 +70 | 940 +100 |
| M27 | 670 +80 | 960 +110 | 760 +80 | 1060 +120 | 900 +100 | 1260 +140 |
| M27 x 2 | 710 +80 | 1000 +130 | 810 +90 | 1140 +120 | 960 +110 | 1350 +150 |
| M30 | 900 +100 | 1300 +150 | 1040 +110 | 1450 +160 | 1215 +135 | 1710 +190 |
| M30 x 2 | 1100 +140 | 1600 +170 | 1130 +120 | 1580 +170 | 1350 + 150 | 1910 +210 |
| M33 | 1250 +150 | 1750 +200 | 1390 +150 | 1960 +210 | 1665 +185 | 2340 +260 |
| M33 x 2 | 1300 +150 | 1900 +200 | 1510 +160 | 2120 +230 | 1800 +200 | 2520 +280 |
| M36 | 1570 +180 | 2250 +250 | 1800 +190 | 2520+280 | 2110 +240 | 2970 +330 |
| M36 x 3 | 1650 +200 | 2350 +250 | 1880 +200 | 2640+290 | 2250 +250 | 3150 +350 |
| M39 | 2100 +200 | 3000 +300 | 2310 +250 | 3240+360 | 2700 +300 | 3850 +450 |
| M39 x 3 | 2100 +250 | 3050 +350 | 2420 +260 | 3400+ 370 | 2900 +300 | 4100 +500 |

The tightening torques are designed for a torque controlled tightening with a torque spanner ,a torque setting wrench , or a precision mechanical screw driver with dynamic torque measurement .

The tolerance of the torque should not exceed plus/minus 10% .

The tightening torques are similar to DIN 25202-B .

