



## Tightening torques

Contact surface/head support made from A2 or A4 stainless steel.

Coefficient of friction for thread and head support  $\mu_{ges} = 0.23$ .

Incl. use of K1491 Hygienic USIT® sealing and shim washer (hole diameter of washer = di).

Preload force based on 80% of the 0.2% yield point of  $R_{p0.2} = 200 \text{ N/mm}^2$ .

	Coefficient of friction $\mu_{ges}$	Hole $\emptyset$ [mm]	Tensile stress cross section [mm <sup>2</sup> ]	Preload force FV [N]	Tightening torque MA [Nm]
M3	0,23	4,2	5,03	805	1,05
M4	0,23	4,2	8,78	1405	2,04
M5	0,23	5,2	14,2	2272	3,89
M6	0,23	6,2	20,1	3216	6,61
M8	0,23	8,2	36,6	5856	15,68
M10	0,23	10,2	58	9280	30,87
M12	0,23	12,2	84,3	13488	53,63
M16	0,23	16,2	157	25120	131,65