

1. TIGHTENING TORQUE FOR STAINLESS STEEL SCREWS



Please use in heated-up condition the half of the values shown!

Max. tightening torque [Nm]			
metric regular thread DIN13		metric fine thread DIN13	
M 4	2,4		
M 5	5,0		
M 6	8,5	M 8 x1	23
M 8	21	M 10 x1,25	44
M 10	41	M 12 x1,25	80
M 12	72	M 12 x1,5	76
M 14	115	M 14 x1,5	125
M 16	180	M 16 x1,5	190
M 18	245	M 18 x1,5	275
M 20	345	M 20 x1,5	385
M 22	465	M 22 x1,5	520
M 24	600	M 24 x2	650
M 27	890	M 27 x2	970
M 30	1200	M 30 x2	1350



Tighten all screws in several steps and in crosswise (alternate) pattern.
 Retighten all screws, nuts and heaterbands after heating-up.
 Always use a torque wrench!
 Lubrication (Anti-seize i.e. AS040P) is recommended on all threads.

2. ASSEMBLY ORDER FOR PATTERNED BOLT CONNECTIONS

- screw on bolts in the order shown below with 30% of required torque
- retighten bolts with 60% of required torque
- retighten bolts with 100% of required torque
- retighten bolts again with 100% of required torque and repeat procedure until all screws do not turn anymore.



**Retighten all screws, nuts and heaterbands after heating-up.
Always use a torque wrench!
Lubrication (anti-seize) is recommended on all threads.**

