

STAINLESS STEEL

BOLT SIZE	WASHER SIZE	PITCH [MM]	A4-70, Cu/C paste, $G_f=65\%$, $\mu_{th}=0,13$, $\mu_h=0,13$		A4-80, Cu/C paste, $G_f=65\%$, $\mu_{th}=0,13$, $\mu_h=0,13$	
			TORQUE [Nm]	CLAMP LOAD [kN]	TORQUE [Nm]	CLAMP LOAD [kN]
M3	NL3ss	0,5	0,8	1,5	1,1	2,0
M4	NL4ss	0,7	1,8	2,6	2,4	3,4
M5	NL5ss	0,8	3,6	4,1	4,8	5,5
M6	NL6ss	1,0	6,3	5,9	8,4	7,8
M8	NL8ss	1,25	15	11	20	14
M10	NL10ss	1,5	30	17	39	23
M12	NL12ss	1,75	51	25	68	33
M14	NL14ss	2,0	81	34	108	45
M16	NL16ss	2,0	124	46	165	61
M18	NL18ss	2,5	173	56	231	75
M20	NL20ss	2,5	243	72	323	95
M22	NL22ss	2,5	330	89	440	118
M24	NL24ss	3,0	418	103	557	137
M27	NL27ss	3,0	609	134	812	179
M30	NL30ss	3,5	831	164	1108	219
M36	NL36ss	4,0	1444	239	1925	319

Cu/C paste = Copper/graphite paste (Molykote® 1000)
 G_f = ratio of yield point. When tightening according to guidelines and with no deviation, this is the pre-stress achieved expressed as % of yield point.

μ_{th} = thread friction coefficient

μ_h = under head friction coefficient

1 N = 0,225 lb

1 Nm = 0,738 ft-lb

Thread friction coefficients have theoretical values but are verified through testing. Under head friction coefficients have been established by tests.

Torque guidelines for other bolt grades are available through your local Nord-Lock representative.

Nord-Lock stainless steel washers with stainless steel bolt, lubricated with copper/graphite paste (Molykote® 1000).

■ Torque guide (Kellermann&Klein or VDI2230):
torquelator.nord-lock.com

■ 2D / 3D CAD models:
www.nord-lock.com/cad