

Nachstehende Drehmomente sind für die Spannschrauben zulässig. Wir empfehlen keine zusätzlichen Gleitmittel wie Kupferpaste oder ähnliches für die Schrauben zu verwenden.

Following torques are allowed for screws of inserts. We recommend to use no additional gliding means (such as copper paste) for screws.

Die passenden Drehmomentschlüssel finden Sie im Kapitel Zubehör.

For torque screw drivers please see chapter additional equipment.

Typ type	Schraube Screw	M _d Nm	Schlüssel Clamping wrench	Klinge Blade
050	030.0518.T20P	5,0	T20PQ	DT20PK
208	6.16	3,0	SW3DIN911	DSW30K
210	218.3	6,5 - 7,0	SW6DIN911	DSW60K
210...09/...K9	5.32T15P	4,5 - 5,0	T15PQ	DT15PK
211	6.19	3,0	SW3DIN911	DSW30K
213	218.3	6,5 - 7,0	SW6DIN911	DSW60K
213...09	5.32T15P	4,5 - 5,0	T15PQ	DT15PK
213...IK	DIN912-M6x14	6,0	SW5DIN911	DSW50K
214	218.3	6,5 - 7,0	SW6DIN911	DSW60K
214...09	5.32T15P	4,5 - 5,0	T15PQ	DT15PK
218	218.3	6,5 - 7,0	SW6DIN911	DSW60K
218...0.03.IK - 0.05.IK 218...2.03.IK - 2.05.IK	6.23.T25P	7,0	T25PQ	DT25PK
218...09/...K9	5.32T15P	4,5 - 5,0	T15PQ	DT15PK
219	218.3	6,5 - 7,0	SW6DIN911	DSW60K
219...09	5.32.3T15P	4,5 - 5,0	T15PQ	DT15PK
221	6.20.70P	5,0	T20PQ	DT20PK
225	218.3	6,5 - 7,0	SW6DIN911	DSW60K
226	218.3	6,5 - 7,0	SW6DIN911	DSW60K
226...09	5.32T15P	4,5	T15PQ	DT15PK
226...0.03.IK - 0.05.IK 226...2.03.IK - 2.05.IK	6.23.T25P	7,0	T25PQ	DT25PK
226.2608.../3208...	4.15T15P	5,0	T15PQ	DT15PQ
228	6.20.70P	5,0	T20PQ	DT20PK/DT20PQ
230	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K
232	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K
233	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K
234	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K
235	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K
240	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K
245	51.27.984P	4,0	T15PQ	DT15PK
248	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K
250	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K
253	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K

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Typ type	Schraube Screw	M _d Nm	Schlüssel Clamping wrench	Klinge Blade
254	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K
255	5.14	2,0 - 2,5	SW2,5DIN911	DSW25K
257...05	218.3	6,5	SW6DIN911	DSW60K
257...07/...09	5.32.3T15P	5,0	T15PQ	DT15PK
309	6.25	4,0 - 4,5	SW3DIN911	DSW30K
330	5.12T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
333	5.12T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
340	6.25	4,0 - 4,5	SW3DIN911	DSW30K
356...3/...5	5.12T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
356...45.03	5F.08T20P	5,0	T20PQ	DT20PK/DT20PQ
356...6/...7/...10/...2.13 356...2.13.IK/...2.14.IK	5.15T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
357	5.12T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
360	6.25	4,0 - 4,5	SW3DIN911	DSW30K
361	030.0422.T10P	3,0	T10PL	DT10PK
368	4.15T15P	4,0	T15PQ	DT15PK
368...10.01	030.0422.T10	4,0	T10PL	DT10PK
369	6.25	4,0 - 4,5	SW3DIN911	DSW30K
390	6.25	4,0 - 4,5	SW3DIN911	DSW30K
391.1212...	030.0422.T10P	3,0	T10PL	DT10PK
391.1616...	5.32.3T15P	5,0	T15PQ	DT15PK
391.2...	6.25	4,0 - 4,5	SW3DIN911	DSW30K
974	030.3509.T15P	3,0	T15PQ	DT15PK
B105/BU105 B105KM BU105	6.075T15P	5,0	T15PQ	DT15PK
B105.A022...	030.0422.T10P	3,0	T10PL	DT10PK
B105MD	DIN913-M5x5	1,0	SW2,5DIN911	DSW25K
B108 B108KM	2.6.5T8EP	1,2	T8PL	DT8PK
B110	6.075T15P	5,0	T15PQ	DT15PK
B111	3.5.12T10EP	3,0	T10PL	DT10PK
B114	4.2T15EP	5,0	T15PQ	DT15PK
B119	5.11T15P	2,5 - 3,0	T15PL	DT15PK
B209	3.5.12T10EP	2,5	T10PQ	DT10PK
B223	5.11T15P	2,5 - 3,0	T15PL	DT15PK
B223...K2	4.09T15P	2,5 - 3,0	T15PL	DT15PK
B224.00...	5.13T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
B224.45... B224.60...	6.14T25P	7,0	T25PQ	DT25PK/DT25PQ

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TORQUE OF SCREWS



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Typ type	Schraube Screw	M _d Nm	Schlüssel Clamping wrench	Klinge Blade
BK224	5.13T20EP	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
BK229	5.13T20EP	6,0	T20PQ	DT20PK/DT20PQ
BKT	6.075T15P	5,0 - 5,5	T15PQ	DT15PK
E223	5.11T15P	2,5 - 3,0	T15PL	DT15PK
H105	6.075T15P	5,0	T15PQ	DT15PK
H100...01/...11/...21 + IK H100...02/...12/...22 + IK H100...71/...72 H100...71R/L/...72R/L	4.15T15P	5,0	T15PQ	DT15PK
H100...03/...13/...23 H100...04/...14/...24 H100...15 H100...1.23.IK	5.17T20P	6,5	T20PQ	DT20PK/DT20PQ
H100...04.IK H100...23.IK/...24.IK H100...73.IK/...74.IK	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
H100...73R/L/...74R/L	DIN912-M5x20	4,0	SW4DIN911	DSW40K
H100...83/...84	030.505P.0718	5,0	T15PQ	DT15PK
H100...83R/L/N/...84R/L/N	030.505P.0660	5,0	T15PQ	DT15PK
H100...93/...93R/L	030.0413.T15P	3,0	T15PQ	DT15PK
H100.2020.3.0.. H100.2525.3.0.. H100.3225.3.0../...38 H100.3225.4.0../...4.1.. H100...08/...10/...12	030.6075.T20P	5,0	T20PQ	DT20PK
H100.3232...	030.0625.T25P	7,0	T25PQ	DT25PK/DT25PQ?
H100.52...	5.13T20P	5,0	T20PQ	DT20PK/DT20PQ
H117...10/...12 H117.1407.../...1439... H117.1441.../...1442...	4.09T15P	4,5 - 5,0	T15PQ	DT15PK
H117.1010.10	030.400P0227	5,0	T15PQ	DT15PK
H117...16/...32/...45 H117.1419.../...1440...	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
H117...20/...26	6.17T20P	7,0	T20PQ	DT20PK/DT20PQ
H117MD	030.400P.0227	5,0	T15PQ	DT15PK
H223	5.11T15P	2,5 - 3,0	T15PL	DT15PK
H223.2608.../...3208...	4.15T15P	5,0	T15PL	DT15PK
H224	6.23T25P	6,0	T25PQ	DT25PK/DT25PQ
H224.1212.81	6.17T25P	5,0	T25PQ	DT15PK
H224.1608.02/...23/...24 H224.2608.81/...82/...83	4.15T15P	5,0	T15PQ	DT15PK
H224.2608.01/...02/...03 H224.3208.01/...02/...03	4.20T15P	4,3	T15PL	DT15PK
H224.3208.93	030.0413T15P	3,0	T15PQ	DT15PK

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Typ type	Schraube Screw	M _d Nm	Schlüssel Clamping wrench	Klinge Blade
H224..61/..62/..63/..64+IK	4.12.T15EP	5,0	T15PQ	DT15PK
H224...65/...66/...83R	5.13.T20EP	6,5	T20PQ	DT20PK/DT20PQ
H264 H264KM	3.5.12T10EP	2,5 - 3,0	T10PL	DT10PK
H274...04/...04.E	030.3509.T15P	3,0	T15PQ	DT15PK
H274...07	030.3513.T15P	3,0	T15PQ	DT15PK
H274KM	030.3509.T15P	3,0	T15PQ	DT15PK
H316	5.12T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
HC105	6.075T15P	5,0 - 5,5	T15PQ	DT15PK
HC105MD	DIN911-M4x5	1,0	SW2,0DIN911	SW20K
HC114	4.12T15EP	5,0	T15PQ	DT15PK
HC274KM	030.3509.T15P	3,0	T15PQ	DT15PK
HC316	5.12T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
KT274 KTC274	030.3509.T15P	3,0	T15PQ	DT15PK
L368	4.18T15EP	4,0	T15PQ	DT15PK
L849.0220.L...	5.12.T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
L849.0226.L...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LA210	218.3	6,5 - 7,0	SW6.911	DSW60K
LA226	218.3	6,5 - 7,0	SW6.911	DSW60K
LAK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LAK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
LIK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
LIK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
LNK368	5.10T20P	6,0	T20PQ	DT20PK/DT20PQ
LNK760	5.13T20EP	6,0	T20PQ	DT20PK/DT20PQ
N849...10/...12	4.09T15P	4,5 - 5,0	T15PQ	DT15PK
N849...16/...32	5.12T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
N849...20/...26	6.17T20P	7,0	T20PQ	DT20PK/DT20PQ
N849....K1	DIN1835-B M10x12	6,0	SW5,0DIN911	DSW50K
NH105MD	DIN911-M4x5	1,0	SW2,0DIN911	SW20K
NK100	5.13T20P	6,5	T20PQ	DT20PK/DT20PQ
NK100.0840...	4.20T15P	4,3	T15PL	DT15PK
NK100.3215...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
NK224.3215...	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
NK224.0840...	5.12T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
NK264	4.20T15P	4,3	T15PL	DT15PK
NK274	030.3509.T15P	3,0	T15PQ	DT15PK

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Typ type	Schraube Screw	M _d Nm	Schlüssel Clamping wrench	Klinge Blade
NK356	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
NK360	5.12T20P	6,0	T20PQ	DT20PK/DT20PQ
NK360.0220...	5.32.3T15P	4,5 - 5,0	T15PQ	DT15PK
NK360.0840.1.01/02/03	030.0422.T10P	3,0	T10PL	DT10PK
NK360.0840.1.04	5.32.3T15P	4,5 - 5,0	T15PQ	DT15PK
NK368	030.400P.0602	4,0	T10PL	DT10PK
R76	030.3509.T15P	5,0	T15PQ	DT15PK
R849.0220.R...	5.12.T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
R849.0226.R...	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
R849...K2	DIN913-M8x12	7,0	SW5DIN911	DSW50K
RA210	218.3	6,5 - 7,0	SW6.911	DSW60K
RA226	218.3	6,5 - 7,0	SW6.911	DSW60K
RAK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
RAK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
RBA114	4.12.T15EP	5,0	T15PQ	DT15PK/DT15PQ
RIK220	6.23T25P	7,0	T25PQ	DT25PK/DT25PQ
RHC274	030.3509.T15P	5,0	T15PQ	DT15PK
RIK224	5.13T20P	6,0	T20PQ	DT20PK/DT20PQ
SB105	6.075T15P	5,0	T15PQ	DT15PQ
SB110	6.075T15P	5,0	T15PQ	DT15PQ
SH117...08	030.3509.T15P	3,5	T15PQ	DT15PK
SH117...10/...12	4.09T15P	4,5 - 5,0	T15PQ	DT15PK
SH117...16	5.12T20P	6,0 - 6,5	T20PQ	DT20PK/DT20PQ
SHM117...08	030.3509.T15P	3,5	T15PQ	DT15PK
VDI	6.075T15P	5,0	T15PQ	DT15PK