

ANZUGSMOMENTE

TORQUE OF SCREWS



Nachstehende Drehmomente sind für die Spannschrauben zulässig. Wir empfehlen keine zusätzlichen Gleitmittel wie Kupferpaste oder ähnliches für die Schrauben zu verwenden. Die passenden Drehmomentschlüssel finden Sie im Kapitel Zubehör.

Following torques are allowed for screws of inserts. We recommend to use no additional gliding means (such as copper paste) for screws. For torque screw drivers please see chapter additional equipment.

| Typ type | Schraube Screw | M _d Nm | Schlüssel Clamping wrench | Klinge Blade |
|---------------------|-------------------|-------------------|------------------------------|-----------------|
| 380 | 5.12T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| 381.0... | 5.12T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| 382...06 | 5F.06T15P | 5,0 - 5,5 | T15PQ | DT15PK |
| 382...08 | 5F.08T20P | 5,0 - 5,5 | T20PQ | DT20PK |
| 382...10/12/14 | 5.10T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| 383...06 | 5F.06T15P | 5,0 - 5,5 | T15PQ | DT15PK |
| 383...08 | 5F.08T20P | 5,0 - 5,5 | T20PQ | DT20PK |
| 383...10/12 | 5.10T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| ABS | 5.12T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| ADR.01... | C009000 | 0,75 | T6W | DT6K |
| ADR.02/03... | C009001 | 1,5 | T8L | DT8K |
| ADR.04/05/06... | C009002 | 1,5 | T8L | DT8K |
| B105/BKT105 | 6.075T15P | 5,0 | T15PQ | DT15PK |
| B110/BKT110 | 6.075T15P | 5,0 | T15PQ | DT15PK |
| BKT356 | 5.12T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| DAH | 5.12T20P | 6,5 | T20PQ | DT20PK / DT20PQ |
| DAH.M.25.012... | 030.2547.T8P | 1,3 | T8PL | DT8PK |
| DAH.M.25... | 030.2553.T8P | 1,3 | T8PL | DT8PK |
| DAH.M.37... | 030.3070.T10P | 3,4 | T10PL | DT10PK |
| DAH.M.62... | 5.12T20P | 6,5 | T20PQ | DT20PK / DT20PQ |
| DAM31...02B | 030.2541.T8P | 1,1 | T8PL | DT8PK |
| DAM31...03A/B | 030.2547.T8P | 1,1 | T8PL | DT8PK |
| DAM31...04A/B | 030.2553.T8P | 1,1 | T8PL | DT8PK |
| DAM31...05A/B | 030.2557.T8P | 1,1 | T8PL | DT8PK |
| DAM32...A... | 030.3576.T10P | 3,5 | T10PL | DT10PK |
| DAM32...02A/B | 030.3562.T10P | 3,5 | T10PL | DT10PK |
| DAM32.025.D...03A/B | 030.3569.T10P | 3,5 | T10PL | DT10PK |
| DAM32.032.D...03A/B | 030.3576.T10P | 3,5 | T10PL | DT10PK |
| DAM32.417...03B | 030.3569.T10P | 3,5 | T10PL | DT10PK |
| DRHD | 6.075T15P | 5,0 | T15PQ | DT15PK |
| HSK | 5.12T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| L381.A060... | 5F.08T20P | 5,0 - 5,5 | T20PQ | DT20PK |
| L381.D080... | 5F.08T20P | 5,0 - 5,5 | T20PQ | DT20PK |
| L381.D086... | 5.12T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| L381.G070... | 5.10T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| L381.G080... | 5F.08T20P | 5,0 - 5,5 | T20PQ | DT20PK |
| L381.G086/090/098 | 5.12T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| L381.N090... | 5F.08T20P | 5,0 - 5,5 | T20PQ | DT20PK |

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|------------------|-------------------|-------------------|------------------------------|-----------------|
| L381.S... | 5.15T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| L381.T... | 5F.08T20P | 5,0 - 5,5 | T20PQ | DT20PK |
| L381.X090... | 5.12T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| LM275.D... | 030.357P.0315 | 2,5 - 3,0 | T10PL | DT10PK |
| M116 | 5.13T20EP | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| M117K...05 | 030.265P.0821 | 1,2 | T8PL | DT8PK |
| M117K...07 | 030.265P.0819 | 1,2 | T8PL | DT8PK |
| M117K...09 | 030.400P.0227 | 4,3 | T15PQ | DT15PK |
| M117.MD10... | 030.400P.0227 | 4,3 | T15PQ | DT15PK |
| M117U...05 | 030.265P.0818 | 1,2 | T8PL | DT8PK |
| M117U...07 | 2.6.5T8EP | 1,2 | T8PL | DT8PK |
| M117P...05 | 030.265P.0818 | 1,2 | T8PL | DT8PK |
| M117P...07 | 2.6.5T8EP | 1,2 | T8PL | DT8PK |
| M275 | 3.5.10T10P | 2,5 - 3,0 | T10PL | DT10PK |
| M306 | 2.6.5T8EP | 1,2 | T8PL | DT8PK |
| M308 | 3.5.12T10EP | 3,0 | T10PL | DT10PK |
| M310...03 | 030.0324.T7P | 1,2 | T7PL | DT7PK |
| M310...04 | 030.3535.T8P | 2,0 | T8PL | DT8PK |
| M310...05 | 030.3543.T8P | 2,0 | T8PL | DT15PK |
| M311 | 4.14T15P | 5,0 | T15PQ | DT15PK |
| M311.0016.00.B/E | 4.16T15KP | 5,0 | T15PQ | DT15PK |
| M313 | 5.14T20P | 6,5 | T20PQ | DT20PK / DT20PQ |
| M313.0016.00.B/E | 5.15T20KP | 6,5 | T20PQ | DT20PK / DT20PQ |
| M328 | 5.14T20P | 6,5 | T20PQ | DT20PK / DT20PQ |
| M328.0020.00.B/E | 5.13T20KP | 6,5 | T20PQ | DT20PK / DT20PQ |
| M328.0020.D... | 5.17T20P | 6,5 | T20PQ | DT20PK / DT20PQ |
| M332 | 5.17T20P | 6,5 | T20PQ | DT20PK / DT20PQ |
| M335 | 6.17T25P | 12,0 | T25PQ | DT20PQ |
| M409 | 030.3511.T10P | 3,0 | T10PL | DT10PK |
| MDR.01... | C009000 | 0,75 | T6W | DT6K |
| MDR.02/03... | C009001 | 1,5 | T8L | DT8K |
| MDR.04/05/06... | C009002 | 1,5 | T8L | DT8K |
| MDR.08/09/10... | C009004 | 3,5 | T15Q | DT15K |
| R381.T... | 5F.08T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| R381.X090... | 5.12T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| R381.X073... | 5F.08T20P | 6,0 - 6,5 | T20PQ | DT20PK / DT20PQ |
| RM275.D... | 030.357P.0315 | 2,5 - 3,0 | T10PL | DT10PK |
| RM275.T... | 3.510.T10P | 2,5 - 3,0 | T10PL | DT10PK |
| SM328 | 5.17T20P | 6,5 | T20PQ | DT20PK / DT20PQ |
| Z313...057 | 5.26T20P | 6,5 | T20PQ | DT20PK / DT20PQ |
| Z313...082 | 5.28T20P | 6,5 | T20PQ | DT20PK / DT20PQ |
| Z313...107 | 5.30T20P | 6,5 | T20PQ | DT20PK / DT20PQ |

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