Tolerance for welded constructions According to DIN 8570, Pt.1+3/B+F,10.87

Welding (W P S) according to DIN-EN 288 - 2

All unmarked welds to be fillet continuous a=4mm thick, not greater than 0.7 d of the thinner element

The material for cap plates >20 mm thick to be examined for laminations

Required torques,prestressing forces and forced tension angles according to DIN 18800 Pt. 7, 05.83

	1	2	3	4	5	6				
	Bolts	Required compressing force Fv	Prestressing of HV bolts (Class 10.9) according to a) Torque techniques – Manual torque wrench – Required grip rotary moment – Lubricated MoS2 1)	Slightly oiled	b) Impulse technique – Mechanical impact wrench – Req. compressing force Fv 2)	c) Angle of rotation techniques – Required tightening torque Mv 2)	Grip length lk		Angle of rotation pH	Rot. measure U
		kN	Nm	Nm	kN	Nm	mm			
1	M12	50	100	120	60	10	M12 to M22	lk < 50	180	1/2
2	M16	100	250	350	110	50		51 < lk < 100	240	2/3
3	M20	160	450	600	175			101 < lk < 170	270	3/4
4	M22	190	650	900	210	100		171 < lk < 240	360	1
5	M24	220	800	1100	240		M24 to M36	lk < 50	180	1/2
6	M27	290	1250	1650	320	200		51 < lk < 100	240	2/3
7	M30	350	1650	2200	390			101 < lk < 240	270	3/4
8	M36	510	2800	3800	560					

1) Due to the great dependence of the Mv value on the type of thread lubricant adhere to the bolt manufacturer's recommendations.
2) Independently on the lubricant of the threads and surfaces of bolts and nuts.
CAUTION! For hot galvanized HV bolts use values from column 3.

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	DATE	NAME	SIGNATURE
Designed by	12.06.2007	M.Mucha	
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1:10 SCALE

Simple parts 1131-1213

DESC.
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