

Material	Tightening torque MA [Nm]								Preload force FV [N]
	M10	M12	M16	M20	M24	M27	1 1/4-8UN	M33	
C35E - 1.1181	20								3.200
X6CrNiMoTi17-22-2 - 1.4571; ASME SA-193 Gr. B8M, cl. 1	10								2.400
		18							6.000
			100						14.100
				200					24.000
					270				38.000
						380			52.300
42CrMo4 - 1.7225; ASME SA-193 Gr. B7 + B16		52							12.780
			100						35.400
				320					57.900
					400				70.600
						650			114.000
							850		101.000
								1.300	156.000
25CrMo4 - 1.7218			100						26.400
				160					42.000
					320				63.000
						400			81.000

\* lubricants Molykote/OKS280

The tightening torques, specified in the table for the prestressing forces, are mean values for oiled thread surfaces which are determined by experiments. It should be noted that by repeated tightening and other lubricants or surface treated threads, the tightening torques can be change. (Deviations of + / - 10% are possible).

On request, the torques are determined by experiments in our laboratory as a function of the biasing force (resulting from the kind and size of the seal) and the lubricant used by the pressure equipment manufacturer.