

HV sets assembly guide according to k-class K1 requirements EN 1090-2 or DASt - Richtlinie 024/DIN EN 1993-1-8/NA

Combined assembly method according to EN 1090-2							
FIRST STEP OF ASSEMBLY							
	M12	M16	M20	M22	M24	M27	M30
Nm	70	170	320	440	560	820	1100
SECOND STEP OF ASSEMBLY	Nominal length (L) in mm of HV bolts						
Additional rotation angle in [°]	M12	M16	M20	M22	M24	M27	M30
60°	L ≤ 35	L ≤ 45	L ≤ 60	L ≤ 65	L ≤ 70	L ≤ 80	L ≤ 105
*90°	<i>L=40mm for Σt = 24-26 mm</i>	<i>L=50mm for Σt = 32 mm</i>	<i>L=65 mm for Σt = 40-43 mm</i>	<i>L=70 mm for Σt = 44-47 mm</i>	<i>L=75 mm for Σt = 48-49 mm</i>	<i>L= 85mm for Σt = 54-56 mm</i>	<i>L=95mm for Σt = 60-64 mm</i>
90°	L 45...85	L 55...110	L 70...140	L 75...150	L 80...165	L 100...190	L 100...210
120°	L ≥ 90	L ≥ 120	L ≥ 150	L ≥ 160	L ≥ 170	L ≥ 200	L ≥ 220

** For lengths with Σt in the specified range, a tightening angle of 90 degrees is recommended
Σt - clamping length range [mm]*

Modified method of controlled torque according to DASt - Richtlinie 024/DIN EN 1993-1-8/NA							
FIRST STEP OF ASSEMBLY							
	M12	M16	M20	M22	M24	M27	M30
Nm	75	190	340	490	600	940	1240
SECOND STEP OF ASSEMBLY							
	M12	M16	M20	M22	M24	M27	M30
Nm	100	250	450	650	800	1250	1650

* L = Length

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