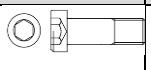
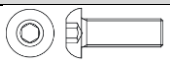
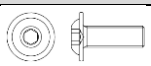
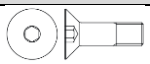
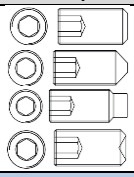
Tightening torque for fasteners with reduced loadability fasteners

Some screws are because of their head geometry and/or drive form subject to a reduced loadability according to ISO 898-1. Therefore reduced torque values are to be taken into account. Torque values are based on VDI 2230-2015.
The given tightening torques cannot always be applied reliably depending on the choice of the inner drive – conical bits in particular may be helpful.

Values for reduced tightening torques M_A [Nm]

	DIN 7984	ISO 7380-1 PGB-ULS	ISO 7380-2 PGB-ULF	DIN 7991 ISO 10642		DIN 913 / ISO 4026 DIN 914 / ISO 4027 DIN 915 / ISO 4028 DIN 916 / ISO 4029
						
Carbon steel	**08.8**	**010.9**	**010.9**	**08.8**	**010.9**	**45H**
M 2	-	0,27	-	-	-	-
M 2,5	-	0,6	-	0,5	0,55	-
M 3	0,9	0,95	1	0,9	0,95	0,5
M 4	2,1	2,3	2,5	2,0	2,3	1,5
M 5	4,0	4,6	5,0	4,0	4,6	3,0
M 6	7,2	8,0	8,0	7,2	7,9	5,0
M 8	17,3	19	20	17	19	12
M 10	34,4	38	40	35	38	24
M 12	58	65	66	58	65	40
M 14	-	-	-	93	100	60
M 16	144	-	-	144	158	100
M 18	-	-	-		220	120
M 20	290	-	-		310	180
M 22	-	-	-		420	210
M 24	500	-	-		530	310
Stainless steel	**A2**	**A2**	**A2**	**A2/A4**		
M 2	-	0,19	-	-		-
M 2,5	-	0,37	-	0,23		-
M 3	0,6	0,64	0,64	0,4		0,2
M 4	1,3	1,5	1,5	0,9		0,7
M 5	2,6	3,0	3,0	1,8		1,5
M 6	4,5	5,0	5,0	3,1		2,5
M 8	10	12	12	7,6		6,0
M 10	21	24		15		12
M 12	36	40		25		20
M 14	-			40		30
M 16	90			63		50
M 18	-			82		90
M 20	180			120		105
M 22	-			160		150
M 24	310			200		-