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Material	Tightening torque MA [Nm]									Preload force FV [N]
	M10	M12	M16	M20	M24	M27	M30 (out of 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
							700			117.800
								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.