Anzugsmomente (tightening torque)

IsoSeal GGR / IsoSeal D200 / IsoSeal D200 PTFE Kompakt / IsoSeal D300 PTFE Kompakt

Calculated with coefficient of friction μ=0.14
Friction surfaces lightly oiled during installation - between screw, nut and steel washer

	5.6 Ck35	**8.8**	**A2-70** μG = 0,2	**42CrMo4+QT**	**25CrMo4+QT**
M12	40	85	60	85	80
M16	100	210	145	210	200
M20	200	420	280	420	400
M22	280	570	380	570	540
M24	360	720	480	720	700
M27	530	1.050	(720)	1050	1.000
M30	710	1.450	(960)	1450	1.400
M33	950	2.000	*always lubricated, Paarung A2 / A4 Possibly preliminary examination up to max. 8xd*	2000	1.600
M36	1.200	2.500		2500	2.100
M39	1.500	3.300		3300	*For screws with Rp0,2 ≥ 550 Nm/mm2*
M42	1.900	4.000		4000	

ASME / ASTM	**A193 B7**
1/2 -13 UNC	80
5/8 -11 UNC	160
3/4 -10 UNC	320
7/8 -9 UNC	480
1 -8 UNC	750
1 1/8 -7 UNC	1.050
1 1/4 -7 UNC	1.450
1 3/8 -6 UNC	1.900
1 1/2 -6 UNC	2.500

All numbers in Newton metres (Nm)

Usage Instructions for this Table

- applicable for insulating gaskets and insulating screws make GfD Paulmann GmbH
- Applicable for pressure ratings up to PN40 (EN1092-1)
- Applicable for pressure ratings up to Class600 (ASME B16.5)
- in case of deviating conditions, they receive an explicit flange-bolt force calculation
- Tightening the screws in at least 3 passes (30% / 70% / 100%)
- For further instructions, see installation instructions for the insulating gasket

As of: January 2025