07.1991 Schrau

Schrauben aus Stahl mit klemmender Berschichtung Technische Lieferbedingungen 267 Totl 28

Anwendungsbereich

Die in dieser Norm festgelegten technischen Lieferbedingungen gehen für Schrauben aus Stahl mit.

- metrischem ISO-Gewinde nach ISO 281 : 1973,
- Gewinde-Nenndurchmesser von 3 bis 36 mm.
- Festigkeitsklassen nach DIN ISO 896 Te i 1 1*) und
- Einsatztemperaturbereich 50°C bis + 90°C.

die mit einer klentmenden Beschichtung auf dem Gewinde versehen sind.

Die Norm gilt nicht für Beschichtungen, bei deren Aufbringung eine zusätzliche spanende Bearbeitung der Schraube erforderlich ist.

2 Begriffe

4

Die unter Abschnitt 2 festgelegten Definitionen gelten nur für Schrauben mit Kemmender Beschichtung.

2.1 Klemmende Beschlichtung

Eine klemmende Beschichtung (KL) im Sinne dieser Normbesteht aus einem auf das Gewinde der Schraube aufgebrachten Kunststoff, der beim Einschrauben eine Werstrawerkung hervorruft.

Klemmende Beschichtungen können als Rundumbeschichtung, streiferförmige Beschichtung oder Reckbeschichtung ausgeführt sein. Sie können des Losdreihen der Verbindung nicht aufhalten, verhindem jedoch ein vollständiges Lösen.

2.2 Einschraubdrehmoment Mr.,

Das Einschraubdrehmoment ist des beim Einschrauben einer Schraube in eine Prüfmutter gemessene Drehmoment.

2.3 Anziehdrehmoment M.

Das Anziehdrehmoment ist das zur Erzeugung der Vorspannkraft erforderliche Drehmoment.

2.4 Losdrehmoment ML

Das Losdrehmoment ist das bei der ensten Relativbewegung zwischen Prüfmutter und Sichraube bei einervorgespannten klemmenden. Sichrauberverbindung gemessene Drehmoment.

2.5 Ausschraubdrehmoment Man

Das Ausschräubdrehmerment ist das Drehmoment, das beim Ausschräuben einer mit einer klemmenden Beschlichtung versichenen Schraube nach dem Loadrehen gemessen wird.

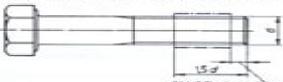
3 Maße, Bezeichnung

3.1 Beechichtung im Regelfall

Falls nichts anderes angegeben wird, muß die Beschichtung in einem Bereich mit der Länge

gemessen vom Schraubenende, liegen.

Die ersten 2 bis 3 Gewindeglinge sollten weitgehend trei von Kunststoff sein, um das Einschrauben zu erleichtern.



2 bis 3 Devindegunge wertgehend frei von Beschichtung

d = Gewinde-Nenndurchmesser der Schraube

P - Gewindesteigung

Bild 1. Länge und Lage der Beschichtung im Regelfall.

3.2 Beschichtungen mit besonderer Länge und/oder Lage

Ist aus konstruktiven Gründen eine andere Länge j, undroder Lage a der Beschichtung (siene Bild 2) erforderich, so sind beide Maße entsprechend Abschnitt 3.3 in der Normbackonnung anzugeben. Für die Maße j, und a geben die Tolerangen



L - Länge der Beschichtung

Lage der Beschichtung gemessen vom Schraubenende

P - Gewindesteigung

Bild 2. Beschichtungen mit besonderer Länge und Lage

*) statt DIN ISO 898 Teil 1 gilt N 13 020

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