

Mercedes-Benz AG

Werkzeugzeug
07.1991**Mechanische Verbindungselemente**Schrauben aus Stahl mit klemmender Beschichtung
Technische Lieferbedingungen**DIN****267**
Teil 28**1 Anwendungsbereich**

Die in dieser Norm festgelegten technischen Lieferbedingungen gelten für Schrauben aus Stahl mit:

- metrischem ISO-Gewinde nach ISO 261 : 1973,
 - Gewinde-Nenndurchmesser von 3 bis 16 mm,
 - Festigkeitsklassen nach DIN ISO 898 Teil 1 (*) und
 - Einsatztemperaturbereich - 50 °C bis + 90 °C,
- die mit einer klemmenden 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

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

2.1 Klemmende Beschichtung

Eine klemmende Beschichtung (KL) im Sinne dieser Norm besteht aus einem auf das Gewinde der Schraube aufgetragenen Kunststoff, der beim Einschrauben eine Klemmwirkung hervorruft.

Klemmende Beschichtungen können als Rundumbeschichtung, streifenförmige Beschichtung oder Fleckbeschichtung ausgeführt sein. Sie können das Lockdrehen der Verbindung nicht aufhalten, verhindern jedoch ein vollständiges Lösen.

2.2 Einschraubdrehmoment $M_{E\ldots}$

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

2.3 Anziehdrehmoment M_A

Das Anziehdrehmoment ist das zur Erzeugung der Vorspannkraft erforderliche Drehmoment.

2.4 Lockdrehmoment M_L

Das Lockdrehmoment ist das bei der ersten Relativbewegung zwischen Prüfmutter und Schraube bei einer vorgespannten klemmenden Schraubenverbindung gemessene Drehmoment.

2.5 Ausschraubdrehmoment $M_{A\ldots}$

Das Ausschraubdrehmoment ist das Drehmoment, das beim Ausschrauben einer mit einer klemmenden Beschichtung versehenen Schraube nach dem Lockdrehen gemessen wird.

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

3 Maße, Bezeichnung**3.1 Beschichtung im Regelfall**

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

$$1,5 d \pm 2 P \text{ für } P < 1$$

$$\text{und } 1,5 d \pm P \text{ für } P \geq 1,$$

gemessen vom Schraubenende, liegen.

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



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 l_b und/oder Lage a der Beschichtung (siehe Bild 2) erforderlich, so sind beide Maße entsprechend Abschnitt 3.3 in der Normbezeichnung anzugeben. Für die Maße l_b und a gelten die Toleranzen

$$\pm 2 P \text{ für } P < 1$$

$$\pm P \text{ für } P \geq 1.$$



l_b = Länge der Beschichtung

a = Lage der Beschichtung gemessen vom Schraubenende

P = Gewindesteigung

Bild 2. Beschichtungen mit besonderer Länge und Lage

Fortsetzung Seite 2 und 3

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SJ Ball



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