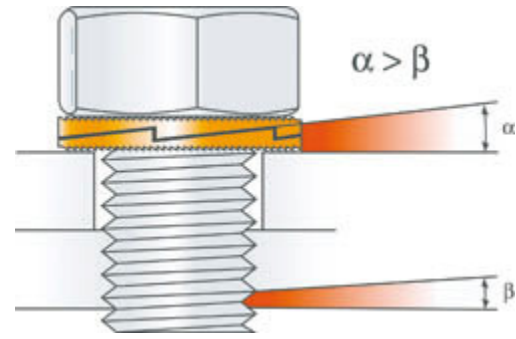


**Assembly instructions and
Torque guidelines**



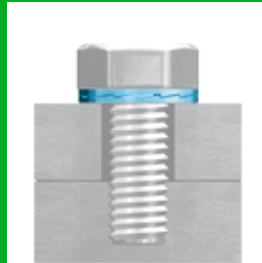
GLOBAL SUPPLIER



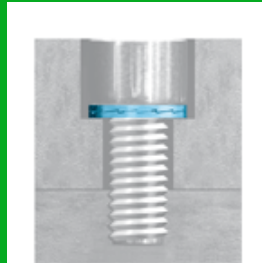
Tension makes the bolt self-locking

The key is the difference in angles. Since the cam angle " α " is larger than the thread pitch " β ", the pair of washers expand more than the corresponding pitch of the thread. NORD-LOCK washers positively lock the fastener in a joint which is subjected to extreme vibration or dynamic loads.

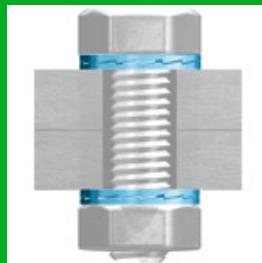
**NORD-LOCK for
tapped holes.**



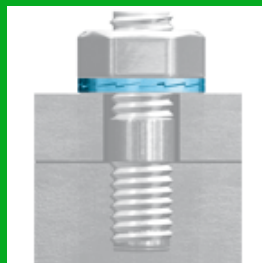
**NORD-LOCK are sized
for counter-bores.**



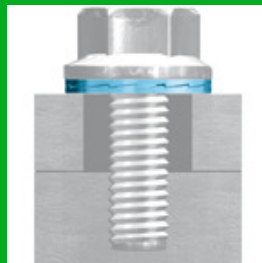
**Through holes require
two pairs of NORD-LOCK. To
keep the bolt secured when
tightening the nut.**



**For stud bolts
NORD-LOCK washers
lock the nut, and
eliminate the need
for adhesives.**



**Use a flanged
nut/bolt together
with NORD-LOCK "sp"
washers for slotted
holes or on soft material.**



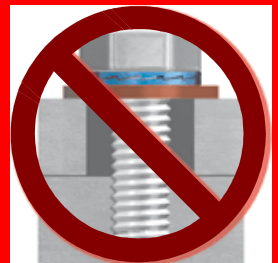
**Please note that
NORD-LOCK should be
used as a pair. Never
use a single washer to
keep the bolt secured.**



**Please note that through
holes require
two pairs of NORD-LOCK. To
keep the bolt secured when
tightening the nut.**



**Please note that
NORD-LOCK cannot be
used on washers that
are not captivated
in place.**





Torque guideline									
Bolt grade	8.8			10.9		12.9		A4-70	A4-80
Lubricant	Oil	Grease	Dry	Oil	Grease	Oil	Grease	Grease	Grease
Bolt size	Torque Nm	Torque Nm	Torque Nm	Torque Nm	Torque Nm	Torque Nm	Torque Nm	Torque Nm	Torque Nm
M3	1.3	1.2	1.3	1.8	1.6	2.0	1.7	0.9	1.2
M4	3.1	2.8	3.1	4.1	3.6	4.6	4.0	2.0	2.7
M5	6.0	5.4	6.0	8.1	7.0	9.1	7.7	3.9	5.3
M6	10.5	9.5	10.5	14.1	12.3	15.8	13.5	6.9	9.2
M8	25	23	25	34	30	38	32	17	22
M10	49	45	50	67	58	75	64	33	43
M12	85	77	85	115	99	128	109	56	75
M14	135	122	136	183	158	204	174	89	119
M16	205	185	208	279	240	311	263	136	181
M18	288	260	291	391	337	437	370	191	254
M20	402	363	408	547	470	610	515	267	356
M22	548	494	557	745	639	831	699	364	485
M24	693	625	703	942	809	1052	887	460	613
M27	1010	910	1028	1375	1176	1533	1288	671	895
M30	1379	1243	1401	1875	1608	2091	1761	915	1220
M33	1855	1669	1889	2526	2157	2815	2362	1233	1644
M36	2394	2156	2436	3259	2788	3633	3053	1591	2121
M39	3087	2777	3145	4203	3588	4683	3925	2053	2737
M42	3820	3439	3890	5202	4445	5799	4866	2540	3386

This is an advice torque guideline for standard NORD-LOCK applications. For more information go to www.nord-lock.com

NORD-LOCK recommends the use of a good lubricant(e.g. GTP600 or Molykote®1000) in order to reduce friction, minimize preload deviation and protect against corrosion.