

# Fasteners Steel screws, bolts and studs with locking coating Technical delivery conditions

**DIN**  
**267**  
Part 2B

Mechanische Verbindungselemente; Schrauben aus Stahl mit klammender Beschichtung; technische Lieferbedingungen

In keeping with current practice in standards published by the International Organization for Standardization (ISO), a comma has been used throughout as the decimal marker.

## 1 Scope and field of application

This standard specifies technical delivery conditions for M3 to M16 steel screws, bolts and studs ("bolts", for short) provided with a locking coating with ISO metric screw thread as specified in ISO 261, assigned to property classes as specified in ISO 898 Part 1, and designed for service temperatures from  $-50^{\circ}\text{C}$  to  $90^{\circ}\text{C}$ .

It does not cover bolts with coating the application of which requires additional machining.

## 2 Concepts

For the purposes of this standard the following definitions apply.

### 2.1 Locking coating

Locking coating is a plastic coating applied on the thread of bolts which, when the latter are tightened, is designed to prevent disengagement of the bolts and to prevent the threads coated or the coating applied in the form of rings or spots. Such coatings do not prevent the bolts working loose, but do prevent complete disengagement.

### 2.2 Screw-in torque

The screw-in torque,  $M_{si}$ , is the torque measured when a bolt is screwed into a test nut.

### 2.3 Tightening torque

The tightening torque,  $M_t$ , is the torque required to tighten a bolt to a level of stress as given in table 1.

### 2.4 Breakaway torque

The breakaway torque,  $M_{br}$ , is the torque measured at the moment when the relative motion between test nut and bolt is detected in both stressed and unstressed assemblies.

### 2.5 Loosening torque

The loosening torque,  $M_{lo}$ , is the torque measured after the breakaway point when unscrewing bolts with a locking coating.

## 3 Dimensions and designation

### 3.1 Standard coating

Unless otherwise specified, the coating shall cover a zone, measured from the bolt end, of length equal to  $1,5d \pm 2\text{ P}$  for  $P$  smaller, and  $1,5d \pm 2\text{ P}$  for  $P$  equal to or greater than 1. The first two or three turns of thread should be free from coating required to facilitate bolting.



$d$  = nominal bolt thread diameter

$P$  = pitch

Figure 1. Length and position of coated zone on bolts with standard coating.

### 3.2 Non-standard coating

For design reasons, a different length,  $l_c$ , or distance from the bolt end,  $a$ , of the coated zone is required (see figure 2). Both dimensions shall be indicated in the standard designation (cf. subclause 2.2), both dimensions being subject to a tolerance equal to  $\pm 0,2\text{ P}$  for  $P$  smaller than 1, and to  $\pm 0,5\text{ P}$  for  $P$  equal to or greater than 1.



$l_c$  = length of coated zone

$a$  = distance of coated zone from bolt end

$P$  = pitch

Figure 2. Length and position of coated zone on bolts with nonstandard coating.

Continued on pages 2 and 3

In part of the typical representation which is not a part of the standard, the dimensions are given in millimetres.

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**Julia Schneider**



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