

Mechanische Verbindungselemente

Technische Lieferbedingungen

Feuerverzinkte Teile

DIN
267
 Teil 10

Fasteners; technical specifications, hot dip galvanized parts
 Éléments de fixation; spécifications techniques, pièces galvanisées à chaud

Ersatz für Ausgabe 03.77

Maße in mm

1 Anwendungsbereich

Diese Technischen Lieferbedingungen gelten für mechanische Verbindungselemente (im wesentlichen Schrauben und Muttern) mit Regelgewinde M 6 bis M 36 und mit Zinküberzügen durch Feuerverzinken sowie mit Festigkeitsklassen bis einschließl. 10.9 für Schrauben bzw. 10 für Muttern. Die in dieser Norm festgelegten Mindestschichtdicken gelten auch für feuerverzinkte mitverspannte Elemente (Scheiben und Ringe).

2 Allgemeines

Bei mechanischen Verbindungselementen mit Zinküberzügen durch Feuerverzinken gilt im allgemeinen als Hauptmerkmal die Schichtdicke des Zinküberzuges und nicht dessen Flächengewicht. Diese Norm legt daher vornehmlich die Schichtdicken, deren Bezeichnung und Prüfung fest. Soll im Einzelfall das Flächengewicht zugrunde gelegt werden, so gilt: $100 \mu\text{m}$ Schichtdicke $\approx 700 \text{ g/m}^2$ Flächengewicht.

Die Grundabmaße des Bolzengewindes mit ISO-metrischem Profil und der Toleranz 6g sind für das Aufbringen der in Abschnitt 4 festgelegten Mindestschichtdicken nicht ausreißend. Um zu erreichen, daß die Gewindepaarung Schraube/Mutter nach dem Feuerverzinken funktionstüchtig ist, gibt es zwei Möglichkeiten:

- a) Das ISO-metrische Bolzengewinde muß die Toleranzfeldlage a nach DIN 13 Teil 15 und somit die Grundabmaße nach Tabelle 1 haben und vor dem Feuerverzinken innerhalb der Toleranzklasse 6 (Produktklasse C) bzw. der Toleranzklasse 6 (Produktklasse A) liegen. Durch den Überzug darf die Nulllinie des Bolzengewindes nicht überschritten werden.
- b) Das für das Aufbringen des Zinküberzuges erforderliche Abmaß wird in die Mutter gelegt, so daß das Bolzengewinde nach dem Verzinken die Nulllinie überschreiten darf. Dieses Vorgehen ist möglich, wenn Schraube und Mutter zusammen, d. h. als Garnitur, geliefert werden.

Das Bolzengewinde darf nach dem Feuerverzinken nicht nachgeschliffen werden. Die Mindestmaße des feuerverzinkten Gewindes ergeben sich aus den Mindestmaßen vor dem Feuerverzinken plus der Mindestschichtdicke (siehe Tabelle 1).

Muttergewinde werden nicht feuerverzinkt, sondern nachträglich in den feuerverzinkten Rohling eingeschliffen.

Die Grenzabmaße nach DIN ISO 4759 Teil 1 gelten vor dem Feuerverzinken. Durch das Feuerverzinken darf die Montierbarkeit der Teile nicht beeinträchtigt werden.

Graues Aussehen von Zinküberzügen ist werkstoffbedingt und nicht Qualitätsmerkmal des Korrosionsschutzes.

Anforderungen an Zinküberzüge auf Gegenständen aus Eisenwerkstoffen, die als Fertigteile feuerverzinkt werden, siehe DIN 50 976.

Für die Beurteilung der mechanischen Eigenschaften gelten DIN ISO 898 Teil 1 und Teil 2 bzw. DIN 267 Teil 4. Abweichend dazu sind jedoch wegen des relativ großen Gewinde-Grundabmaßes (Toleranzfeldlage a) bzw. der verminderten Flankenüberdeckung von Bolzen- und Muttergewinde die Mindestbruch- und Prüfkraften kleiner (siehe Tabellen 3 und 4).

3 Bezeichnung

Feuerverzinkte Verbindungselemente sind nach den jeweiligen Maßnormen zu bezeichnen. Für die Feuerverzinkung gilt das Kurzzeichen t2n nach DIN 50 976. Durch dieses Kurzzeichen wird gleichzeitig die Schichtdicke entsprechend Tabelle 1 erfaßt (Mindestschichtdicke an der Meßstelle).

Bezeichnungsbeispiel:

Bezeichnung einer Sechskantschraube DIN 601 - M 12 $\times$ 50 der Festigkeitsklasse 4.6 mit Zinküberzug durch Feuerverzinken (t2n):

Sechskantschraube
 DIN 601 - M 12 $\times$ 50 - 4.6 - t2n

4 Gewinde-Grundabmaße und Schichtdicken sowie Gewinde-Grenzmaße für Schrauben

Die Tabelle 1 enthält die Grundabmaße nach Toleranzfeldlage a für Bolzengewinde und die Mindestschichtdicken an der Meßstelle (siehe Abschnitt 7.2.1).

In Tabelle 2 sind die Gewinde-Grenzmaße vor dem Feuerverzinken aufgeführt.

Tabelle 1. Grundabmaße im Bolzengewinde und Mindestschichtdicke

Regelgewinde	Gewindesteigung <i>P</i>	Grundabmaß <i>A₀</i> μm	Mindestschichtdicke an der Meßstelle μm
M 6	1	- 290	40
M 8	1,25	- 295	40
M 10	1,5	- 300	40
M 12	1,75	- 310	40
M 14; M 16	2	- 315	40
M 18; M 20; M 22	2,5	- 325	40
M 24; M 27	3	- 335	40
M 30; M 33	3,5	- 345	40
M 36	4	- 355	40

Fortsetzung Seite 2 bis 5

Normenausschuß Mechanische Verbindungselemente (PMV) im DIN Deutsches Institut für Normung e. V.

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Table of Contents Din 267 Pdf Amboh Hol

1. Understanding the eBook Din 267 Pdf Amboh Hol
 - The Rise of Digital Reading Din 267 Pdf Amboh Hol
 - Advantages of eBooks Over Traditional Books
2. Identifying Din 267 Pdf Amboh Hol
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Din 267 Pdf Amboh Hol
 - User-Friendly Interface
4. Exploring eBook Recommendations from Din 267 Pdf Amboh Hol
 - Personalized Recommendations
 - Din 267 Pdf Amboh Hol User Reviews and Ratings
 - Din 267 Pdf Amboh Hol and Bestseller Lists

5. Accessing Din 267 Pdf Amboh Hol Free and Paid eBooks
 - Din 267 Pdf Amboh Hol Public Domain eBooks
 - Din 267 Pdf Amboh Hol eBook Subscription Services
 - Din 267 Pdf Amboh Hol Budget-Friendly Options
6. Navigating Din 267 Pdf Amboh Hol eBook Formats
 - ePub, PDF, MOBI, and More
 - Din 267 Pdf Amboh Hol Compatibility with Devices
 - Din 267 Pdf Amboh Hol Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Din 267 Pdf Amboh Hol
 - Highlighting and Note-Taking Din 267 Pdf Amboh Hol
 - Interactive Elements Din 267 Pdf Amboh Hol
8. Staying Engaged with Din 267 Pdf Amboh Hol
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Din 267 Pdf Amboh Hol
9. Balancing eBooks and Physical Books Din 267 Pdf Amboh Hol
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Din 267 Pdf Amboh Hol
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Din 267 Pdf Amboh Hol
 - Setting Reading Goals Din 267 Pdf Amboh Hol
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Din 267 Pdf Amboh Hol
 - Fact-Checking eBook Content of Din 267 Pdf Amboh Hol
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning

- Utilizing eBooks for Skill Development
- Exploring Educational eBooks

14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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