

# 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 12n 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 (12n):

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

## 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<br>$P$ | Grundabmaß<br>$A_0$<br>$\mu\text{m}$ | Mindestschichtdicke an der Meßstelle<br>$\mu\text{m}$ |
|------------------|------------------------|--------------------------------------|-------------------------------------------------------|
| 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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