HEICO-LOCK

RECOMENDACIONES PAR DE APRIETE 1/4

HEICO-LOCK	**Recubrimiento de laminas de cinc**
BOLT	**8.8 (cincado electrolítico)**

			LUBRICADO GF=0,75 | µG=0,10 | µK=0,16		SECO GF=0,62 | µG=0,15 | µK=0,18	
TAMAÑO TORNILLO	**HEICO N° ART.**	**PASO DEL FILETE [MM]**	**APRIETE [NM]**	**PRECARGA [KN]**	**APRIETE [NM]**	**PRECARGA [KN]**
M3	HLS-3	0,50	1,3	2,4	1,3	2,0
M4	HLS-4	0,70	3,1	4,2	3,1	3,5
M5	HLS-5	0,80	6,0	6,8	6,0	5,6
M6	HLS-6	1,00	10,5	9,7	10,5	8,0
M8	HLS-8	1,25	25,0	18,0	25,0	15,0
M10	HLS-10	1,50	49,0	28,0	50,0	23,0
M12	HLS-12	1,75	85,0	40,0	85,0	33,0
M14	HLS-14	2,00	135,0	55,0	136,0	46,0
M16	HLS-16	2,00	205,0	75,0	208,0	62,0
M18	HLS-18	2,50	266,0	92,0	291,0	76,0
M20	HLS-20	2,50	402,0	118,0	408,0	97,0
M22	HLS-22	2,50	548,0	146,0	557,0	120,0
M24	HLS-24	3,00	693,0	169,0	703,0	140,0
M27	HLS-27	3,00	1.010,0	221,0	1.028,0	182,0
M30	HLS-30	3,50	1.379,0	269,0	1.401,0	222,0
M33	HLS-33	3,50	1.855,0	333,0	1.889,0	275,0
M36	HLS-36	4,00	2.394,0	392,0	2.436,0	324,0
M39	HLS-39	4,00	3.087,0	468,0	3.145,0	387,0
M42	HLS-42	4,50	3.820,0	538,0	3.890,0	445,0

GF = Grado de pretensado (Aprovechamiento de limite elástico [%])
µG = Coeficiente de rozamiento de la rosca
µK = Coeficiente de rozamiento HEICO-LOCK

HEICO-LOCK

RECOMENDACIONES PAR DE APRIETE 2/4

HEICO-LOCK	**Recubrimiento de laminas de cinc**
BOLT	**10.9 (sin recubrimiento)**

			LUBRICADO GF=0,75 | µG=0,10 | µK=0,16	
TAMAÑO TORNILLO	**HEICO N° ART.**	**PASO DEL FILETE [MM]**	**APRIETE [NM]**	**PRECARGA [KN]**
M3	HLS-3	0,50	1,8	3,2
M4	HLS-4	0,70	4,1	5,6
M5	HLS-5	0,80	8,1	9,1
M6	HLS-6	1,00	14,1	12,9
M8	HLS-8	1,25	34,0	23,0
M10	HLS-10	1,50	67,0	37,0
M12	HLS-12	1,75	115,0	54,0
M14	HLS-14	2,00	183,0	74,0
M16	HLS-16	2,00	279,0	100,0
M18	HLS-18	2,50	391,0	123,0
M20	HLS-20	2,50	547,0	156,0
M22	HLS-22	2,50	745,0	194,0
M24	HLS-24	3,00	942,0	225,0
M27	HLS-27	3,00	1.375,0	294,0
M30	HLS-30	3,50	1.875,0	358,0
M33	HLS-33	3,50	2.526,0	443,0
M36	HLS-36	4,00	3.259,0	522,0
M39	HLS-39	4,00	4.203,0	624,0
M42	HLS-42	4,50	5.202,0	716,0

GF = Grado de pretensado (Aprovechamiento de limite elástico [%])
µG = Coeficiente de rozamiento de la rosca
µK = Coeficiente de rozamiento HEICO-LOCK

HEICO-LOCK

RECOMENDACIONES PAR DE APRIETE 3/4

HEICO-LOCK	**Recubrimiento de laminas de cinc**
BOLT	**12.9 (sin recubrimiento)**

			LUBRICADO GF=0,75 | µG=0,10 | µK=0,16	
TAMAÑO TORNILLO	**HEICO N° ART.**	**PASO DEL FILETE [MM]**	**APRIETE [NM]**	**PRECARGA [KN]**
M3	HLS-3	0,50	2,0	3,9
M4	HLS-4	0,70	4,6	6,7
M5	HLS-5	0,80	9,1	10,9
M6	HLS-6	1,00	15,8	15,4
M8	HLS-8	1,25	38,0	28,0
M10	HLS-10	1,50	75,0	44,0
M12	HLS-12	1,75	128,0	65,0
M14	HLS-14	2,00	204,0	89,0
M16	HLS-16	2,00	311,0	120,0
M18	HLS-18	2,50	437,0	148,0
M20	HLS-20	2,50	610,0	188,0
M22	HLS-22	2,50	831,0	233,0
M24	HLS-24	3,00	1.052,0	270,0
M27	HLS-27	3,00	1.533,0	352,0
M30	HLS-30	3,50	2.091,0	430,0
M33	HLS-33	3,50	2.815,0	532,0
M36	HLS-36	4,00	3.633,0	626,0
M39	HLS-39	4,00	4.683,0	748,0
M42	HLS-42	4,50	5.799,0	860,0

GF = Grado de pretensado (Aprovechamiento de limite elástico [%])
µG = Coeficiente de rozamiento de la rosca
µK = Coeficiente de rozamiento HEICO-LOCK

HEICO-LOCK

RECOMENDACIONES PAR DE APRIETE 4/4

HEICO-LOCK	**Acero inoxidable (1.4404)**
BOLT	**Acero Inoidable A4**

			A4-70, MoS2 GF=0,65 | µG=0,14 | µK=0,15		A4-80, MoS2 GF=0,65 | µG=0,14 | µK=0,15	
TAMAÑO TORNILLO	**HEICO N° ART.**	**PASO DEL FILETE [MM]**	**APRIETE [NM]**	**PRECARGA [KN]**	**APRIETE [NM]**	**PRECARGA [KN]**
M3	HLS-3S	0,50	0,9	1,5	1,2	2,0
M4	HLS-4S	0,70	2,0	2,6	2,7	3,4
M5	HLS-5S	0,80	3,9	4,2	5,3	5,5
M6	HLS-6S	1,00	6,9	5,9	9,2	7,8
M8	HLS-8S	1,25	17,0	11,0	22,0	14,0
M10	HLS-10S	1,50	33,0	17,0	43,0	23,0
M12	HLS-12S	1,75	56,0	25,0	75,0	33,0
M14	HLS-14S	2,00	89,0	34,0	119,0	45,0
M16	HLS-16S	2,00	136,0	46,0	181,0	61,0
M18	HLS-18S	2,50	191,0	56,0	254,0	75,0
M20	HLS-20S	2,50	267,0	72,0	356,0	96,0
M22	HLS-22S	2,50	351,0	89,0	468,0	118,0
M24	HLS-24S	3,00	460,0	103,0	613,0	138,0
M27	HLS-27S	3,00	671,0	134,0	895,0	179,0
M30	HLS-30S	3,50	915,0	164,0	1.220,0	219,0
M33	HLS-33S	3,50	1.233,0	203,0	1.644,0	271,0
M36	HLS-36S	4,00	1.591,0	239,0	2.121,0	319,0
M39	HLS-39S	4,00	2.053,0	285,0	2.737,0	381,0
M42	HLS-42S	4,50	2.585,0	333,0	3.447,0	443,0

GF = Grado de pretensado (Aprovechamiento de limite elástico [%])
µG = Coeficiente de rozamiento de la rosca
µK = Coeficiente de rozamiento HEICO-LOCK