

Assembly torques

Progress MS, S2, S4 EMC, easyConnect			Progress GFK			SYNTEC Synthetic			SYNTEC MS			with antikink nozzle			EMC Series 85			Progress MS Multi Progress GFK Multi		
Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)
M6x1	2.0 - 2.5	2																		
M6x1	2.5 - 3.0	1																		
M6x1	2.0 - 3.5	1																		
M8x1.25	2.5 - 3.5	2	M8x1.25	2.5 - 3.5	1							M8x1.25	3.8 - 4.8	2						
M8x1.25	3.0 - 5.0	1	M8x1.25	3.0 - 5.0	1															
M10x1.5	3.0 - 4.0	4	M10x1.5	3.0 - 4.0	1							M10x1.5	4.0 - 6.0	3						
M10x1.5	4.0 - 6.0	2	M10x1.5	4.0 - 6.0	1															
M12x1.5	3.5 - 5.0	4	M12x1.5	3.5 - 5.0	2	M12x1.5	2.5 - 6.5	1	M12x1.5	1.5 - 5.0	2.2	M12x1.5	4.0 - 6.0	5						
M12x1.5	5.0 - 6.5	5	M12x1.5	5.0 - 6.5	3				M12x1.5	3.0 - 7.0	2.2									
M12x1.5	6.5 - 8.0	3	M12x1.5	6.5 - 8.0	2															
M16x1.5	3.5 - 4.5	7	M16x1.5	4.5 - 6.0	5	M16x1.5	2.0 - 6.0	3.5	M16x1.5	2.0 - 6.0	3.5	M16x1.5	6.0 - 8.8	9				M16x1.5	2 x 2.0 - 3.0	6
M16x1.5	4.5 - 6.0	6	M16x1.5	6.0 - 8.0	4	M16x1.5	4.5 - 10.0	3.5	M16x1.5	4.5 - 10.0	4				M16x1.5	4.5 - 6.0	6	M16x1.5	2 x 2.5 - 4.0	5
M16x1.5	6.0 - 8.0	5	M16x1.5	8.0 - 10.5	2										M16x1.5	6.0 - 10.5	6	M16x1.5	2 x 3.5 - 5.0	4
M16x1.5	8.0 - 10.5	3	M16x1.5	6.0 - 10.5	2										M16x1.5	8.0 - 15.0	5			
M16x1.5	6.0 - 10.5	4																		
M20x1.5	6.0 - 8.0	10	M20x1.5	6.0 - 8.0	6	M20x1.5	3.5 - 8.0	5.5	M20x1.5	3.5 - 8.0	5.5	M20x1.5	9.0 - 11.0	11				M20x1.5	2 x 3.5 - 5.0	10
M20x1.5	8.0 - 11.0	9	M20x1.5	8.0 - 11.0	5	M20x1.5	7.0 - 13.0	5.5	M20x1.5	7.0 - 13.0	5.5	M20x1.5	10.5 - 13.0	10				M20x1.5	2 x 4.5 - 6.0	9
M20x1.5	11.0 - 15.0	5	M20x1.5	11.0 - 15.0	2										M20x1.5	8.0 - 15.0	5	M20x1.5	2 x 5.5 - 7.5	5
M20x1.5	8.0 - 15.0	5	M20x1.5	8.0 - 15.0	3										M20x1.5	12.5 - 20.5	7	M20x1.5	3 x 3.5 - 5.0	5
M25x1.5	9.5 - 12.5	10	M25x1.5	9.5 - 12.5	6	M25x1.5	5.0 - 11.0	8	M25x1.5	5.0 - 11.0	9	M25x1.5	13.0 - 16.5	31				M20x1.5	3 x 4.5 - 6.0	5
M25x1.5	12.5 - 16.0	10	M25x1.5	12.5 - 16.0	4	M25x1.5	10.0 - 17.0	8	M25x1.5	10.0 - 17.0	9							M20x1.5	3 x 5.2 - 6.5	5
M25x1.5	16.0 - 20.5	4	M25x1.5	16.0 - 20.5	3													M20x1.5	4 x 3.5 - 5.0	5
M25x1.5	12.5 - 20.5	7	M25x1.5	12.5 - 20.5	4													M20x1.5	4 x 4.5 - 6.0	5
M32x1.5	14.0 - 17.0	5	M32x1.5	14.0 - 17.0	5	M32x1.5	17.0 - 25.0	7	M32x1.5	7.0 - 15.0	25							M25x1.5	2 x 5.0 - 7.0	8
M32x1.5	17.0 - 21.0	4	M32x1.5	17.0 - 21.0	4				M32x1.5	13.0 - 21.0	25							M25x1.5	2 x 6.7 - 9.0	10
M32x1.5	21.0 - 25.5	4	M32x1.5	21.0 - 25.5	3													M25x1.5	2 x 7.7 - 10.0	5
M32x1.5	17.0 - 25.5	6	M32x1.5	17.0 - 25.5	4													M25x1.5	3 x 5.5 - 7.0	4
M40x1.5	20.0 - 24.0	10	M40x1.5	20.0 - 24.0	10	M40x1.5	22.0 - 33.0	10	M40x1.5	15.0 - 23.0	40							M25x1.5	3 x 6.8 - 9.0	4
M40x1.5	24.0 - 28.5	8	M40x1.5	24.0 - 28.5	7				M40x1.5	19.0 - 28.0	40							M25x1.5	4 x 5.5 - 7.0	4
M40x1.5	28.5 - 33.0	9	M40x1.5	28.5 - 33.0	10													M25x1.5	6 x 4.8 - 6.0	4
M40x1.5	24.0 - 33.0	12	M40x1.5	24.0 - 33.0	9															
M50x1.5	29.0 - 33.0	11	M50x1.5	29.0 - 33.0	11	M50x1.5	28.0 - 38.0	23	M50x1.5	20.0 - 29.0	40							M32x1.5	2 x 9.0 - 11.5	5
M50x1.5	33.0 - 37.0	14	M50x1.5	33.0 - 37.0	12				M50x1.5	25.0 - 35.0	40							M32x1.5	2 x 7.0 - 9.0	4
M50x1.5	37.0 - 42.0	14	M50x1.5	37.0 - 42.0	16													M32x1.5	3 x 8.5 - 10.5	4
M50x1.5	33.0 - 42.0	22	M50x1.5	33.0 - 42.0	15													M32x1.5	4 x 7.0 - 9.0	4
M63x1.5	35.0 - 40.0	40	M63x1.5	35.0 - 40.0	28	M63x1.5	32.0 - 44.0	25	M63x1.5	28.0 - 39.0	60							M32x1.5	6 x 5.8 - 7.0	4
M63x1.5	40.0 - 46.0	39	M63x1.5	40.0 - 46.0	19				M63x1.5	35.0 - 48.0	40									
M63x1.5	46.0 - 52.0	33	M63x1.5	46.0 - 52.0	41				M63x1.5	44.0 - 45.0	50									
M63x1.5	40.0 - 52.0	38	M63x1.5	40.0 - 52.0	26															
M75x1.5	45.0 - 50.0	53																		
M75x1.5	50.0 - 56.0	42																		
M75x1.5	56.0 - 63.0	43																		
M75x1.5	50.0 - 63.0	50																		

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Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)	Thread	Range (mm)	Md ₁ (Nm)		
Pg7	3.5 - 5.0	4	Pg7	3.5 - 5.0	2	Pg7	2.5 - 6.5	1	Pg7	1.5 - 5.0	2.2	Pg7	4.0 - 6.0	5								
Pg7	5.0 - 6.5	5	Pg7	5.0 - 6.5	3				Pg7	3.0 - 7.0	2.2											
Pg7	6.5 - 8.0	3	Pg7	6.5 - 8.0	2																	
Pg9	3.5 - 4.5	7				Pg9	3.0 - 8.0	2.5	Pg9	2.0 - 6.0	3.5	Pg9	6.0 - 8.8	9				Pg9	2 x 2.0 - 3.0	6		
Pg9	4.5 - 6.0	6	Pg9	4.5 - 6.0	5				Pg9	4.5 - 10.0	4							Pg9	2 x 2.5 - 4.0	5		
Pg9	6.0 - 8.0	5	Pg9	6.0 - 8.0	4													Pg9	2 x 3.5 - 5.0	4		
Pg9	8.0 - 10.5	3	Pg9	8.0 - 10.5	2																	
Pg9	6.0 - 10.5	4	Pg9	6.0 - 10.5	2																	
Pg11	4.0 - 5.5	8	Pg11	4.0 - 5.5	5	Pg11	2.0 - 7.0	5	Pg11	3.5 8.0	5.5	Pg11	6.0 - 8.8	9	Pg11	6.0 - 10.5	4	Pg11	2 x 3.5 - 5.0	8		
Pg11	5.5 - 8.5	7	Pg11	5.5 - 8.5	4	Pg11	4.0 - 10.0	6	Pg11	7.0 13.0	5.5				Pg11	8.0 - 15.0	5	Pg11	2 x 4.5 - 6.0	7		
Pg11	8.5 - 12.0	5	Pg11	8.5 - 12.0	2													Pg11	2 x 5.5 - 7.0	7		
Pg11	5.5 - 12.0	5	Pg11	5.5 - 12.0	2													Pg11	3 x 3.5 - 5.0	5		
Pg13	6.0 - 8.0	10	Pg13	6.0 - 8.0	6	Pg13	3.0 - 7.0	3	Pg13	3.5 - 8.0	5.5	Pg13	9.0 - 11.0	11				Pg13/Pg16	2 x 3.5 - 5.0	8		
Pg13	8.0 - 11.0	9	Pg13	8.0 - 11.0	5	Pg13	5.5 - 12.0	4	Pg13	7.0 - 13.0	5.5	Pg13	10.5 - 13.0	10				Pg13/Pg16	2 x 4.5 - 6.0	8		
Pg13	11.0 - 15.0	5	Pg13	11.0 - 15.0	2													Pg13/Pg16	2 x 5.5 - 7.5	5		
Pg13	8.0 - 15.0	5	Pg13	8.0 - 15.0	3													Pg16	2 x 6.7 - 9.0	5		
Pg16	6.0 - 8.0	10	Pg16	6.0 - 8.0	6	Pg16	5.0 - 11.0	8	Pg16	5.0 11.0	9	Pg16	9.0 - 11.0	11	Pg16	8.0 - 15.0	5	Pg13/Pg16	3 x 3.5 - 5.0	5		
Pg16	8.0 - 11.0	9	Pg16	8.0 - 11.0	5	Pg16	8.5 - 14.0	8	Pg16	7.0 13.0	9	Pg16	10.5 - 13.0	10	Pg16	12.5 - 20.5	7	Pg13/Pg16	3 x 4.5 - 6.0	5		
Pg16	11.0 - 15.0	5	Pg16	11.0 - 15.0	2													Pg13	3 x 5.2 - 6.5	5		
Pg16	8.0 - 15.0	5	Pg16	8.0 - 15.0	3													Pg16	3 x 5.0 - 7.0	5		
Pg21	9.5 - 12.5	10	Pg21	9.5 - 12.5	6	Pg21	6.5 - 14.0	6.5	Pg21	7.0 - 15.0	25	Pg21	13.0 - 16.5	31	Pg21	12.5 - 20.5	7	Pg13/Pg16	4 x 3.5 - 5.0	5		
Pg21	12.5 - 16.0	10	Pg21	12.5 - 16.0	4	Pg21	11.0 - 18.0	10	Pg21	10.0 - 17.0	25				Pg21	17.0 - 25.5	7	Pg13/Pg16	4 x 4.5 - 6.0	5		
Pg21	16.0 - 20.5	4	Pg21	16.0 - 20.5	3													Pg13/Pg16	4 x 5.5 - 7.0	5		
Pg21	12.5 - 20.5	7	Pg21	12.5 - 20.5	4													Pg21	2 x 5.0 - 7.0	8		
Pg29	16.0 - 19.0	10	Pg29	16.0 - 19.0	8	Pg29	17.0 - 25.0	7	Pg29	15.0 - 23.0	40				Pg29	17.0 - 25.5	7	Pg21	2 x 6.7 - 9.0	8		
Pg29	19.0 - 23.0	8	Pg29	19.0 - 23.0	8				Pg29	19.0 28.0	40				Pg29	24.0 - 33.0	12	Pg21	2 x 7.7 - 10.0	4		
Pg29	23.0 - 27.5	8	Pg29	23.0 - 27.5	10													Pg21	3 x 5.5 - 7.0	4		
Pg29	19.0 - 27.5	8	Pg29	19.0 - 27.5	10													Pg21	3 x 6.8 - 9.0	4		
Pg36	21.5 - 26.0	12	Pg36	21.5 - 26.0	10	Pg36	22.0 - 33.0	10	Pg36	20.0 - 29.0	40							Pg21	3 x 8.5 - 10.0	4		
Pg36	26.0 - 30.5	12	Pg36	26.0 - 30.5	10				Pg36	25.0 35.0	40							Pg21	4 x 5.5 - 7.0	4		
Pg36	30.5 - 35.0	12	Pg36	30.5 - 35.0	10													Pg21	4 x 7.0 - 9.0	4		
Pg36	26.0 - 35.0	15	Pg36	26.0 - 35.0	12													Pg21	6 x 4.8 - 6.0	4		
Pg42	29.0 - 33.0	11	Pg42	29.0 - 33.0	11	Pg42	28.0 - 38.0	23	Pg42	20.0 - 29.0	40											
Pg42	33.0 - 37.0	14	Pg42	33.0 - 37.0	12				Pg42	25.0 35.0	40											
Pg42	37.0 - 42.0	14	Pg42	37.0 - 42.0	16																	
Pg42	33.0 - 42.0	22	Pg42	33.0 - 42.0	15																	
Pg48	32.0 - 37.0	40	Pg48	32.0 - 37.0	28	Pg48	32.0 - 44.0	25	Pg48	28.0 - 39.0	60											
Pg48	37.0 - 43.0	40	Pg48	37.0 - 43.0	25				Pg48	35.0 48.0	40											
Pg48	43.0 - 49.0	35	Pg48	43.0 - 49.0	40																	
Pg48	37.0 - 49.0	40	Pg48	37.0 - 49.0	40																	

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