

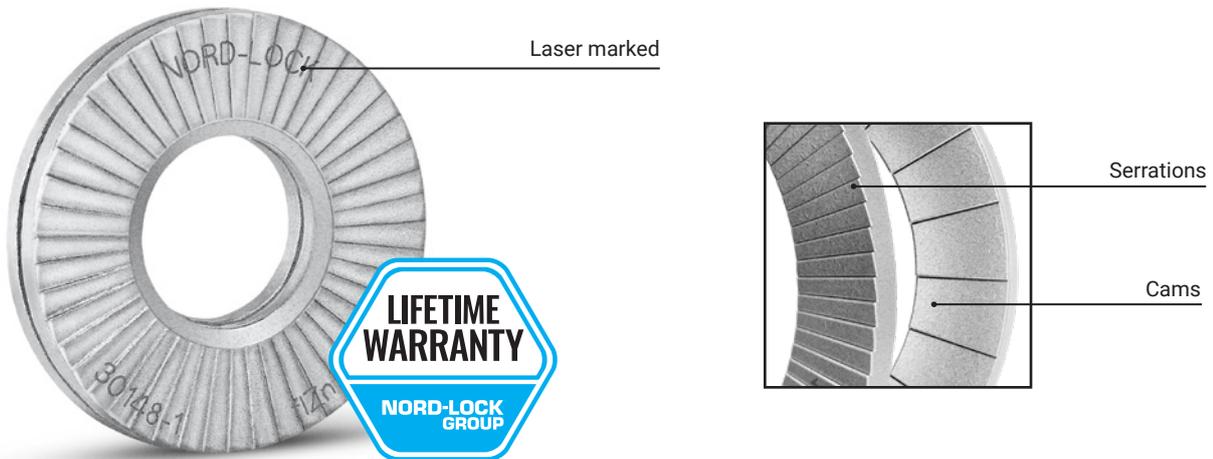
Nord-Lock® Steel Construction Washers

USER MANUAL

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Prevents bolts from loosening



A pair of washers for maximum safety

Nord-Lock bolt securing solutions consist of a pair of washers with cams facing each other and serrations gripping the mating surfaces. They use cam-geometry to effectively prevent the bolt from vibrating loose. A hot melt adhesive is used to assemble the washers in pairs. The ingredients of the adhesive meet the compositional requirements of the American Food & Drug Administration regulations 21 CFR 175.105 "Adhesives". Store dry the washer boxes at -15°C to 25°C (5°F to 77°F).

Applications

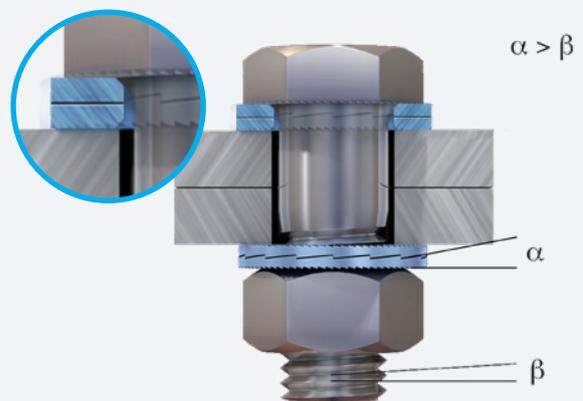
Nord-Lock SC-washers can easily replace a standard plain washer as well as chamfered washer to prevent the bolt from rotating loose. They are safe to use with high-strength structural bolting assemblies for preloading and are confirmed for HV-assemblies by the European Technical Assessment ETA-20/0010 issued by the German Institute for Construction Technology (DIBt).

SC-washers, NLO, NLSS and 254 SMO® are safe to use in non-preloaded structural bolting assemblies according EN 15048 and confirmed by the ETA-19/0813 issued by the DIBt.

How it works

The system consists of a pair of washers that use Nord-Lock wedge-locking technology. Each washer has cam faces on one side and serrations on the other. They also have chamfers on the inner diameter.

The chamfer on the inner diameter ensures optimal contact surface between the bolt and the washer. Since the chamfer is present on both sides of each pair, it also eliminates the risk of incorrect installation.



Joint Guide



Through holes

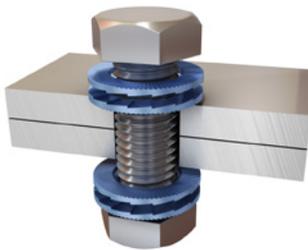
Nord-lock SC-washers are very simple to use. They come pre-glued together, ready to be installed together with your HV- or HR bolt set. Through holes require two pairs of Nord-Lock SC-washers — one pair for securing the bolt and one pair for securing the nut.



Designs where Nord-Lock SC-washers are not recommended

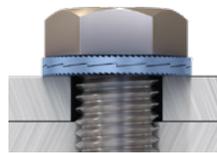
- With plain washers
- When mating surfaces are not locked in place
- When mating surfaces are harder than the washers
- With very soft mating surfaces — for example, wood and plastic
- For applications with extremely large settlements
- When there is no clamping force in the joint

Assembly Instructions

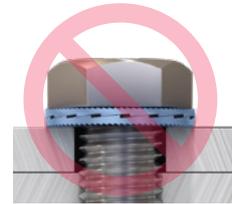


1.

Place one pair of Nord-Lock washers underneath the head of the bolt and mount it in the through hole. Place the second pair of washers on the bolt and mount the nut.



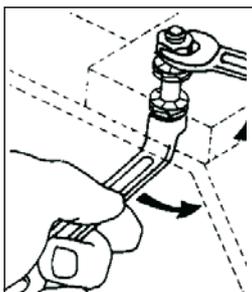
Closed cams - correct



Open cams – not correct

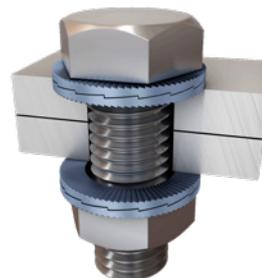
2.

Turn both fasteners (bolt head/nut) in order to close the cams on both washers before tightening to minimize settlements.



3.

Keep the bolt/nut secured while tightening the other part (bolt/nut). For guidance on which torque to tighten with, check the Nord-Lock torque guidelines.



4.

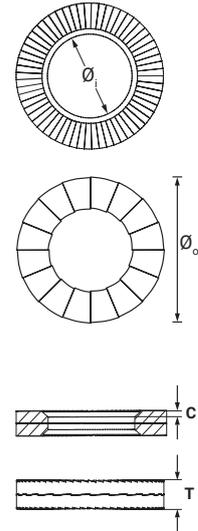
Ready!

Material Guide

Material standard	Hardening	Coating	Corrosion resistance	Temperature range
Steel EN 1.7182	Through hardened	Base coat: Delta Protokt® KL100 zinc flake coating Top coat: VH 302 GZ	Minimum 1,000 hours in salt spray test (according to ISO 9227)	-40°C to 150°C

Dimension Chart

Bolt size	Product designation	\varnothing_1 [mm]	\varnothing_0 [mm]	Thickness T [mm]	Chamfer C [mm]	Approx. weight kg/100 pairs	Min. Package [pairs]	
Metric	UNC							
M12		NL12SC	13,1	23,7	4,6	1,2	1,0	100
M16	5/8"	NL16SC	17,1	29,7	4,6	1,2	1,5	100
M20		NL20SC	21,4	36,7	4,6	1,5	2,3	100
M22	7/8"	NL22SC	23,4	38,7	4,6	1,5	2,5	50
M24		NL24SC	25,3	43,7	4,6	1,5	3,2	50
M27		NL27SC	28,4	49,5	5,8	1,8	5,6	25
M30	1 1/8"	NL30SC	31,4	55,4	5,8	1,8	6,9	25
M36	1 3/8"	NL36SC	37,4	65,4	6,0	1,6	11,0	25



Torque Guidelines

Washer size	Reduced preload force	Modified torque method	Modified combined method* [torque + angle]		Securing effect
	$F_{P,C,SC}^*$	torque $M_{A,SC}$	pre-torque $M_{A,MKV,SC}$	minimum torque $M_{A,SC,min}$	
	[kN]	[Nm]	[Nm]	[Nm]	
NL12SC	45	130	100	80	
NL16SC	90	330	250	200	
NL20SC	145	660	490	360	
NL22SC	170	850	640	520	
NL24SC	200	1100	825	640	
NL27SC	260	1600	1220	1000	
NL30SC	315	2150	1650	1320	
NL36SC	460	3750	2800	2240	

*Required angle of further rotation

Clamp length	angle	part tum
$t < 2d$	45°	1/8
$2d \leq t < 6d$	60°	1/6
$6d \leq t \leq 10d$	90°	1/4
$10d < t$	no recommendations	

Tightening angles when using the combined method varies depending on the clamp length, t, in relation to bolt diameter, d.

