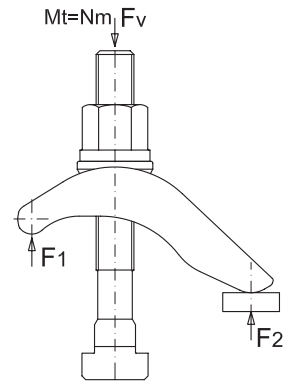


Technical Data for mechanical Clamps

Clamping Frames S10 – S45



Imperial

Numbers are based on the average clamping height and the centered position within the grooves of the frame S30–S45 only
Recommended Torques (friction = 0.14)

Clamping Frames S10 – S20							Clamping Frames S30 – S45									
		0–45	10–70	30–110	90–180				0–45	10–70	10–80	30–110	60–160	90–180	130–260	
Bolt		Torque Fixing Set Bolt	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Bolt		Torque Fixing Set Bolt	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1
inch	metric	ft-lbs	lbs	lbs	lbs	lbs	inch	metric	ft-lbs	lbs	lbs	lbs	lbs	lbs	lbs	lbs
5/16	M08	22	2.600	–	–	–	5/16	M08	18	2.600	–	–	–	–	–	–
3/8	M10	44	4.000	4.000	4.000	–	3/8	M10	36	3.300	4.000	–	4.000	–	–	–
1/2	M12	73	4.400	4.400	4.900	5.600	1/2	M12	66	3.300	4.000	–	4.400	–	5.600	–
–	M14	110	6.700	7.100	7.800	7.800	–	M14	95	5.600	5.600	–	6.700	–	7.800	7.800
5/8	M16	162	6.700	7.100	7.800	8.900	5/8	M16	147	5.600	5.600	7.800	6.700	–	7.800	7.800
–	M18	221	–	10.100	11.200	11.200	–	M18	221	–	7.800	11.200	11.200	–	11.200	7.800
3/4	M20	295	–	10.100	11.200	11.200	3/4	M20	295	–	8.900	11.200	11.200	11.200	11.200	11.200
7/8	M22	368	–	–	13.400	13.400	7/8	M22	368	–	–	12.300	11.200	13.400	11.200	11.200
1	M24	516	–	–	13.400	15.700	1	M24	516	–	–	12.300	13.400	13.400	13.400	13.400
1 1/4	M30	516	–	–	13.400	15.700	1 1/4	M30	516	–	–	12.300	13.400	15.700	13.400	13.400

Metric

Numbers are based on the average clamping height and the centered position within the grooves of the frame S30–S45 only
Recommended Torques (friction = 0.14)

Clamping Frames S10 – S20						Clamping Frames S30 – S45										
		0–45	10–70	30–110	90–180				0–45	10–70	10–80	30–110	60–160	90–180	130–260	
Bolt		Torque Fixing Set Bolt	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Bolt		Torque Fixing Set Bolt	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1	Holding Force max. F1
d	Mt Nm	kN	kN	kN	kN	kN	d	Mt Nm	kN	kN	kN	kN	kN	kN	kN	kN
M08	30	12	–	–	–	–	M08	25	12	–	–	–	–	–	–	–
M10	60	18	18	18	18	–	M10	50	15	18	–	18	–	–	–	–
M12	100	20	20	22	25	–	M12	90	15	18	–	20	–	25	–	–
M14	150	30	32	35	35	–	M14	130	25	25	–	30	–	35	35	–
M16	220	30	32	35	40	–	M16	200	25	25	35	30	–	35	35	–
M18	300	–	45	50	50	–	M18	300	–	35	50	50	–	50	35	–
M20	400	–	45	50	50	–	M20	400	–	40	50	50	50	50	50	–
M22	500	–	–	60	60	–	M22	500	–	–	55	50	60	50	50	–
M24	700	–	–	60	70	–	M24	700	–	–	55	60	60	60	60	–
M30	700	–	–	60	70	–	M30	700	–	–	55	60	70	60	60	–

We reserve the rights to make technical changes