

Imperial

Numbers are based on average clamping heights and the centered position within the grooves of the Frame S33-S45 only
Recommended Torques (friction = 0.14)

Clamping Frames S10 - S20							Clamping Frames S33 - S45										
Bolt (d)		Torque Fixing-Set Bolt	0-45	10-70	30-110	90-180	Bolt (d)		Torque Fixing-Set Bolt	0-45	10-70	10-80	30-110	40-120	60-160	90-180	130-260
Ø inch	Ø metric	Ft-lbs	lbf	lbf	lbf	lbf	Ø inch	Ø metric	Ft-lbs	lbf	lbf	lbf	lbf	lbf	lbf	lbf	lbf
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	7,800	-	6,700	-	-	7,800	7,800
5/8	M16	162	6,700	7,100	7,800	8,900	5/8	M16	147	5,600	7,800	7,800	6,700	-	-	7,800	7,800
-	M18	221	-	10,100	11,200	11,200	-	M18	221	-	8,900	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	11,200
7/8	M22	368	-	-	13,400	13,400	7/8	M22	368	-	-	12,300	11,200	13,400	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	13,400
1 1/4	M30	516	-	-	13,400	15,700	1 1/4	M30	516	-	-	12,300	13,400	15,700	15,700	13,400	13,400

Metric

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Ø metric	Mt Nm	kN	kN	kN	kN	kN	Ø metric	Mt Nm	kN	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	25	M12	90	15	18	-	20	-	-	25	-	
M14	150	30	32	35	35	35	M14	130	25	25	-	30	-	-	35	35	
M16	220	-	32	35	40	40	M16	200	25	25	35	30	-	-	35	35	
M18	300	-	45	50	50	50	M18	300	-	35	50	50	-	-	50	35	
M20	400	-	45	50	50	50	M20	400	-	40	50	50	50	50	50	50	
M22	500	-	-	60	60	60	M22	500	-	-	55	50	60	60	50	50	
M24	700	-	-	60	70	70	M24	700	-	-	55	60	60	60	60	60	
M30	700	-	-	60	70	70	M30	700	-	-	55	60	70	70	60	60	