



All tightening torques and maximum loads in pipe direction refer to clamps with cover plates and hexagon head bolts acc. to DIN EN ISO 4014/4017 (DIN 931/933).

The max. load in pipe direction (according to DIN 3015, part 10) is an average value, determined by three tests at 23° C with a steel pipe according to DIN 2448, St 37 – rolled surface – taking static friction into consideration.

Sliding starts when the shown values (**F**) are reached.

STANDARD-SERIES (according to DIN 3015, part 1)

STAUFF Group	Hexagon Head Bolt	Polypropylene				Polyamide				Aluminum			
		Tightening torque		Max. load in pipe direction F		Tightening torque		Max. load in pipe direction F		Tightening torque		Max. load in pipe direction F	
		[Nm]	Ft/lb	[kN]	lbf	[Nm]	Ft/lb	[kN]	lbf	[Nm]	Ft/lb	[kN]	lbf
1	M6 / 1/4" - 20 UNC	8	6	0,6	135	10	7	0,6	135	12	9	3,5	787
1A		8	6	1,1	247	10	7	0,7	157	12	9	4,2	944
2		8	6	1,3	292	10	7	0,8	180	12	9	4,3	967
3		8	6	1,4	315	10	7	1,6	360	12	9	4,9	1.101
4		8	6	1,5	337	10	7	1,7	382	12	9	5,0	1.124
5		8	6	1,9	427	10	7	2,0	450	12	9	7,3	1.641
6		8	6	2,0	450	10	7	2,5	562	12	9	8,9	2.000
7		8	6	2,3	517	10	7	3,2	719	N/A	N/A	N/A	N/A
8		8	6	2,6	585	10	7	3,5	787	N/A	N/A	N/A	N/A

HEAVY-SERIES (according to DIN 3015, part 2)

STAUFF Group	Hexagon Head Bolt	Polypropylene				Polyamide				Aluminum			
		Tightening torque		Max. load in pipe direction F		Tightening torque		Max. load in pipe direction F		Tightening torque		Max. load in pipe direction F	
		[Nm]	Ft/lb	[kN]	lbf	[Nm]	Ft/lb	[kN]	lbf	[Nm]	Ft/lb	[kN]	lbf
3S	M10 / 3/8" - 16 UNC	12	9	1,6	360	20	15	4,2	944	30	22	12,1	2.720
4S		12	9	2,9	652	20	15	4,5	1.044	30	22	15,1	3.395
5S		15	11	3,3	742	25	18	5,1	1.146	35	26	15,5	3.485
6S	M12 / 7/16" - 14 UNC	30	22	8,2	1.843	40	30	9,3	2.090	55	41	29,5	6.609
7S	M16 / 5/8" - 11 UNC	45	33	11,0	2.472	55	41	25,8	5.800	120	86	34,9	7.845
8S	M20 / 3/4" - 10 UNC	80	59	14,0	3.147	150	111	21,0	4.720	220	162	70,6	15.871
9S	M24 / 7/8" - 9 UNC	110	81	28,0	6.300	200	148	32,0	7.193	250	184	50,0	11.240
10S	M30 / 1 1/8" - 7 UNC	133	132	40,0	8.992	350	258	48,0	10.790	500	369	84,5	18.996
11S	M30 / 1 1/4" - 7 UNC	148	147	119,0	26.752	370	273	125,0	27.650	500	369	181,5	40.802
12S		199	200	168,0	37.767	450	332	180,0	40.465	600	443	244,5	54.965

TWIN-SERIES (according to DIN 3015, part 3)

STAUFF Group	Hexagon Head Bolt	Polypropylene				Polyamide			
		Tightening torque		Max. load in pipe direction F		Tightening torque		Max. load in pipe direction F	
		[Nm]	Ft/lb	[kN]	lbf	[Nm]	Ft/lb	[kN]	lbf
1D	M6 / 1/4" - 20 UNC	5	4	0,9	202	5	4	0,9	202
2D	M8 / 5/16" - 8 UNC	12	9	2,1	472	12	9	2,2	495
3D		12	9	1,9	427	12	9	2,0	450
4D		12	9	2,7	607	12	9	2,9	652
5D		8	6	1,7	382	8	6	2,5	562