

siegmund

WELDING TABLES AND CLAMPING SYSTEMS



**That's not your language?
Scan the QR code.**

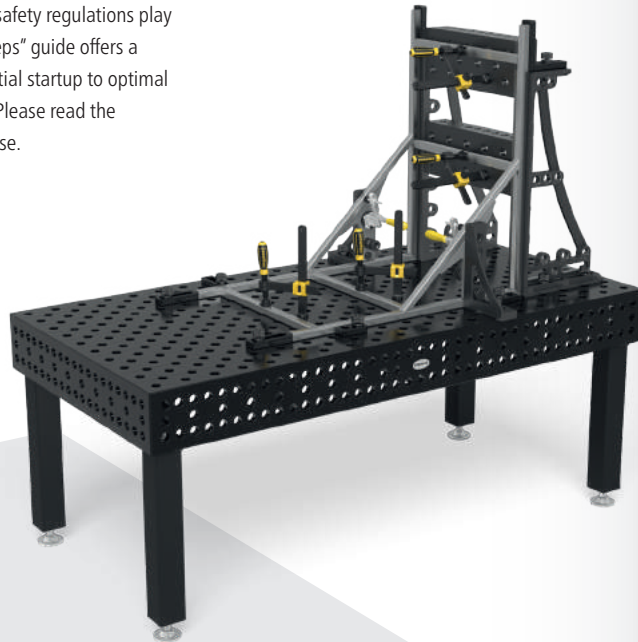


[www.siegmund.com/
F-tablefirststeps](http://www.siegmund.com/F-tablefirststeps)

**The first steps
with your
Siegmund
welding table**

We are pleased that you have chosen a Siegmund welding table!

Siegmund products stand for maximum functionality. Correct handling, maintenance and safety regulations play an important role here. Our "First Steps" guide offers a comprehensive introduction from initial startup to optimal use and care of your welding table. Please read the instructions completely before first use.



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Attention

This symbol indicates important steps during assembly. These specifications must be strictly observed.



Do not walk under lifted load

This symbol indicates that it is not allowed to occur under the lifted load (trucks, repair shop).

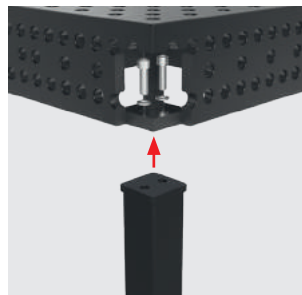




- Reduce hazards from heavy and falling parts.
- Only install the system if you have suitable lifting gear (forklift or crane), assembly tools and are competent to operate them. Otherwise, commission an assembly company equipped for this type of work.
- Wear safety shoes at all times during assembly work.
- Never place tools or other parts on the tabletop during assembly work.
- Only mount the system on a level and load-bearing surface.
- Note the weight of the table top before lifting it.



Never step under the raised table top. Immediately secure the raised table plate against falling. Only work on a secured table top.



1

Insert two mounting bolts per table leg into the mounting plates.

2

Apply the table legs to the table top. Tighten the mounting bolts with a torque of 150 Nm.



Protect your welding and clamping table from lateral impacts. Set down the welding and clamping table carefully and uniformly after assembly. Create an operating environment with impact and collision protection. In this way, you prevent impermissible shear forces that can destroy table legs or plates.

Leg standard equipment

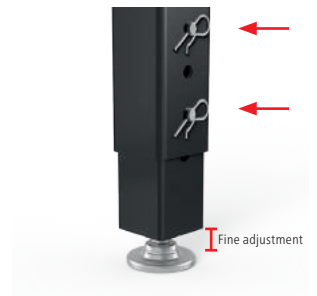
System	28	22	16
max. fine adjustment (mm)	50	50	40



Leg height-adjustable

Select the same height for all table legs and secure each adjusting pin with a cotter pin.

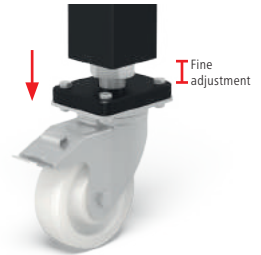
System	28	22	16
max. fine adjustment (mm)	50	50	40



Leg with Caster and Locking Brake

Secure the lockable swivel castor before assembly.

System	28	22	16
max. fine adjustment (mm)	20	20	30



Leg with Floor Anchoring

System	28	22	16
max. fine adjustment (mm)	50	50	50



Prevent the table from tilting or rolling away. Do not unscrew the foot adjustment further than specified.

Capacity per table leg

The permissible load per leg is 200 to max. 2.000 kg depending on the leg type and system/table. Mathematically resulting in substantially higher overall loads. However, the indicated bearing loads were calculated with reserves for safety reasons. Maximum stability due to large profile tube (System 28: 90x90 mm, System 22: 80x80 mm, System 16: 70x70 mm (Data for leg standard equipment)).

For maximum safety:

Allowed bearing loads (valid for leg standard equipment):

System	28	22	16
Vertical force direction (kN)	20	15	10

Leg standard equipment

System	28	22	16
Overall load with 4 legs (kg)	4.000	3.000	2.000
Overall load with 6 legs (kg)	6.000	4.500	3.000
Overall load with 8 legs (kg)	8.000	6.000	4.000

Item No.:

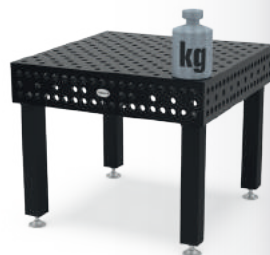
280858.X, 220858, 160858.X
280857.X, 220857.X, 160857.X

Leg height-adjustable

System	28	22	16
Overall load with 4 legs (kg)	4.000	2.000	2.000
Overall load with 6 legs (kg)	6.000	3.000	3.000
Overall load with 8 legs (kg)	8.000	4.000	4.000

Item No.:

280878.X, 220878.X,
280877.X, 220877.X, 160877.X



Leg with Caster and Locking Brake

System	28	22	16
Overall load with 4 legs (kg)	1.600	1.600	400
Overall load with 6 legs (kg)	2.400	2.400	600
Overall load with 8 legs (kg)	3.200	3.200	800

Item No.:

280876.X, 220866, 160876.X



Leg height-adjustable with Caster and Locking Brake

System	28	22	16
Overall load with 4 legs (kg)	1.600	1.600	400
Overall load with 6 legs (kg)	2.400	2.400	600
Overall load with 8 legs (kg)	3.200	3.200	800

Item No.:

280879.X, 220879.X, 160879.X



Leg with Floor Anchoring

System	28	22	16
Overall load with 4 legs (kg)	4.000	3.000	2.000
Overall load with 6 legs (kg)	6.000	4.500	3.000
Overall load with 8 legs (kg)	8.000	6.000	4.000

Item No.:

280874.X, 220874,
280875.X, 160875.X, 160873.X



Capacity per table leg

The permissible load per leg is 200 to max. 3.000 kg depending on the leg type and system/table. Mathematically resulting in substantially higher overall loads. However, the indicated bearing loads were calculated with reserves for safety reasons. Maximum stability due to large profile tube (System 28: 90x90 mm, System 22: 80x80 mm, System 16: 70x70 mm (Data for leg standard equipment)).

For maximum safety:

Allowed bearing loads (valid for leg standard equipment):

System	28	22	16
Vertical force direction (kN)	30	15	10



Leg standard equipment

System	28	22	16
Overall load with 4 legs (kg)	6.000	3.000	2.000
Overall load with 6 legs (kg)	9.000	4.500	3.000
Overall load with 8 legs (kg)	12.000	6.000	4.000

Item No.:

280853.X, 220853.X, 160853.X

Leg height-adjustable

System	28	22	16
Overall load with 4 legs (kg)	4.000	2.000	2.000
Overall load with 6 legs (kg)	6.000	3.000	3.000
Overall load with 8 legs (kg)	8.000	4.000	4.000

Item No.:

280878.X, 220878.X,

280877.X, 220877.X, 160877.X



Leg with Caster and Locking Brake

System	28	22	16
Overall load with 4 legs (kg)	1.600	1.600	400
Overall load with 6 legs (kg)	2.400	2.400	600
Overall load with 8 legs (kg)	3.200	3.200	800

Item No.:

280860.X, 220860.X, 160860.X



Leg height-adjustable with Caster and Locking Brake

System	28	22	16
Overall load with 4 legs (kg)	1.600	1.600	400
Overall load with 6 legs (kg)	2.400	2.400	600
Overall load with 8 legs (kg)	3.200	3.200	800

Item No.:

280879.X, 220879.X, 160879.X



Leg with Floor Anchoring

System	28	22	16
Overall load with 4 legs (kg)	6.000	3.000	2.000
Overall load with 6 legs (kg)	9.000	4.500	3.000
Overall load with 8 legs (kg)	12.000	6.000	4.000

Item No.:

280872.X, 220872.X, 160872.X

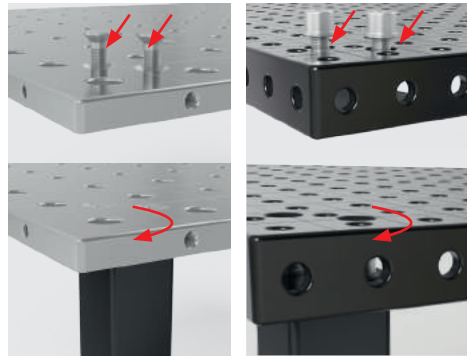




- Reduce hazards from heavy and falling parts.
- Only install the system if you have suitable lifting gear (forklift or crane), assembly tools and are competent to operate them. Otherwise, commission an assembly company equipped for this type of work.
- Wear safety shoes at all times during assembly work.
- Never place tools or other parts on the tabletop during assembly work.
- Only mount the system on a level and load-bearing surface.
- Note the weight of the table top before lifting it.



Never step under the raised table top. Immediately secure the raised table plate against falling. Only work on a secured table top.



1 Insert two mounting bolts per table leg into the mounting plates.

2 Apply the table legs to the table top. Tighten the mounting bolts with a torque of 150 Nm.

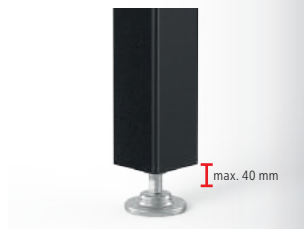


Protect your welding and clamping table from lateral impacts. Set down the welding and clamping table carefully and uniformly after assembly. Create an operating environment with impact and collision protection. In this way, you prevent impermissible shear forces that can destroy table legs or plates.

Leg standard equipment

System	28	16
Overall load with 4 legs (kg)	2.000	1.000
Overall load with 6 legs (kg)	3.000	1.000
Overall load with 8 legs (kg)	4.000	1.000

Item No.:
161856, 160857.X, 160858.X



Leg height-adjustable

Select the same height for all table legs and secure each adjusting pin with a cotter pin.

System	28	16
Overall load with 4 legs (kg)	2.000	1.000
Overall load with 6 legs (kg)	3.000	1.000
Overall load with 8 legs (kg)	4.000	1.000

Item No.:
160877.X

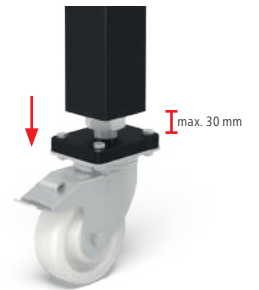


Leg with Caster and Locking Brake

Secure the lockable swivel castor before assembly.

System	28	16
Overall load with 4 legs (kg)	400	400
Overall load with 6 legs (kg)	600	600
Overall load with 8 legs (kg)	800	800

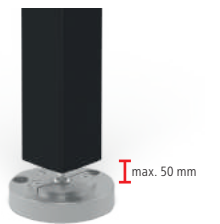
Item No.:
161855, 160879.X



Leg with Floor Anchoring

System	28	16
Overall load with 4 legs (kg)	2.000	1.000
Overall load with 6 legs (kg)	3.000	1.000
Overall load with 8 legs (kg)	4.000	1.000

Item No.:
160874.X



Prevent the table from tilting or rolling away. Do not unscrew the foot adjustment further than specified.

1

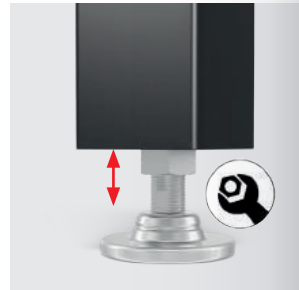
Unscrew the adjustment unit (foot spindle) halfway.

System 16: 20 mm

System 22: 25 mm

System 28: 25 mm

Please note the possible fine adjustment for each table leg variant.



2

Lift the table with suitable lifting equipment (e.g. transport handle Item No. 000830.N, 160830) and mount the legs with the bolts supplied. The bolts supplied are countersunk, hexagon head or cylinder head bolts, depending on the type of table. The tightening torque is 150 Nm (please check the tightening torque regularly). Then set down the table.



Warnings:

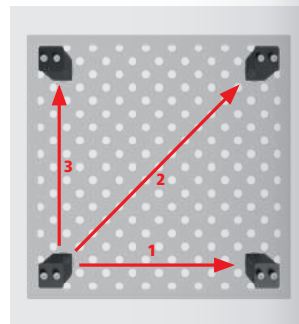
Do not step under the suspended load.
Do not lift the load higher than necessary.

3

Now align the table with the help of a spirit level. To do this, start from a point above one leg and align the other legs to it. A spirit level of suitable length should be used. Its length should approximately correspond to the distance between the legs.

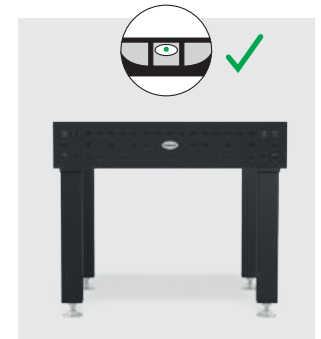
Please note:

All legs should always be in contact with the ground at all times and the adjustment unit should not be completely unscrewed. By gradually aligning the legs to the reference leg with the aid of the fine adjustment, you will approach the desired evenness.



4

By repeating the 3rd step for all table legs, you will achieve the desired evenness through iterative measurement and readjustment.



5

After the table has reached the desired level, fix the setting of the legs by securing the adjustment unit with the locking nut.



System

Wrench size locking nut Table leg without caster

Wrench size locking nut Table leg with caster

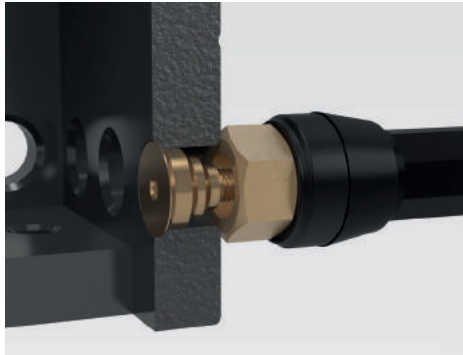
	28	22	16
Wrench size locking nut Table leg without caster	36	36	24
Wrench size locking nut Table leg with caster	55	55	36



Grounding the table

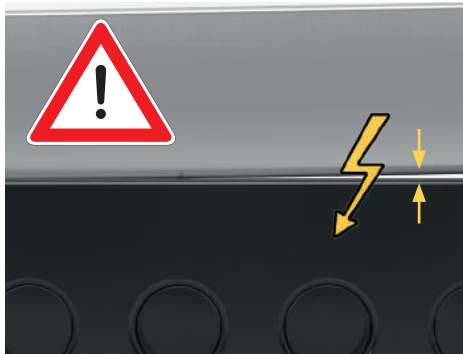
The adapter allows the use of the ground connection (Item No. 000810) for the system 16, system 22 and system 28. Insert the adapter into the system borehole, then place the hexagon nut on the adapter and screw the connection to the connector plug. The power cable of your ground connection is connected to the welding cable socket. With the help of the „square-block system“, the connection between the welding cable socket and the connector plug can be locked by simply turning it.

Connect your component or your welding table to the ground in a safe and secure way. The surface of the table must be free of dirt and residues before the component is placed and fixed in place. Note, that the component must be clamped to the table in a contact-safe way (without an air gap), in order to avoid flashovers.



Comment

If any of the above points are not fulfilled, flashovers can occur during the welding process and thus cause damage to the surface (see picture on the left). This is not a reason for complaint. In general, a direct connection of the ground connection to your component is recommended to avoid damage to your welding table.



Plasma nitration

Siegmund's plasma nitriding is a proven surface treatment for our welding tables. The thermochemical process leads to surfaces that are more wear-free, corrosion-resistant and durable. Welding spatter adheres significantly less to a table with plasma nitriding than to welding tables without plasma nitriding. As a result, the surface evenness is better preserved even after years. Due to the significant increase in service life and the increased resilience of the welding tables by around 20-30%, plasma nitriding is always worthwhile.

Plasma nitriding is one of the most environmentally friendly hardening processes because only nitrogen, hydrogen and oxygen are required for the hardening process. These gases are the main components of the air. At Siegmund, the required energy is provided exclusively electrically, instead of the fossil fuels that are otherwise customary on the market for heating the components.

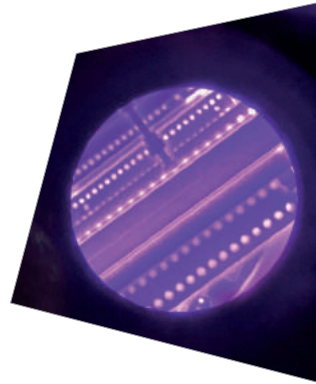
BAR-Coating

Unique to Siegmund is the subsequent BAR coating of the welding tables and many tool parts, which takes place after plasma nitriding. The BAR coating (Black-Anti-Rust Coating) additionally planes the surface and increases protection against rust.

Comment

Through the plasma nitration tables may get several changes in color. These changes in color are process-related and thus technical unavoidable. This does not affect the table's quality. In the course of use it is possible that the BAR-Coating shows slight signs of wear. This does not affect the function or the hardness of the plasma nitriding of your welding table.

We recommend regular maintenance with Anti-Spatter and CleanBasic.



Maintenance products

To ensure a long service life for the table, we recommend that you check the table regularly to ensure that it is clean and, if necessary, to clean it with tools or to protect it against weld spatter.

You can use the following care products without hesitation:



000924, 000926

Protection against adhesion of welding spatters on the Siegmund welding table

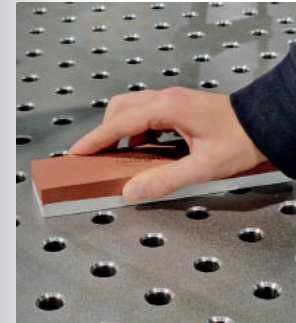
- Anti-Spatter is put on the table preferably with a spray bottle before welding
- the non-stick effect works in a wet and also in a dried situation
- afterwards the welding spatters can be wiped away easily
- can also be used on parts to be welded



000914, 000915

Cleaning of the Siegmund welding table

- CleanBasic is a very strong cleaner
- the Siegmund welding table should be cleaned after every welding process
- CleanBasic is well suited for removing grease, oils and other contaminants
- the cleaner diffuses through plastic vessels, this can shrink the volume over time



To maintain the evenness of Siegmund welding tables and accessories

- the oilstone is used to remove damage or welding spatters
- perfect for maintenance and levelling of unevenness of the welding surface
- **not suitable for use on plasma nitrided tables**
- Item No.: 000940, 000942



Cleaning of boreholes of Siegmund welding tables

- grime in the boreholes can be removed effortlessly with the brush
- Item No.: 160820, 220820, 280820



Oiling

In addition to using Siegmund Anti-Spatter in every welding process to protect the welding table, we recommend impregnating the welding table with a non-corrosive oil to prevent long-term corrosion and avoid damage to your welding table and ensure a long service life. WD40 or similar is recommended for protection. This should ideally be done after each use, but especially if the table is not used for a long time.

General care instructions

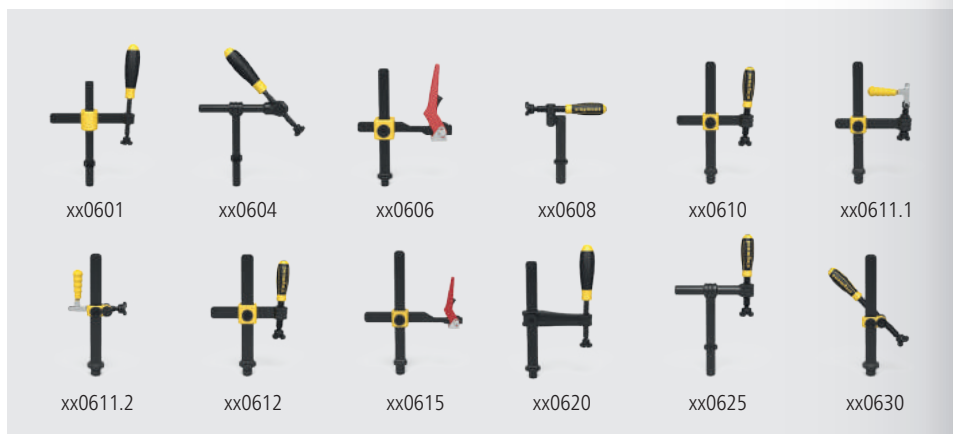
- use of other abrasives is not allowed
- for the installation of your welding table we recommend a place with low humidity and constant temperature
- do not use acids / corrosive liquids (acids, alkalis, especially pickling)
- we recommend removing any components or accessories from your table before you start cleaning
- do not forget to maintain and clean your Siegmund accessories in addition to your table
- remove all superstructures from your table when not in use for extended periods of time

Instructions for the use of clamps

System	28	22	16
xx0601 max. clamping force (kN)	-	-	1,5
xx0604 max. clamping force (kN)	3	1,4	0,6
xx0606 max. clamping force (kN)	-	-	2,5
xx0608 max. clamping force (kN)	3	-	-
xx0610 max. clamping force (kN)	5	3,5	2,5
xx0611.1 max. clamping force (kN)	2,5	-	-
xx0611.2 max. clamping force (kN)	2,5	-	-
xx0612 max. clamping force (kN)	7	-	-
xx0615 max. clamping force (kN)	5	3,5	-
xx0620 max. clamping force (kN)	-	-	2,5
xx0625 max. clamping force (kN)	3	-	-
xx0630 max. clamping force (kN)	5	3,5	2,5

You can order replacements for the inner O-Rings of the prisms under the following article numbers:
 00002558: O-Ring inside for Prism (System 16)
 00001506: O-Ring inside for Prism (System 22)
 00002557: O-Ring inside for Prism (System 28)

For higher clamping forces we recommend the XL clamp for System 28 (Item No. 280612.N), or our Siegmund table press (Article number 280780, 220780, 160780).



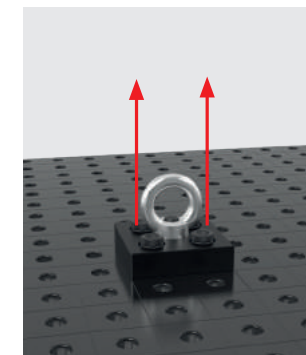
Instructions for the use of fast clamping bolts

Tensile Force:

System	28	22	16
Bolt xx0511 (kN)	25	15	10

Tensile force when used in aluminum profiles:

System	28	22	16
Bolt xx0511 (kN)	25	15	10



Tightening torque:

System	28	22	16
Bolt xx0511 (Nm)	25	15	10

Tightening torque when used in aluminum profiles:

System	28	22	16
Bolt xx0511 (Nm)	10	6	2,5

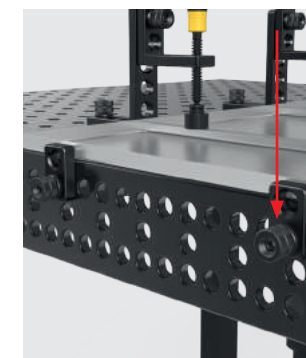


Shearing Force:

System	28	22	16
Bolt xx0511 (kN)	220	130	55

Shearing force when used in aluminum profiles:

System	28	22	16
Bolt xx0511 (kN)	220	130	55



Instructions for the use of squares

Place the square on the welding table in the required position and fasten it with clamping bolts.



Risk of crushing when positioning components on Siegmund tables.
Gloves are recommended for use. Only use original accessories!

Plasma nitrided

System	28	22	16
max. tightening torque (Nm)	25	15	10

Aluminum-Titanium

System	28	22	16
max. tightening torque (Nm)	15	-	10



Any questions?

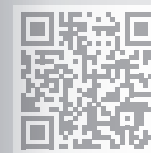
If you have any questions, please do not hesitate to contact our team:

sales@siegmund.com
+49 (0) 8203 96 07-0



Manuals and more information

Detailed information on our products as well as other product versions and our entire product range can be found online.



**www.siegmund.com/
F-instructions**

