

 Zakład Produkcyjno- Handlowy Admet Adam Czachor	FACTORY STANDARD	ZN-ADM-301- 01:2024
	Pipe Clamps Made of Stainless Steel	28-11-2024
		ICS 23.040

TABLE OF CONTENTS

1	INTRODUCTION.....	2
1.1	Subject of the Standard – Product Description	2
1.2	REFERENCED STANDARDS.....	2
2	TYPES OF CLAMPS.....	2
3	MATERIALS.....	3
4	DIMENSIONS.....	3
4.1	Dimension Table	3
4.2	OTHER DIMENSIONAL DESIGNATIONS	5
5	INFORMATION TO BE PROVIDED BY THE CUSTOMER.....	6

1 INTRODUCTION

1.1 Subject of the Standard – Product Description

The subject of this standard is pipe clamps (also called pipe holders, pipe supports) made of stainless steel, intended for mounting pipes. The clamp consists of a lower part – on which the pipe rests, and an upper part which is attached to the structure. Both parts of the clamp are connected by two pairs of bolts and nuts (included in the set). The upper part of the clamp may have a welded:

- a) Smooth rod (also called shaft)
- b) Threaded rod
- c) Wood screw
- d) Nut
- e) Other

1.2 REFERENCED STANDARDS

The following standards are referenced in this document:

DIN 933	M 1,6 to M 52 hexagon head screws threaded up to the head
DIN 985	Prevailing torque type hexagon thin nuts with nonmetallic insert
DIN 975	Threaded rods
DIN 934	Hexagon nuts with metric coarse and fine pitch thread
DIN 6330	Hexagon nuts with a height of 1,5 d
DIN 571	Hexagon head wood screws

2 TYPES OF CLAMPS

Clamps are divided according to the additional mounting welded to the upper clamp:

- a) Without mounting
- b) With a smooth rod (pin)
- c) With a threaded rod [DIN 975]
- d) With a wood screw [DIN 571]
- e) With a nut [DIN 934]
- f) With a 1.5D nut [DIN 6330]
- g) With a 3D nut

3 MATERIALS

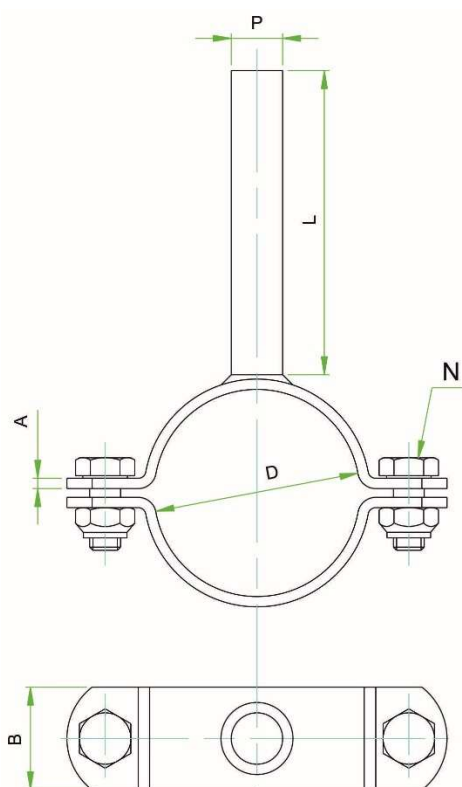
The flat bars from which the clamps are made:

a) Stainless steel	AISI 304	EN 1.4301	DIN X5CrNi18-10
b) Stainless steel	AISI 304L	EN 1.4307	DIN X2CrNi19-11
c) Stainless steel	AISI 316	EN 1.4401	DIN X5CrNiMo17-12-2
d) Stainless steel	AISI 316L	EN 1.4404	DIN X2CrNiMo17-12-2

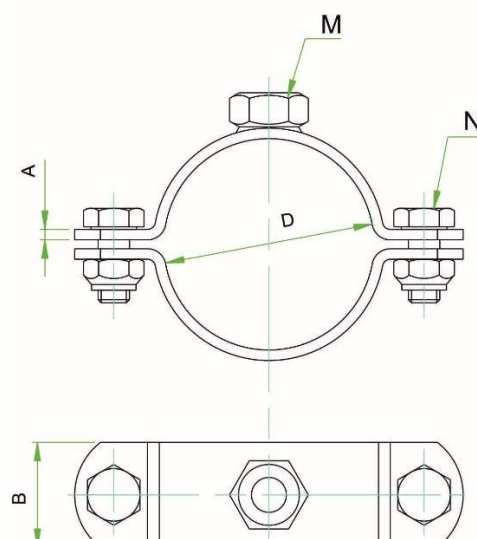
4 DIMENSIONS

4.1 Dimension Table

The table below provides dimensions for clamps with a smooth rod (fig. 1), and for clamps with a DIN 934 nut (fig. 2).



Rys. 1



Rys. 2

¹ Typical dimensions are given for clamps with a smooth rod. Clamps with a threaded rod and wood screw may have the same dimensions as those with a smooth rod, or others, chosen by the customer.

Tab. 1. Clamp Dimensions

[D] : Clamp size (pipe outside diameter) [mm]	[B] x [A] : Flat bar dimensions [mm]	[N] Clamping bolts and nuts (DIN 933, DIN 985)	[P] x [L] : Smooth rod [mm]	[M] Nut (DIN 934)
8	20x2	M6	8x60	M6
10	20x2	M6	8x60	M6
12	20x2	M6	8x60	M8
13,5	20x2	M6	8x60	M8
14	20x2	M6	8x60	M8
15	20x2	M6	8x60	M8
16	20x2	M6	8x60	M8
17,2	20x2	M6	8x60	M8
18	20x2	M6	8x60	M8
20	20x2	M6	8x60	M8
21,3	20x2	M6	8x60	M8
22	20x2	M6	8x60	M8
25	20x2	M6	8x60	M8
26,9	20x2	M6	8x60	M8
28	20x2	M6	8x60	M8
30	20x2	M6	8x60	M8
32	20x2	M6	8x60	M8
33,7	20x2	M6	8x60	M8
34	20x2	M6	8x60	M8
38	20x2	M6	8x60	M8
40	20x2	M6	8x60	M8
42,4	20x2	M6	8x60	M8
48,3	25x2	M6	10x60	M8
50	25x2	M6	10x60	M8
50,8	25x2	M6	10x60	M8
51	25x2	M6	10x60	M8
52	25x2	M6	10x60	M8
54	25x2	M6	10x60	M8
57	25x2	M6	10x60	M10
60,3	25x2	M6	10x60	M10
63,5	25x2	M6	10x60	M10
70	25x2	M6	12x60	M10
75	25x2	M6	12x60	M10
76,1	25x2	M6	12x60	M10
80	25x2	M6	12x60	M10
85	25x2	M6	12x60	M10
88,9	25x2	M6	12x60	M10
101,6	30x2,5	M8	12x60	M10
104	30x2,5	M8	12x60	M10
108	30x2,5	M8	12x60	M10
110	30x2,5	M8	12x60	M10
114,3	30x2,5	M8	12x60	M10
129	30x2,5	M8	14x60	M10
133	30x2,5	M8	14x60	M10
139,7	30x2,5	M8	14x60	M10

140	30x2,5	M8	14x60	M10
154	30x3	M10	14x60	M12
156	30x3	M10	14x60	M12
159	30x3	M10	14x60	M12
160	30x3	M10	14x60	M12
168,3	30x3	M10	14x60	M12
200	30x4	M10	18x60	M16
202	30x4	M10	18x60	M16
204	30x3	M10	18x60	M16
204	30x4	M10	18x60	M16
219,1	30x3	M10	18x60	M16
219,1	30x4	M10	18x60	M16
225	40x4	M12	18x60	M16
254	40x4	M12	20x60	M16
254	50x5	M16	20x60	M16
256	40x4	M12	20x60	M16
256	50x5	M16	20x60	M16
273	40x4	M12	20x60	
273	50x5	M16	20x60	
280	50x5	M16	20x60	
304	50x5	M16	22x80	
306	50x5	M16	22x80	
315	50x5	M16	22x80	
318	50x5	M16	22x80	
323,9	40x4	M12	22x80	
323,9	50x5	M16	22x80	
355,6	50x5	M16	25x80	
406,4	50x6	M16	30x80	
508	50x6	M16	30x80	
609,6	50x6	M16	32x100	

4.2 OTHER DIMENSIONAL DESIGNATIONS

The table below presents the external dimensions of pipes (internal diameter of the clamp) according to various designations.

Tab. 2. Pipe Dimensions.

DN	Inches	DIN	ISO	METRIC	DIN 11850
6	1/8 "	-	10.00 mm	8.00 mm x 1.00 mm	
8	1/4"	-	13.50 mm	10.00 mm x 1.00 mm	
10	3/8"	14.00 mm	17.20 mm	12.00 mm x 1.00 mm	12.00 mm x 1.00 mm
15	1/2"	20.00 mm	21.30 mm	18.00 mm x 1.50 mm	18.00 mm x 1.50 mm
20	3/4"	25.00 mm	26.90 mm	23.00 mm x 1.50 mm	22.00 mm x 1.50 mm
25	1"	30.00 mm	33.70 mm	28.00 mm x 1.50 mm	28.00 mm x 1.50 mm
32	1 1/4"	38.00 mm	42.40 mm	35.00 mm x 1.50 mm	34.00 mm x 1.50 mm
40	1 1/2"	44.50 mm	48.30 mm	43.00 mm x 1.50 mm	40.00 mm x 1.50 mm
50	2"	57.00 mm	60.30 mm	54.00 mm x 2.00 mm	52.00 mm x 1.50 mm
65	2 1/2"	76.10 mm	76.10 mm	69.00 mm x 2.00 mm	70.00 mm x 2.00 mm

80	3"	88.90 mm	88.90 mm	84.00 mm x 2.00 mm	85.00 mm x 2.00 mm
100	4"	108.00 mm	114.30 mm	104.00 mm x 2.00 mm	104.00 mm x 2.00 mm
125	5"	133.00 mm	139.70 mm	129.00 mm x 2.00 mm	129.00 mm x 2.00 mm
150	6"	159.00 mm	168.30 mm	154.00 mm x 2.00 mm	154.00 mm x 2.00 mm
200	8"	216.00 mm	219.10 mm	204.00 mm x 2.00 mm	
250	10"	267.00 mm	273.00 mm	254.00 mm x 2.00 mm	
300	12"	318.00 mm	323.90 mm	304.00 mm x 2.00 mm	
350	14"	368.00 mm	355.60 mm	354.00 mm x 2.00 mm	
400	16"	419.00 mm	406.40 mm		
450	18"	459.00 mm	457.20 mm		
500	20"	521.00 mm	508.00 mm		
600	24"	622.00 mm	609.60 mm		
700	24"	720.00 mm	711.20 mm		
800	28"	820.00 mm	812.80 mm		
900	32"	920.00 mm	914.40 mm		
1000	40"	1020.00 mm	1016.00 mm		

5 INFORMATION TO BE PROVIDED BY THE CUSTOMER

It is recommended that when ordering clamps, the customer provides the following information:

- The number of this standard.
- The internal diameter of the clamp and, if necessary, the flat bar dimension (see Tab. 1)
- Additional clamp mounting or lack thereof
- Steel grade.
- Whether the clamp should have a rubber insert.