

siegmund®

*High Precision Welding Tables
for Heavy Duty Fixturing.*



MADE IN GERMANY



STABILITY • STRENGTH • PRECISION

StrongHandTools®
Better Tools. Better Price.

www.StrongHandTools.com

INTRODUCTION



MADE IN GERMANY 

Five Face, one-piece design for an extremely rigid work surface.



Standard Plasma Nitride Finish for superior surface hardness and protection.

Siegmund Welding Tables are the finest available on the market.

Each Siegmund Welding Table is constructed using the highest quality steel with stringent flatness requirements exceeding industry standards. Welding and assembly is performed with the latest in robotic technology for a deep weld with minimal deformation. Dedicated CNC machines create a precise pattern of work holes on the table according to customer requirements before receiving a **plasma nitride finish**.

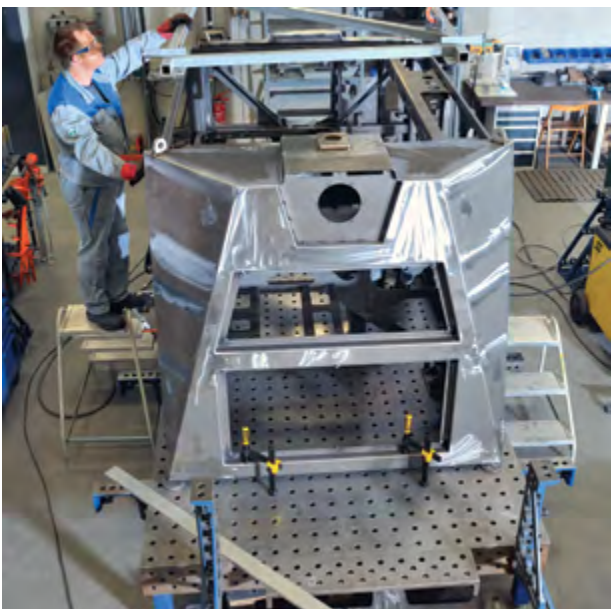
All plasma nitride work is performed in Siegmund's own facilities where the process has been perfected through the years. The result is a beautiful finish that greatly increases table life through decreased wear and deformation.

The unsurpassed technical excellence of Siegmund tables is complemented by a large range of mounting options and fixturing accessories. Siegmund Welding Tables are suitable for every workspace and every job.



Plasma Nitride Finish for Best Quality and Value

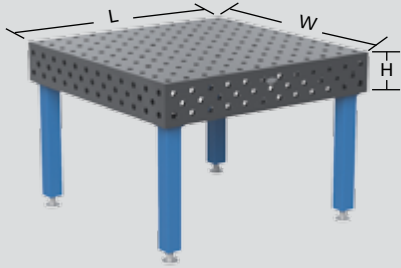
	Plasma Nitrided	Steel	Cast-Iron	HARDOX	Stainless Steel
Protection Against Weld Spatter	★★★★★	★★	★★★	★★★	★★★
Hardness of Surface	★★★★★	★★★	★★	★★★★★	★★★★★
Lifetime	★★★★★	★★★	★★★	★★★★★	★★★★★
Load Capacity	★★★★★	★★★	★★	★★★★★	★★★★★
Protection Against Corrosion	★★★★★	★	★	★	★★★★★



**“ NO JOB TOO LARGE
OR COMPLEX. ”**

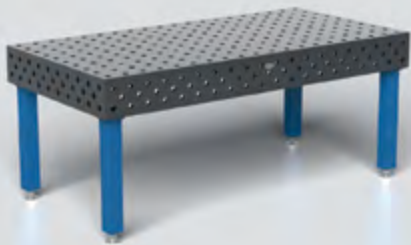
FIVE-FACE TABLES

1.2 x 1.2 meter Professional



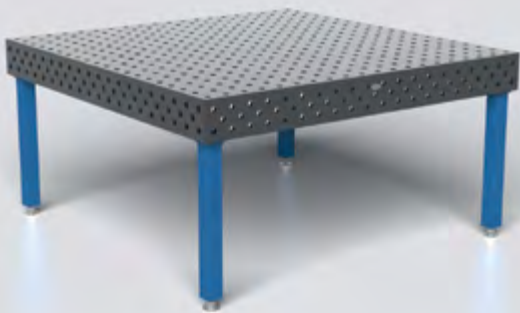
(Legs Sold Separately)

2x1 meter Professional



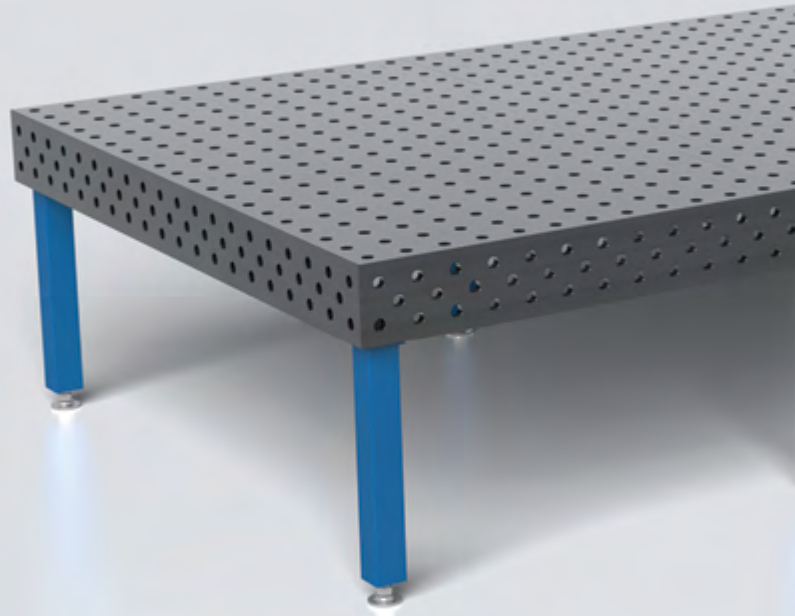
(Legs Sold Separately)

2x2 meter Professional



(Legs Sold Separately)

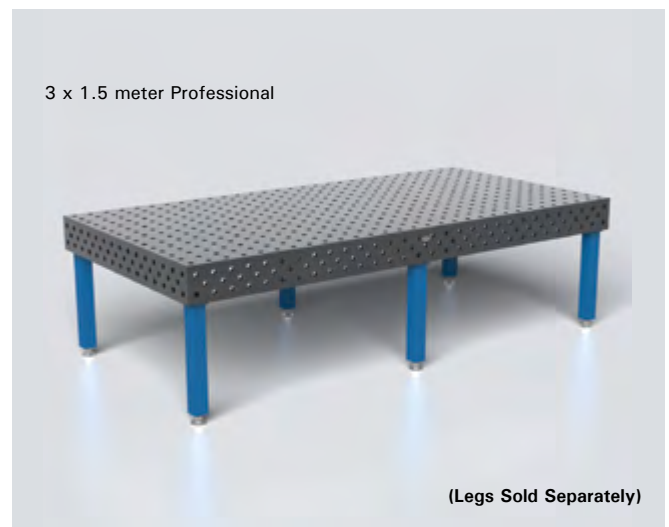
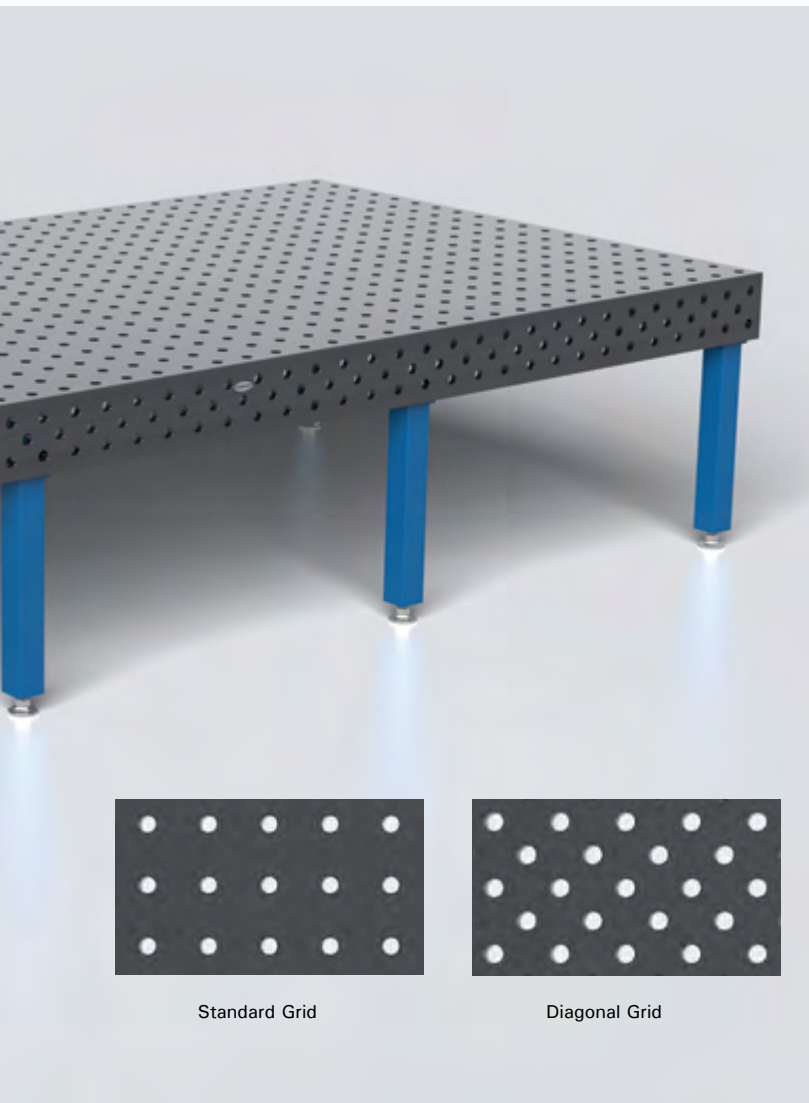
4 x 2 meter Professional



(Legs Sold Separately)

Welding tables come in a variety of sizes to suit your unique fabrication needs. The five face design of the table using 25 mm thick plates and reinforcements underneath creates an extremely rigid table surface. A plasma nitride finish comes standard on all tables for a work surface extremely resistant to wear, deformation, corrosion, and weld spatter.

Work holes are 28 mm diameter and spaced 100 mm apart. An additional diagonal grid on the table top is available as an option. The diagonal grid pattern provides 80-90% more fixture locations on the top face of the table for even greater flexibility. Diagonal threaded hole pattern of M8, M12, or M16 threaded holes available on special order as well as custom tables sizes.



Tabletop ONLY. Legs sold separately. (See page 6)

Name	Item Number (Standard Grid)	Item Number (Diagonal Grid)	Length (mm)	Width (mm)	Height (mm)	Table Weight (kg / LBS.)
1.2 x 1.2 meter Professional	S1-280015-PT1	S1-280015-PT5	1,200	1,200	200	550 / 1,200
2 x 1 meter Professional	S1-280020-PT1	S1-280020-PT5	2,000	1,000	200	650 / 1,430
2.4 x 1.2 meter Professional	S1-280030-PT1	S1-280030-PT5	2,400	1,200	200	1,000 / 2,200
2 x 2 meter Professional	S1-280045-PT1	S1-280045-PT5*	2,000	2,000	200	1,200 / 2,650
3 x 1.5 meter Professional	S1-280040-PT1	S1-280040-PT5	3,000	1,500	200	1,350 / 2,975
4 x 2 meter Professional	S1-280055-PT1	S1-280055-PT5*	4,000	2,000	200	2,300 / 5,070

* Special Order

TABLE LEGS

Siegmund Welding Tables come with a wide range of mounting options to suit every workspace. Legs are ordered individually and the number required will vary depending on table size.

Legs mount onto plates at the bottom of the table; to calculate height of work surface add the height of the leg and the height of the table together. For example, the 750 mm Standard Leg combined with a table height of 200 mm results in a 950 mm high work surface. Leveling feet with spindles at the bottom of the legs offer fine adjustment.

Use of castors not recommended for tables larger than 2 x 2 meters in size.

Anchor plates recommended for use with top heavy loads or with welding robots.



S1-280857

S1-280858



S1-280862



S1-280863



S1-280861



S1-280871

Name	Item Number	Height (mm)	Spindle Adj. Range (mm)	Capacity (kg)	Weight (kg)
Leg, Standard 750	S1-280857	750	50	1,000	8
Leg, Standard 650	S1-280858	650	50	1,000	8
Leg, Height Adj.	S1-280862	450-725	30	1,000	10
Leg, Heavy Duty Castor w/ Brake	S1-280863	750	25	1,000	14
Leg, Height Adj. w/ Castor and Brake	S1-280861	550-750	25	600	15
Leg w/ Anchor Plate	S1-280871	750	50	1,000	11



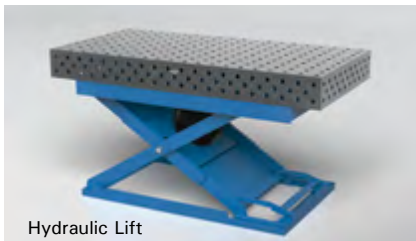
Leg



Bottom View



Mounting Pattern



Hydraulic Lift



Extra low ground clearance castors



Rail Mount and Wheeled Track

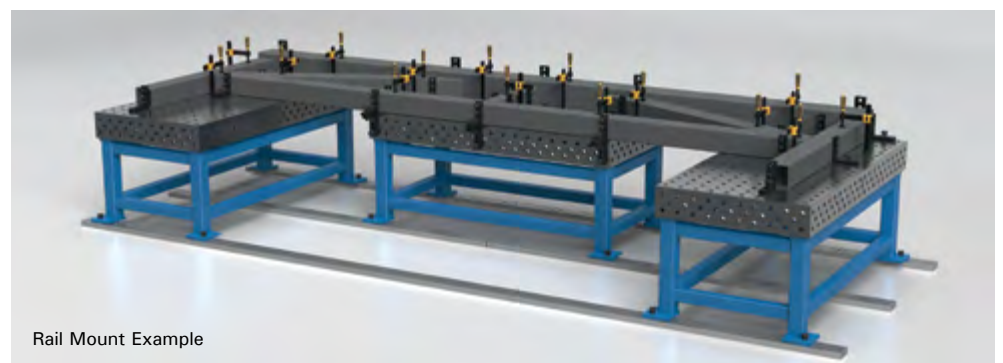
Other Table Mounting Options

In addition to the standard leg options, special mounting kits are available as special order:

- Hydraulic Lift for all sizes
- Extra low ground clearance castors
- Rail mount with heavy duty frame for all sizes
- Rail mount with wheeled track and heavy duty frame for all sizes



Rail Mount and Wheeled Track Detail



Rail Mount Example

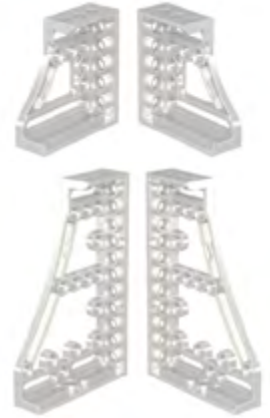
STAINLESS STEEL / POSITIONERS



Fixtures for Stainless Steel *(Special Order)*

Aluminum Overlay Sheets are available for stainless steel welding. Sheets come in standard and diagonal hole patterns to align precisely with the table's existing hole pattern. Overlay sheet is 2 mm thick and can be used with standard Siegmund fast clamp bolts (does not require Universal Bolt). Due to high shipping costs it is recommend the stainless steel overlay sheet be ordered with the table.

Fixture sets are also available for stainless steel work using a combination of stainless steel, aluminum, aluminum-titanium, and chromed fixtures. Non-marring polyamide pads and V-Prisms also available.



Aluminum-Titanium Stop and Clamping Squares



Positioner Mounting Options *(Special Order)*

Custom sized plates for applications such as positioner or turntable use can be manufactured on request.

Toggle Clamp mounting systems available on special order.



STOPS



S1-280410



S1-280420



S1-280423



S1-280430



Stops are used to align workpieces anywhere on the table. Oblong slots provide adjustment and versatility while holes provide anchoring points for accessories such as clamps and V-Prisms. Combine with squares for even more options. Aluminum or chromed versions available on special order.

Item Number	Name	Length (mm)	Width (mm)	Thickness (mm)	Weight (kg)
S1-280410	Universal Stop 150 L	150	50	25	0.8
S1-280420	Universal Stop 225 L	225	50	25	1.4
S1-280423	Universal Stop 300 L	300	50	25	1.6
S1-280430	Universal Stop 500 S	500	50	25	3.3



S1-280402



S1-280403



S1-280411



S1-280413



S1-280419



Eccentric Stops provide infinite adjustment in a compact package. Item S1-280402 can also be used as a ground connection and features an M10 thread.

Flex Steel Stops are designed for use in situations with limited space or as a more affordable substitute for smaller edge stops. Available in 25 mm and 50 mm thickness. Please note, 50 mm thickness stops will require the use of long clamping bolts.

Item Number	Name	Length (mm)	Width (mm)	Thickness (mm)	Weight (kg)
S1-280402	Eccentric Stop 60	N/A	Diameter: 60	25	0.4
S1-280403	Eccentric Stop 100	N/A	Diameter: 100	25	1.4
S1-280411	Steel D-Stop 25 x 90	90	36	25	0.2
S1-280413	Steel D-Stop 50 x 90	90	36	50	0.4
S1-280419	Steel D-Stop 25 x 182	182	36	25	0.3

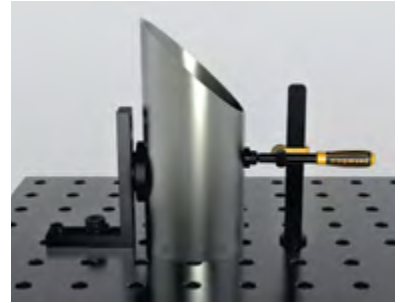


SQUARES



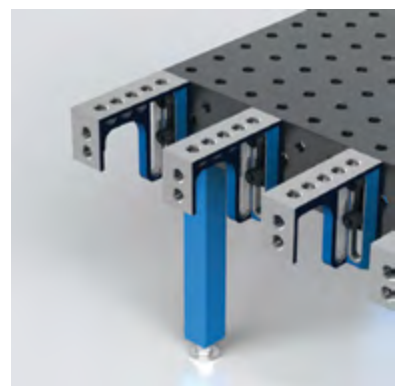
Stop and Clamping Squares can be used in the same manner as a stop or combined with other elements to form more complex fixtures. Oblong slots enable a range of adjustable options. Item S1-280110-G appears as a different color due to cast iron construction. Aluminum or chromed versions of squares available on special order.

Item Number	Name	Length (mm)	Width (mm)	Height (mm)	Thickness (mm)	Weight (kg)
S1-280109	Stop and Clamping Square 175 x 75 SL	175	50	75	25	1.4
S1-280110-G	Stop and Clamping Square 175 L (Cast Iron)	175	50	175	25	1.9
S1-280111	Stop and Clamping Square 175 WL	175	50	175	25	1.8
S1-280112	Stop and Clamping Square 275 L	175	50	275	25	2.8



Cast Stop and Clamping Squares are even more versatile than normal squares due to the presence of work holes on three sides. Their large size and robust construction enables them to act as a stop for large parts and bear heavy loads when used as a table extension. Their cast construction means greater precision while cut outs are optimized for lighter weight and easier handling. Aluminum-titanium alloy versions available on special order with the benefit of 50-60% weight reduction.

Item Number	Name	Length (mm)	Width (mm)	Height (mm)	Thickness (mm)	Weight (kg)
S1-280162	Stop and Clamping Square 500 G	200	75	500	approx 27	9.8
S1-280124 S1-280126	L/R Stop and Clamping Square 300 GK	280	95	300	approx 27	13.3
S2-280134 S2-280136	L/R Stop and Clamping Square 600 GK	376	95	600	approx 27	22.5
S2-280144 S2-280146	L/R Stop and Clamping Square 800 GK	376	95	800	approx 27	28.5



EXTENSION BLOCKS



S2-280302



S2-280303

The Slotted Adjustable Square and Clamp Rail are versatile clamping elements for framing larger work pieces. Use the moveable square with large clamp squares to provide extra work holes in tight spaces.

Item Number	Name	Length (mm)	Width (mm)	Height (mm)	Weight (kg)
S2-280302	Slotted Adj. Square Cast Iron	500	100	100	16
S2-280303	Clamp Rail 1000	1,000	100	100	48



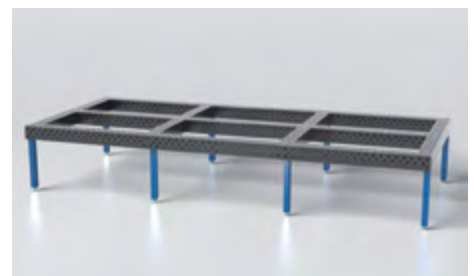
Riser Blocks are ideally suited for table extensions or large vertical setups. Riser blocks have leg mounting holes and come in a plasma nitride finish.

Special sizes up to 4,000 mm in length available as special order as well as special profiles. Custom sizes can be made in 200x100 mm, 400x200 mm, or 400x400 mm (width x height) profiles.

SAFETY NOTE: Riser Blocks should only be joined to the table using connector bolts (Item S1-280560 or S1-280550-1). Do not use fast clamping bolts or other available bolts to join.

S2-280370-P

Item Number	Name	Length (mm)	Width (mm)	Height (mm)	Weight (kg)
S2-280396-P	Riser Block 200 x 200 x 200	200	200	200	29
S2-280360-P	Riser Block 500 x 200 x 200	500	200	200	61
S2-280370-P	Riser Block 1,000 x 200 x 200	1,000	200	200	120
S2-280380-P	Riser Block 1,500 x 200 x 200	1,500	200	200	170
S2-280390-P	Riser Block 2,000 x 200 x 200	2,000	200	200	220
S2-280391-P	Riser Block 2,400 x 200 x 200	2,400	200	200	255



FIXTURING ELEMENTS



S1-280740



S1-280170



S2-280171



S2-280190-G



Special items - **Magnetic Clamping Bolts** are ideal for sheet metal or holding on to structures that cannot be clamped from the inside such as box shapes.

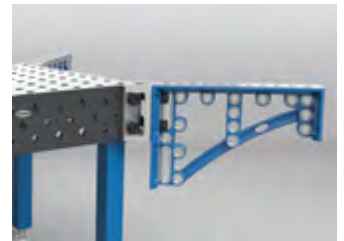
Adjustable Angle Protractor is non weight-bearing and for horizontal use only, comes with an aluminum angle guide.

Load-Bearing Adjustable Angle Protractor is weight bearing due to a hydro mechanical mechanism and has a built in angle guide.

Corner Square is used to mount large squares for use as a corner stop or corner table extension.



Item Number	Description	Length (mm)	Width (mm)	Height (mm)	Thickness (mm)	Weight (kg)
S1-280740	Magnetic Clamping Bolt	68	N/A	N/A	N/A	0.1
S1-280170	Adj. Angle Protractor	350	N/A	N/A	N/A	14.5
S2-280171	Load Bearing Adj. Angle Protractor	450	N/A	N/A	N/A	23.0
S2-280190-G	Corner Square	200	150	120	N/A	11.4

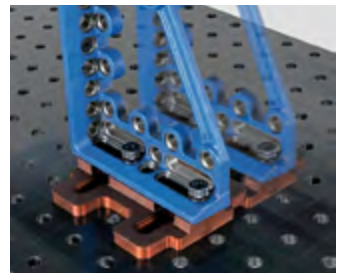


S2-280195



S1-280252

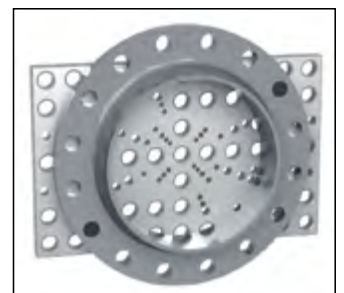
Item Number	Description	Length (mm)	Width (mm)	Thickness (mm)	Weight (kg)
S2-280195	Sliding Base	350	300	50	16
S1-280252	Clamping Plate 400 - 600 LBS for ASME/ANSI flanges	350	250	25	14



Sliding Base and Flange Mounting Plate are designed for pipe fitting. Sliding Base provides an extra axis of adjustment, use with Cast Clamping Square and Slotted Adj. Square for 3-axis adjustment. Fix sliding base onto table with flat clamping bolt, item S1-280522.

DIN standard flange plates also available. Pins for ASME/ANSI flanges come in five sizes, two of each size bolt are provided with plate. Dia. listed corresponds to flange hole diameter.

Flange Fixing Bolts For Pipe Fitting



S1-280255

Fixing Bolt
Dia. 15.5 mm



S1-280256

Fixing Bolt
Dia. 18.9 mm



S1-280257

Fixing Bolt
Dia. 22.2 mm



S1-280258

Fixing Bolt
Dia. 25.2 mm



S1-280259

Fixing Bolt
Dia. 28.2 mm



BOLTS & V-PRISMS



S1-280510



S1-280522



S1-280528



S1-280529



S1-280532



S1-280533



S1-280550-1



S1-280560

All bolts come in short and long versions. Short bolts are designed for connecting two Siegmund components together such as a table to a stop or a stop to a square. Long bolts are designed for connecting three Siegmund components together. Long bolts not listed in this catalog are available by special order.

Fast Clamping Bolts - Standard bolts used for the majority of applications.

Flush Mount / Flat Bolts - Used to connect components without the bolt head interfering with the work piece.

Universal Bolts - Designed for backward compatible use with legacy welding table fixture kits or custom fixtures that are slightly thicker or thinner than standard Siegmund parts.

***Connecting Bolts - The only bolt permitted for use to form connections with heavy parts such as Riser Blocks to tables.**

Item Number	Name	Length (mm)	Dia. (mm)	Weight (kg)	Notes
S1-280510	Fast Clamping Bolt, Short	95	28	0.5	Standard bolt for use with Siegmund components
S1-280522	Flat Clamping Bolt, Short	75	28	0.4	Use in oblong holes such as for sliding base plate (Item S1-280195)
S1-280528	Flush Mount Bolt, Short	67	28	0.3	Flush Mount head not suitable for placement in oblong slots
S1-280529	Flush Mount Bolt, Long	91	28	0.4	Flush Mount head not suitable for placement in oblong slots
S1-280532	Universal Bolt, Short	100	28	0.6	45 - 53 mm clamping zone
S1-280533	Universal Bolt, Long	125	28	0.7	70 - 78 mm clamping zone
S1-280550-1*	Connecting Bolt, Hex, Short	58	28	0.4	For connecting Riser Blocks or large squares to table side w/ slots
S1-280560*	Flush Mount Connecting Bolt, Short	36	28	0.1	For connecting Riser Blocks or large squares to table side



S1-280651



S1-280669



S1-280651-1



S2-280652-1

V-Prisms are used for holding round stock of different sizes. V-Prisms are available with permanent work hole adaptors or with a flat bottom. All V-Prisms come with locking screws to fix them against the table or fixture workholes.

S1-280651- Ideal for use with 80 mm round tubing, has a permanent work hole adaptor with locking screw on the bottom that can be used to secure V-Prism to the work holes on stops and squares.

S1-280669- Removable 28 mm Dia. work hole adaptor screws onto the back of flat bottom V-Prisms. Work hole adaptors can accept locking screws.

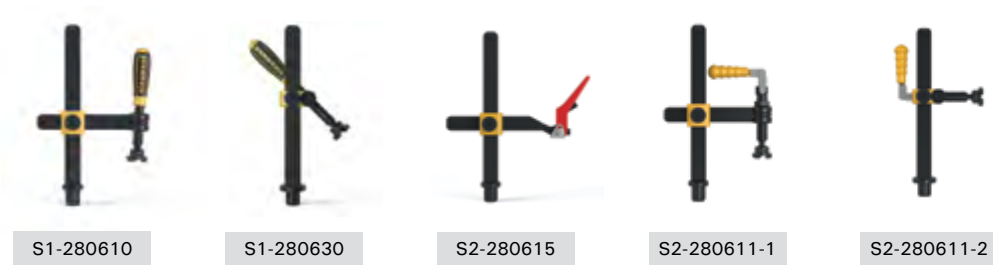
S1-280651-1- Flat bottom V-Prism ideal for use with 80 mm round tubing, can be used independent of table work hole matrix or coupled with work hole adaptor (S1-280669) for use with work holes. Adaptor sold separately.

S2-280652-1- Flat bottom V-Prism for large tubes and pipes up to 400 mm dia. Can be used independent of table work hole matrix or coupled with work hole adaptor (S1-280669) for use with work holes. Adaptor sold separately.

Examples



Item Number	Name	Height (mm)	Dia. (mm)	Prism Degree	Weight (kg)
S1-280651	V-Prism 60/135 w/ locking screw	45	60	135	0.6
S1-280669	V-Prism Work Hole Adapter	15	28	N/A	0.1
S1-280651-1	V-Prism 60/135, flat bottom	30	60	135	0.5
S2-280652-1	V-Prism 120/157, flat bottom	30	120	157	2.2



Versatile clamping systems ensure a clamp for your every need. All clamps easily set with one hand. The standard screw clamp adjusts along the vertical and horizontal axis for precise placement anywhere on the table. 45 and 90 degree clamps pivot and slide to provide a horizontal or diagonal force. Fast Tension Ratchet clamps and toggle clamp "Fast Clamp" varieties also available. Screw thread is Tr 20x4.

XL clamp sizes available on request with vertical bars up to 800 mm and horizontal bars up to 500 mm in length.

Item Number	Name	Vertical Bar Height (mm)	Horizontal Bar Length (mm)
S1-280610	Screw Clamp Standard	310	200, 40 - 165 Clamping Range
S1-280630	Screw Clamp Standard 45/90	310	170 Spindle Length
S2-280615	Ratchet Clamp	310	200
S2-280611-1	Screw Clamp w/ Toggle Clamp	310	200, Spindle Range 90 - 130
S2-280611-2	Screw Clamp w/ Toggle Clamp 45/90	310	200, Spindle Range 90 - 130



Clamp V-Prisms fit onto the end of clamps to hold workpieces in place. The universal V-Prism is the standard prism on Siegmund clamps and is suitable for round or square stock, the end fits either the clamps or 28 mm work holes of the table and fixtures.

V-Prisms are available in stainless steel, aluminum, and polyamide as special order.

Item Number	Name	Height (mm)	Diameter (mm)	Weight (kg)
S1-280657-1	Universal V-Prism for Screw Clamp	24	40	0.1
S1-280650	Dual Fit V-Prism 40	35	40	0.2











FIXTURING KITS

Choose a fixture kit from below or contact us for consultation on a fixture kit to meet your specific needs. All fixture kits come with the accessory pack below for basic maintenance.

Fixture Kit #1	S1-283100	32pcs	Weight: 23 kg / 50 LBS.		
					
S1-280610	S1-280630	S1-280510	S1-280410	S1-280110-G	
4 x	2 x	12 x	12 x	2 x	

Fixture Kit #2	S1-283200	60pcs	Weight: 65 kg / 140 LBS.		
					
S1-280610	S1-280630	S1-280510	S1-280410	S1-280110-G	S1-280162
6 x	4 x	24 x	12 x	12 x	2 x













Fixture Kit #3	S1-283300	98pcs	Weight: 98 kg / 215 LBS.		
					
S1-280610	S1-280630	S1-280510	S1-280410	S1-280420	S1-280651
8 x	8 x	36 x	12 x	12 x	8 x
					
S1-280110-G	S1-280162				
12 x	2 x				

FIXTURING KITS





Fixture Kit #4 **S1-283400** **115pcs** **Weight: 208 kg / 460 LBS.**

					
S1-280610	S1-280630	S1-280510	S1-280410	S1-280420	S1-280430
12 x	12 x	36 x	12 x	12 x	4 x
					
S1-280651	S1-280110-G	S1-280162	S1-280910		
8 x	12 x	6 x	1 x		

Fixture Kit #5 **S1-283500** **131pcs** **Weight: 298 kg / 635 LBS.**

					
S1-280610	S1-280630	S1-280510	S1-280410	S1-280420	S1-280430
12 x	12 x	48 x	12 x	12 x	4 x
					
S1-280651	S1-280110-G	S1-280162	S1-280124 / 126	S2-280144 / 146	S1-280910
8 x	12 x	6 x	1 x + 1 x	1 x + 1 x	1 x

Accessory pack comes with each Siegmund fixture kit.

				
Ground Connector	Allen Key 6	Wire Brush	Oil Stone	O Rings and Ball Bearings
S1-280402	S1-280852-1	S1-280820	S1-000940	S1-289102-1



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