

**System 28**  
**Welding and Clamping Table**





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## System 28



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We reserve the right to make technical changes.  
07.2004



**Planning**

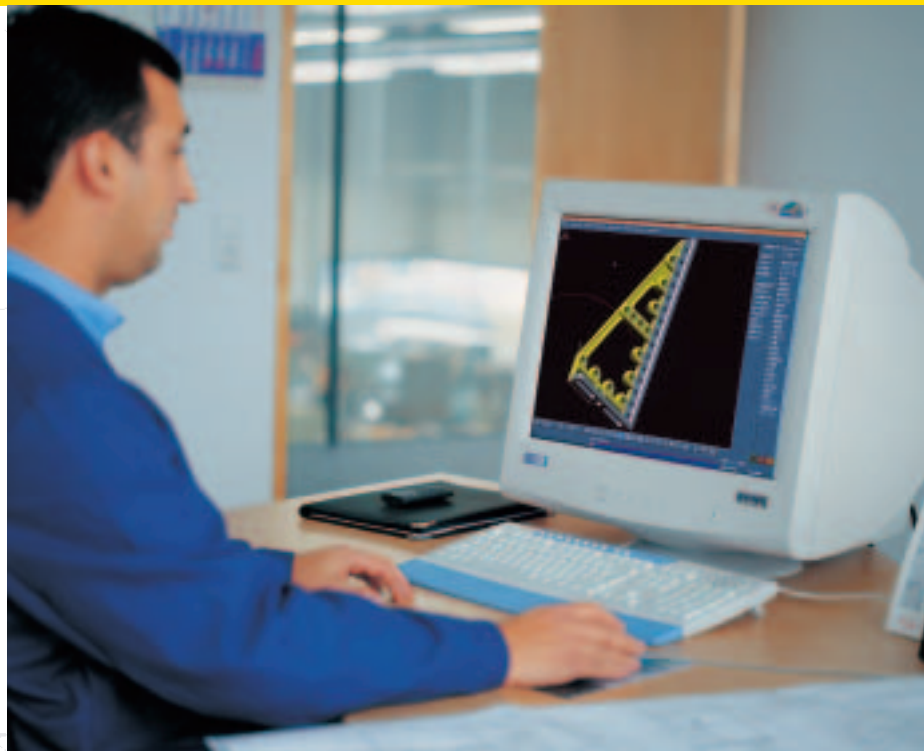
**Developing**

**Activating**

## **Innovation is our field!**

**During our many years of activity in the metal sector, we of the Bernd Siegmund Group have made considerable contributions towards the many products, ideas and developments which today can be regarded as standards.**

**It is our target to offer you products which improve your production, regardless of whether this is in a major industry or in a medium-sized concern.**



Our many years of experience with welding tables enables us today to develop and test products which will make your work more effective, simpler and safer tomorrow.

**We set standards - for your success!**



### Precision from the beginning!

Using the latest CNC production methods (i.e. processing on five sides), enables us to offer you top quality. The precision, 28 mm drill holes, sunk from beneath in combination with the 100 mm grid, provides an option in flexibility and compatibility.



#### Plates supported by 80 mm ribs

Solid execution (material thickness about 24-32 mm made of ST 52/3)  
Cast iron version available on request)  
Ground or finely-milled surface.

#### article no. 0070

- Standard 2000x1000x30**  
2000 x 1000 x 100 mm  
- weight: 520 kg  
- table height 850 mm  
- 4 legs, option 5th. leg  
- with castors 850 **0071**  
- with anchorage 850 **0072**  
- adjustable height 720-1070 **0073**  
- adjustable height 550-800 **0074**

#### article no. 0080

- Standard 2400x1200x30**  
2400 x 1200 x 100 mm  
- weight: 740 kg  
- table height 850 mm  
- 4 legs, option 5th. leg  
- with castors 850 **0081**  
- with anchorage 850 **0082**  
- adjustable height 720-1070 **0083**  
- adjustable height 550-800 **0084**



## Komfort Table



article no. 0010	article no. 0015	article no. 0035	article no. 0050
<b>Comfort 1000x1000x200</b> 1000 x 1000 x 200 mm - weight: 450 kg - table height 850 mm - 4 legs - with castors 850 <b>0011</b> - with anchorage 850 <b>0012</b> - adjustable height 820-1170 <b>0013</b> - adjustable height 650-900 <b>0014</b>	<b>Comfort 1200x1200x200</b> 1200 x 1200 x 200 mm - weight: 650 kg - table height 850 mm - 4 legs - with castors 850 <b>0016</b> - with anchorage 850 <b>0017</b> - adjustable height 820-1170 <b>0018</b> - adjustable height 650-900 <b>0019</b>	<b>Comfort 1500x1000x200</b> 1500 x 1000 x 200 mm - weight: 670 kg - table height 850 mm - 4 legs - with castors 850 <b>0036</b> - with anchorage 850 <b>0037</b> - adjustable height 820-1170 <b>0038</b> - adjustable height 650-900 <b>0039</b>	<b>Comfort 1500x1500x200</b> 1500 x 1500 x 200 mm - weight: 950 kg - table height 850 mm - 4 legs - with castors 850 <b>0051</b> - with anchorage 850 <b>0052</b> - adjustable height 820-1170 <b>0053</b> - adjustable height 650-900 <b>0054</b>



*\* also available for delivery with completely hardend surface (e.g. Hardox 400)*

article no. 0020	article no. 0030	article no. 0040	article no. 0055
<b>Comfort 2000x1000x200</b> 2000 x 1000 x 200 mm - weight: 800 kg - table height 850 mm - 4 legs - with castors 850 <b>0021</b> - with anchorage 850 <b>0022</b> - adjustable height 820-1170 <b>0023</b> - adjustable height 650-900 <b>0024</b>	<b>Comfort 2400x1200x200</b> 2400 x 1200 x 200 mm - weight: 1100 kg - table height 850 mm - 4 legs - with castors 850 <b>0031</b> - with anchorage 850 <b>0032</b> - adjustable height 820-1170 <b>0033</b> - adjustable height 650-900 <b>0034</b>	<b>Comfort 3000x1500x200</b> 3000 x 1500 x 200 mm - weight: 1600 kg - table height 850 mm - 6 legs - with anchorage 850 <b>0042</b> - adjustable height 820-1170 <b>0043</b> - adjustable height 650-900 <b>0044</b>	<b>Comfort 4000x2000x200</b> 4000 x 2000 x 200 mm - weight: 3000 kg - table height 850 mm - 8 legs - with anchorage 850 <b>0057</b> - adjustable height 820-1170 <b>0058</b> - adjustable height 650-900 <b>0059</b>



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Table legs

## Table legs to suit every type of floor

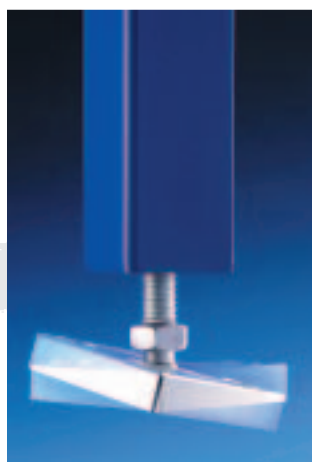
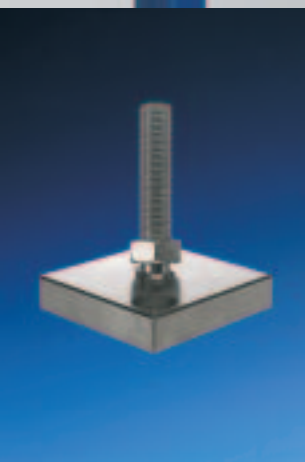
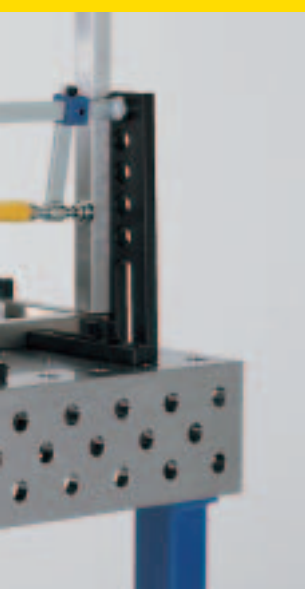
**Not only are they good to look at, but they are also flexible and safe. If they don't suit you, then we'll make them right! Due to a large selection we are able to make sure that your S4 stands solidly and safely. Whether powder-coated or specially lacquered, our bench legs provide the safest support!**





**flexible**

To calculate the overall height of combinations, one must add 100 mm to the height of Standard table and 200 mm to Comfort table.  
All legs are equipped with either a base plate or a castor.  
The weight-bearing capacity results from the maximal 30 mm screwed thread.



**article no. 0868**

**article no.**

**article no.**

**article no.**

**article no.**

**Plate for floor anchoring**  
- Alternative to basic foot configuration

**Leg with anchorage**  
820 mm **0870**  
750 mm **0871**  
650 mm **0872**  
- Weight bearing capacity 1000 kg

**Leg with castors**  
820 mm **0864**  
750 mm **0865**  
650 mm **0866**  
- Weight bearing capacity 600 kg  
- supported Spindle

**Leg adjustable height**  
620 - 970 mm **0860**  
450 - 700 mm **0862**  
- Weight bearing capacity 1000 kg

**Leg basic**  
820 mm **0856**  
750 mm **0857**  
650 mm **0858**  
- Weight bearing capacity 1000 kg



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**Welding and clamping table S4**



**Technology: conceived by professionals**

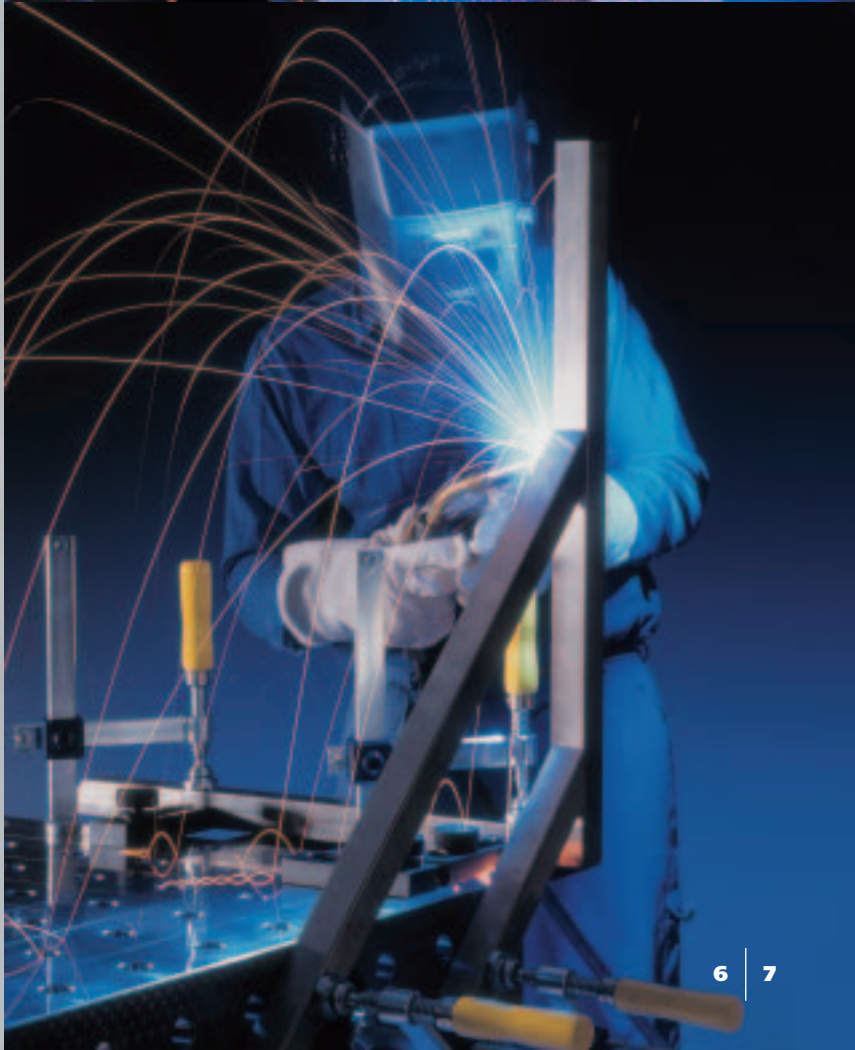
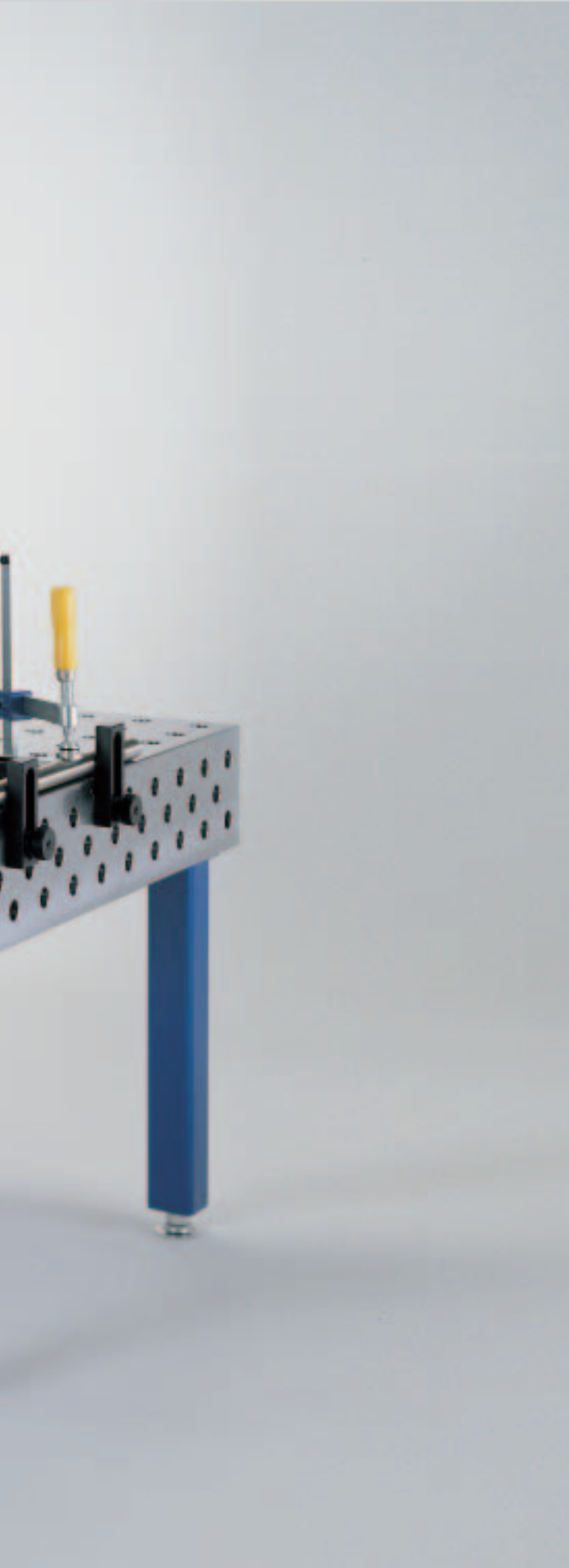
**Principle: easy + logical**

**Quality: easily made**

**Advantage: quick + precise**



**One table does everything!**





## Stops

### article no. 0401

#### **Eccentric Stop 60**

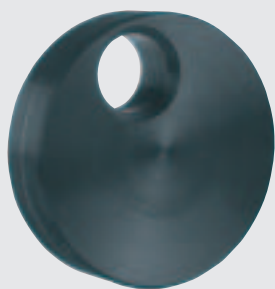
- Ø 60 mm
- weight: 0.4 kg
- suitable in the case of space problems
- burnished



### article no. 0402

#### **Eccentric Stop 60 with M10 thread**

- Ø 60 mm
- weight: 0.4 kg
- with M10 thread
- for mass connections
- burnished



### article no. 0403

#### **Eccentric Stop 100**

- Ø 100 mm
- weight: 1.4 kg
- Could also be used as an adaptor
- burnished



### article no. 0410

#### **Universal Stop 150 L**

- 150 x 50 x 25 mm
- weight: 0.8 kg
- variably adjustable
- through long hole adjustability range has infinite possibilities
- Adjustable range equals 100 mm
- burnished



### article no. 0420

#### **Universal Stop 225 L**

- 225 x 50 x 25 mm
- weight: 1.4 kg
- tight and variably determined
- through the long and drilled hole it allows for universal all fast clamping/tensioning systems
- burnished

## L - series

### article no.

#### Universal Stop

- 325 L - 325 x 50 x 25 mm **0422**
  - weight: 2.1 kg
  - burnished
- 525 L - 525 x 50 x 25 mm **0424**
  - weight: 3.5 kg
  - burnished



## M - series

### article no.

#### Universal Stop

- 450 M - 450 x 75 x 25 mm **0440**
  - weight: 4.6 kg
  - burnished
- 650 M - 650 x 75 x 25 mm **0442**
  - weight: 6.6 kg
  - burnished



## S - series

### article no.

#### Universal Stop

- For stop and positioning on larger components
- 500 S - 500 x 100 x 25 mm **0430**
  - weight: 7.5 kg
  - burnished
- 750 S - 750 x 100 x 25 mm **0432**
  - weight: 11 kg
  - polished
- 1000 S - 1000 x 100 x 25 mm **0434**
  - weight: 15 kg
  - polished





**A series of heavy construction Stops and Clamping Squares**

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**It grows and grows and grows ....**

## **Squares for heavy constructions**

**Larger dimensions involve larger  
angles and larger surface.**

**Thanks to the modular  
construction, you only have to  
invest in what you really need.**

**And because the whole thing  
has been conceived on a building  
block system, you can use your  
tools again and again!**



**Vertical construction using S squares**





## L-Squares / U-Squares

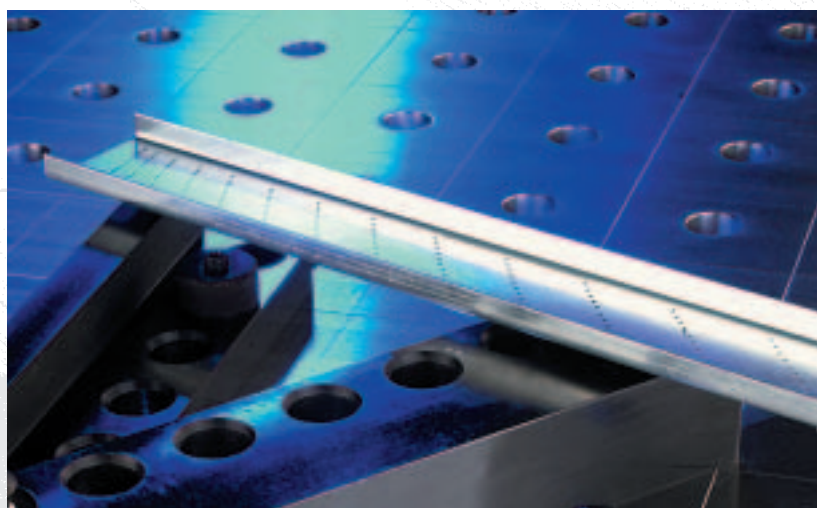


**U-Squares and M-Squares to extend the length and width of the worktable in one**



## **Universal Squares**

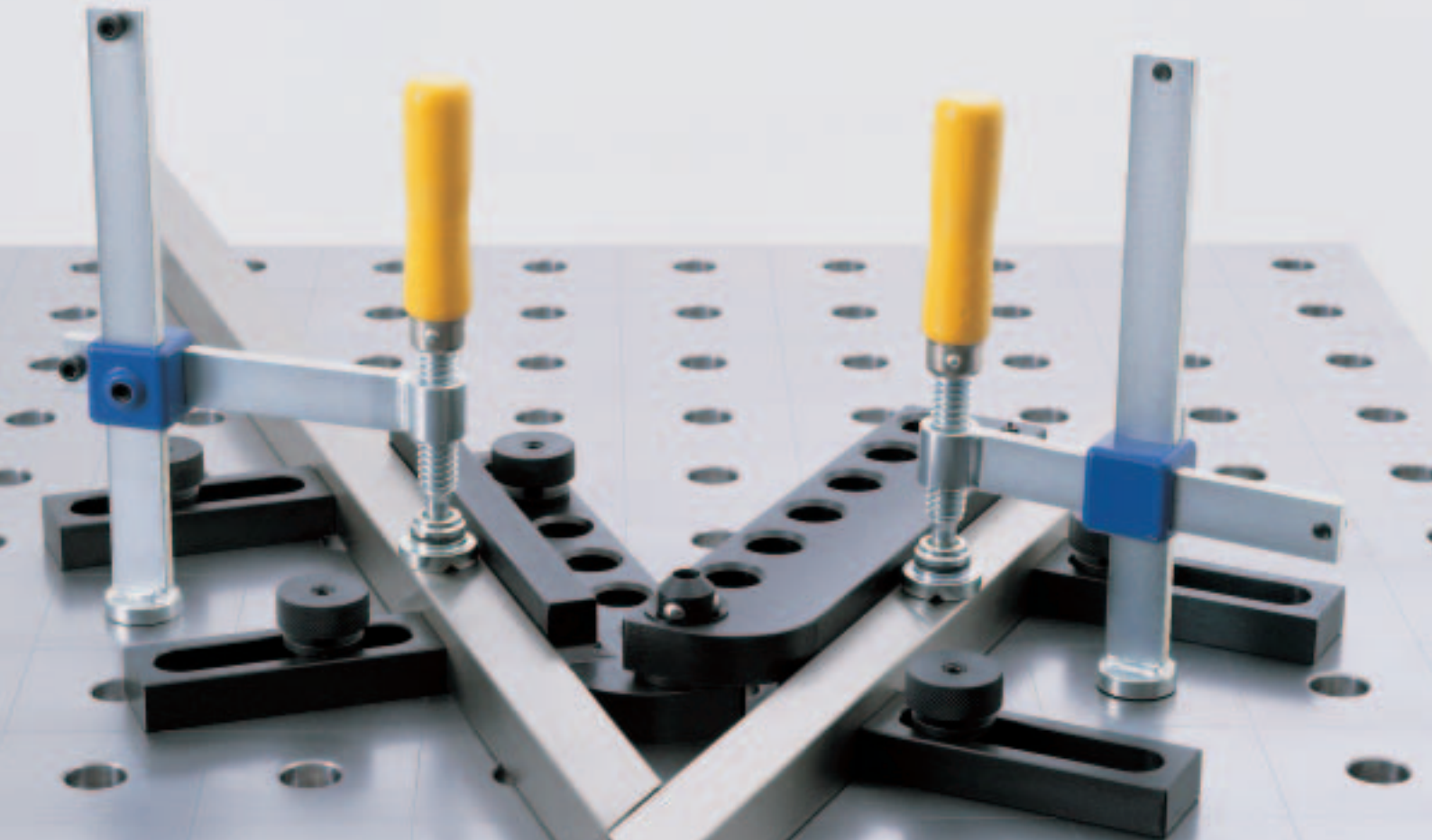
**It is good to be equipped with  
our angle template. Easily  
adjusted and fixed, angles  
can be precisely, quickly and  
effectively created - as often as  
you need. Continuous precision.  
(Adjustment range 15° - 150°)**



**Set the desired angle using the template, tighten with the inbus key**



- Compact construction
- High precision and exact repetition using the template and externally set setting pins
  - All parts are interchangeable
- Hardened bushing for maximum bolt tension power
  - Connecting bolts are sunk on one side



**Fixing the parts to be welded along the angles by using the clamps**



## Stop and Clamping Squares

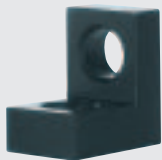
### article no. 0105

#### Stop and Clamping Square 75 L

75 x 75 x 50 mm

- weight: 1 kg

- Stop for large-framed profiles
- In combination with 0111 an adjustable supportive height circulation
- As support when combined with other clamping elements
- burnished



### article no. 0110

#### Stop and Clamping Square 175 L

175 x 175 x 50 mm

- weight: 2.1 kg

- Fixed or adjustable
- Two-sided
- burnished



### article no. 0112

#### Stop and Clamping Square 275 L

275 x 175 x 50 mm

- weight: 2.7 kg

- Fixed or variably adjustable
- Two-sided
- burnished



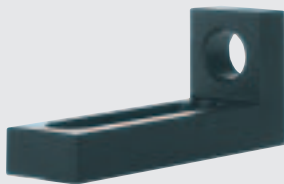
### article no. 0109

#### Stop and Clamping Square 175 SL

175 x 75 x 50 mm

- weight: 1.4 kg

- Ideal for Stop on large-framed profiles
- An adjustable supportive height circulation at all angles
- burnished



### article no. 0111

#### Stop and Clamping Square 175 WL

175 x 175 x 50 mm

- weight: 1.8 kg

- Flexible in each direction
- Combined with 0105/0109 as adjustable circulatory stop
- burnished



### article no.

#### Stop and Clamping Square

- 300 M - 300 x 200 x 75 mm **0150**

- weight: 7 kg

- burnished

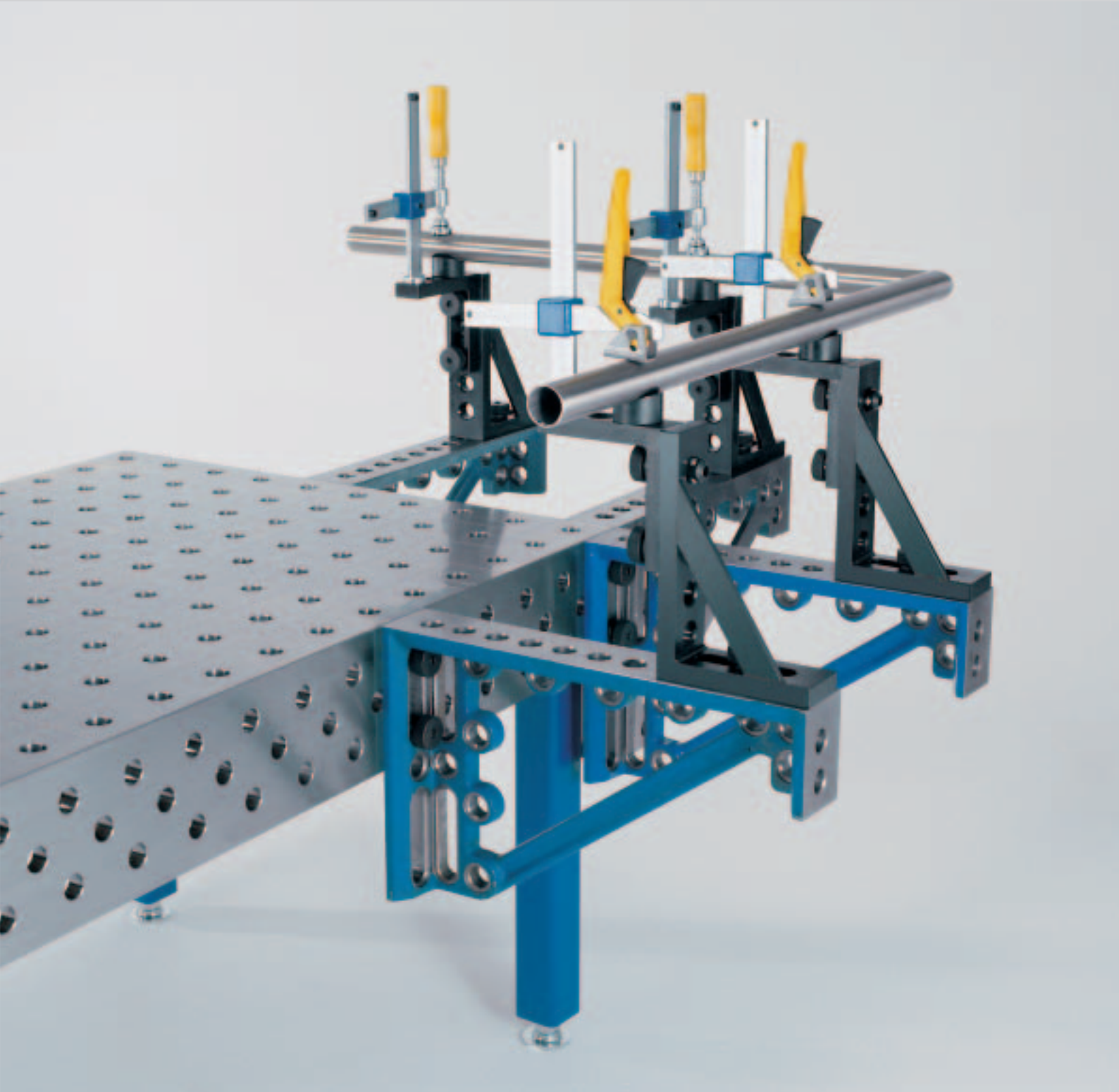
- 500 M - 500 x 200 x 75 mm **0160**

- weight: 10 kg

- burnished







**A part of the device**

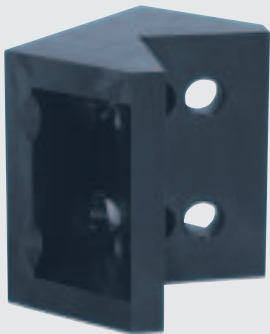
Bench and accessories formed according to the block construction principle with unlimited construction possibilities.



article no. 0190

## Corner connection Standard

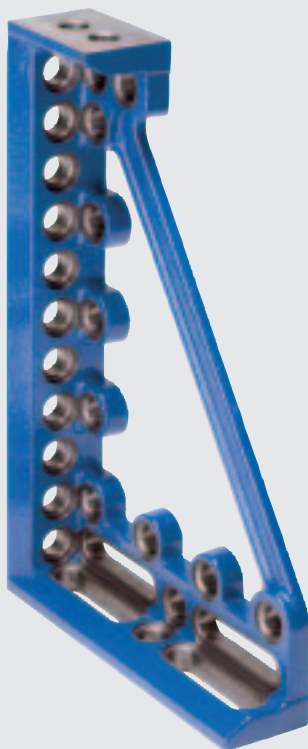
- weight: 13 kg
- Bench extension diagonally connected with corners.
- Also as universal Prism
- burnished



article no.

## Stop and Clamping Square 300 C

- left - 280 x 95 x 300 mm **0124**
- right - 280 x 95 x 300 mm **0126**
- weight: 12 kg
- (order in pairs)
- Fixed or variably adjustable
- four-sided
- lacquered/varnished
- Material GGG 40



article no.

## Stop and Clamping Square 600 C

- left - 380 x 95 x 600 mm **0134**
- right - 380 x 95 x 600 mm **0136**
- weight: 22 kg
- (order in pairs)
- Fixed or variably adjustable
- triangular
- lacquered/varnished
- Material GGG 40



article no.

## Stop and Clamping Square 800 C

- left - 380 x 95 x 800 mm **0144**
- right - 380 x 95 x 800 mm **0146**
- weight: 28 kg
- (order in pairs)
- Fixed or variably adjustable
- triangular
- lacquered/varnished
- Material GGG 40



**article no. 0170**

**Universal Square small**

- weight: 13 kg
- Shank length 300 mm
- Bolts counter-sunk on one side
- Completely adjustable (15° - 150°)
- Including positioning device and Allen Key 0852
- burnished



**article no.**

**L-Shape Square 100x200x500**

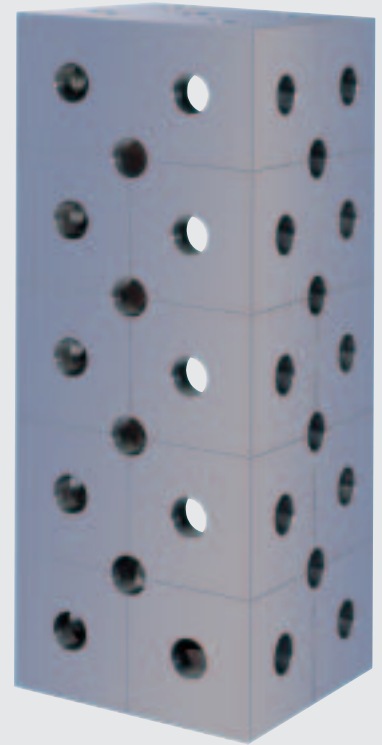
- 100 x 200 x 500 mm **0310**
- 100 x 200 x 1000 mm **0320**
- 100 x 200 x 1500 mm **0330**
- 100 x 200 x 2000 mm **0340**
- Holes on all four sides
- Connection from table to table
- For vertical constructions
- Weighs per 500 mm approximately. 25 kg
- Polished



**article no.**

**U-Shape Square 200x200x500**

- 200 x 200 x 500 mm **0360**
- 200 x 200 x 1000 mm **0370**
- 200 x 200 x 1500 mm **0380**
- 200 x 200 x 2000 mm **0390**
- Holes on all five sides
- Connection from table to table
- For vertical constructions
- Weighs per 500 mm approximately. 25 kg
- Polished



**article no. 0171**

**Universal Square big**

- weight: 22 kg
- Shank length 475 mm
- Hydromechanical Clamping
- Completely adjustable (0° - 225°)
- 14 mm Allen key
- lacquered

**Connection to table using 0550 and 0560 bolts**



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**Prisms**

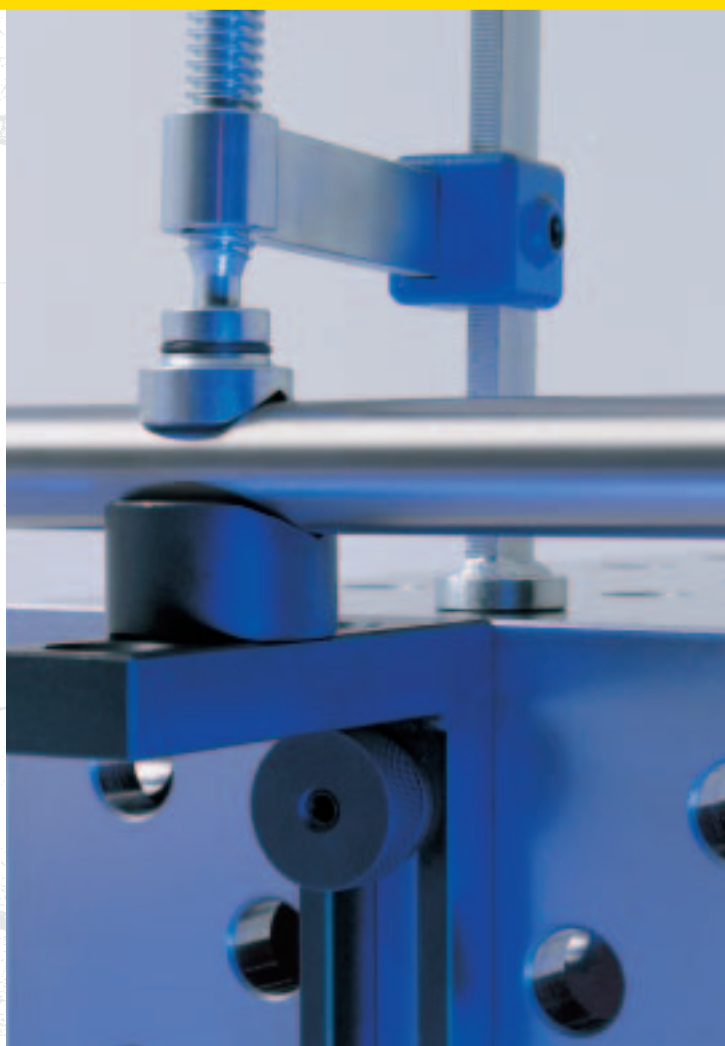
**The correct choice!**

## **Prisms**

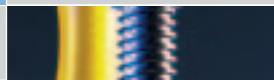
**This round is on you!**

**Special shapes need to be  
specially held.**

**For clamping round shapes,  
we have special V-shaped  
holders, fitting into all  
28 mm holes without  
damaging the them.**







#### article no.

##### **Prism 120**

Ø 120 mm

- for Round and Square pipes
- Suitable for all 28 mm drilled holes
- burnished **0652**
- galvanized **0652-Z**

#### article no.

##### **Prism 60**

Ø 60 mm

- for round pipes
- suitable for all 28 mm drilled holes
- burnished **0651**
- aluminium **0651-A**
- polyamide **0651-P**

#### article no.

##### **Vario Prism 50**

Ø 50 mm

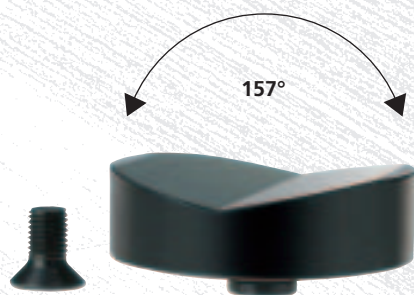
- for round and rectangular pipes
- suitable for all 28 mm drilled holes
- burnished **0645**

#### article no.

##### **Duo Prism 40**

Ø 40 mm

- for clamps and 28 mm drilled holes
- with O-ring
- burnished **0650**
- aluminium **0650-A**
- polyamide **0650-P**
- galvanized **0650-Z**





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## **Clamping bolts**

**Simple, safe, fixed - no compromises**

## **Clamping bolts**

**At the heart of every clamping system in the clamping bolt. Stable, exact, powerful in retention and easy to clean. Based on a globally accepted ball clamping bolt, we have consequently developed it into a tool truly usable with just one hand.**



The clamping bolt is additionally hardened and made out of highquality material. All parts are exchangeable.



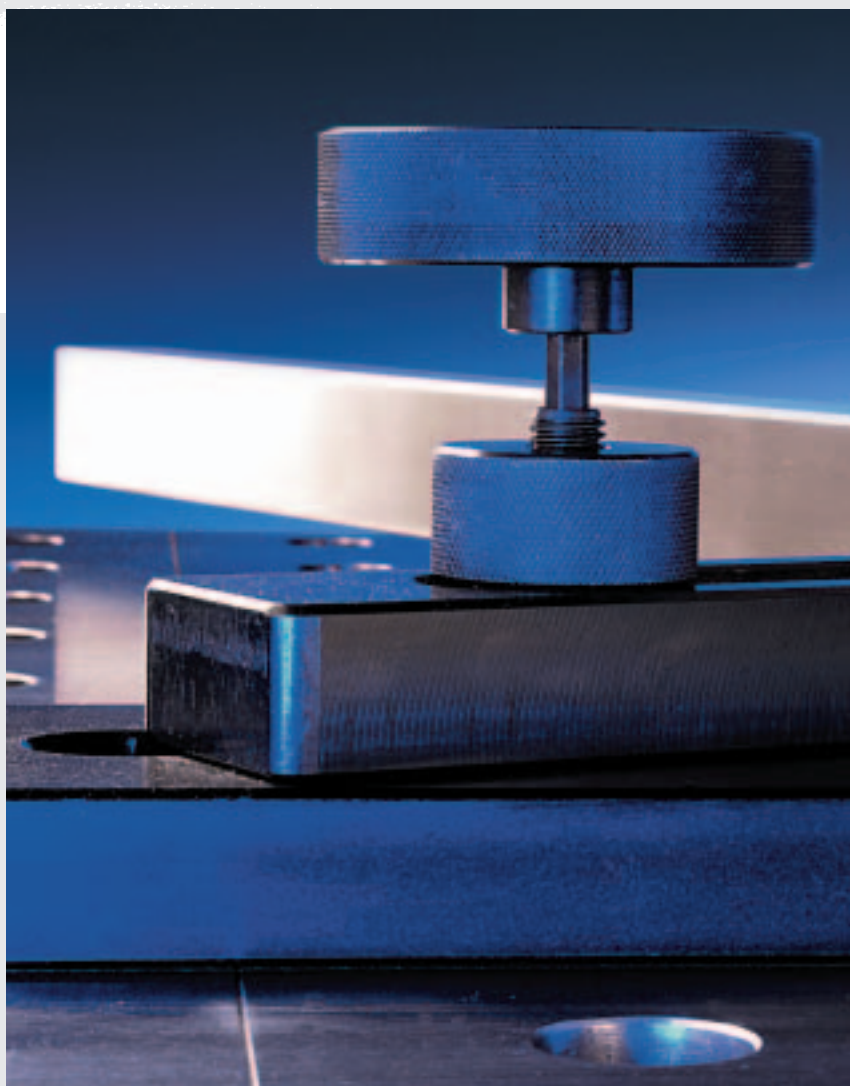
**Stable · exact · powerful in retention**



- Large bearing diameter (13 mm)
- Simple to disassemble
- Easy to clean
- Good holding power with easy tightening
- Spare parts available



The bearing bolt can be set and tightened with one hand while the other hand holds the part to be clamped.



Long bolts for connecting several clamping tools.



## Bolts

**article no. 0510**

**Fast Clamping Bolt with turn-lock fastener short**

- for clamping of two components
- with integrated handwheel
- with Allen Key
- burnished



**article no. 0512**

**Fast Clamping Bolt with turn-lock fastener long**

- for clamping of three components
- with integrated handwheel
- with Allen Key
- burnished



**article no. 0520**

**Clamping Bolt short**

- with Allen Key inside
- Simple tightening without counterholder, with handle 0840 or 0850
- burnished



**article no. 0530**

**Clamping Bolt long**

- clamped by 3 components
- otherwise like Pos. 0520
- burnished



**article no. 0532**

**Positioning Bolt short**

- For Allen key 14
- Compatible to all table systems with 28 mm holes
- burnished



**article no. 0533**

**Positioning Bolt long**

- clamped by 3 components
- otherwise like Pos. 0532
- burnished



**article no. 0528**

**Counterunk Bolt with balls short**

- For hidden application
- with Allen key inside
- burnished



**article no.**

**Connecting Bolt countersunk**

- with countersunk Allen key inside
- Long-term connection
- Self-centering
- suitable for long hole
- also for hidden applications
- burnished
- for connecting 2 components
- short **0560**
- for connecting 3 components
- long **0561**



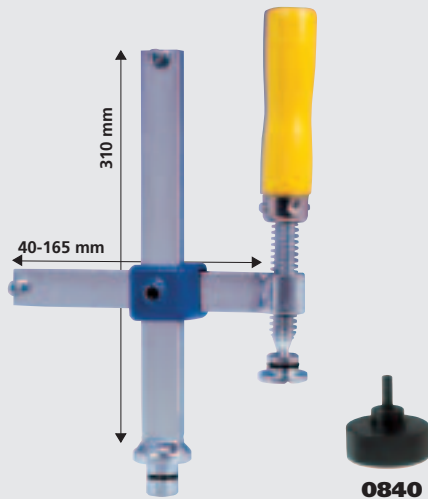


## Clamps

article no. 0610

### Screw Clamp Standard

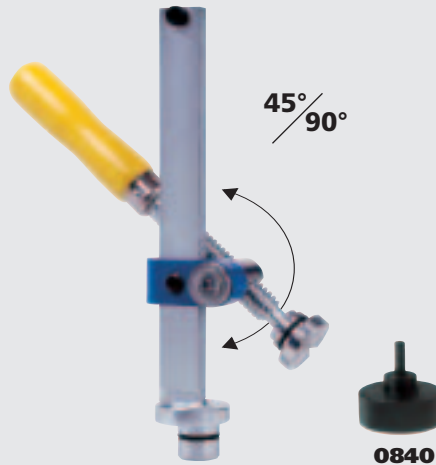
- 50-180 mm
- completely adjustable
- exchangeable prisms
- galvanized



article no. 0630

### Screw Clamp 45°/90°

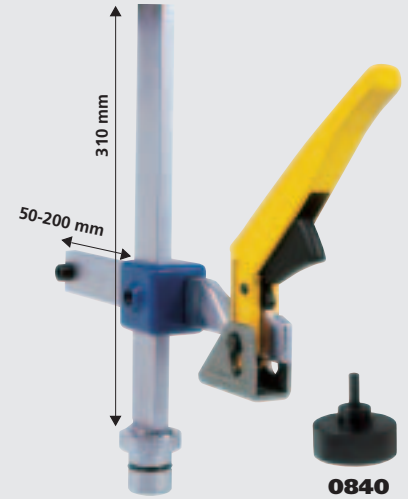
- completely adjustable 0-360°
- exchangeable prisms
- galvanized



article no. 0615

### Fast Tension Clamp

- 50-200 mm
- for shortest clamping time / period
- galvanized



article no. 0540

### Positioning Bolt

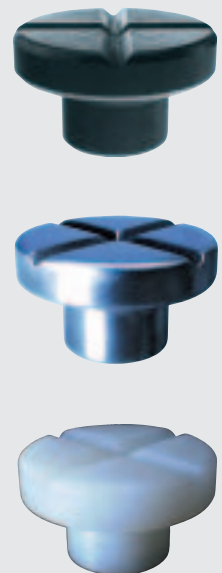
- easily constructed at an angle of 90°, with 3 bolts.
- for positioning angles and clamps
- as support
- burnished



article no.

### Connecting Bolt hexagonal

- Hexagonal model
- Long-term connection
- Self-centering
- inexpensive Spherical Bolt substitute parts
- suitable for long hole
- burnished
- for connecting 2 components
- short **0550**
- for connecting 3 components
- long **0551**



article no.

### Prism for screw clamp

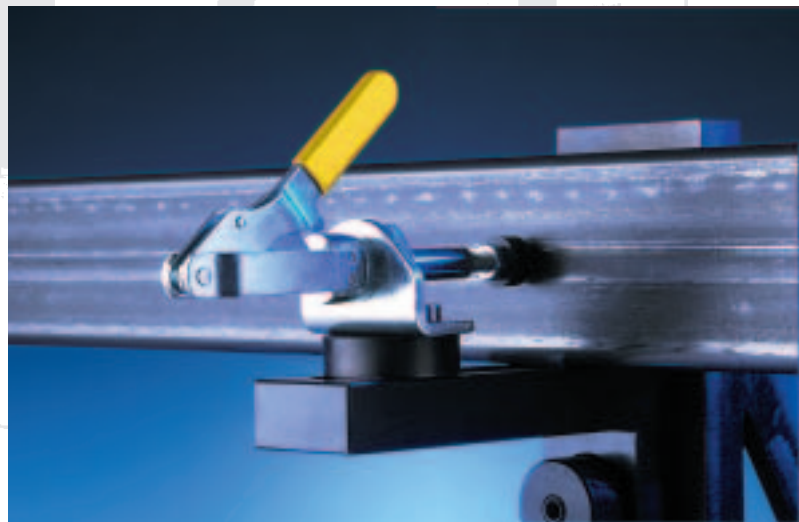
- burnished **0657**
- stainless steel **0658**
- polyamide **0659**



## **Fast clamping equipment**

**Ready for large series production!**

**Increases your production by being flexible. A special adapter gives you the opportunity of using well-established fast clamping systems in your production.**



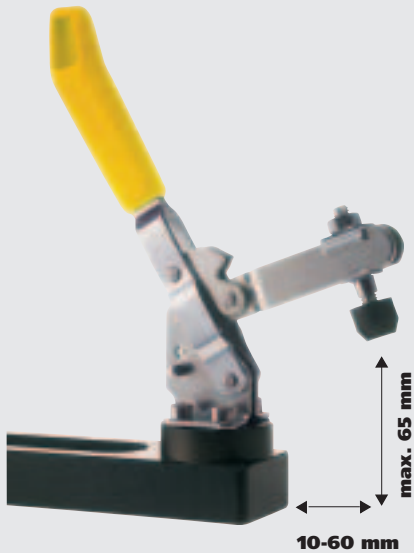


#### article no. 0705

##### **Vertical clamp with adapter**

(delivered without stop iron)

- suitable for all 28 mm drilled holes
- with O-ring
- adapter burnished

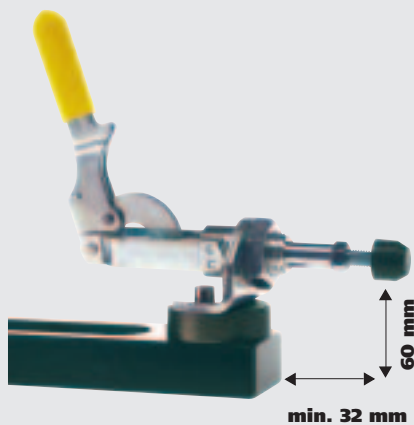
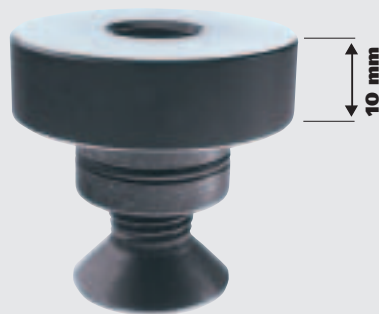


#### article no. 0720

##### **Raw Adaptor**

Ø 48 mm

- weight: 0.3 kg
- Usable in all 28 mm holes
- with O-ring
- burnished

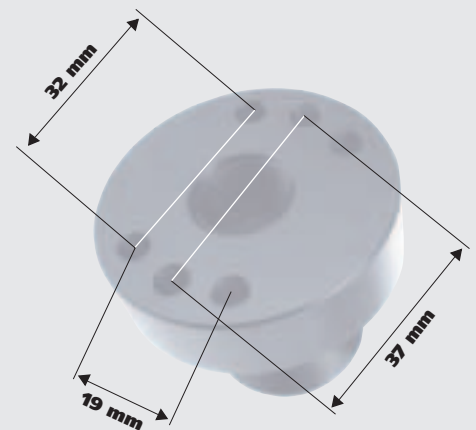


#### article no. 0710

##### **Connecting rod clamp with adapter**

(delivered without stop iron)

- suitable for all 28 mm drilled holes
- with O-ring
- adapter burnished



#### article no. 0715

##### **Adapter for fast tensioner**

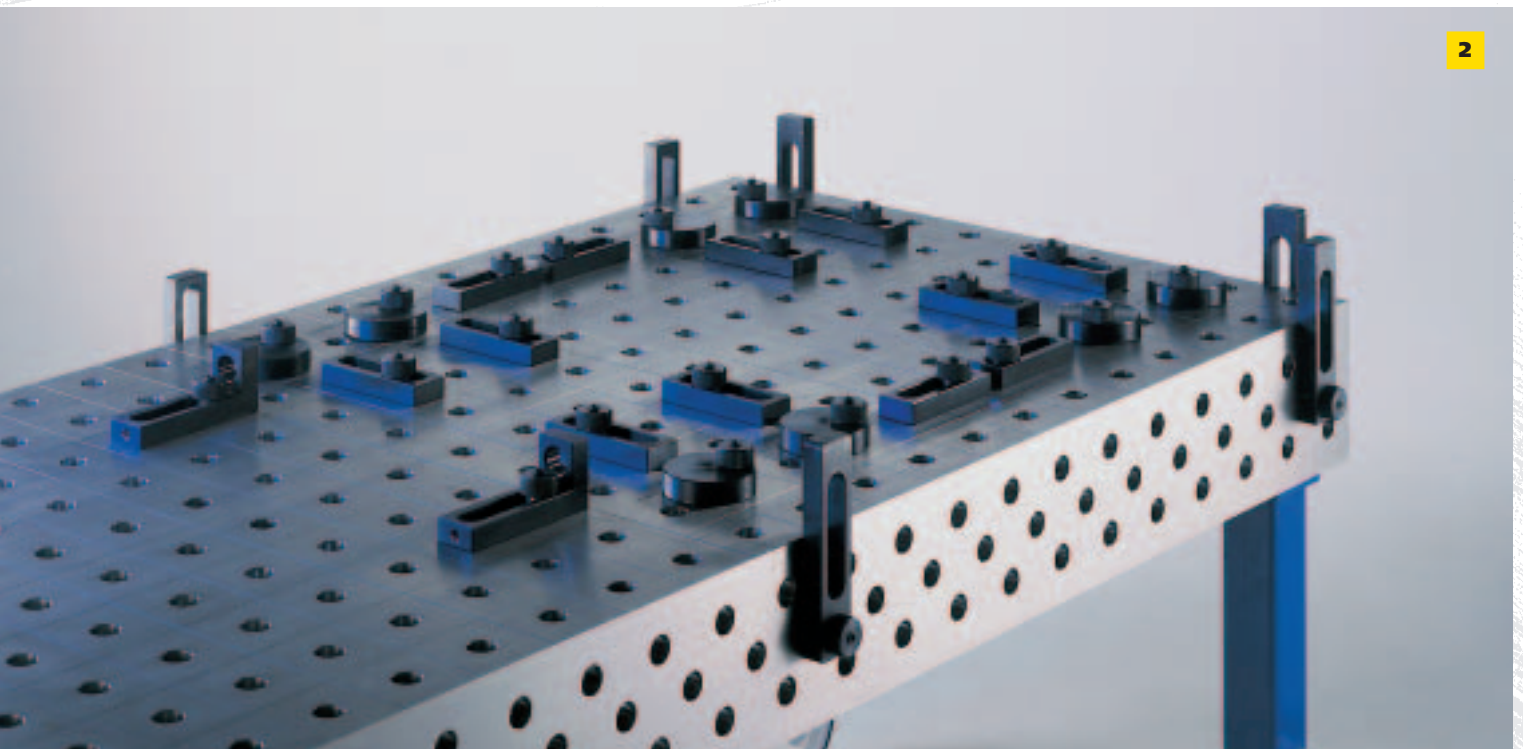
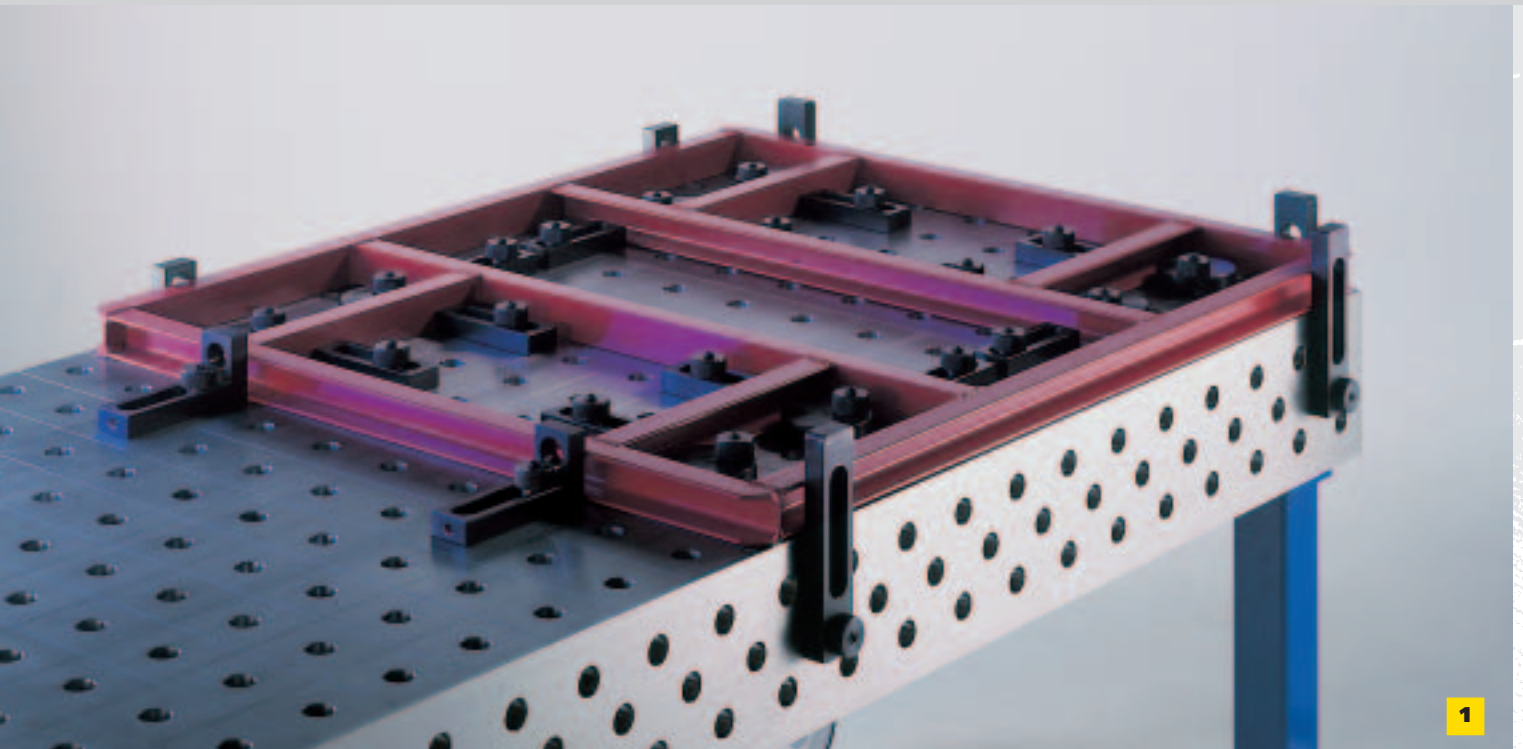
Ø 48 mm

- weight: 0.3 kg
- For fast tension clamp with distance between holes according to drawing or customer preferences
- Usable in all 28 mm holes
- with O-ring
- burnished



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**This is how you can build-up your assembly quickly and precisely!**



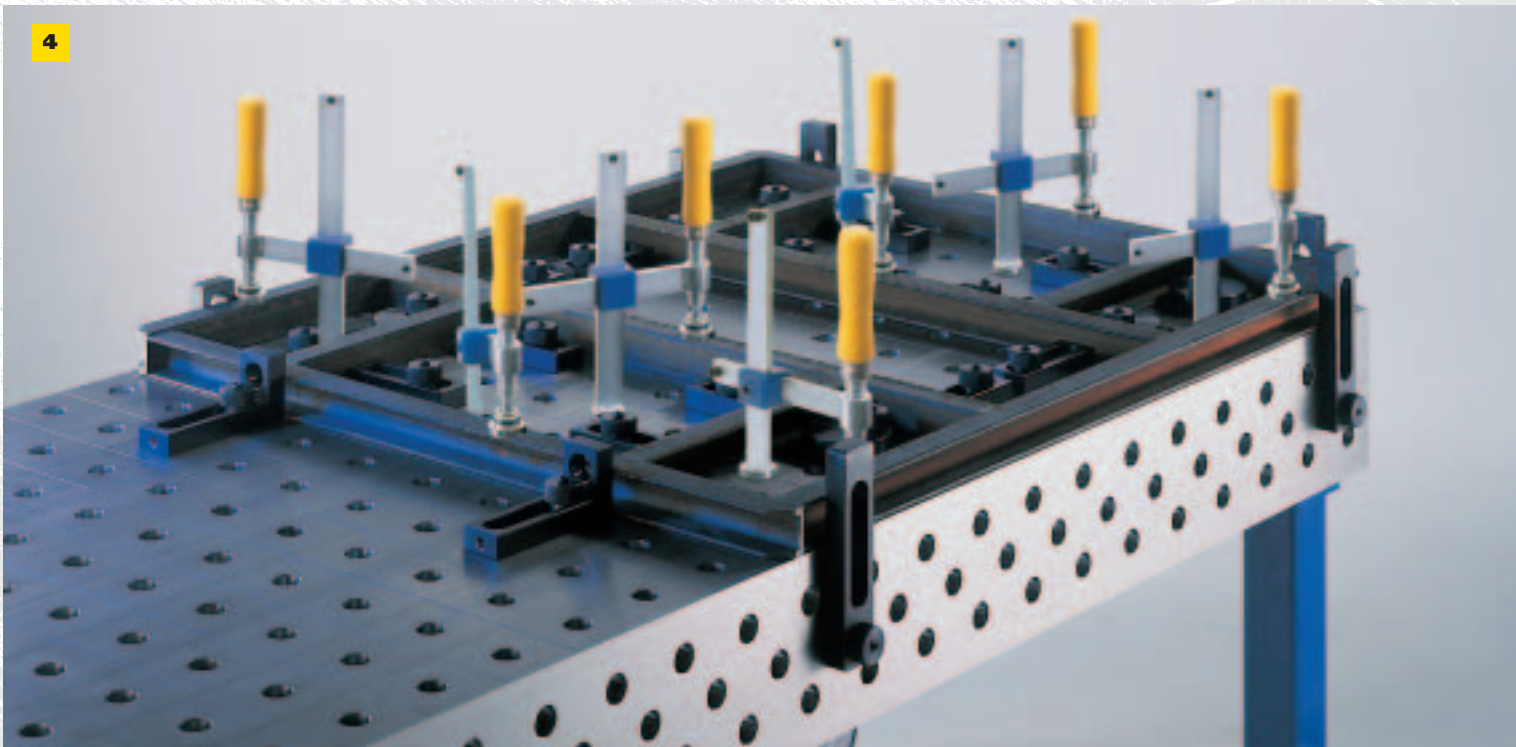
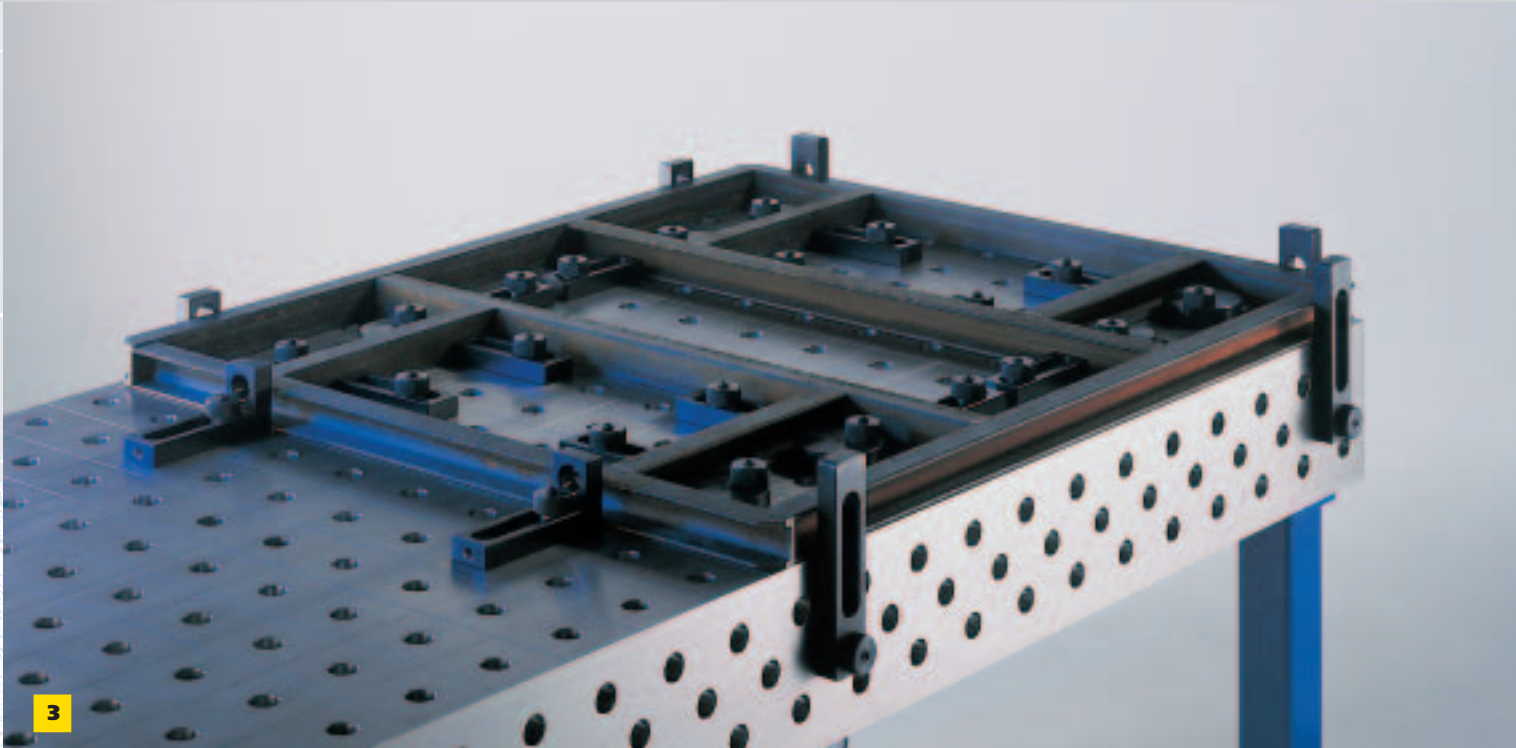
Place the prototype or part of a previous series on the bench and position the stops as desired, giving the desired play

Remove the prototype and your set-up is ready (approx. 10 minutes).

Spray bench and device with S4-Antistick. (dries out after a few minutes)

Taking a photo for documentation is useful.





3

Cut parts layed together. If needed, the parts you want to weld has to have a distance between the table and the part. Parts which had been sprayed by anti-tick-liquid and to be cleaned, then finally lacquered.

4

Clamp, haste and remove (if needed, you can weld without hasteing) and insert the next part



**Prisms · Bolts · Clamps**

## **Accessories**

**Keeping order in half the job!**

**Well sorted and quickly at  
hand - saves nerves and time  
for searching.**

**Your entire tool set has room  
on our trolley.**

**Your service mobile!**

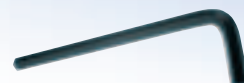
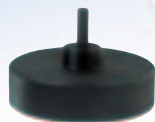


**This is how you can save your tools to damages**

**article no. 0910**

**Tool trolley**





**article no. 0840**

**Allen key Handwheel**  
Ø 50 mm  
- 6 mm Allen Key  
- suitable for Spherical  
clamping bolts  
0510, 0520, 0530

**article no. 0850**

**Allen key Handwheel**  
Ø 75 mm  
- 6 mm Allen key  
- suitable for Spherical  
clamping bolts  
0510, 0520, 0530

**article no. 0820**

**Brush**  
Ø 30 mm  
- for cleaning 28mm inch  
drilled holes

**article no. 0852**

**Allen key 6**  
- 6 mm Allen key  
- suitable for bearing  
bolts (0510, 0520, 0530)  
and universal-angle small  
(0170)

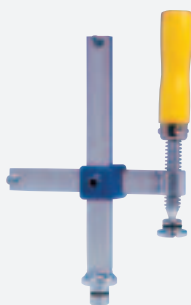
**article no. 0854**

**Allen key 14**  
- 14 mm Allen Key  
- suitable for positioning  
bolts (0532, 0533) and  
universal-angle large  
(0171)



# Sets

## Tools set 1.1



4 x 0610



1 x 0402



1 x 0840



12 x 0520 \*



12 x 0410



1 x 0820

**Article No. 3100-1**

## Tools set 2.1



8 x 0610



1 x 0402



1 x 0840



24 x 0520 \*



12 x 0410



12 x 0110



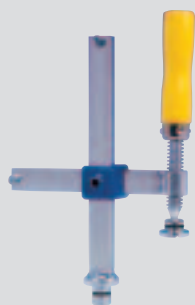
1 x 0820

**Article No. 3200-1**

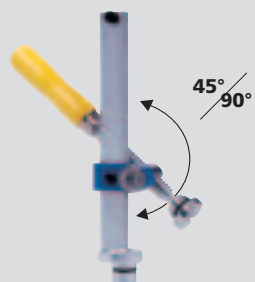
**\* Article 0520 / 0530 could be delivered against a slightly higher price as fast clamping bolt (article 0510 / 0512).**



### Tools set 3.1



12 x 0610



4 x 0630



1 x 0402



1 x 0840



36 x 0520 \*



12 x 0410



12 x 0420



8 x 0651

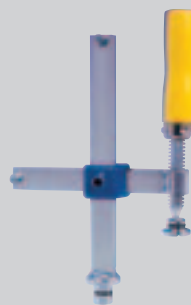


12 x 0110

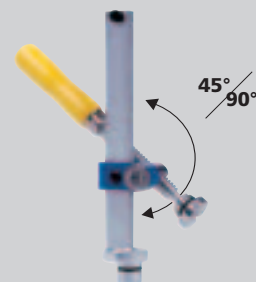


1 x 0820

### Tools set 4.1



16 x 0610



8 x 0630



1 x 0402



1 x 0840



36 x 0520 \*



12 x 0410



12 x 0420



8 x 0651



12 x 0110



1 x 0820



4 x 0430



4 x 0160



1 x 0910

Article No. 3300-1

Article No. 3400-1



## Antistick

**Allow your welding bench a longer life.**

**S4 Antistick works through creating a light metal dividing face and prevents the sticking of welding sparks from steel. Compare the effect with normal welding dividing anti stick sprays!**

**S4 Antistick is affected through the creation of a light metal separate layer and prevents the adhesion of the welding nozzle on steel and cast iron surfaces. Compare it with usual sprays!**



**article no. 0924**

**S4 Anti-stick liquid 1 kg**  
Spray bottle



**article no. 0922**

**S4 Anti-stick liquid 1kg**  
Canister



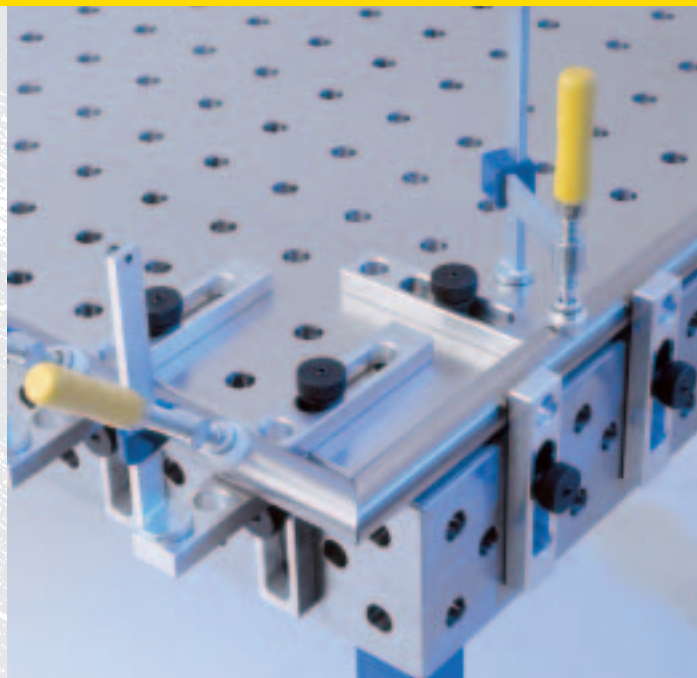
**article no.**

**S4 Anti-stick liquid**  
Canister  
- 5 kg **0926**  
- 33 kg **0928**

**Cleaning concentrate on request!**



## Aluminium Plate for stainless steel works



**If you work with iron and stainless steel on the table, think about using an aluminium plate. The plate has got the same holes as the bench and separates the iron from the stainless steel.**

**articleno.:**

**Aluminium plate**

- 996 x 996 x 2 mm **0200**
- 1996 x 996 x 2 mm **0201**
- 2396 x 1196 x 2 mm **0202**
- 2996 x 1496 x 2 mm **0203**





Bernd Sigmund Gruppe

## **System 28 Welding and Clamping Bench**

► **Manufacturer:**

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[www.weldingtables.com](http://www.weldingtables.com)

► **Your distributor:**

