

Grip range influences

The following values can be used as a guidance for other versions :

TYPE	Grip	ALUMINIUM			STEEL			STAINLESS STEEL 304 + 316		
		SETTING FORCE	STROKE	PULL-OUT	SETTING FORCE	STROKE	PULL-OUT	SETTING FORCE	STROKE	PULL-OUT
		N	mm	N	N	mm	N	N	mm	N
M3 UPO 20	1,0	2000	2,0	3750	4000	2,5	> 5000			
	2,0	2600	1,5	3280	4750	2,0	> 5000			
M3 UPO 30	2,0	1850	1,5	3900	3700	2,5	> 5000			
	3,0	2050	1,0	3968	4750	2,0	> 5000			
M4 UPO 20	1,0							4900	2,0	> 9000
	2,0							5500	1,5	> 9000
M4 UPO 30	1,0	2100	3,0	5170	4300	2,5	> 8000			
	3,0	2430	1,0	4330	5650	1,5	> 8000			
M4 UPO 35	2,0							5500	2,6	> 9000
	3,5							6000	1,7	> 9000
M4 UPO 45	3,0	2050	2,8	4838	4200	2,5	> 8000			
	4,5	2875	1,5	4421	5000	1,5	> 8000			
M5 UPO 30	1,0	3050	3,5	5500	6150	3,5	12240	7500	3,0	> 15000
	3,0	3650	2,0	5000	7200	2,5	9600	8500	1,7	> 15000
M5 UPO 50	3,0							7500	4,0	> 15000
	5,0							8500	2,0	> 15000
M5 UPO 55	3,0	3000	3,5	6450	5750	4,0	11800			
	5,5	4300	1,5	5525	9650	2,0	10300			
M6 UPO 30	1,0	4500	3,0	11000	9400	4,0	21200	11850	4,0	> 24000
	3,0	5750	2,0	10000	12000	3,0	18500	14460	3,0	> 24000
M6 UPO 50	3,0							13500	4,5	> 24000
	5,0							15000	2,8	> 24000
M6 UPO 55	3,0	4500	3,5	11000	9000	3,5	22700			
	5,5	6100	1,8	10000	11000	2,0	19700			
M6 UPO 80	5,5	4950	4,7	9160	8700	4,0	19900			
	8,0	5400	2,0	8200	11750	2,5	17200			
M8 UPO 30	1,0	5000	3,0	14900	11500	4,0	30400	14500	4,2	> 41000
	3,0	6600	2,0	14000	13750	2,5	26100	18000	2,8	> 41000
M8 UPO 55	3,0	5400	4,0	15500	11500	4,0	32500	14500	5,5	> 41000
	5,5	7400	2,0	11200	15500	2,5	31900	18500	3,0	> 41000

TYPE	Grip	ALUMINIUM			STEEL			STAINLESS STEEL 304 + 316		
		SETTING FORCE	STROKE	PULL-OUT	SETTING FORCE	STROKE	PULL-OUT	SETTING FORCE	STROKE	PULL-OUT
		N	mm	N	N	mm	N	N	mm	N
M8 UPO 80	5,5	5900	4,0	16100	10700	4,0	32400			
	8,0	7850	2,0	13600	14700	2,5	26500			
M10 UPO 30	1,0							14500	3,5	> 45000
	3,0							18500	2,5	> 45000
M10 UPO 35	1,0	6750	4,0	22100	13600	4,5	39600			
	3,5	9000	2,5	17700	17000	2,5	32400			
M10 UPO 50	3,0							14500	3,5	> 39500
	5,0							18500	2,5	> 37000
M10 UPO 60	3,5	9000	5,0	25250	14900	4,0	42300			
	6,0	13000	3,0	23000	17900	2,5	31700			
M10 SPO 35	1,0				13500	4,5	40500	19500	4,5	> 45000
	3,5				16100	2,5	36100	26500	3,5	> 45000
M10 SPO 60	3,5				15900	5,5	48000			
	6,0				20400	3,0	37500			
M12 UPO 40	1,0				19500	5,5	> 50000			
	4,0				25000	4,0	> 50000			
M12 UPO 70	4,0				19500	5,5	> 50000			
	7,0				25000	4,0	> 50000			

Setting Force or Upset Load: Force (in Newton) necessary to deform the **TUBTARA®** referred to in an adequate way.

Upset Stroke: Stroke (in mm) that should be set on the setting tool to give the **TUBTARA®** referred to, the adequate deformation.

Pull-out or Ultimate Thread Strength: Surpassing this ultimate force (in Newton), the thread of the set **TUBTARA®** will be pulled out.

The mentioned values are average reference values only.

We strongly advise the customer to do his own tests in the proper material thickness and specific application.