

SYSTEM 28

FOR HEAVY DUTY APPLICATIONS



MATERIALS

Material thickness approx. 24,5 – 27 mm

PROFESSIONAL 750

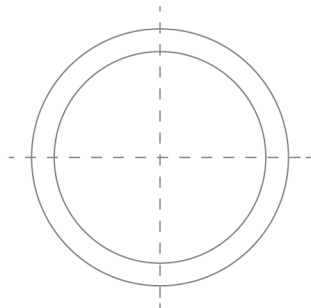
Steel S355J2+N,
plasma nitrided and BAR-coated

PROFESSIONAL EXTREME 8.7 / 8.8

Hardened tool steel X8.7 / X8.8,
plasma nitrided and BAR-coated

BOREHOLE Ø 28 MM

1. Boreholes on the surface in diagonal grid or 100x100 mm grid
2. Boreholes with radius 3 mm
3. Radius 3 / 6 mm on table edges and corners
4. Height of table side 200 mm
Borehole spacing of table side 50 mm
5. With scaling on the surface
6. Construction reinforced with ribbing



Supplied By

Surtech

Since 2004

www.welding-tables.co.uk



OUR RECOMMENDATION: ANTI-SPATTER TO EVERY WELDING TABLE

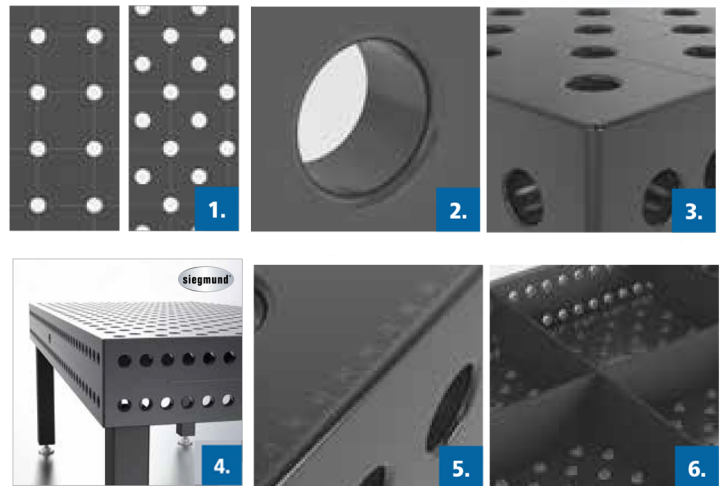
The non-flammable, water-soluble Anti-Spatter prevents the adhesion of welding spatters, in addition to the plasma nitration.



ACCESSORIES-SET 283999

(Free in all sets)

- 280402.N Eccentric Stop
- 280852.1 Allen Wrench
- 280820 Brush
- 000940 Oilstone
- 000911 Sample CleanBasic
- 000921 Sample Anti-Spatter
- 280920 Burner Holder



TABLES	PROFESSIONAL 750			PROFESSIONAL EXTREME 8.7		PROFESSIONAL EXTREME 8.8	
Table size	100x100 mm Grid without Plasma nitration ¹	100x100 mm Grid with Plasma nitration ²	Diagonal grid with Plasma nitration ²	100x100 mm Grid with Plasma nitration ²	Diagonal grid with Plasma nitration ²	100x100 mm Grid with Plasma nitration ²	Diagonal grid with Plasma nitration ²
1,0 x 1,0 m 4 Legs approx. 415 kg	4-280010 ○	4-280010.P ●	4-280010.PD ○	4-280010.X7 ●	4-280010.XD7 ●	4-280010.X ○	4-280010.XD ○
1,2 x 0,8 m 4 Legs approx. 408 kg	4-280025 ○	4-280025.P ○	4-280025.PD ○	4-280025.X7 ○	4-280025.XD7 ●	4-280025.X ○	4-280025.XD ○
1,2 x 1,2 m 4 Legs approx. 544 kg	4-280015 ○	4-280015.P ●	4-280015.PD ○	4-280015.X7 ●	4-280015.XD7 ●	4-280015.X ○	4-280015.XD ○
1,5 x 1,0 m 4 Legs approx. 577 kg	4-280035 ○	4-280035.P ●	4-280035.PD ○	4-280035.X7 ●	4-280035.XD7 ●	4-280035.X ○	4-280035.XD ○
1,5 x 1,5 m 4 Legs approx. 801 kg	4-280050 ○	4-280050.P ○	4-280050.PD ○	4-280050.X7 ○	4-280050.XD7 ●	4-280050.X ○	4-280050.XD ○
2,0 x 1,0 m 4 Legs approx. 730 kg	4-280020 ○	4-280020.P ●	4-280020.PD ●	4-280020.X7 ●	4-280020.XD7 ●	4-280020.X ●	4-280020.XD ●
2,0 x 1,2 m 4 Legs approx. 843 kg	4-280060 ○	4-280060.P ○	4-280060.PD ○	4-280060.X7 ○	4-280060.XD7 ●	4-280060.X ○	4-280060.XD ○
2,0 x 2,0 m 4 Legs approx. 1.300 kg	4-280045 ○	4-280045.P ○	4-280045.PD ○	4-280045.X7 ○	4-280045.XD7 ●	4-280045.X ○	4-280045.XD ○
2,4 x 1,2 m 4 Legs approx. 986 kg	4-280030 ○	4-280030.P ●	4-280030.PD ●	4-280030.X7 ●	4-280030.XD7 ●	4-280030.X ●	4-280030.XD ●
3,0 x 1,5 m 6 Legs approx. 1.518 kg	4-280040 ○	4-280040.P ●	4-280040.PD ●	4-280040.X7 ●	4-280040.XD7 ●	4-280040.X ●	4-280040.XD ●
4,0 x 2,0 m 8 Legs approx. 2.503 kg	4-280055 ○	4-280055.P ●	4-280055.PD ○	4-280055.X7 ●	4-280055.XD7 ●	4-280055.X ○	4-280055.XD ○

● = Item produced for stock ○ = Item produced to order

¹without Plasma nitration
 Unprotected against rust, scratches and welding spatters. Protection against welding spatters is only given by using anti-spatter spray.
 Due to the lack of material hardness of Professional 750 significantly higher product wear.

²with Plasma nitration
 Well protected against rust, scratches and weld spatter.
 All tables without plasma nitriding are also available upon request.

TABLE LEGS



Standard equipment



Standard equipment, alternative height



Height adjustable



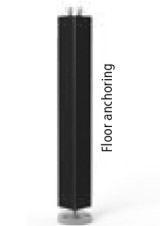
Height adjustable, alternative height



Caster, locking brake



Height adjustable, caster, locking brake



Floor anchoring

Item No.	280858.X	280857.X ³	4-280878.XX	4-280877.XX	4-280876.XX ⁴	4-280879.XX ⁴	4-280874.XX
Capacity per table leg	2.000 kg	2.000 kg	2.000 kg	2.000 kg	800 kg	800 kg	2.000 kg
Leg height	650 mm	750 mm	450 – 700 mm	550 – 900 mm	650 mm	550 – 750 mm	650 mm
Table height	850 mm	950 mm	650 – 900 mm	750 – 1.100 mm	850 mm	750 – 950 mm	850 mm
Fine adjustment	50 mm	50 mm	50 mm	50 mm	20 mm	20 mm	50 mm

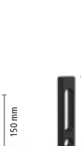
³ **Standard equipment, alternative height:** Available without a surcharge.

⁴ **Note caster:** Not recommended for welding tables with 6 or 8 table legs.

SETS



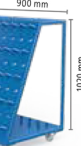








	Clamp	Clamp	Prism	Bolt	Magnetic Bolt	Stop	Stop	Stop	Square	Square	Square	Rotation Angle	Square	Square	Tool Cart
Material	Nitrided	Nitrided	Burnished	Burnished	Aluminum	Nitrided	Nitrided	Nitrided	Nitrided	Nitrided	Nitrided	Nitrided	Nitrided	Nitrided	
Item No.	280610.N	280630.N	280648.1	280510	280740	280410.N	280420.N	280430.N	280110.N	280152.N	280162.N	280164+65.N	280166+67.N	280144+46.N	280910
Set 1.1: 4-283100.1	4 x	2 x	2 x	12 x		4 x	4 x		2 x	2 x					
Set 2.1: 4-283200.1	6 x	4 x	4 x	18 x	4 x	6 x	6 x		4 x	2 x	2 x				
Set 3.1: 4-283300.1	10 x	6 x	4 x	24 x	4 x	8 x	8 x		6 x	2 x	2 x		1 x + 1 x		
Set 4.1: 4-283400.1	14 x	10 x	6 x	30 x	8 x	10 x	10 x	4 x	8 x	2 x	2 x	1 x + 1 x	1 x + 1 x		1 x
Set 5.1: 4-283500.1	14 x	10 x	8 x	36 x	8 x	12 x	12 x	4 x	12 x	2 x	2 x	1 x + 1 x	1 x + 1 x	1 x + 1 x	1 x

WELDING TABLES

The materials used are fundamental to the high level of hardness and long service life.

The choice of a Siegmund table is a long term saving thanks to the high level of precision engineering and the consistent superior quality.



PROFESSIONAL 750¹

without Plasma nitriding

Basic hardness approx. 165 – 220 Vickers



Specific base material
S355J2+N



PROFESSIONAL 750

with Plasma nitriding

Basic hardness approx. 165 – 220 Vickers
Surface hardness approx. 450 – 750 Vickers



BAR-Coating
iron nitride
Transient region
Specific base material
S355J2+N



Our bestsellers Professional Extreme 8.7 and 8.8:
Exceptional hardness and a long service life



PROFESSIONAL EXTREME 8.7

with Plasma nitriding

Basic hardness approx. 280 – 340 Vickers
Surface hardness approx. 450 – 850 Vickers



BAR-Coating
iron nitride
Transient region
Through-hardened tool steel out of
special alloy Siegmund X8.7



PROFESSIONAL EXTREME 8.8

with Plasma nitriding

Basic hardness approx. 360 – 420 Vickers
Surface hardness approx. 500 – 900 Vickers



BAR-Coating
iron nitride
Transient region
Through-hardened tool steel out of
special alloy Siegmund X8.8



The hardening test –
Professional Extreme:
www.siegmund.com/
ViplasmaNitriding

Hardness in Vickers	Basic hardness approx. 165 – 220 Vickers	Basic hardness approx. 165 – 220 Vickers Surface hardness approx. 450 – 750 Vickers	Basic hardness approx. 280 – 340 Vickers Surface hardness approx. 450 – 850 Vickers	Basic hardness approx. 360 – 420 Vickers Surface hardness approx. 500 – 900 Vickers
Material	 Specific base material S355J2+N	 BAR-Coating iron nitride Transient region Specific base material S355J2+N	 BAR-Coating iron nitride Transient region Through-hardened tool steel out of special alloy Siegmund X8.7	 BAR-Coating iron nitride Transient region Through-hardened tool steel out of special alloy Siegmund X8.8
Basic hardness	★ ★	★ ★	★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★ ★ ★
Surface hardness	★ ★	★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★ ★ ★ ★ ★
Impact-proof	★ ★	★ ★ ★	★ ★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★ ★ ★ ★ ★
Scratch-proof	★ ★	★ ★ ★ ★	★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★ ★ ★
Protection against weld spatter	★	★ ★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★ ★
Corrosion resistance	★	★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★
Point Load	★ ★ ★	★ ★ ★ ★	★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★
Flatness in its new state	★ ★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★ ★
Maintenance of the flatness under heavy use	★	★ ★ ★	★ ★ ★ ★	★ ★ ★ ★ ★ ★
Life span	★ ★	★ ★ ★ ★	★ ★ ★ ★ ★	★ ★ ★ ★ ★ ★

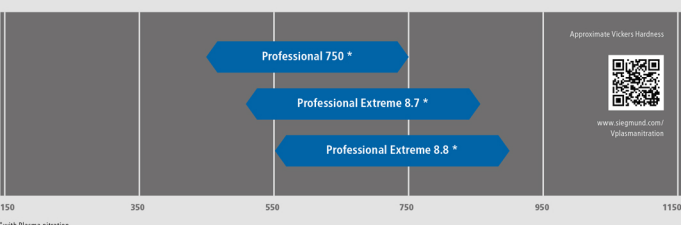
With our evaluation, we would like to make it easier for you to compare the different materials and to support you in selecting the right welding table.
★ Also applies to all Basic tables System 28.

★ Shows the improvement of the properties in the last few years.

Side surface of Professional Extreme 8.7 and 8.8 is made of specific basic material S355J2+N incl. plasma nitriding and BAR-coating.

COMPARISON OF HARDNESS: SURFACE HARDNESS

The plasma nitriding and subsequent BAR-coating protect against scratches, corrosion and welding spatter.



COMPARISON OF HARDNESS: BASIC HARDNESS

The high basic hardness is the essential hardness and allows a high impact resistance and a long service life of the welding table.

