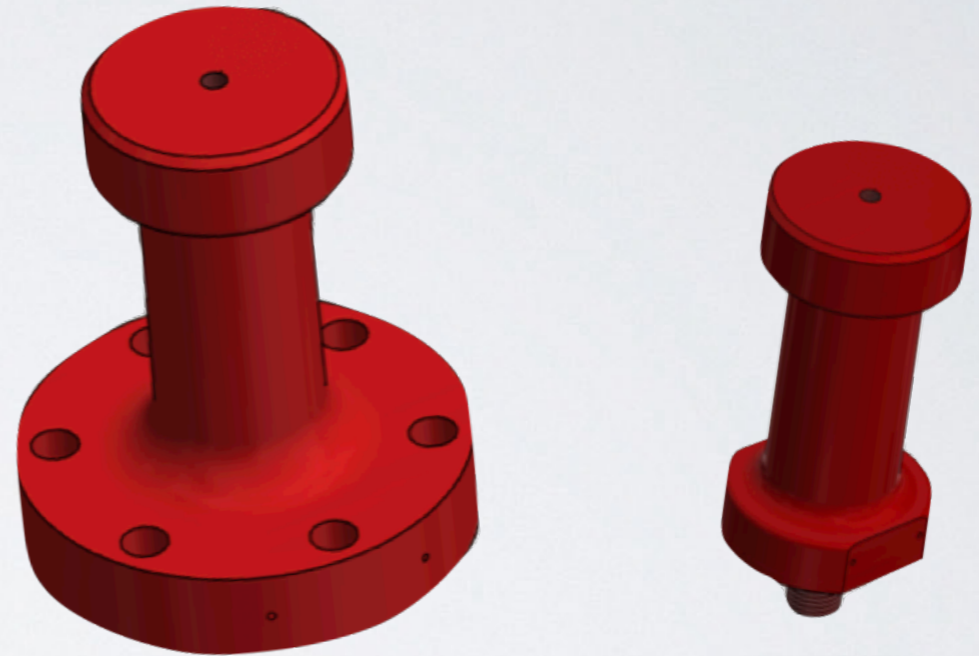


# Liftmould studs technical document



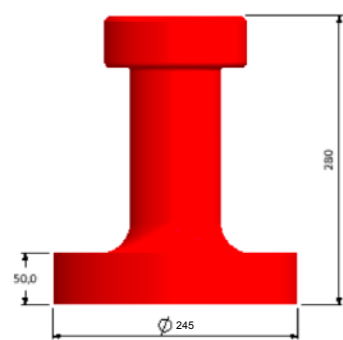
# TABLE OF FORCES

The Liftmould company experimentally tested and certified its products with the supervision of Bureau Veritas.

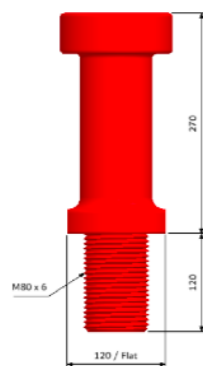
All the components were dimensioned with a minimum factor of safety to ensure user safety.

PRODUCTS CODE	PRODUCTS	CMU	TYPE OF FIXATION	SAFETY COEFICIENT
ELS 60T	ELS 60T	60 T	-	5
PL60T	PIN 60T	60 T	6 screws M24 (class 12/9)	5
PL40T80	PIN 40T (M80)	40 T	Thread M80	5
PL30T64	PIN 30T (M64)	30 T	Thread M64	5
PL25T56	PIN 25T (M56)	25 T	Thread M56	5
PL20T48	PIN 20T (M48)	20 T	Thread M48	5
PL15T42	PIN 15T (M42)	15 T	Thread M42	5
PL10T36	PIN 10T (M36)	10 T	Thread M36	5

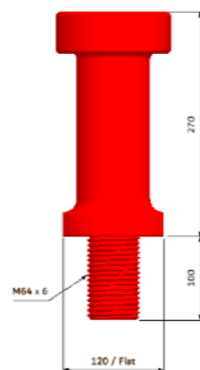
# LIFTMOULD STUDS



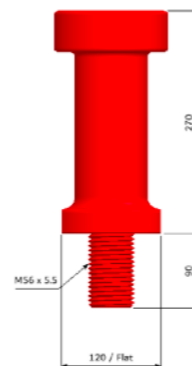
**Pin 60T**  
**(6 screws)**



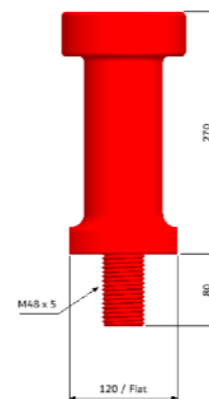
**Pin 40T**  
**(M80)**



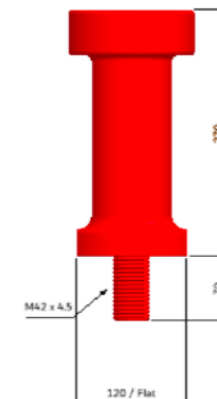
**Pin 30T**  
**(M64)**



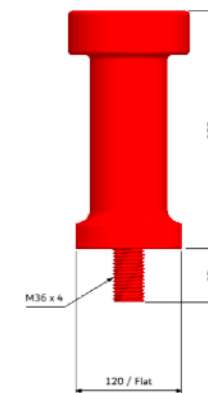
**Pin 25T**  
**(M56)**



**Pin 20T**  
**(M48)**



**Pin 15T**  
**(M42)**



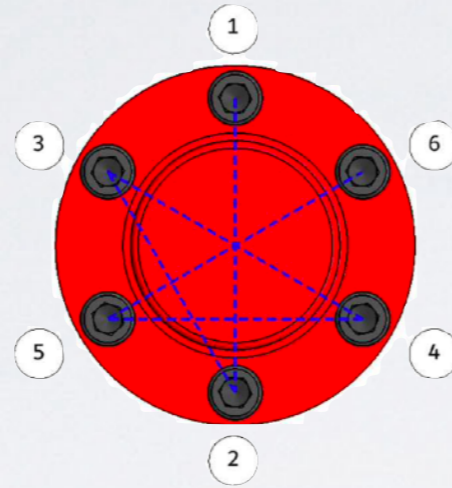
**Pin 10T**  
**(M36)**

# 60T STUD

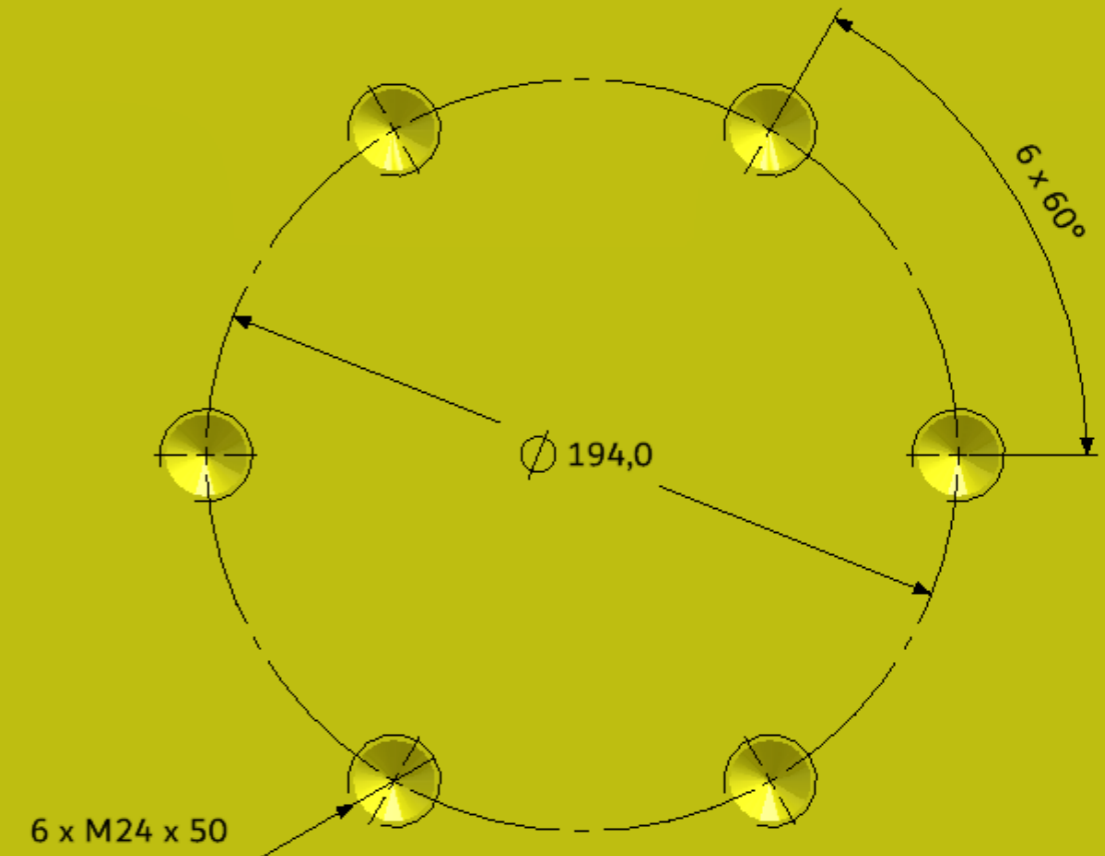
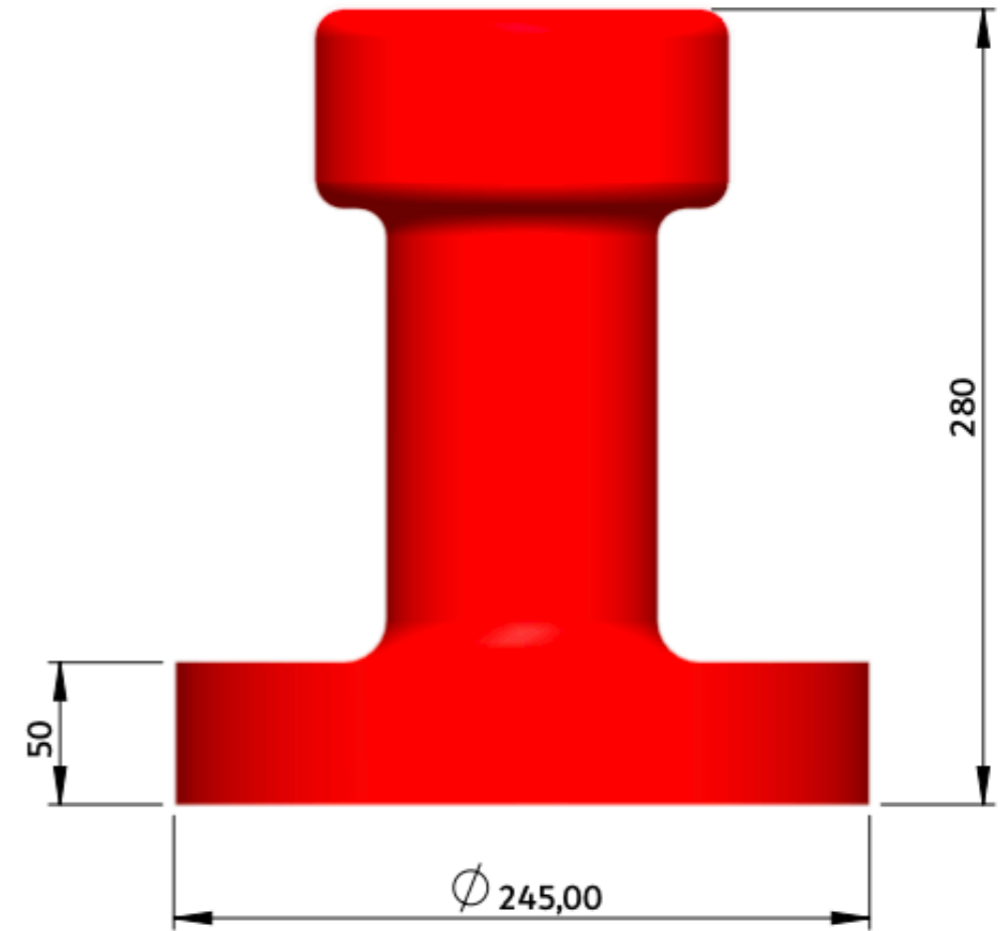
## 6 screws

CMU : 60T

tightening torque :  
Screws M24 : 380 N.m



- It is mandatory to use CHC M24 L= 90 mm class 12.9 screws to fix the 60T stud on the mould.
- The LIFTMOULD company does not supply the screws.
- The 60T stud must be placed at the center of gravity of the mould.
- This plot is fixed to the mould with 6 hexagon head socket cap M24 screws length 90mm. The bolts must be class 12.9. The bolts must be tightened in a criss-cross pattern (figure below), increasing progressively the tightening torque. The final recommended torque is 380 N.m per bolt.



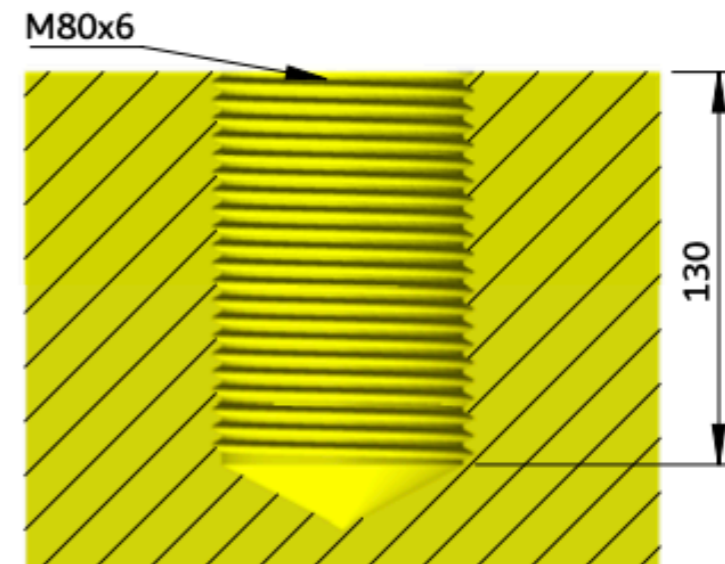
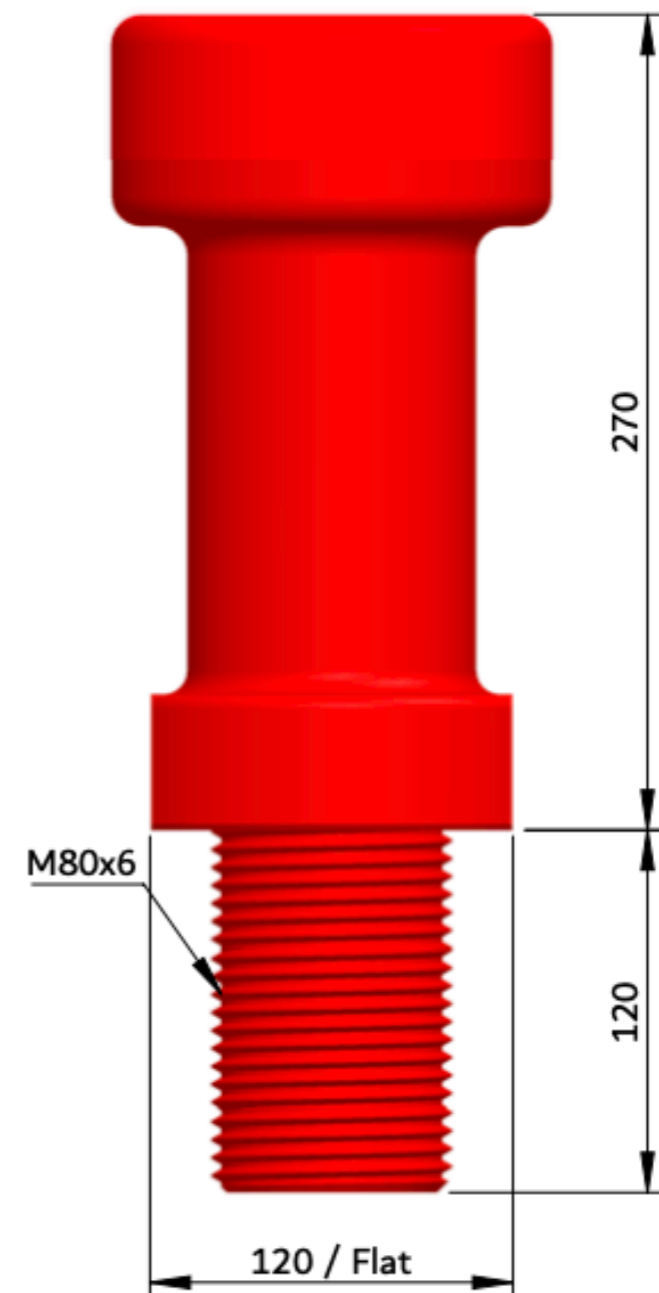
# 40T STUD

## M80 thread

CMU : 40T

tightening torque :  
600 N.m

- The 40TM80 stud must be placed at the center of gravity of the mould.



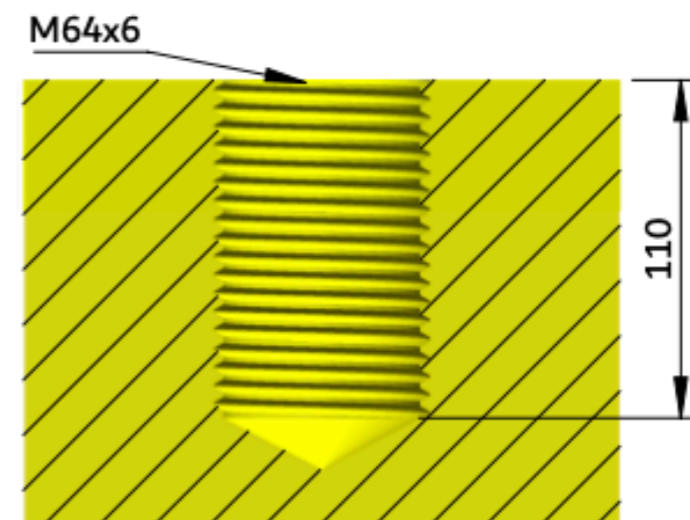
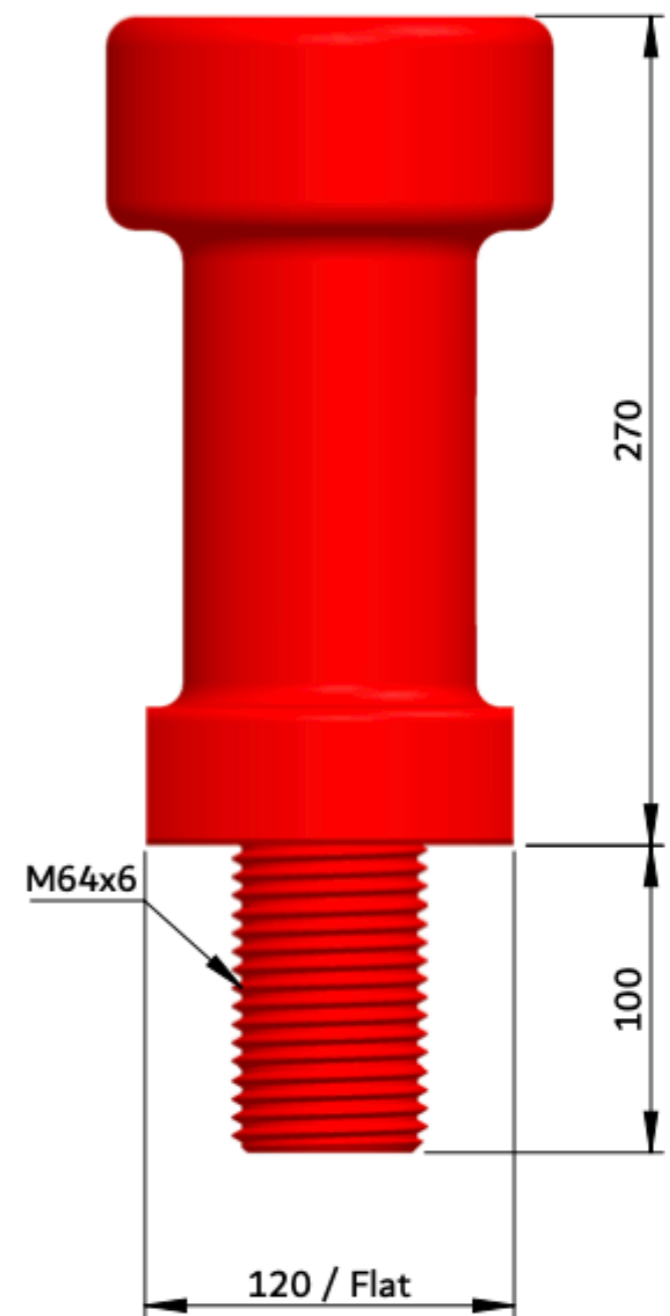
# 30T STUD

## M64 thread

CMU : 30T

tightening torque :  
600 N.m

- The 30TM64 stud must be placed at the center of gravity of the mould.



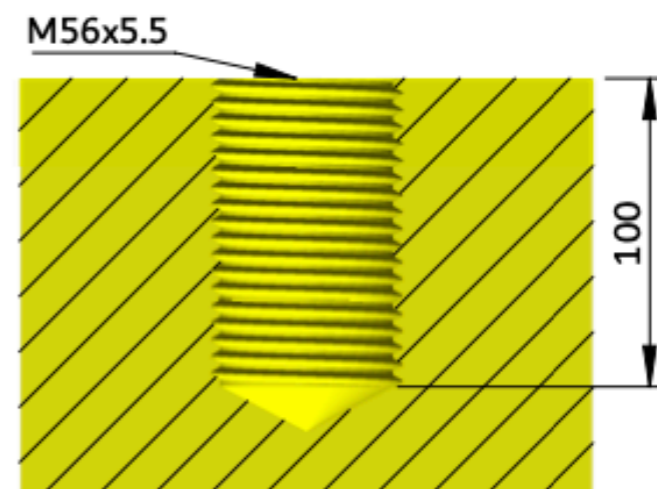
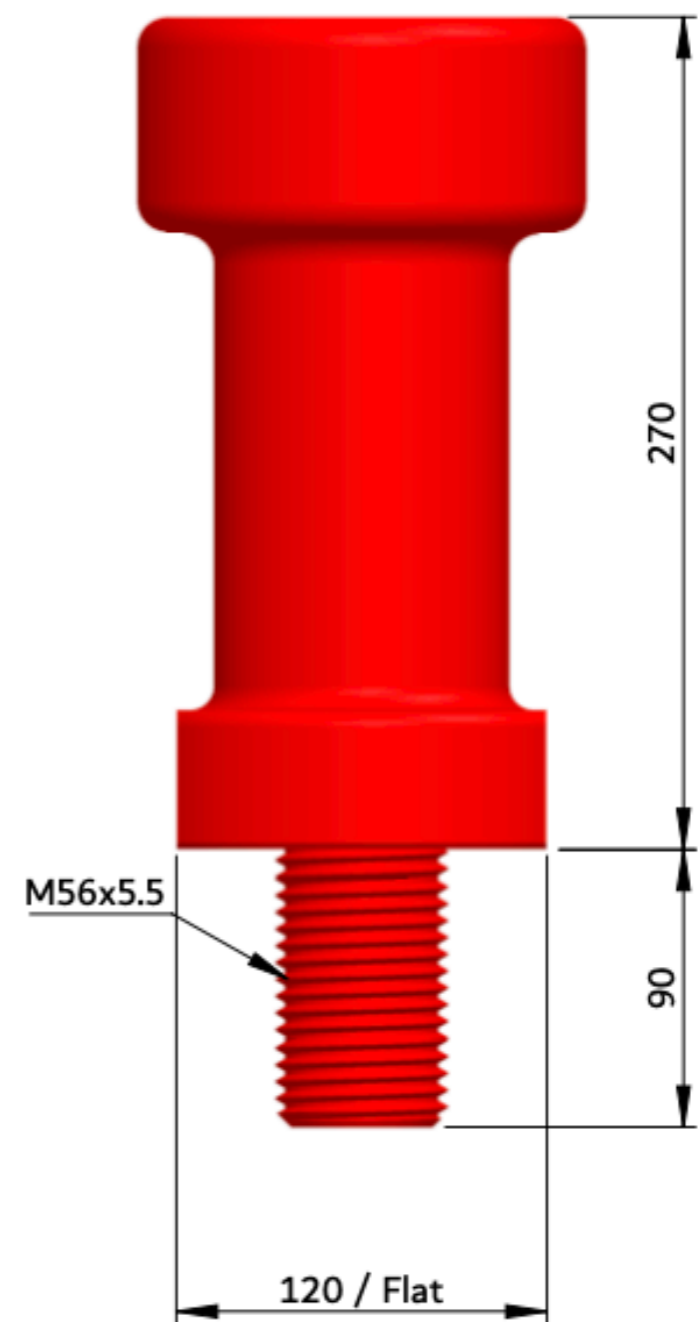
# 25T STUD

## M56 thread

CMU : 25T

tightening torque :  
600 N.m

- The 25TM56 stud must be placed at the center of gravity of the mould.



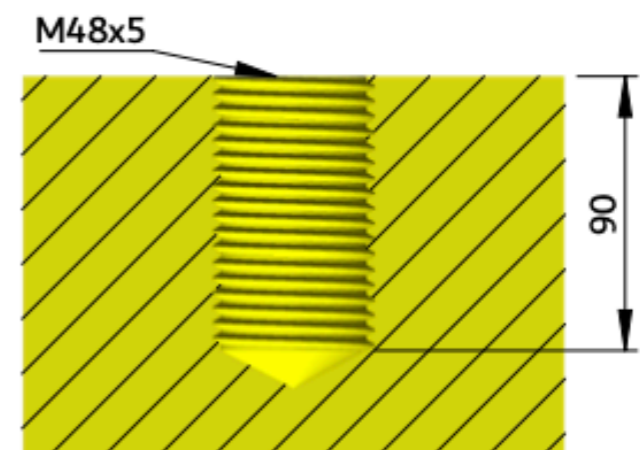
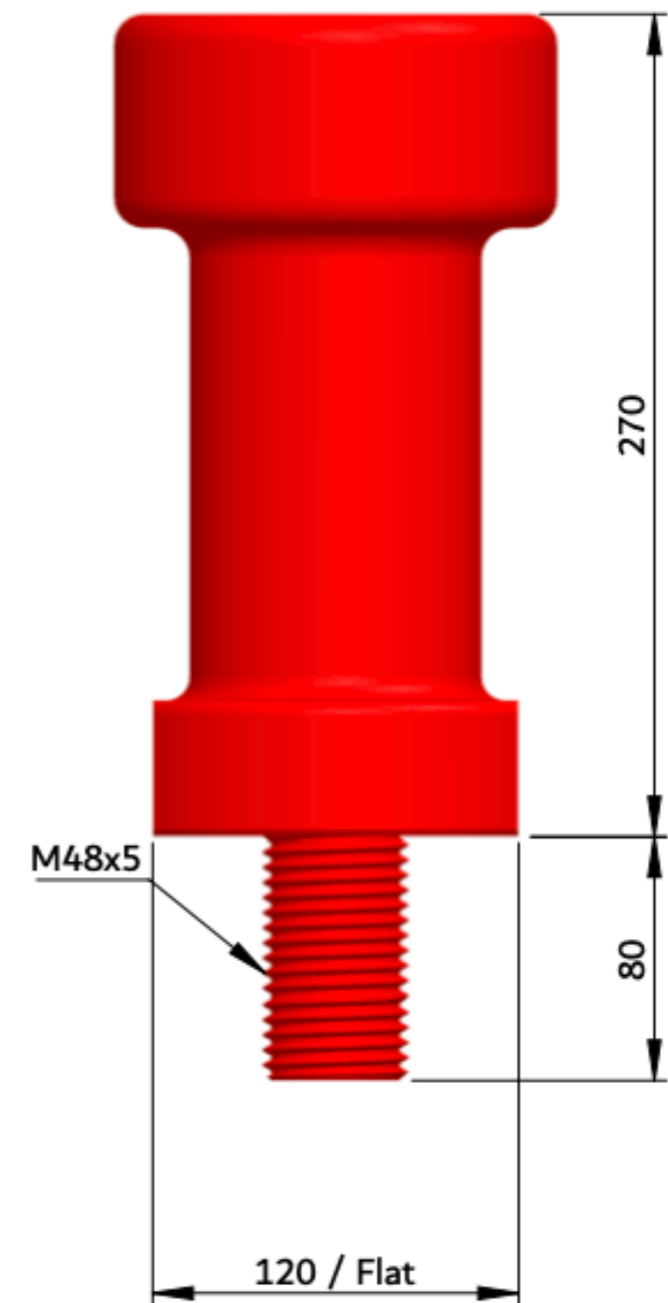
# 20T STUD

## M48 thread

CMU : 20T

tightening torque :  
600 N.m

- The 20TM48 stud must be placed at the center of gravity of the mould.



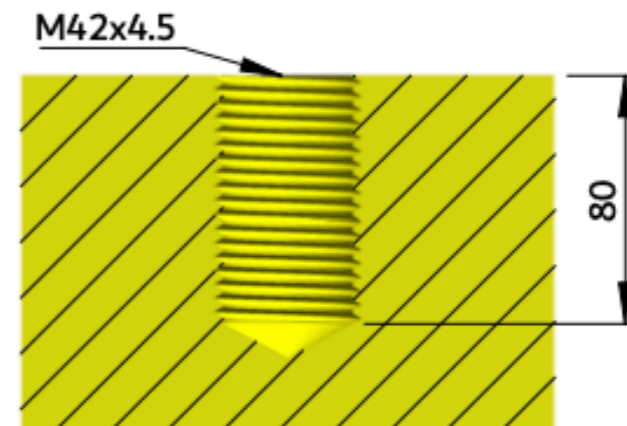
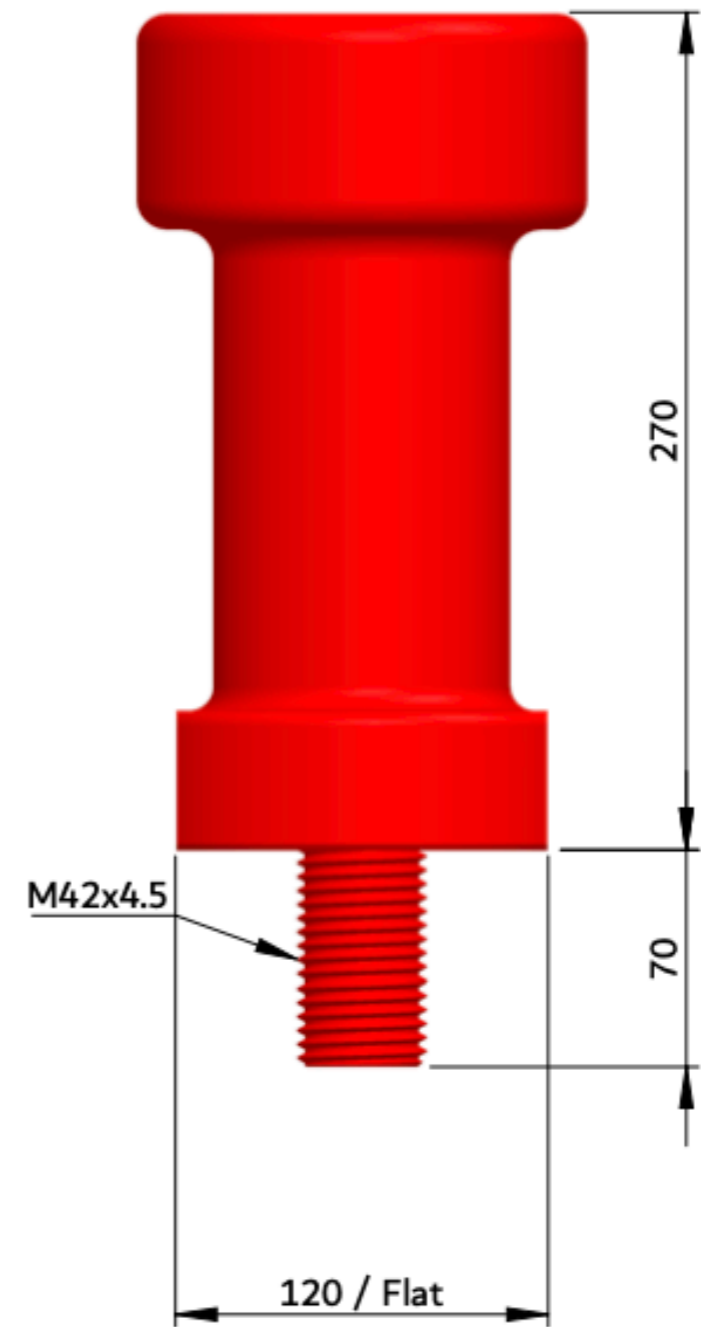
# 15T STUD

## M42 thread

CMU : 15T

tightening torque :  
400 N.m

- The 15TM42 stud must be placed at the center of gravity of the mould.



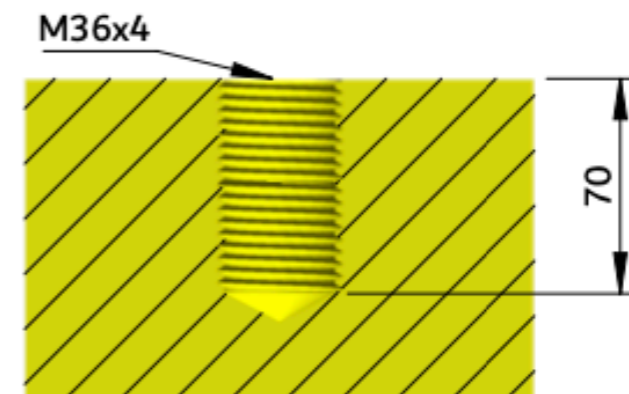
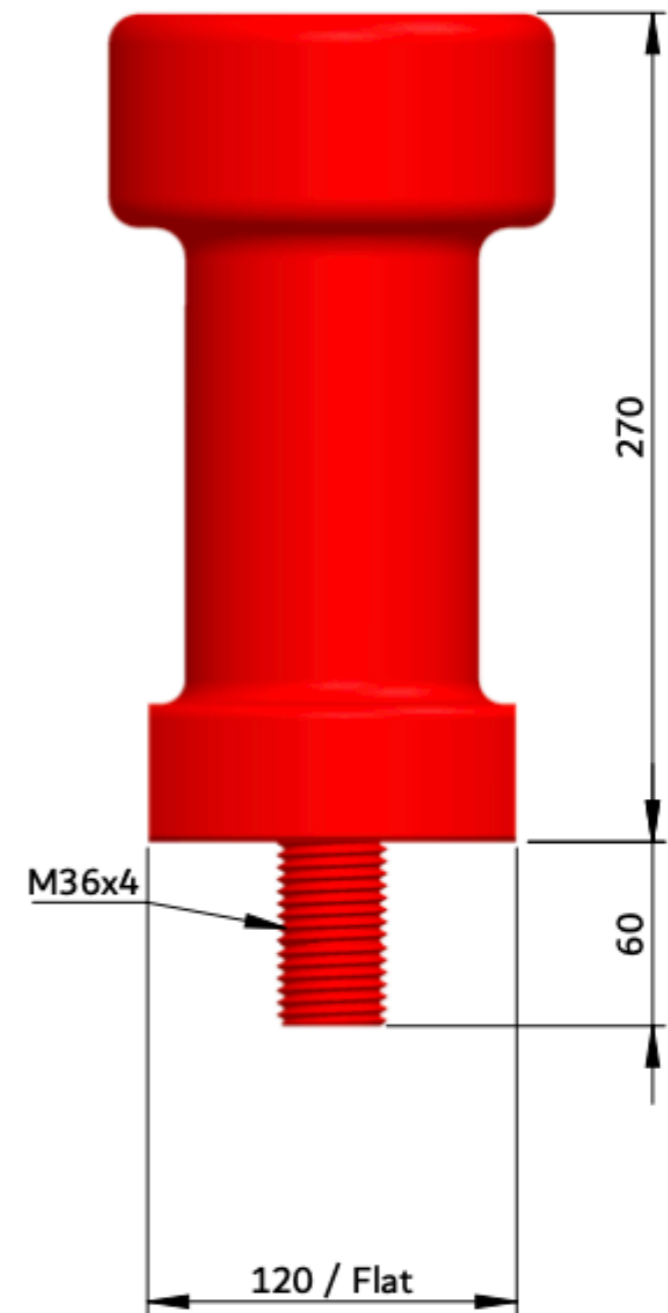
# 10T STUD

## M36 thread

CMU : 10T

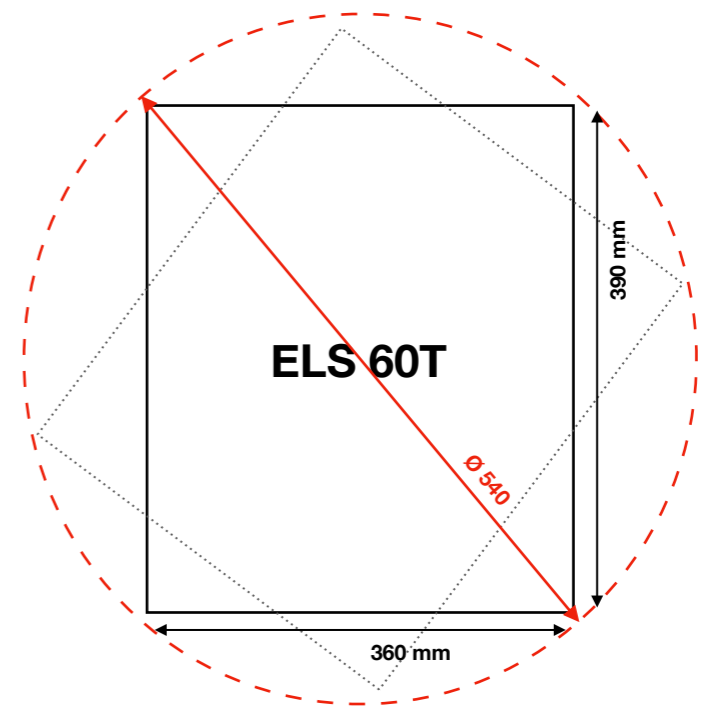
tightening torque :  
320 N.m

- The 10TM36 stud must be placed at the center of gravity of the mould.



# DIAMETER AROUND THE CENTER POINT

To avoid any interference with the ELS 60T system, it is advisable to provide a gap of  $\varnothing 540$  around the center point of the stud.



# CONTACT /

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**LIFTMOULD.COM**



**LIFTMOULD**

## COMMERCIAL

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BP 20433  
SAINT OZEN L' AUMÔNE  
95005 CERGY PONTOISE  
CEDEX FRANCE

## PLANT :

ZONA INDUSTRIAL DE  
VIADORES  
LOTE 34, PAMPILHOSA  
3050-480 PAMPILHOSA  
PORTUGAL

In 2019,  
the Liftmould Group has  
just acquired a new plant  
to double its production  
area



**LIFTMOULD**

Your security is our priority