



Compact one-piece clamp: for robust, secure connections, miniature sizes

Clamp ear: fast and simple installation, visible deformation provides evidence of proper closure

Deburred edges: reduced risk of damage to parts being clamped

With insert

Pre-shaped insert: effective and powerful all-round seal

1-Ear Clamps Product Group 153 & 154

Material

PG 153 Stainless Steel, Material no. 1.4307/UNS S30403

PG 154 Clamp: Stainless Steel, Material no. 1.4307/
UNS S30403

Insert: Stainless Steel, Material no. 1.4310/UNS S30100

Corrosion resistance according to DIN EN ISO 9227

PG 153 ≥ 800 h

PG 154 ≥ 800 h

Size range

PG 153 3.3 – 30.7 mm

PG 154 2.9 – 30.0 mm

Some sizes are only available if an appropriate minimum quantity is ordered.

Process

The manufacturing process for Oetiker 1-Ear and 2-Ear Clamps commences with the spiral roll-forming and welding of raw material into lengths of tube, a technique developed to obtain a robust, continuous welded ring.

Oetiker 1-Ear Clamps with insert

This type of clamp combines the geometry and properties of the 1-Ear Clamp with an insert made of stainless steel.

These clamps are ideal for demanding applications involving soft or hard rubbers and plastics. The thin-walled insert ring (up to 0.3 mm thick), with an oval protrusion that locates in the ear space, bridges the ear gap and ensures almost uniform compression around the whole circumference of a clamp.

Edge condition

Burrs generated during the shearing and forming processes are entirely eliminated in a barrel-finishing operation.

Clamp ear (closing element)

Using tools designed or endorsed by Oetiker, the clamp is closed by drawing together the lower radii of the "ear". The maximum diameter reduction is proportional to the open "ear" width. The maximum reduction in diameter is given by the formula:

$$\text{Max. diameter reduction} = \frac{\text{Ear width (s)}}{\pi}$$

Important

Single tool stroke closure only, do not apply secondary crimping force.

The data in this catalog are based on many years experience. They are intended for reference, not as design specifications.



GENERAL
Marine
SERVICES

156 Beaumont Street · Westhaven · Auckland · New Zealand

Sales Ph +64 9 309 0048 · sales@generalmarine.co.nz

Service Ph +64 9 368 0938 · service@generalmarine.co.nz

www.generalmarine.co.nz

Installation data

Size (mm)	Closing force max. (N)		Installation tools force-monitored ¹ :		Cordless	Electronically controlled
	galvanized	stainless	Manual	Pneumatic		
PG 153						
3.3 – 11.0	-	1400	HMK 01/S01	HO ME 2000	CP 01	HO EL 2000
11.3 – 20.7	-	2300	HMK 01/S01	HO ME 3000	CP 01	HO EL 3000
21.0 – 30.7	-	2800	-	HO ME 3000	CP 01	HO EL 3000
PG 154						
3.3 – 11.8	-	1500	HMK 01/S01	HO ME 2000	CP 01	HO EL 2000
12.0 – 20.7	-	2500	HMK 01	HO ME 3000	CP 01	HO EL 3000
21.0 – 30.7	-	3600	-	HO ME 4000	CP 01	HO EL 4000

Important note

These figures are intended as a guide, they may vary depending on the type and tolerances of parts being clamped. To ensure optimum clamp selection, we recommend making functional tests with several assemblies.

Order information

Item No.	Ref. No.	Ear width inside (mm)	Size range (mm)	Item No.	Ref. No.	Ear width inside (mm)	Size range (mm)
1-Ear Clamps with insert, stainless				1-Ear Clamps with insert, stainless			
15400010	03.3RER	1.4	2.5 – 2.9	15400031	13.3RER	6.5	10.6 – 12.6
15400011	03.5RER	1.4	2.7 – 3.1	15400032	13.8RER	6.5	11.1 – 13.1
15400012	04.1RER	2.5	2.9 – 3.7	15400033	14.0RER	6.5	11.3 – 13.3
15400063	04.6RER	3	3.4 – 4.2	15400034	14.5RER	6.5	11.8 – 13.8
15400013	05.1RER	3.2	3.7 – 4.7	15400035	15.0RER	6.5	12.3 – 14.3
15400064	05.6RER	3.2	4.2 – 5.2	15400036	15.5RER	6.5	12.8 – 14.8
15400014	06.1RER	3.2	4.7 – 5.7	15400037	16.0RER	7	13.1 – 15.3
15400015	06.6RER	3.2	5.2 – 6.2	15400038	16.5RER	8	13.2 – 15.8
15400016	07.0RER	3	5.6 – 6.5	15400039	16.8RER	7	13.9 – 16.1
15400017	07.5RER	3.5	5.9 – 7	15400040	17.5RER	7	14.6 – 16.8
15400018	08.0RER	4	6.3 – 7.5	15400041	18.5RER	7	15.6 – 17.8
15400019	08.3RER	4	6.6 – 7.8	15400042	19.5RER	7.5	16.5 – 18.8
15400020	08.7RER	4	7 – 8.2	15400043	20.0RER	7.5	17.1 – 19.3
15400021	09.0RER	5	7 – 8.5	15400044	20.7RER	9	17.1 – 20
15400022	09.5RER	5	7.5 – 9	15400045	21.0RER	7.5	18 – 20.3
15400023	10.0RER	5	8 – 9.5	15400046	21.8RER	7.5	18.8 – 21.1
15400024	10.5RER	5	8.5 – 10	15400065	22.5RER	8.5	19.2 – 21.8
15400025	11.0RER	5.5	8.8 – 10.5	15400048	23.5RER	8.5	20.2 – 22.8
15400026	11.3RER	5.5	9.1 – 10.8	15400049	24.5RER	9	21 – 23.8
15400027	11.8RER	5.5	9.6 – 11.3	15400050	25.5RER	9	22 – 24.8
15400028	12.0RER	6.5	9.5 – 11.5	15400051	26.3RER	8.5	23 – 25.6
15400029	12.3RER	6.5	9.8 – 11.8	15400052	27.0RER	9.5	23.3 – 26.3
15400030	12.8RER	6.5	10.3 – 12.3	15400053	30.7RER	11	26.5 – 30

The data in this catalog are based on many years experience. They are intended for reference, not as design specifications.



GENERAL
Marine
SERVICES

156 Beaumont Street · Westhaven · Auckland · New Zealand

Sales Ph +64 9 309 0048 · sales@generalmarine.co.nz

Service Ph +64 9 368 0938 · service@generalmarine.co.nz

www.generalmarine.co.nz