

STAMPING FASTENERS SERIES

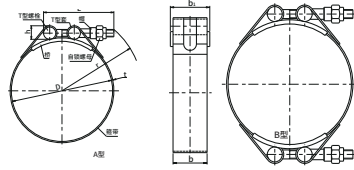
Q677 Heavy Duty Hose Clamps

Standard: Q677
(QC/T 931-2013)



①. The selection of clamp specifications is within the specification range, starting from the smallest D dimension, and increasing in the order of the value of the specification order. Example: A-type clamp with D=68 mm is within the specification range of 66 mm - 110 mm, determined by 66 mm + 2 mm = 68 mm.
 ②. Roundness tolerance in D dimension: D < 80 mm, roundness tolerance is 2 mm; 80 mm < D < 220 mm, roundness tolerance is 3 mm; D > 220 mm, roundness tolerance is 4 mm.
 ③. The remaining unspecified details shall be determined by the manufacturer.
 ④. Numbering example:
 1. D = 68, M5 thread size A-type strong hose clamp number is Q67768A.
 2. D = 136, M10 thread size B-type strong hose clamp number is Q677136B10.
 Material: Steel (T-Bolt + Lock Nut), Band, V-Slot, T-Sleeve and Cap (12C117W7, 12C118W9, 10C117M6) Thread: 6g-6H
 Surface treatment: electroless zinc flake coating, Polished surface defects: No sharp corners, burrs, cracks, wrinkles and other defects that affect use Corrosion resistance: The clamp should be disassembled into parts, and the salt spray test should be carried out together for 480 h. After the test, there is no white, gray-black and other corrosive substances on the surface.
 Assembly torque: Determine the assembly torque according to the sealing medium, hose packing, and working conditions, but should not exceed the specified guaranteed torque.
 Acceptance inspection: According to GB/T 90.1, the D dimension in the band, bridge, T-sleeve and cap is AQL=1.5, and other dimensions AQL=2.5. When there are special requirements, it shall be negotiated by both parties.

Part Number Designation
JX-Q677 - 30 - M5 - SS
Type and Material Code Range Size Thread Material Code Code



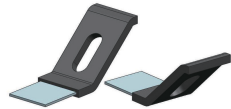
Part Number Designation
JX-Q677 - 30 - M5 - ST
Type and Material Code Range Size Thread Material Code Code

Unit:mm

| Size Range D | P/N | | Specifications for order | | Gripping Range | | b max | b1 max | h max | L max | r ≈ | t | | Thread Size | |
|--------------|---------|------------------------|--------------------------|--------|----------------|--------|-------|--------|-------|-------|-----|----------------|-----|-------------|-----|
| | A Type | B Type | A Type | B Type | A Type | B Type | | | | | | max | min | | |
| 30-64 | - | JX-Q677-30-M5-ST | JX-Q677-30-M5-SS | 1 | - | - | - | - | - | - | - | 0.8 | 0.5 | M5 | |
| 66-110 | 82-130 | JX-Q677-66/82-M5-ST | JX-Q677-66/82-M5-SS | 2 | 6 | ±2 | ±4 | 15 | 18 | 13 | 54 | 44+(D-30)X0.36 | 0.8 | 0.5 | M5 |
| 50-64 | - | JX-Q677-50-M6-ST | JX-Q677-50-M6-SS | 2 | - | - | - | - | - | - | - | - | - | - | - |
| 66-110 | 82-130 | JX-Q677-66/82-M6-ST | JX-Q677-66/82-M6-SS | 2 | 6 | ±2 | ±4 | 20 | 23 | 15 | 70 | 60+(D-50)X0.36 | 0.7 | 1.0 | M6 |
| 76-100 | - | JX-Q677-76-M8-ST | JX-Q677-76-M8-SS | 4 | - | - | - | - | - | - | - | - | - | - | - |
| 106-220 | 100-256 | JX-Q677-106/100-M8-ST | JX-Q677-106/100-M8-SS | 6 | 12 | ±3 | ±6 | 25 | 28 | 18 | 86 | 82+(D-76)X0.36 | 1.4 | 1.1 | M8 |
| 80-100 | - | JX-Q677-80-M10-ST | JX-Q677-80-M10-SS | 4 | - | - | - | - | - | - | - | - | - | - | - |
| 106-328 | 124-352 | JX-Q677-106/124-M10-ST | JX-Q677-106/124-M10-SS | 6 | 12 | ±4 | ±8 | 30 | 33 | 21 | 107 | 97+(D-80)X0.36 | 1.7 | 1.4 | M10 |

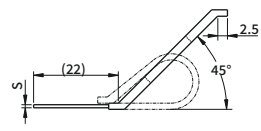
Q678 Weldable Pipe Clip

Standard: Q678
(QC/T 372-1999)



Material: 08, 08F, Q235F

Surface treatment: zinc passivation, Fe/Zn8
 Surface coating: According to functional requirements, polyethylene, vulcanized rubber coating or vulcanized rubber sleeve can be added to the clamping part of the galvanized and passivated clip. Black carbon and stabilizer should be added to the vulcanized rubber. The color is black and the thickness is 0.8mm-1.5mm.
 Defects: discoloration, deformation and deterioration are not allowed; Polyethylene coating or vulcanized rubber coating is not allowed to have cracks, burrs, scratches, dents, bubbles, ripples, impurities and rough surfaces; The thickness of polyethylene coating or vulcanized rubber coating should be uniform.
 Acceptance and packaging: according to GB/T 90.1, GB/T 90.2, of which AQL=4.0. When there are special requirements, it shall be negotiated by both parties.



Part Number Designation
JX-Q678 - 60 - ST
Type and Material Code Long Material Code Code

Part Number Designation
JX-Q678 - 60 - SS
Type and Material Code Long Material Code Code

Unit:mm

| L | P/N | | L1 | L2 | L3 | B | b | S |
|----|---------------|-----------------|----|----|----|----|---|-----|
| | Steel | Stainless steel | | | | | | |
| 40 | JX-Q678-40-ST | JX-Q678-40-SS | 15 | 20 | 15 | 15 | 6 | 0.8 |
| 50 | JX-Q678-50-ST | JX-Q678-50-SS | | 25 | | | 8 | |
| 60 | JX-Q678-60-ST | JX-Q678-60-SS | | 30 | | | 8 | |
| 70 | JX-Q678-70-ST | JX-Q678-70-SS | 20 | 40 | 30 | 20 | 8 | 1.0 |
| 80 | JX-Q678-80-ST | JX-Q678-80-SS | | 50 | | | 8 | |
| 90 | JX-Q678-90-ST | JX-Q678-90-SS | | 50 | | | 8 | |

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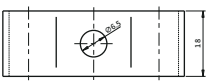
Q679 Symmetrical Clip for Twin Pipes

Standard: Q679
(QC/T 371-1999)



Material: 08, 08F, Q235F Surface treatment: zinc passivation, Fe/Zn8
 Surface coating: According to functional requirements, polyethylene, vulcanized rubber coating or vulcanized rubber sleeve can be added to the clamping part of the galvanized and passivated clip. Black carbon and stabilizer should be added to the vulcanized rubber. The color is black and the thickness is 0.8mm-1.5mm.
 Remarks: discoloration, deformation and deterioration are not allowed; Polyethylene coating or vulcanized rubber coating is not allowed to have cracks, burrs, scratches, dents, bubbles, ripples, impurities and rough surfaces; The thickness of polyethylene coating or vulcanized rubber coating should be uniform. Acceptance and packaging: according to GB/T 90.1, GB/T 90.2, of which AQL=4.0. When there are special requirements, it shall be negotiated by both parties.

Part Number Designation
JX-Q679 - 10 - ST
Type and Material Code Pipe Diameter Code Material Code



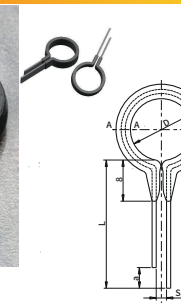
Part Number Designation
JX-Q679 - 10 - SS
Type and Material Code Pipe Diameter Code Material Code

Unit:mm

| D | P/N | | L | K | S | R |
|----|---------------|-----------------|----|-----|-----|---|
| | Steel | Stainless steel | | | | |
| 5 | JX-Q679-5-ST | JX-Q679-5-SS | 26 | 1.5 | 1.2 | 1 |
| 6 | JX-Q679-6-ST | JX-Q679-6-SS | 28 | | | |
| 8 | JX-Q679-8-ST | JX-Q679-8-SS | 30 | | | |
| 10 | JX-Q679-10-ST | JX-Q679-10-SS | 32 | | | |
| 12 | JX-Q679-12-ST | JX-Q679-12-SS | 34 | | | |
| 14 | JX-Q679-14-ST | JX-Q679-14-SS | 36 | | | |
| 16 | JX-Q679-16-ST | JX-Q679-16-SS | 38 | 2.0 | 1.5 | 2 |
| 18 | JX-Q679-18-ST | JX-Q679-18-SS | 40 | | | |
| 20 | JX-Q679-20-ST | JX-Q679-20-SS | 42 | | | |

Q680 Split Clips

Standard: Q680
(QC/T 882-2011)



A-A
5:1

Part Number Designation
JX-Q680 - 16 - ST
Type and Material Code Diameter Code Material Code

Material: Q195, Q215

Surface treatment: zinc passivation, Fe/Zn12c
 Test method: at 0°C, unfold the legs to 90°, then close together, repeat 5 times, the opening clip does not break, and the coating does not fall off.

Surface coating: According to functional requirements, polyethylene, vulcanized rubber coating or vulcanized rubber sleeve can be added to the clamping part of the galvanized passivation treated clip. Black carbon and stabilizer should be added to the vulcanized rubber. The color is black and the thickness is 0.8 mm-1.5 mm.

Remarks: discoloration, deformation and deterioration are not allowed; Polyethylene coating or vulcanized rubber coating is not allowed to have cracks, burrs, scratches, dents, bubbles, ripples, impurities and rough surfaces; The thickness of polyethylene coating or vulcanized rubber coating should be uniform.

Acceptance inspection: According to GB/T 90.1, D and L dimensions AQL=2.5, other dimensions AQL=4.0. When there are special requirements, it shall be negotiated by both parties.

Part Number Designation
JX-Q680 - 16 - SS
Type and Material Code Diameter Code Material Code

Unit:mm

| D | P/N | | L | a | | t | | S | | | | |
|----|-------|-----------------|---------------|---------------|-----|-----|-----|-----|------|------|-----|-----|
| | Steel | Stainless steel | | max | min | max | min | max | min | | | |
| 10 | 10.5 | 9.0 | JX-Q680-10-ST | JX-Q680-10-SS | 25 | 24 | 4.0 | 3.0 | 0.80 | 0.73 | 2.0 | 1.0 |
| 12 | 12.5 | 11.0 | JX-Q680-12-ST | JX-Q680-12-SS | 25 | 24 | 4.0 | 3.0 | 0.80 | 0.73 | 2.0 | 1.0 |
| 16 | 16.5 | 15.0 | JX-Q680-16-ST | JX-Q680-16-SS | 28 | 27 | 6.0 | 5.0 | 0.90 | 0.83 | 2.5 | 1.0 |
| 20 | 20.5 | 19.0 | JX-Q680-20-ST | JX-Q680-20-SS | 28 | 27 | 6.0 | 5.0 | 0.90 | 0.83 | 2.5 | 1.0 |
| 25 | 25.5 | 24.0 | JX-Q680-25-ST | JX-Q680-25-SS | 31 | 30 | 8.0 | 7.0 | 1.00 | 0.91 | 3.0 | 1.0 |
| 30 | 30.5 | 29.5 | JX-Q680-30-ST | JX-Q680-30-SS | 31 | 30 | 8.0 | 7.0 | 1.00 | 0.91 | 3.0 | 1.0 |