

STARCON



Ring clutch systems 2.5T to 26T

*Ring clutch, Ring clutch with wire and ring clutch with
Extreema® XS round sling*

User and design manual

Lifting and handling systems for concrete elements.

1 Nomenclature

Symbol	Description	Unit
σ_{ele}	Concrete strength of the element at the time of lifting	MPa
d_s	Diameter of the wire cable	mm
SF	Safety factor	-
S	Load group symbol (STARCON)	-
a	Hole height	mm
b	Hole width	mm
c	Head diameter	mm
d	Head width	mm
L	Plate length or length	mm
t	Plate thickness	mm
d_{sl}	Extreema® XS round sling diameter	mm
d_s	Wire rope diameter	mm
WLL	Working Load limit	tons
EWL	Effective working length	m

Table 1 Nomenclature

Starcon Precast Concrete Design & Lifting Manual

1	Nomenclature	1
2	Identification.....	2
3	Introduction Starcon ring clutch system 2.5T to 26T.....	3
4	Safety instructions before use	4
5	Advantages of the Starcon system.	4
6	Using the Starcon system.....	5
7	Safety factors for lifting systems.....	6
8	Marking on the ring clutch.....	7
9	Misuse of the Ring clutch.....	8
10	Checking connection fittings.....	9
11	General safety information when using the Starcon system.	12
12	Maintenance and inspection	14
13	Disposal / Recycling	15
14	Product data of STA Ring clutch.....	15
15	Product data of STA Ring clutch with wire	16
16	Product data of STA Ring clutch with Extreema® XS round sling	17
17	EC – Declaration of Conformity of the Machinery.....	18

2 Identification

Table 2 provides insight into the revision number of this document. It facilitates tracking changes and ensuring version control for accurate referencing and updates.

Version	Responsible	Creator	Date	Comment
A	CERTEX Denmark	JLJ	09-04-2025	New documentation

Table 2 Revision table

3 Introduction Starcon ring clutch system 2.5T to 26T.

Read this instruction manual before using the Starcon system. Incorrect use can cause injury or danger!

Safety is paramount when using lifting devices and equipment.

Only trained individuals should operate them as per national law.

Familiarize yourself with the instruction manual before use to ensure safe operation.

Adhering to these guidelines reduces the risk of accidents.

Consult relevant national regulations as they may supersede these instructions.

All individuals involved with the equipment must read and understand this manual.

Contact Certex for assistance or clarification.

Always keep the manual with the product. Contact information is provided on the last page.



General concept of the use Starcon system

The Starcon ring clutch is available in three different variants: one with a lifting plate for attaching the hook, another using a wire, and a third variant with a sling, all of which are illustrated in Figure 1.

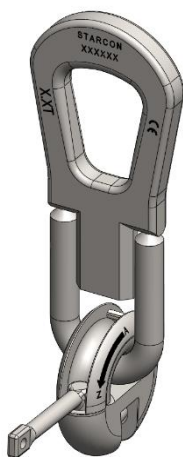
The Starcon ring clutch systems use the guidelines described in the German guidelines VDI/BV-BS 6205 and Technical Report CEN/TR 15728, combined with EN 13155-2009. This ensures the highest level of safety when using our products.

Material:

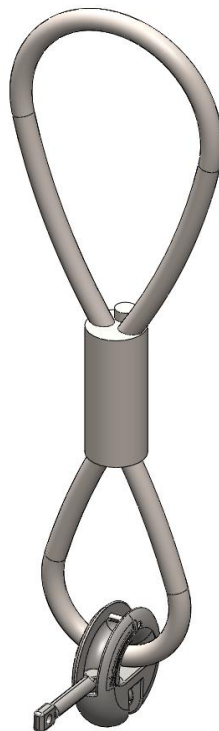
Steel.

Surface treatment:

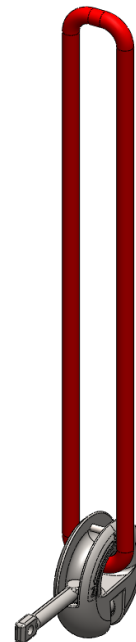
Electro galvanizing (Corrosion Class: C3, ISO 12944).



Starcon STA Ring clutch



Starcon STA Ring clutch with wire



Starcon STA Ring clutch with Extreema® XS round sling

Figure 1 Starcon Ring clutches.

4 Safety instructions before use



- Starcon lifting anchors that are exposed of corrosion, or damaged must not be used.
- The Starcon lifting anchor must only be hoisted by a lifting unit of the same load group.
- The Starcon lifting and handling system must not be used to lift more than the specified load.
- The Starcon lifting and handling system must not be used for personnel lifting.
- The Starcon products are designed for one-time lifting only.
- The Starcon lifting system must only be used by skilled, trained employees.
- A lifting accessory used with the ring clutch must be correctly marked and approved for lifting.
- Before use, check the weather conditions. Never operate the system if there is a likelihood of lightning in the area and avoid use in extreme weather conditions such as storms, heavy rain, or snowing.
- The concrete safety factor assumes a factory production control complying with EN13369. If these requirements are not fulfilled, a safety factor of $\gamma = 2,5$ shall be used.
- All relevant concrete failure modes shall be verified by the pre casting manufacturer of the concrete elements; the different failure modes and verification methods are specified in EN13155 (Annex H).

5 Advantages of the Starcon system.

The Starcon system offers quick and secure assembly and release options for the ring clutch, facilitating the safe and economical handling of precast concrete units. The self-locking lifting ring clutch prevents accidental release, eliminating the need for time-consuming screw connections and wear-prone wires. The robust lifting ring clutches ensure long-term reliability.

Available in load groups 2.5T to 26T, the Starcon system features a ring clutch that rotates freely around the anchor's axis. Its unique geometry allows the anchors to bear their full load, even when pulled perpendicularly.

The system's efficiency is proven through years of use and extensive laboratory testing. Components undergo regular production testing and are clearly marked with maximum load information. Each ring clutch is individually tested and marked with a traceability batch code.

5.1 Note

The information in this manual is for guidance only, and the use of the manual does not in any way exempt the user from ensuring that the chosen lifting system is suitable for the intended purpose. The information and data listed in this manual only refer to original Starcon products supplied by CERTEX DANMARK A/S.

6 Using the Starcon system

The Starcon system comprises a wide range of STA anchors in a load group from 2.5T to 26T per anchor with various lengths. The principle for using the system is the same for the entire range. The Starcon system consists of the following three main components:

6.1 Starcon STA Anchor

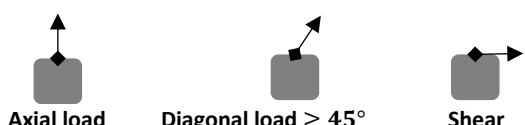
The Starcon anchor is a steel component for embedding with a specially designed foot for solid anchoring in hardened concrete. The head of the Starcon anchor, which is flat in shape, connects to a Starcon ring clutch for lifting purposes. Starcon anchors are clearly labeled with sizes (e.g., 2.5T) and are available in different lengths. They undergo sample testing for defects, dimensional deviations, and tensile strength with a safety factor of minimum 3:1 for metallic failure.

6.2 Starcon Former

The former are soft PVC components used for embedding an anchor in wet concrete. The anchor head is placed in the former, which can be attached to the formwork. After the unit is cast and hardened, the former is removed, revealing the anchor head seated in the concrete. Each former can be used for multiple castings if cleaned and lubricated after each use.

6.3 Starcon STA Ring clutch

The Starcon ring clutch is a specially designed component with a bolt-shaped ring that grips in the hole of the STA anchor. Starcon Ring clutches are tested to twice the allowable load, and all test results are recorded. Each Starcon ring clutch is marked with maximum working load with a safety factor of 4:1. A certificate is issued for each delivery. See Table 3 for load capacity of the ring clutch.

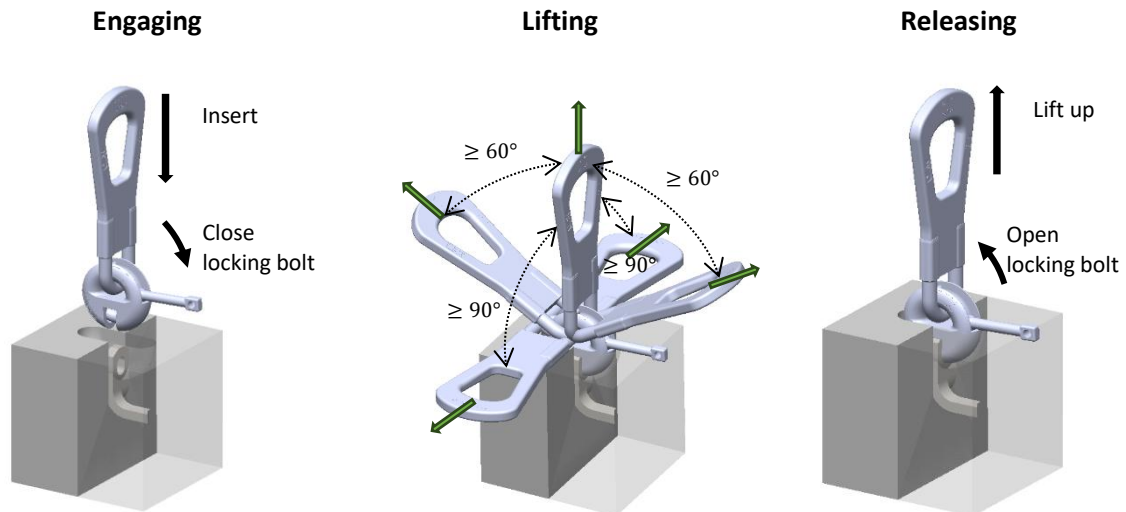
Designation	Load group ring clutch	Load class lifting STA anchors	Load capacity [kN] ring clutch in all directions ①.
			
Ring clutch 2.5T	2.5	1.4	14
		2.5	25
Ring clutch 5T	5	5	50
Ring clutch 10T	10	7.5	75
		10	100
Ring clutch 26T	26	12.5	125
		14	140
		17.5	175
		22	220

① The ring clutch system operates based on the load capacity of the lifting anchor, ensuring safe and efficient handling of loads up to the specified limit of the anchor's capability.

Table 3 Load capacity of the ring clutch

6.4 Starcon Ring clutch assembly instructions.

The Starcon Ring clutch system enables efficient handling of flat cast concrete elements. To secure the ring clutch, insert it into the concrete recess and tighten the locking bolt manually. The system allows safe lifting in any direction, up to 60° vertically and 90° sideways, see Table 4. To remove the clutch, open the locking bolt manually.



Insert the ring clutch into the concrete recess and manually close the locking bolt by sliding it to its limit position. Once secured, you can begin the lifting process.

The ring clutch is designed to handle loads from any direction, provided the load limits of the anchors are not exceeded. When using a spreader beam, it is permissible to apply an angled pull of up to 60°. And up to 90° to the sides.

Manually retract the pin to enable the removal of the ring clutch.

Table 4 The connection between the Starcon ring clutch and Starcon STA anchor is fast and easy.

7 Safety factors for lifting systems

For the calculations of the lifting system, the following safety factors shown in Table 5 have been applied to ensure reliability and safety. These factors, in accordance with the recommendation of EN13155, have been carefully selected as guidelines to ensure optimal safety during the system's operation.

Failure safety factors	
Steel failure of anchors	$SF_{Steel} = 3$
Concrete pull out failure	$SF_{concrete} = 2,5$
Failure in the ring clutch	$SF_{Link} = 4$
Safety in Extreema® XS round sling	$SF_{sling} = 7$

Table 5 Failure safety factors

8 Marking on the ring clutch

Each ring clutch is clearly labeled with its load group, identification no., production date, ensuring easy and secure identification of the systems, even post-installation. The marking is shown on Figure 2.

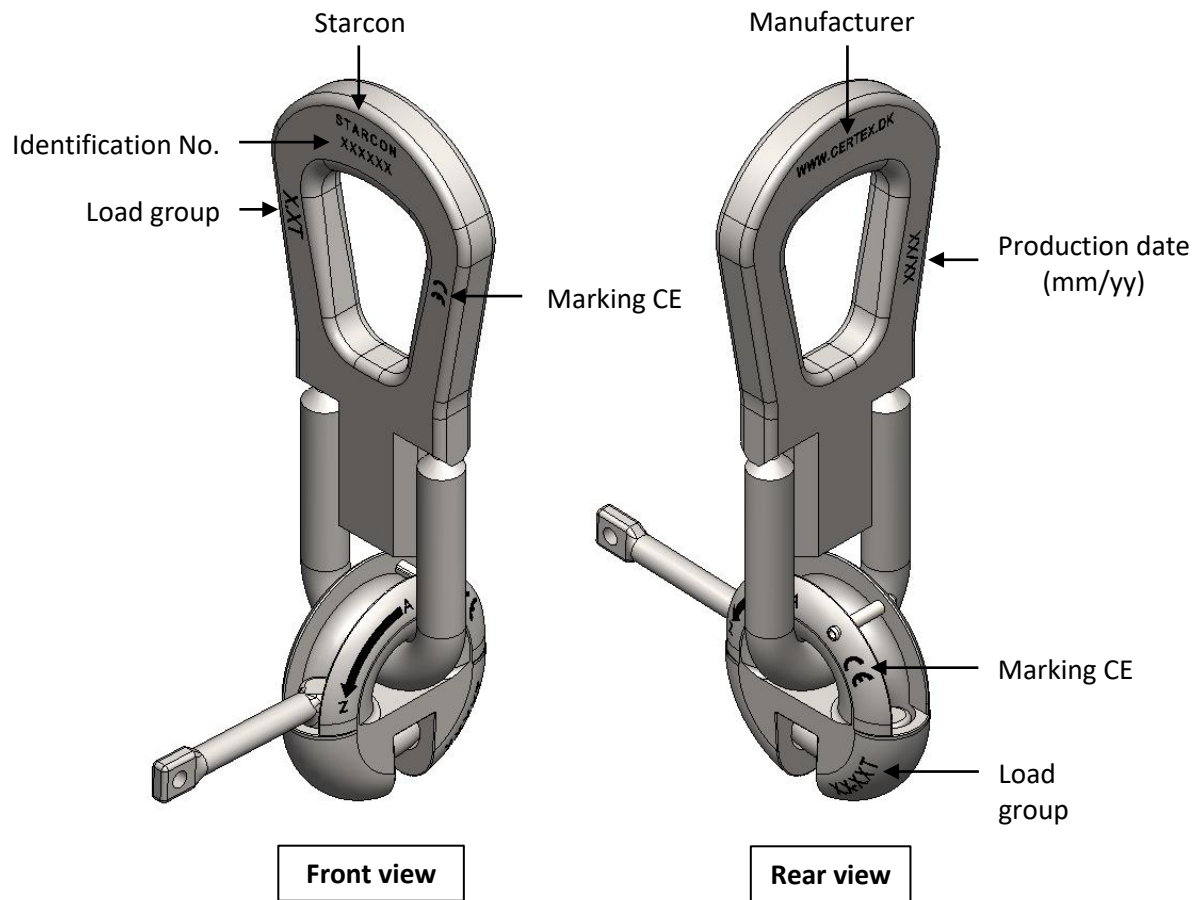
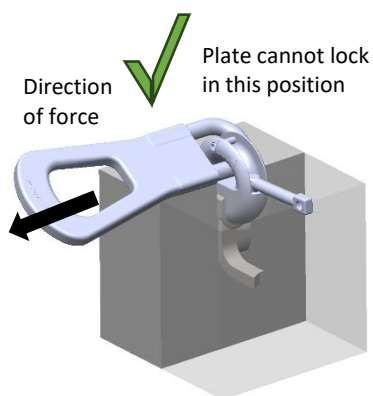
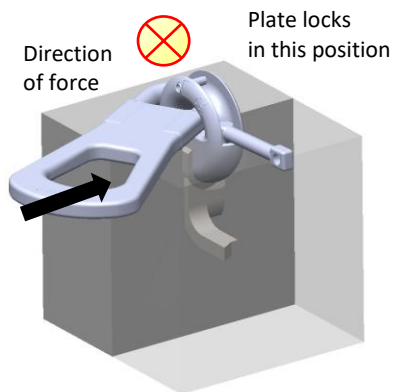


Figure 2 Marking on ring clutch.

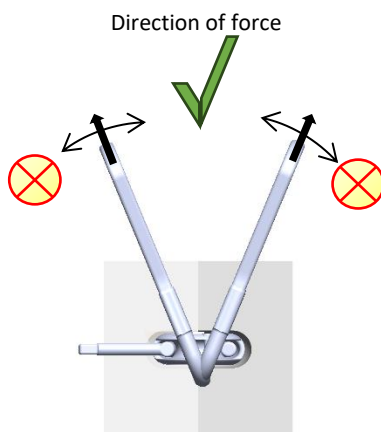
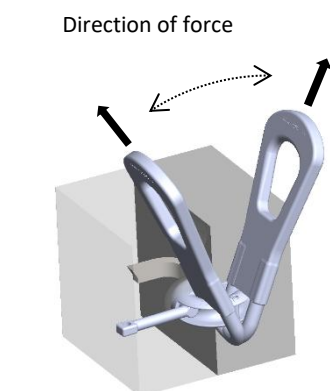
9 Misuse of the Ring clutch.

The Starcon Ring Clutch is used for lifting loads securely. Correct shackle positioning is crucial to avoid bending and damage. Align the shackle at a 45° angle to prevent it from locking or bending under load, ensuring optimal performance and safety. The misuse of the Starcon ring clutch is shown in Table 6. The requirements in the table also apply to ring coupling with wire and ring coupling with Extreema® XS round sling.

To prevent locking and deformation, ensure the plate is not positioned beneath the clutch head when the load is applied. An incorrect placement can cause the round shackle to bend under the applied load.



In its upper position, the shackle can become secured within the clutch housing. If the lifting plate is at a narrow angle, it can cause the shackle to bend. This issue can be prevented by rotating the shackle approximately 45 degrees.



If the shackle is pulled towards the upper surface of the slab under load, it will bend at the edge of the slab.

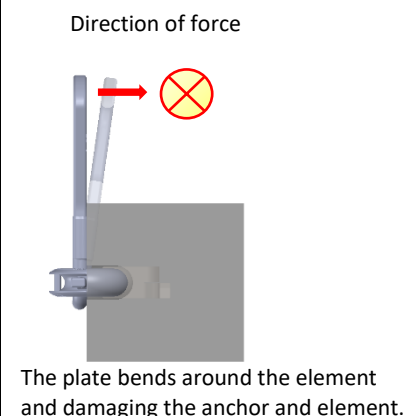
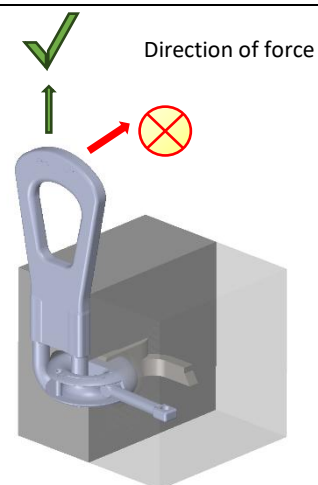


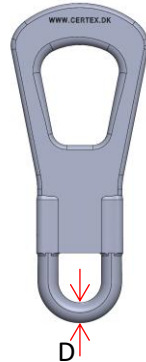
Table 6 Misuse of the Starcon ring clutch system

10 Checking connection fittings

Starcon Ring clutches are load-bearing devices designed to work exclusively with STARCON STA Anchors. They require an annual inspection by a qualified expert to ensure safe operation. The product's correct function and safety can only be guaranteed when using original components from STARCON. Users are cautioned against mixing products from other manufacturers. Key inspection points must be followed for maintenance shown in Table 7, Table 8 and Table 9.

Ring clutch Plate

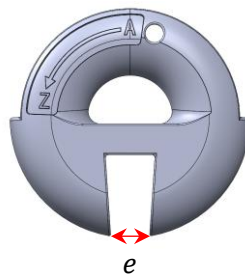
If the clutches showing any signs of damage or significant wear should be taken out of service immediately. Please consult the table for the acceptable wear tolerances.



Load group	Nominal dimension D [mm]		Min. D [mm]
	SF 4:1	SF 5:1	
2.5T	14±0.5	14±0.5	12.5
5T	20±0.5	20±0.5	18.5
10T	26±0.5	28±0.5	24
26T	40±0.5	N/A	38

Clutch head

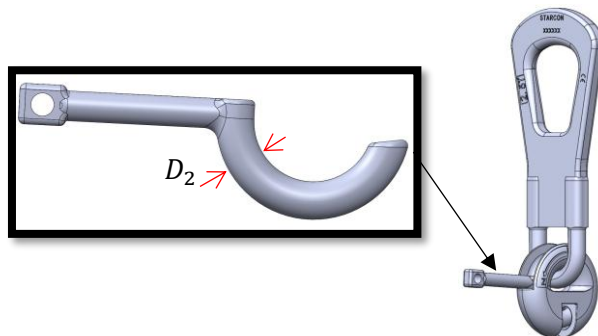
If the clutches showing any signs of damage or significant wear should be taken out of service immediately. Please consult the table for the acceptable wear tolerances.



Load group	Nominal dimension e [mm]		Max. e [mm]
	SF 4:1	SF 5:1	
2.5T	13±1	13±1	14
5T	17±1	19.5±1	20
10T	22±1	23±1	24
26T	35±1	N/A	38

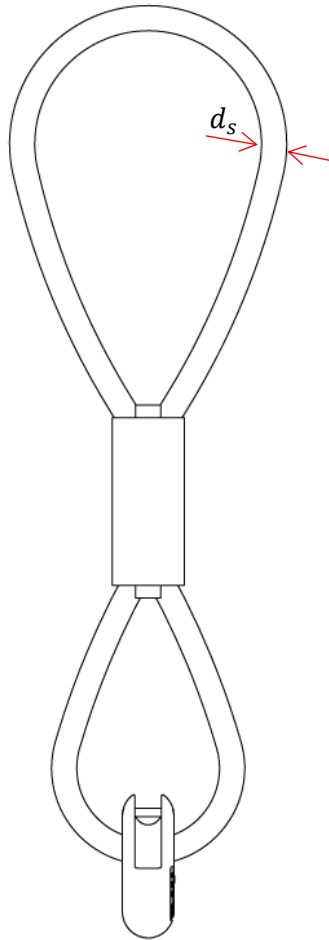
Locking bolt on ring clutch

Bent or worn locking bolts should be replaced immediately. Check the allowable wear tolerances in the provided table.



Load group	Nominal dimension D ₂ [mm]		Min. D ₂ [mm]
	SF 4:1	SF 5:1	
2.5T	13±0.8	13±0.8	12
5T	16.5±0.5	17±0.8	15
10T	23±0.5	24±0.8	22
26T	32±0.8	N/A	30.5

Table 7 Checking for defects of the ring clutch for safe operation.



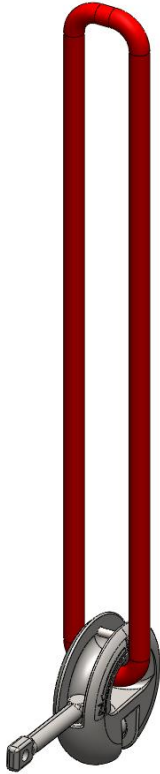
Starcon ring clutch with wire cables must be regularly inspected for defects such as:

- Kinking, buckling
- Broken braids
- Corrosion
- Crushing, slackening, and severe wear.
- Specific thresholds for ruptured wires are provided for different cable types and lengths.
- Ensure cables are free from contact with corrosive substances.
- Crane hooks should have a large cross-section radius to prevent cable damage.
- Ring clutches must be inspected annually by qualified experts, and decommissioned if deformed or excessively worn.
- Only original STARCON Ring clutch and Anchors should be used together to ensure safety and proper function.

Decommission wire cables immediately if the following numbers of ruptured wire cables are visible.

Cable type	No. of visible ruptured wires over a length of		
	$3d_s$	$6d_s$	$30d_s$
Braided cable	4	6	16

Table 8 Checking for defects on wire cables.



Starcon ring clutch with Extreema® XS round sling must be regularly inspected for defects such as:

- Missing or illegible identification tag
- Holes, tears, cuts, embedded particles, abrasive wear, or snags that expose the core yarn
- Broken or damaged core yarn
- Knots in any part of the sling body
- Chemical damage (including acid or alkali burns)
- Heat-related damage, such as melting, charring, or weld spatter on any part of the sling
- Fitting damage, including distortion, pitting, corrosion, cracks, bending, twisting, gouging, or breakage.
- Broken or worn stitching in the cover that exposes the core yarn
- Discoloration, brittleness, or stiff areas indicating potential chemical or thermal degradation
- Any other condition that raises doubts about the sling's strength or continued safe use
- Only original STARCON Ring clutch and Anchors should be used together to ensure safety and proper function.

Table 9 Checking for defects **on Extreema® XS round sling.**

11 General safety information when using the Starcon system.

General safety information when using the Starcon system.



- Ensure that the marking on the Starcon lifting unit always points in the direction of pull during lifting.
- The lifting machine must be approved to lift at least the maximum applied load + the weight of the Starcon lifting and handling system + any hoisting accessories.
- Lifting movements must be smooth; no sudden or abrupt changes in direction with the lifting machine should be made during a lifting operation, as this can lead to pendulum movements of the load, causing crushing hazards or dropping of the load.
- Where there is a risk of crushing between the load and objects, building parts, machinery, etc., the operator must not be in the danger zone.
- The operator's work area must be flat and free of obstacles that could pose a tripping hazard.
- When depositing the load, the operator must ensure this accepts on a flat and stable surface.
- Only when the load has been deposited and secured the Starcon lifting unit is completely unloaded may it be released and lifted free.
- Before each lift, ensure that both the Starcon lifting unit and the Starcon lifting anchor embedded in the concrete product are free from dirt that could reduce grip.
- Never insert arms or feet under a concrete product.
- Concrete products must never be dragged, only lifted.
- No modifications to the Starcon lifting and handling system may be made without written permission from the manufacturer.
- The operator must always ensure that the connection between the lifting machine and/or any hoisting accessories and the Starcon lifting unit is correct and secured against unintentional detachment.
- The operator must always ensure that the connection between the Starcon lifting unit and the Starcon lifting anchor is correct and secured against unintentional detachment.
- Keep a safe distance and never walk under a suspended load.
- Use gloves, safety shoes and other PPE when handling.
- Never use a Starcon lifting and handling system that has visible defects such as wear, deformations, rust damage, etc.
- Most anchors are designed to be easily handled during installation without the need for lifting equipment. However, some anchors may weigh more and should be handled using lifting equipment. Please refer to the order list for the accurate weight of each product.

11.1 Personal Protection

Always use gloves, a safety helmet, and safety shoes as a minimum requirement when operating the equipment. Keep hands and other body parts away from the lifting stand, lifting accessories, and the load during use.



11.2 Preparation of the product before use

11.2.1 Transport and Storage

The Starcon system should be transported and stored safely to prevent risks to personnel and nearby objects.

11.2.2 Unpacking

Remove the pallet and packaging protecting from the Starcon system.

Cut the safety straps. The person unpacking should wear gloves, safety shoes, and safety glasses when cutting the straps.

11.2.3 Safe Disposal of Packaging Materials

All packaging used by Certex Denmark can be reused. Pallets and all wooden packaging can be reused or recycled.

All plastic, cardboard, and paper materials should be sent to the local recycling center.

If there are no local recycling facilities, the packaging should be returned to Certex Denmark for disposal at the customer's expense.

11.2.4 Preparatory Work Before Installation

After unpacking, visually inspect the Starcon system for any damage.

11.2.5 Installation and Assembly

The Starcon system are delivered ready for use.

11.2.6 Storage and Protection Between Periods of Normal Use

Inspect the Starcon system before each use and lift. Never use anchors or lifting accessories with visible defects such as wear, deformations, corrosion damage, etc.

Always store the lifting bar indoors, in a dry and ventilated area.

11.2.7 Provision of Information (Users, Operators, Service Experts)

All operators or individuals within the danger zone must receive information on operating the Starcon lifting system and must be trained by the supervisor, familiarizing themselves with the product and its use before lifting operations commence.

Operators must be trained in the use of the lifting bar and all its functions and positioned to have a clear view of the entire lifting operation.

11.2.8 Placement of Instruction

All user manuals should always be stored together with the lifting bar.

12 Maintenance and inspection

- All maintenance must be performed when the Starcon lifting unit is unloaded.
- The Starcon lifting unit should be inspected and maintained to ensure it remains in proper condition during use.
- After each use, the Starcon lifting unit should be cleaned and inspected for any faults or deficiencies.
- If any faults are found, they must be rectified, or the Starcon lifting unit should be discarded.
- The Starcon lifting unit should always be stored in a dry and well-ventilated area.
- Any damaged, corroded, or worn-out Starcon lifting unit must be immediately taken out of service and marked not be used again.
- Equipment from Starcon should undergo at least one annual inspection by a qualified skilled person to inspect lifting equipment and cranes.

12.1 Maintenance Schedule



- Only original spare parts may be used, and they must be replaced by a trained individual.
- The annual inspection must be carried out by a qualified individual who has received the necessary training and certification for lifting equipment.
- All services must be documented, and the data must be stored.
- If there are any visual defects or if the labeling is not present on the lifting stand, the lifting stand must be marked as "out of service".

B Before use

A After use

M Monthly, or a maximum of 200 hours of usage.

Y Annually, or after a maximum of 2400 hours of use.

Inspection	B	A	M	Y
Perform a visual inspection to check for signs of overload, deformation, damage, wear, and corrosion.	X	X	X	X
The equipment must undergo inspection.			X	
Ensure that the equipment is ready and clearly labeled.			X	X
Inspection should be carried out by a qualified individual with a report prepared.				X

Table 10 Maintenance schedule

13 Disposal / Recycling

This section describes the end of use for the product.

- End of use / Disposal The lifting points shall be sorted / scrapped as general steel scrap.
- The Starcon lifting and handling system should be sorted and disposed of according to appropriate material categories, including metal, plastic, etc.
- Certex can assist you with disposal if required.

14 Product data of STA Ring clutch

Figure 3 shows a measurement sketch for the STA Ring clutch.

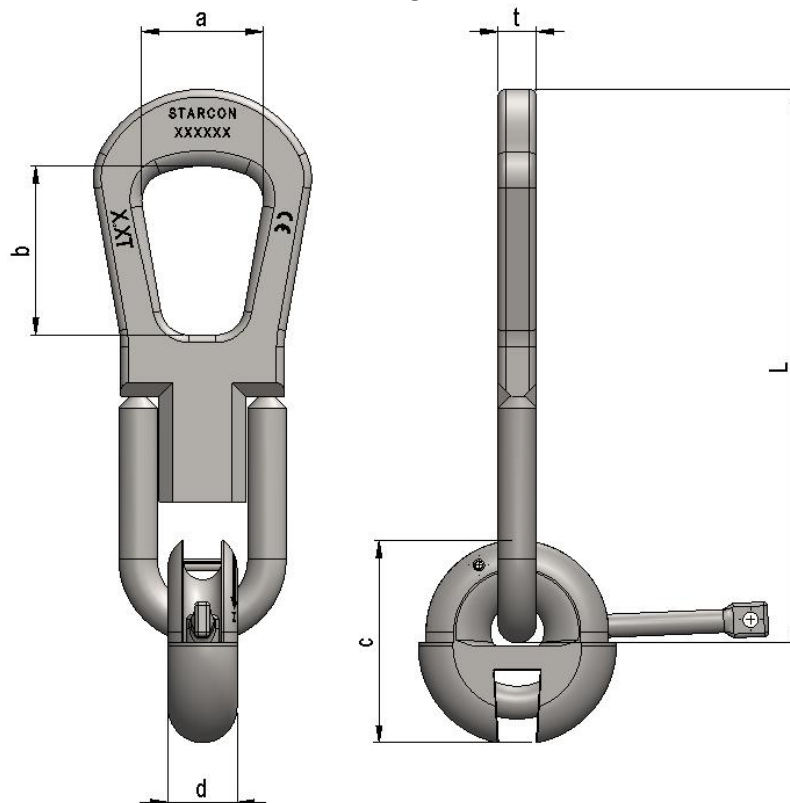


Figure 3 Ring clutch sketch.

14.1 Technical data

Table 11 shows the dimensions of the various types of ring clutch.

Load group	Safety factor	Hole height a mm	Hole width b mm	Head dia. c mm	Head width d mm	Plate length L mm	Plate thickness t mm
2.5T	4:1	70	54	79	27	223	12.5
	5:1	70	57	79	27	267	16
5T	4:1	85	59.5	107	37	281	17
	5:1	88	63	103	36	288.5	20
10T	4:1	110	82.5	148	50	352	25
	5:1	120	90	160	50	374	28
26T	4:1	155	136	203	72	520.5	36

Table 11 Ring clutch dimension.

15 Product data of STA Ring clutch with wire

Figure 3 shows a measurement sketch for the ring clutch with wire.

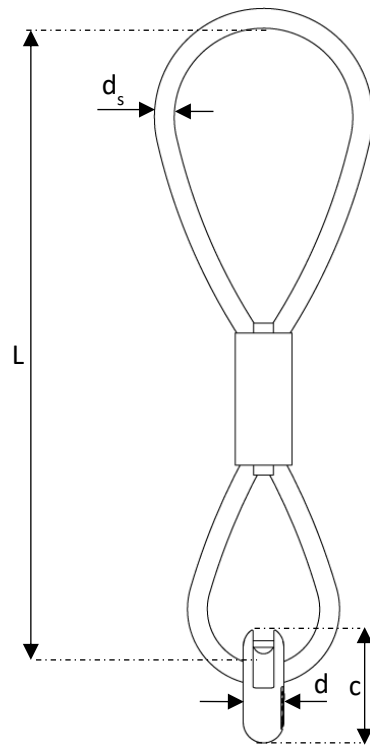


Figure 4 Ring clutch with wire sketch.

15.1 Technical data

Table 12 shows the dimensions of the various types of ring clutch with wire.

Load group	Length L mm	Wire dia. d_s mm	Head dia. c mm	Head width d mm
2.5T	581	14	79	27
5T	664	18	107	37
10T	814	24	148	50

Table 12 Ring clutch with wire dimension.

16 Product data of STA Ring clutch with Extreema® XS round sling

Figure 3 shows a measurement sketch for the ring clutch with Extreema® XS round sling.

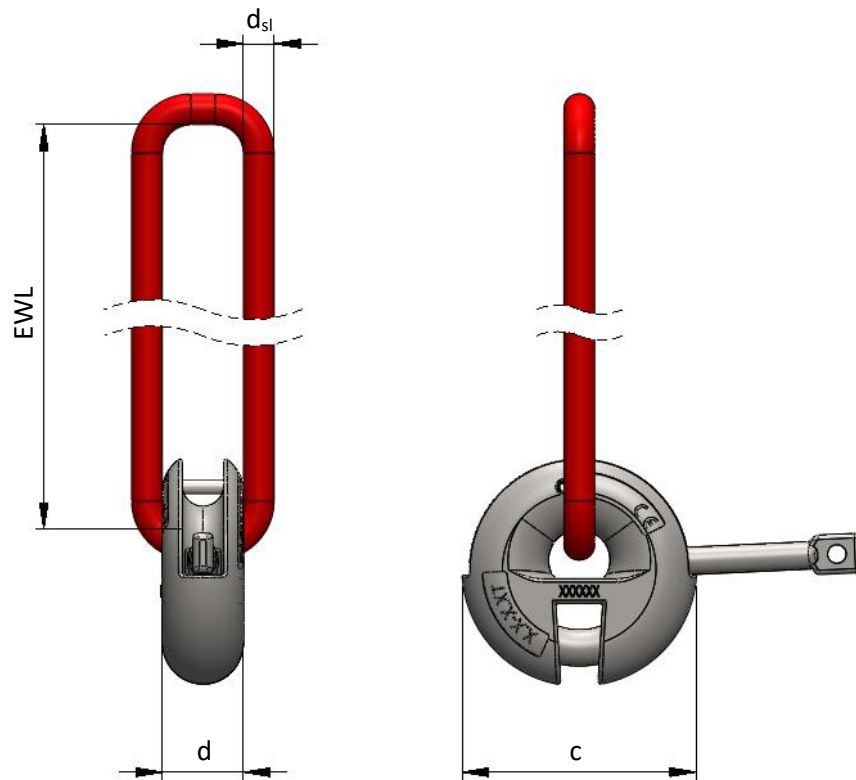


Figure 5 Ring clutch with Extreema® XS round sling sketch.

16.1 Technical data

Table 13 shows the dimensions of the various types of ring clutch with Extreema® XS round sling.

Load group	Clutch head diameter c mm	Clutch head width d mm	Effective working length EWL m	Extreema® XS round sling core dia. d _{sl} mm
5T	107	37	0.5	14
10T	148	50	0.25	23
26T	203	72	1	45

Table 13 Ring clutch with Extreema® XS round sling dimension.

17 EC – Declaration of Conformity of the Machinery

This certificate meets the requirements of the Directive 2006/42/EC Annex II.

Manufacturer and responsible for compiling the technical documentation:

Company:	CERTEX Danmark A/S	Tel. No.:	+45 74 54 14 37
Address:	Trekanten 6-8	E-mail:	info@certex.dk
	6500 Vojens		
	Denmark		

The undersigned hereby declares that the below specified tool comply with the current safety and health rules and legislation within the European Union. If any changes are made on the tool without approval from the manufacturer, this Declaration no longer applies.

Description:	Ring clutch
Drawing No.:	XXXXXXXXXX
Serial No.:	XXXXXX
Lifting Capacity:	WLL pr unit
Own Weight:	Kg pr unit

Is made in accordance with the following EC-directive;
2006/42/EC

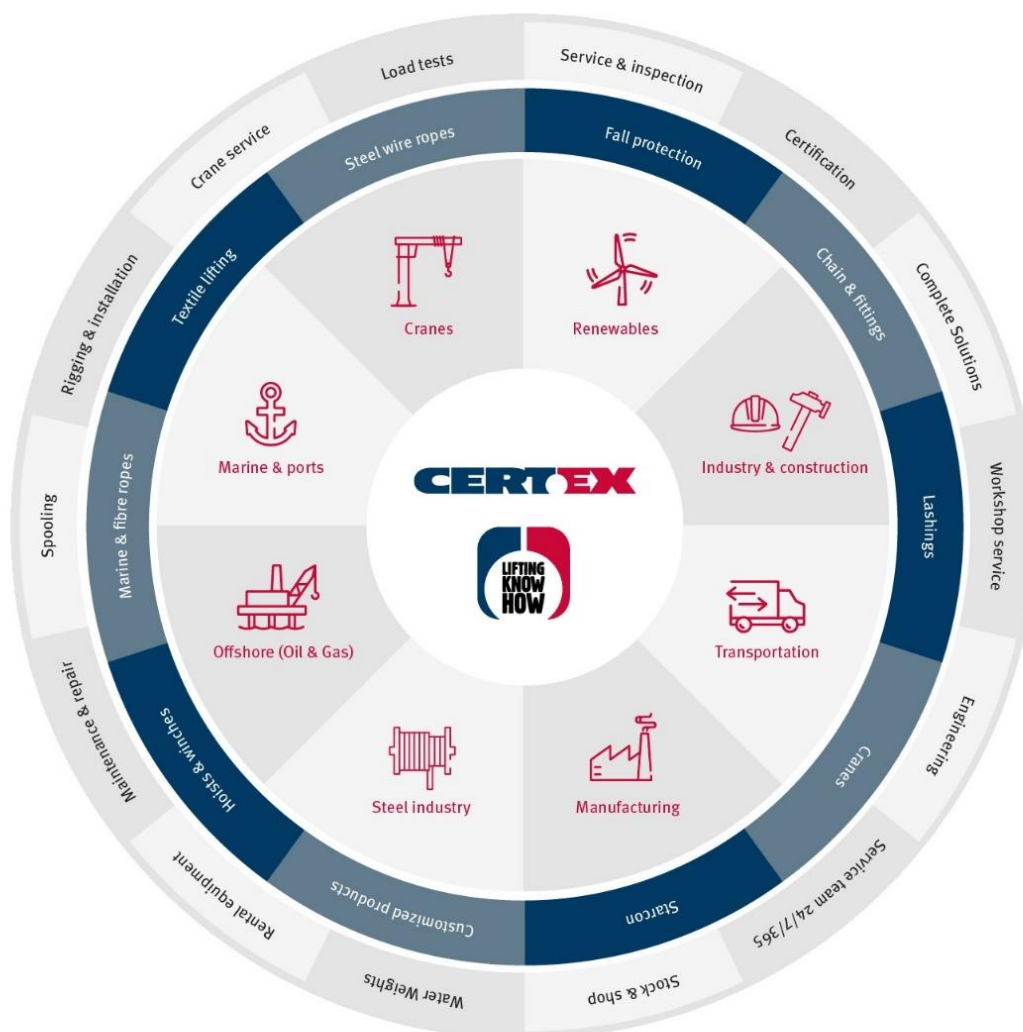
The following standards have been used:
EN 13155+A2 : 2009

Date:

For CERTEX Danmark A/S

Our industries, products & services

At CERTEX Denmark, we are a secure and reliable total supplier and partner within lifting equipment. Below is an overview of the industries we service, our product range, and the services we offer."



"

**Based on many years of experience
& know-how within lifting, load
tests & engineering, CERTEX
Denmark is your reliable partner &
supplier of steel wire, lifting
applications & related services."**