

CLAMPING TECHNOLOGY

Volume 1: Manual | Pneumatic | Hydraulic



End Effectors	Grippers	Indexers
Manual Clamps	Power Clamps	Remote Handling

PRODUCT CATALOG



Precision in Productivity

destaco.com

ABOUT DESTACO

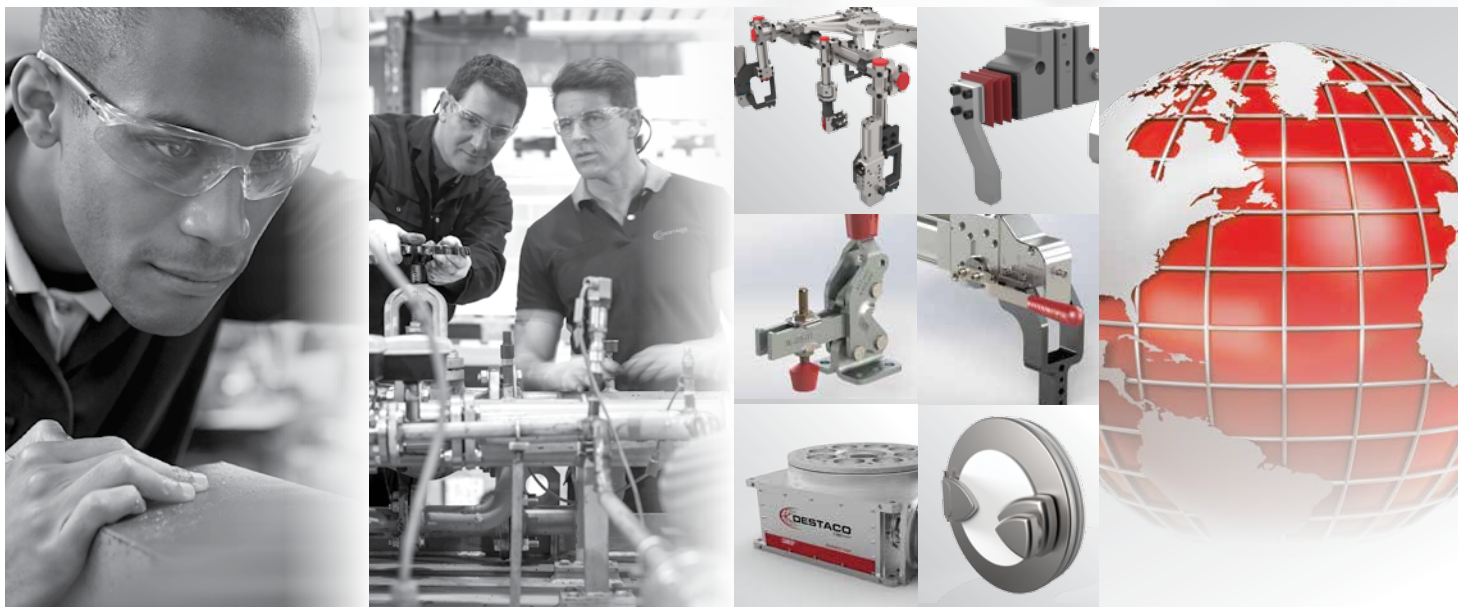


Precision in Productivity™

DESTACO Mission Statement

Enable optimal manufacturing productivity through a comprehensive suite of easy to integrate high-performance, precision automation, workholding and containment solutions.

- **Focused** - Dedicated talent and resources to help manufacturers improve precision and productivity
- **Insightful** - Full line of products improves production flexibility and meets any manufacturing requirement
- **Comprehensive** - Through perspective gained on plant floors around the world, we deliver unique, creative solutions nobody else can
- **Global** - Production, customer and technical support worldwide, wherever you need us



FOCUSED



INSIGHTFUL



COMPREHENSIVE



GLOBAL



A LEGACY OF PERFORMANCE AND DEPENDABILITY

Whether on the
workbench or on
the line, DESTACO
is always at the
point of precision.

For more than 100 years, we've focused our resources on providing great products, service and reliability for all market segments around the world. Today, our insight and high-performance automation and workholding products continue to help manufacturers improve productivity and quality while reducing scrap and production costs.



Precision in Productivity™

End Effectors

Grippers

Indexers

Manual Clamps







Power Clamps

Remote Handling

destaco.com

CLAMPING TECHNOLOGY

Vol. 1: Manual, Pneumatic, Hydraulic | Table of Contents

	Vertical Hold Down Clamps.....	MC-VHD
	Horizontal Hold Down Clamps	MC-HHD
	Straight Line Action Clamps.....	MC-SLA
	Variable Stroke Straight Line Action Clamps.....	MC-VSC
	Pull Action Latch Clamps	MC-PAL
	Squeeze Action Clamps.....	MC-SAP
	Accessories	MC-ACC
	Carver Clamps.....	MC-CVR
	Pneumatic Toggle Clamps.....	MC-PTC
	Pneumatic Swing Clamps	MC-PSC
	Pneumatic Power Cylinders.....	MC-PPC

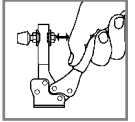
CLAMPING TECHNOLOGY

Vol. 1: Manual, Pneumatic, Hydraulic | Table of Contents

Pneumatic Power Clamps PC-PPC



Technical Appendix.....MC-TEC



Hydraulic Clamping Technology..... MC-HYD



Product IndexMC-IND

MANUAL CLAMPING CUSTOM SOLUTIONS

Custom Solutions for Manual Clamps

Below are some examples of standard products modified to customer specified custom solutions. If there is no product that fits your needs, we will partner with your to design a product that fits.

Model 330
Standard Product



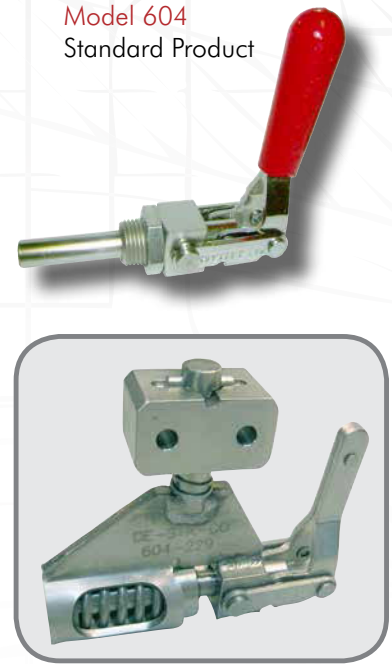
330-201 Stainless steel clamp with special hook and locking tab

Model 2002-U
Standard Product



2002-200 with bar cut and bolt retainer welded on

Model 604
Standard Product



604-229 Stainless steel straight line clamp used in chemical machining process

Contact us today to get started on your custom application: clamps@destaco.com

Markets



Industrial



Aerospace



Food & Packaging



Transportation



Consumer Goods

Applications



Assembly



Welding



Fixture and Testing



CNC/Machining



White Goods/
Appliance



Woodworking

MAKING OUR PRODUCTS SPECIAL FOR YOU

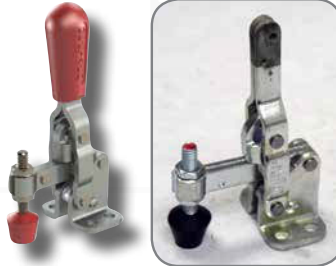
Custom Solutions for Manual Clamps

DESTACO offers three levels of modifications for customizing our manual clamping products to fit our customers specified applications. Depending on the severity of the modifications, quoting times may take longer.

Level 1 Modifications:

- Alternate standard accessories
- Removal of grips
- Alternate plating/coating
- Alternate vinyl dipping
- Quotes within 1 day*

Model 202
Standard Product



202-200 without grip,
with imperial threaded
spindle

Model 630-M
Standard Product

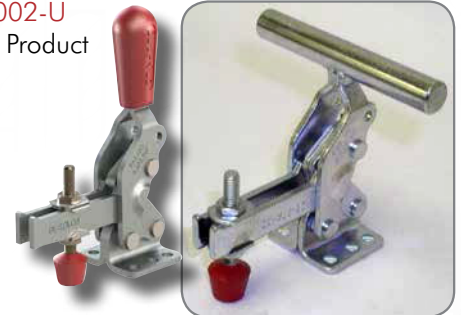


630-38 with electroless nickel plating

Level 2 Modifications:

- Handle and arm extensions
- Custom hooks for pull-action clamps
- Cut-off handles and arms
- Drilled & tapped arms
- Quotes within 3 days*

Model 2002-U
Standard Product



2002-201 with special T-handle

Level 3 Modifications:

- Engineered modifications
- Special plungers for straight line action clamps
- Quotes within 5 days*

Model 624/624-MM
Standard Product



624-MM-872 with modified handle and
square plunger

Model 802-U
Standard Product



802-U219 with handle for manual operation

(*) All inquiries subject to minimum order

2002 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- Large hand clearance for improved safety
- Bolt pattern interchangeable with 202 Series
- Three times the holding capacity of 202 Series
- Hardened bushings at key pivot points
- Near vertical clamping contact
- BLK models feature a black, non-reflective finish

Applications:

- Checking fixtures
- Assembly & test
- Light machining
- Woodworking

Also Available:

See page MC-ACC-1 for accessories
Accepts M6 or 1/4 spindle accessories

Covered under one or more U.S./International Patents

2002-**U**

Flanged Base
U-Bar



2002-**U-LS-BLK** ⓘ

Blackout Series
Flanged Base
U-Bar



2002-**S**

Flanged Base
Solid Bar



2002-**UB**

Straight Base
U-Bar



2002-**UB-LS-BLK** ⓘ

Blackout Series
Straight Base
U-Bar



2002-**SB**

Straight Base
Solid Bar



2002-**UR**

Flanged Base
U-Bar
with
DESTACO®
Toggle Lock
Plus



2002-**SR** ⓘ

Flanged Base
Solid Bar
with
DESTACO®
Toggle Lock
Plus



2002-**UBR**

Straight Base
U-Bar
with
DESTACO®
Toggle Lock
Plus



2002-**SBR** ⓘ

Straight Base
Solid Bar
with
DESTACO®
Toggle Lock
Plus



2002-**U207**

Flanged Base
U-Bar
Interchangeable
with 207 Series



2002-**UR207**

Flanged Base
U-Bar
Interchangeable
with 207 Series,
DESTACO®
Toggle
Lock Plus

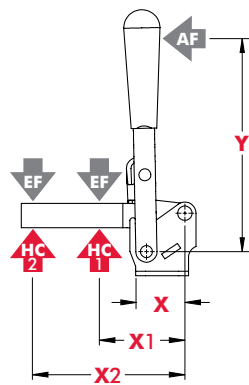


ⓘ This item is available upon request

Model	Max. Holding Capacity	Clamp Bar Opening(+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)		
					Bolt Retainer	Spindle Assembly	Flanged Washers
2002-U	2700 N [600 lbf]	75°	66°	0,22kg [0.48lb]	--	215208-M	215105
2002-U-LS-BLK ⓘ					--	--	215105-BLK
2002-S					2002115-E	--	--
2002-UB					--	215208-M	215105
2002-UB-LS-BLK ⓘ					--	--	215105-BLK
2002-SB					2002115-E	--	--
2002-UR		--	215208-M	215105			
2002-SR ⓘ		2002115-E	--	--			
2002-UBR		--	215208-M	215105			
2002-SBR ⓘ		2002115-E	--	--			
2002-U207		90°	72°	0,26kg [0.57lb]	--	215208-M	215105
2002-UR207		75°	57°				

ⓘ This item is available upon request

Holding Capacities



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
2002-()	[1.12] 28,5	[1.45] 37	[2.64] 67	[3.66] 93	[600 lbf] 2700N	[295 lbf] 1310N	11:1	5:1

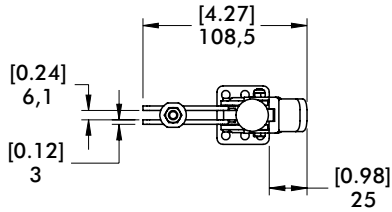
Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

2002 SERIES

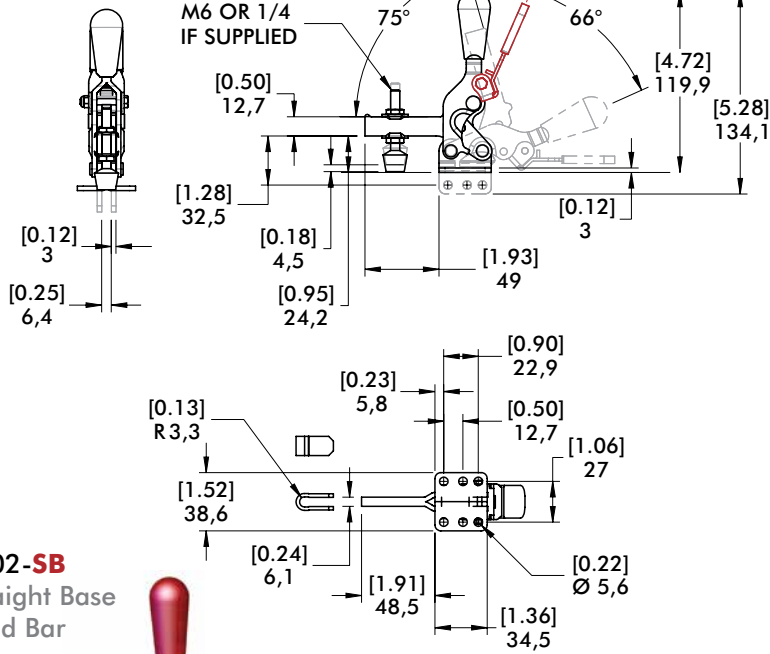
Vertical Hold Down Clamps | Dimensions | -U/-S/-UB/-SB/-UR/-SR/-UBR/-SBR

2002-U

Flanged Base
U-Bar

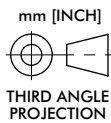


DESTACO®
TOGGLE LOCK
PLUS OPTION

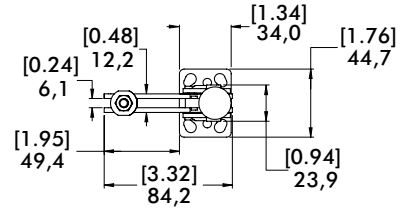


2002-SB

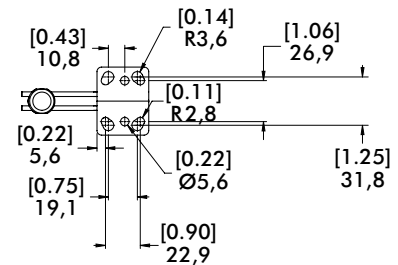
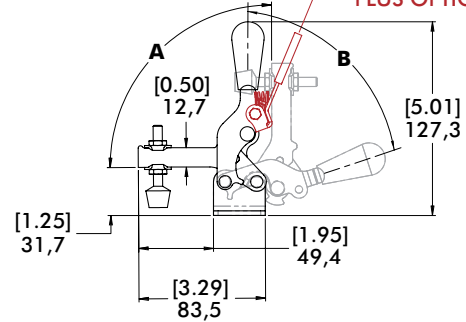
Straight Base
Solid Bar



2002-U207/2002-UR207 with interchangeable Series 207 Mounting Pattern



DESTACO®
TOGGLE LOCK
PLUS OPTION



Model	A	B
2002-U-207	90°	72°
2002-UR207	75°	57°

2007 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- Large hand clearance for improved safety
- Bolt pattern interchangeable with 207 Series
- Over two times the holding capacity of 207 Series
- Hardened bushings at key pivot points
- Near vertical clamping contact

Applications:

- Checking fixtures
- Assembly & test
- Light machining
- Woodworking

Also Available:

See page MC-ACC-1 for accessories
Accepts M8 or 5/16 spindle accessories

Covered under one or more U.S./International Patents

2007-U
Flanged Base
U-Bar



2007-U-LS-BLK ⓘ
Blackout Series
Flanged Base
U-Bar



2007-S
Flanged Base
Solid Bar



2007-UB
Straight Base
U-Bar



2007-UB-LS-BLK ⓘ
Blackout Series
Straight Base
U-Bar



2007-SB
Straight Base
Solid Bar



2007-UR
Flanged Base
U-Bar
with
DESTACO®
Toggle Lock
Plus



2007-SR ⓘ
Flanged Base
Solid Bar
with
DESTACO®
Toggle Lock
Plus



2007-UBR
Straight Base
U-Bar
with
DESTACO®
Toggle Lock
Plus



2007-SBR ⓘ
Straight Base
Solid Bar
with
DESTACO®
Toggle Lock
Plus

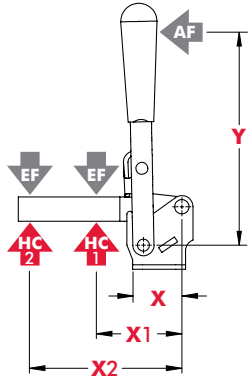


Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)		
					Bolt Retainer	Spindle Assembly	Flanged Washers
2007-U	4450 N [1000 lbf]	76°	64°	0,54kg [1.20lbs]	--	2007208-M	507107
2007-U-LS-BLK ⓘ					--	--	507107-BLK
2007-S					2007115-E	--	--
2007-UB					--	2007208-M	507107
2007-UB-LS-BLK ⓘ					--	--	507107-BLK
2007-SB					2007115-E	--	--
2007-UR					--	2007208-M	507107
2007-SR ⓘ					2007115-E	--	--
2007-UBR					--	2007208-M	507107
2007-SBR ⓘ					2007115-E	--	--

ⓘ This item is available upon request

Vertical Hold Down Clamps | Holding Capacities

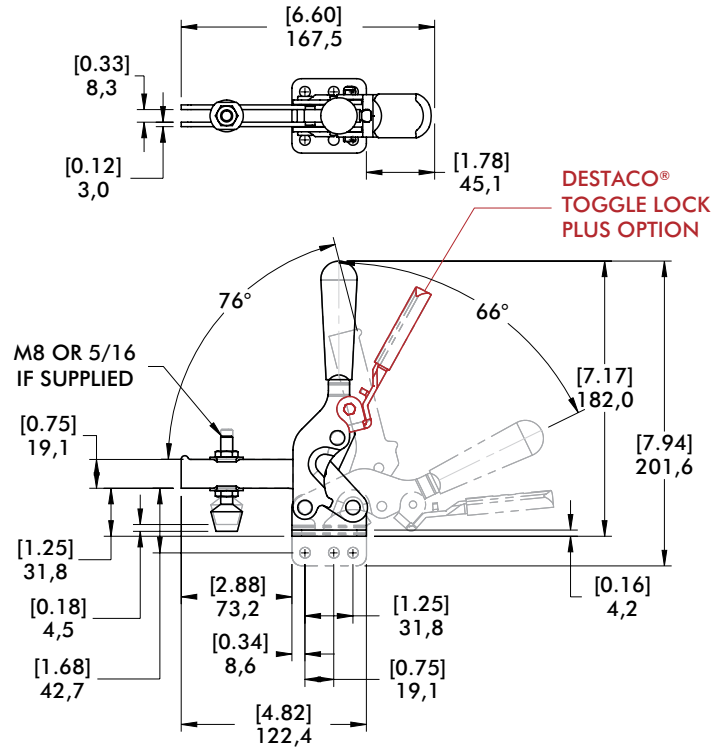
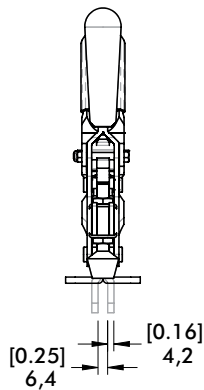


Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
2007-()	[1.59] 40,5	[1.95] 49,5	[3.92] 99,5	[5.16] 131	[1000lbf.] 4450N	[470lbf.] 2090N	10:1	5.3:1

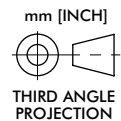
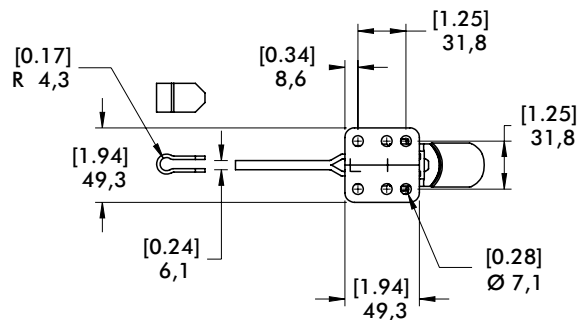
Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

Dimensions | -U/-S/-UB/-SB/-UR/-SR/-UBR/-SBR

2007-U Flanged Base U-Bar



2007-SB Straight Base Solid Bar



2010 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- Large hand clearance for improved safety
- Bolt pattern interchangeable with 210 Series
- Over two times the holding capacity of 210 Series
- Hardened bushings at key pivot points
- Near vertical clamping contact

Applications:

- Checking fixtures
- Assembly & test
- Light machining
- Woodworking

Also Available:

See page MC-ACC-1 for accessories
Accepts M10 or 3/8 spindle accessories

Covered under one or more U.S./International Patents

2010-U
Flanged Base
U-Bar



2010-S
Flanged Base
Solid Bar



2010-UB
Straight Base
U-Bar



2010-SB
Straight Base
Solid Bar



2010-UR
Flanged Base
U-Bar
with DESTACO®
Toggle Lock Plus



2010-SR ⓘ
Flanged Base
Solid Bar
with DESTACO®
Toggle Lock Plus



2010-UBR
Straight Base
U-Bar
with DESTACO®
Toggle Lock Plus



2010-SBR ⓘ
Straight Base
Solid Bar
with DESTACO®
Toggle Lock Plus



Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)		
					Bolt Retainer	Spindle Assembly	Flanged Washers
2010-U	6230 N [1400 lbf]	78°	66°	1,16kg [2.56lbs]	---	240208-M	235106
2010-S					2010115-E	---	---
2010-UB					---	240208-M	235106
2010-SB					2010115-E	---	---
2010-UR					---	240208-M	235106
2010-SR ⓘ					2010115-E	---	---
2010-UBR					---	240208-M	235106
2010-SBR ⓘ					2010115-E	---	---

ⓘ This item is available upon request

201 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- Smallest series in the Vertical Handle series
- Stainless steel version available

Applications:

- Checking fixtures
- Assembly & test
- Woodworking

Also Available:

See page MC-ACC-1 for accessories

812-U Pneumatic Toggle Clamp
(See page MC-PTC-3)

201-U
Flanged Base
U-Bar



201-UB
Straight Base



201-TU
Flanged
Base, U-Bar,
T-Handle



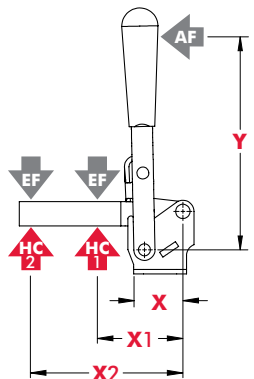
201-USS
Flanged Base
U-Bar, Stainless
Steel



Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
201-U	440 N [100 lbf]	100°	55°	0,70kg [0.15lbs]	305208-M	102111
201-UB						
201-TU						
201-USS	560 N [125 lbf]				201943-M	102911

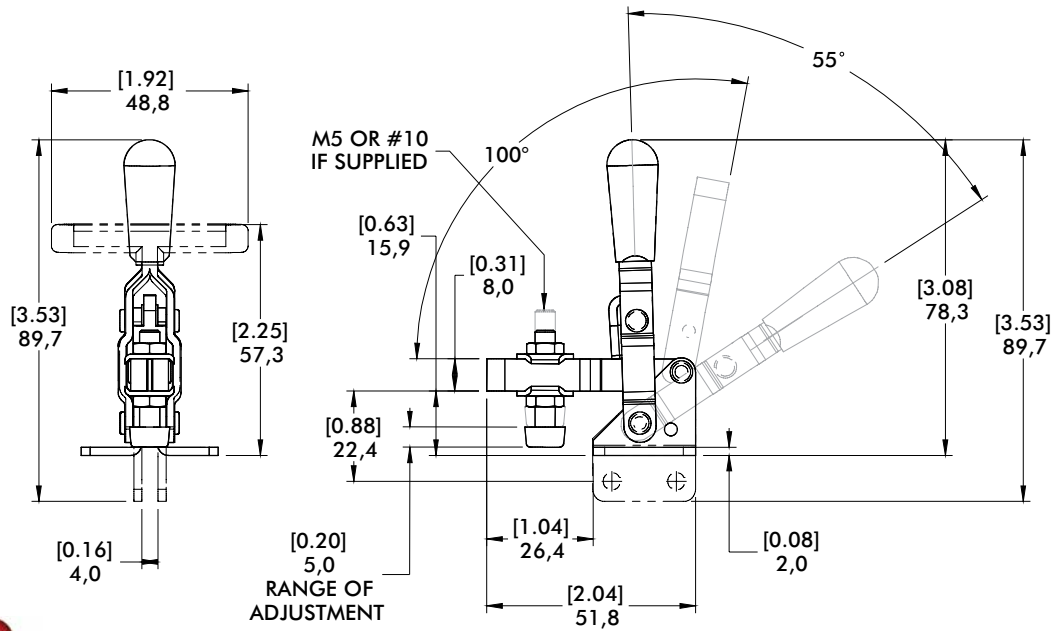
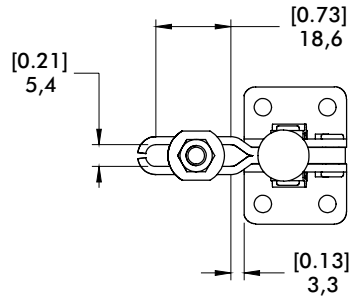
Holding Capacities



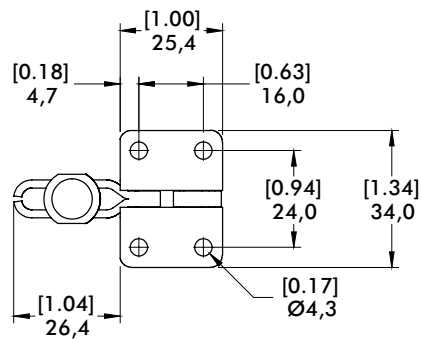
Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U/UB				[2.25] 57	[100lbf.] 440N	[55lbf.] 245N	9:1	6:1
TU	[0.87] 22	[1.06] 27	[1.75] 44,5	[1.38] 35			8.4:1	4:4:1
USS				[2.25] 57	[125lbf.] 560N	[60lbf.] 270N	9:1	6:1

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

201-U
Flanged Base
U-Bar



201-UB
Straight Base



mm [INCH]
THIRD ANGLE
PROJECTION

202 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- Two bar styles available
- Low profile T-Handle version available
- Available in stainless steel
- Accommodates M6 or 1/4" spindle accessories
- BLK models feature a black, non-reflective finish

Applications:

- Checking fixtures
- Assembly & test
- Light machining
- Woodworking

Also Available:

See page MC-ACC-1 for accessories

802-U Pneumatic Toggle Clamp
(See page MC-PTC-5)

202-U
Flanged Base
U-Bar



202-UL
Flanged Base
Long U-Bar



202-USS
Flanged Base
U-bar, Stain-
less Steel



202
Flange Base
Solid Bar



202-SS
Flanged Base
Solid Bar
Stainless Steel



202-UB
Straight Base
U-bar



202-B
Straight Base
Solid Bar



202-TU
Flanged Base
U-bar,
T-Handle



202-T
Flanged Base
Solid Bar
T-Handle



202-U-L ⓘ
Flanged Base
Open U-Bar



202-U-L-BLK ⓘ
Blackout Series
Flanged Base
Open U-Bar



202-UB-L ⓘ
Straight Base
Open U-Bar



202-UB-L-BLK ⓘ
Blackout Series
Straight Base
Open U-Bar



202305

Flanged Grip.
Provides added safety
and protection. Fits all
202 Series (except
T-Handle) clamps.
Order separately.

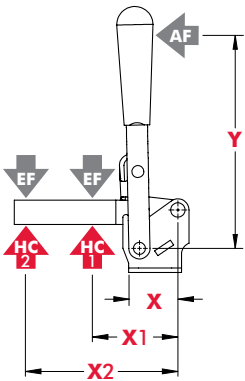


ⓘ This item is available upon request

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
202-U	890 N [200 lbf]	105°	65°	0,16kg [0.35lbs]	202208-M	215105
202-UL	890 N [200 lbf]				202943-M	215905
202-USS	1110 N [250 lbf]				202208-M	---
202	890 N [200 lbf]			0,15kg [0.33lbs]	205943-M	---
202-SS	1110 N [250 lbf]			0,16kg [0.35lbs]	202208-M	215105
202-UB	890 N [200 lbf]			0,15kg [0.33lbs]		
202-B	890 N [200 lbf]			0,17kg [0.38lbs]		
202-TU	890 N [200 lbf]			0,16kg [0.35lbs]		
202-U-L ⓘ	890 N [200 lbf]			---	---	
202-U-L-BLK ⓘ	890 N [200 lbf]					
202-UB-L ⓘ	890 N [200 lbf]					
202-UB-L-BLK ⓘ	890 N [200 lbf]					

ⓘ This item is available upon request

Holding Capacities



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
202-U	[0.79] 20	[1.25] 32	[2.25] 57	[3.42] 87	[200 lbf] 890N	[140 lbf] 625N	10:1	5:1
202-UL			[2.88] 73	[3.00] 76	[250 lbf] 1110N	[150 lbf] 670N		4:1
202-USS			[2.25] 57	[3.00] 76	[250 lbf] 1110N	[170 lbf] 760N		5:1
202		---	[1.88] 48	[3.42] 87	---	[200 lbf] 890N	---	8:1
202-SS		---	[1.88] 48	[3.00] 76	---	[250 lbf] 1110N	---	8:1
202-UB		[1.25] 32	[2.25] 57	[3.42] 87	[200 lbf] 890N	[140 lbf] 625N	10:1	5:1
202-B		---	[1.88] 48	[3.42] 87	---	[200 lbf] 890N	---	8:1
202-TU		[1.25] 32	[2.25] 57	[2.13] 54	[200 lbf] 890N	[140 lbf] 625N	11:1	7:1
202-T		---	[1.88] 48	[3.42] 87	---	[200 lbf] 890N	---	6:1
202-U-L ⓘ		---	---	---	---	---	---	---
202-U-L-BLK ⓘ		[1.25] 32	[2.25] 57	[3.42] 87	[200 lbf] 890N	[140 lbf] 625N	10:1	5:1
202-UB-L ⓘ		---	---	---	---	---	---	---
202-UB-L-BLK ⓘ		---	---	---	---	---	---	---

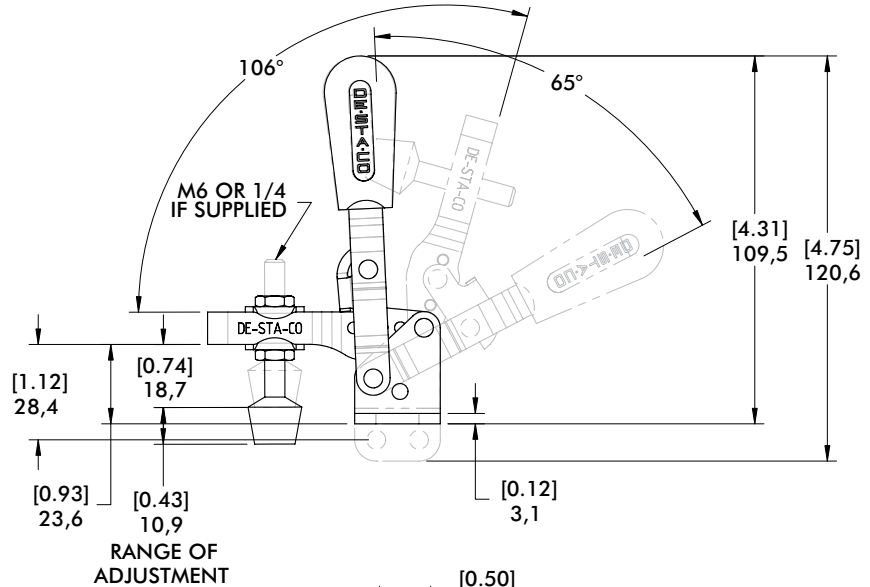
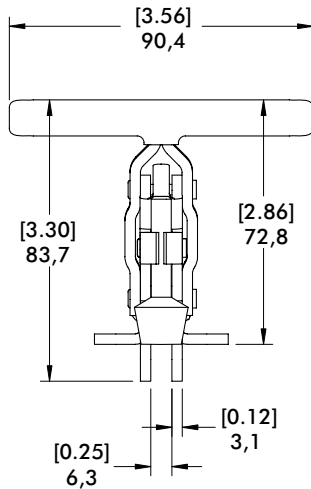
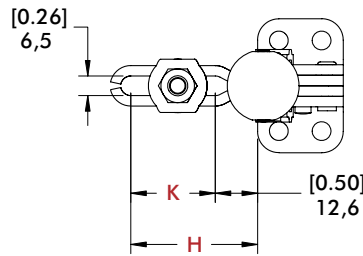
Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force

ⓘ This item is available upon request

202 SERIES

Vertical Hold Down Clamps | Dimensions | -U/-UL/-USS/-SS/-UB/-B/-TU/-T

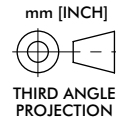
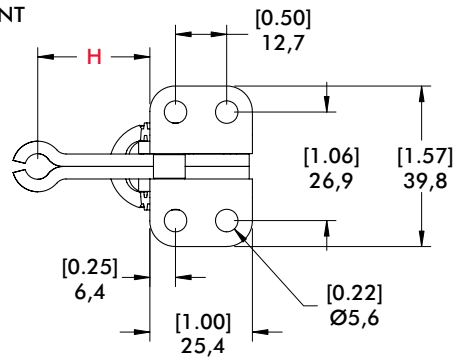
202-U
Flanged Base
U-Bar



Open Bar Option

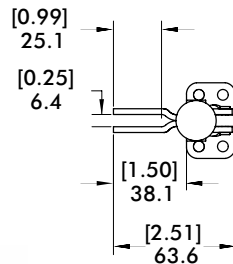


See page
MC-ACC-7
for complete
offering of open
bar accessories



Flanged Base
Model

202-U-L ⓘ
202-U-L-BLK ⓘ



Straight Base
Model

202-UB-L ⓘ
202-UB-L-BLK ⓘ



Bar Style	Clamp Models	H	K
	202-U/202-UB/ 202-USS/202-TU	[1.73] 44,1	[0.98] 25
	202-UL ⓘ	[2.29] 58,1	[1.51] 38,4
	202/202-B/ 202-T/202-SS	[1.08] 27,4	---
	202-U-L ⓘ/ 202-UB-L ⓘ	[1.50] 38,1	---

ⓘ This item is available upon request

VERTICAL HOLD DOWN CLAMPS

Application Example

Application Areas

Clamping during the assembling, drilling, testing, gluing, locking of covers and much more. The vertical clamp is the most frequently used product whenever clamping products are to be integrated with a manual fixture.

The essential product features

- In the clamping position, the handle is vertical
- Vertical clamps open at an angle between 75° and 215°
- Vertical clamps are offered with U-shaped or heavy-duty solid clamping bars
- Vertical clamps have a straight or flanged base.
The heavy-duty vertical clamps possess a base that can be welded on without a hole pattern



207 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- Largest selection of arm and mounting options
- Low profile T-Handle version available
- Available in stainless steel
- BLK models feature a black, non-reflective finish

Applications:

- Checking fixtures
- Assembly & test
- Light machining
- Woodworking

Also Available:

See page MC-ACC-1 for accessories

807-U Pneumatic toggle clamp
(See page MC-PTC-8)

807-S Pneumatic toggle clamp
(See page MC-PTC-8)

Accepts M8 or 5/16 spindle accessories

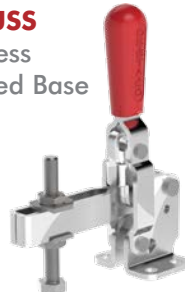
207-U
Flanged Base
U-Bar



207-UL
Flanged Base
Long U-Bar



207-USS
Stainless
Flanged Base
U-Bar



207-S
Flanged Base
Solid Bar



207-L
Flanged Base
Long Solid Bar



207-TU
Flanged Base
T-Handle
U-Bar



207-TUL
Flanged Base
T-Handle
Long U-Bar



207-UR
Flanged Base
U-Bar
with
DESTACO®
Toggle Lock
Plus



207-LR
Flanged Base
Long Solid Bar
with
DESTACO®
Toggle Lock
Plus



207-UB
Straight Base
U-Bar



207-ULB
Straight Base
Long U-Bar



207-SB
Straight Base
Solid Bar



207-LB
Straight Base
Long Solid
Bar



207-LBR ⓘ
Straight Base
Long Solid
Bar with
DESTACO®
Toggle Lock
Plus



207-UF ⓘ
U-Bar
Dual Mount



207-SF ⓘ
Solid Bar
Dual Mount



207-U-L ⓘ
Flange Base
Open Bar



207-U-L-BLK
Blackout Series
Flanged Base
Open U-Bar



207-UB-L ⓘ
Straight Base
Open Bar



207-UB-L-BLK
Blackout Series
Straight Base
Open U-Bar



207305

Flanged Grip. Provides added safety and protection. Fits all 207 Series (except T-Handle) clamps. Order separately.

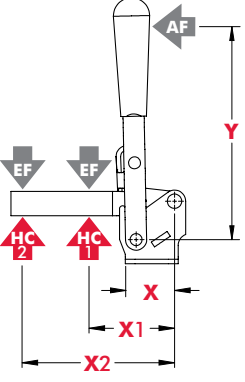


ⓘ This item is available upon request

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)				
					Bolt Retainer	Spindle Assembly	Flanged Washers		
207-U	1670 N [375 lbf]	99°	57°	0,30kg [0.67lb]	---	225208-M	507107		
207-UR				0,45kg [1.00lb]					
207-UL				0,30kg [.67lb]					
207-USS	2000 N [450 lbf]			---	207943-M	507907			
207-S	2220 N [500 lbf]			---	---	0,31kg [0.69lb]	207105	---	---
207-L						0,34kg [0.74lb]			
207-LR						0,45kg [1.00lb]			
207-UB	1670 N [375 lbf]			---	---	0,33kg [0.72lb]	---	225208-M	507107
207-ULB									
207-SB	2220 N [500 lbf]			---	---	0,31kg [0.69lb]	207105	---	---
207-LB						0,34kg [0.75lb]			
207-LBR ⓘ						0,45kg [1.00lb]			
207-TU	1670 N [375 lbf]			---	---	0,33kg [0.72lb]	---	---	507107
207-TUL									
207-UF ⓘ	1670 N [375 lbf]			96°	56°	0,43kg [0.94lb]	---	225208-M	507107
207-SF ⓘ	2220 N [500 lbf]	90°	---	0,38kg [0.84lb]	207105	---	---		
207-U-L ⓘ	1670 N [375 lbf]	99°	57°	0,38kg [0.84lb]	---	---	507107		
207-U-L-BLK ⓘ							507107-BLK		
207-UB-L ⓘ							507107		
207-UB-L-BLK ⓘ							507107-BLK		

ⓘ This item is available upon request

Holding Capacities



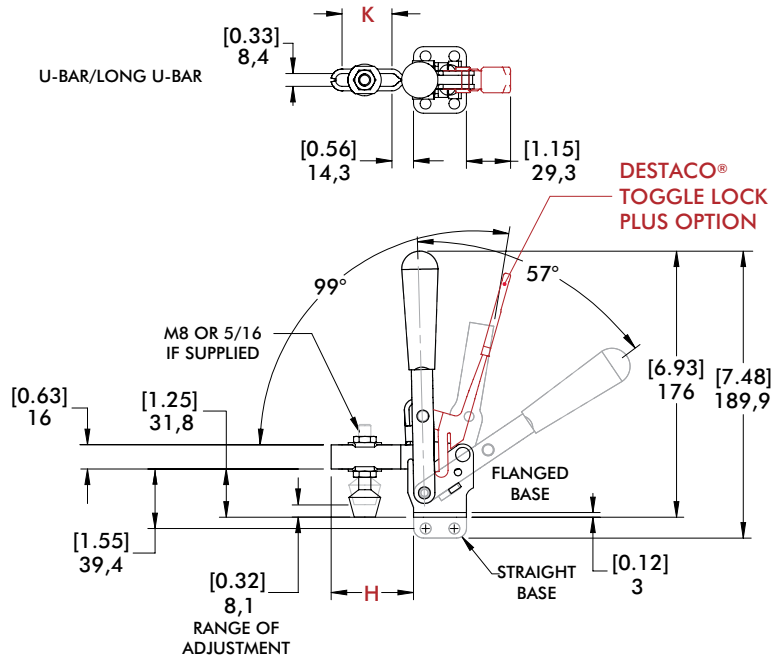
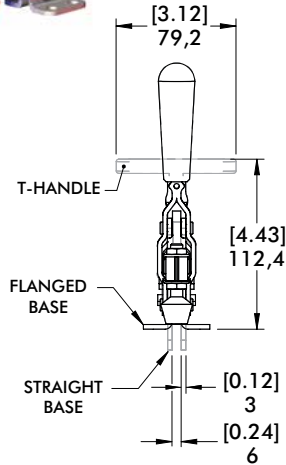
Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U/UB/UR	[1.28] 32,6	[2.00] 50,8	[3.75] 95,3	[4.90] 124,5	[375 lbf] 1670N	[225 lbf] 1000N	12:1	6:1
UL/ULB		[3.88] 98,5	[5.00] 127			[150 lbf] 670N		
USS		[2.00] 50,8	[3.75] 95,3		[450 lbf] 2000N	[240 lbf] 1070N		
S/SB		[2.88] 73,0	[5.00] 127	[500 lbf] 2220N	[350 lbf] 1560N	10:1	7:1	
L/LR LB/LBR		[2.88] 73,0	[5.00] 127					
TU		[2.00] 50,8	[3.75] 95,3	[3.66] 9	[375 lbf] 1670N	[225 lbf] 1000N	6:1	4:1
TUL		[3.88] 98,5	[5.00] 127	[150 lbf] 670N				
U-L		[2.00] 50,8	[3.75] 95,3	[4.90] 124,5	[375 lbf] 1670N	[2225 lbf] 1000N	12:1	6:1
UB-L								

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force

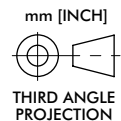
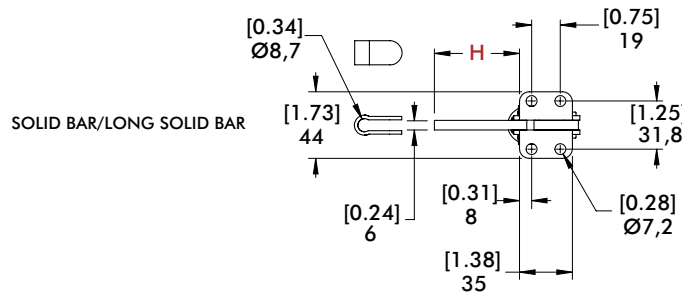
207 SERIES

Vertical Hold Down Clamps | Dimensions | -U/-UL/-S/-L/-TU/-TUL/-UR/-LR/-UB/-ULB/-SB/-LB/-LBR

207-U
Flanged Base
U-Bar



207-SB
Straight Base
Solid Bar

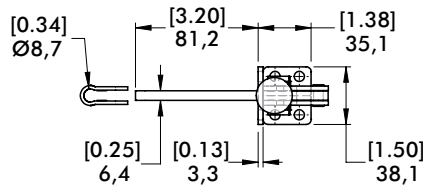
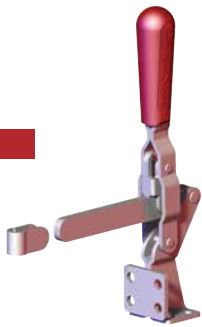


Bar Style	Clamp Models	H	K
	207-U/207-UR/207-TU/207-UB	[2.14] 54,4	[1.30] 33
	207-UL/207-ULB/207-TUL	[3.84] 97,6	[2.94] 74,6
	207-S/207-SB	[2.21] 56,2	---
	207-L/207-LR/207-LB/207-LBR ⓘ	[3.48] 88,4	---

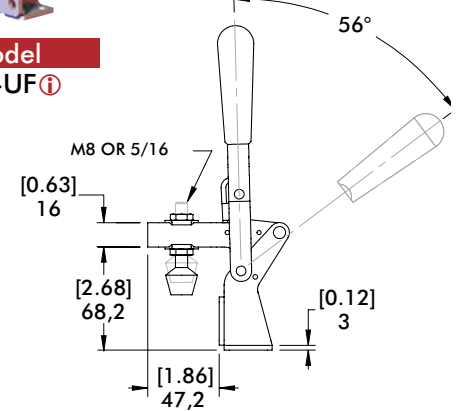
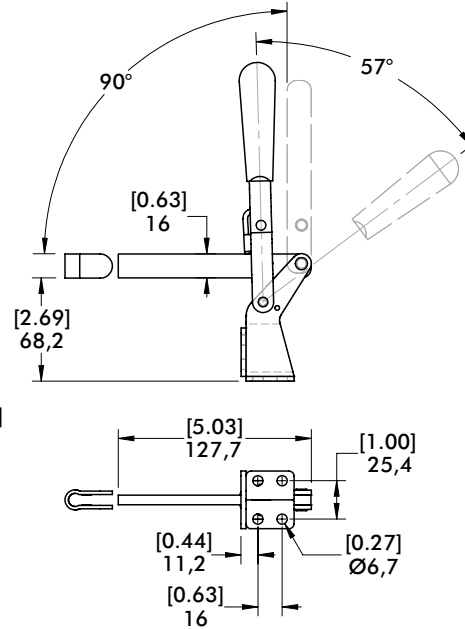
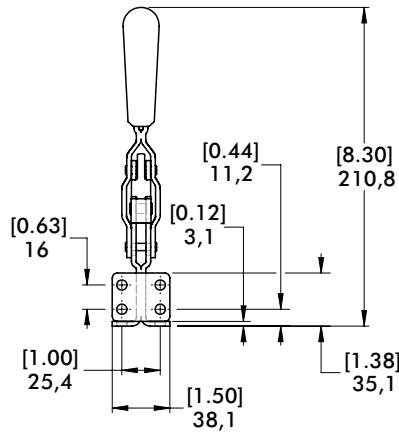
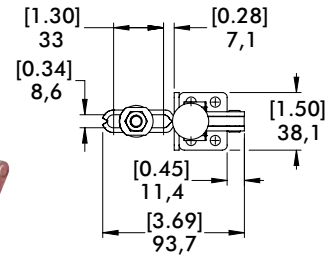
ⓘ This item is available upon request

Vertical Hold Down Clamps | Dimensions | Dual Mount

Model
207-SF ⓘ



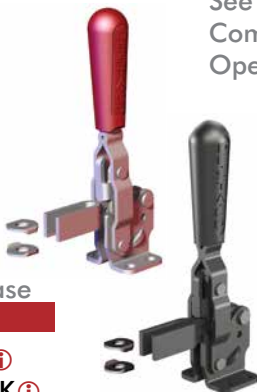
Model
207-UF ⓘ



ⓘ This item is available upon request

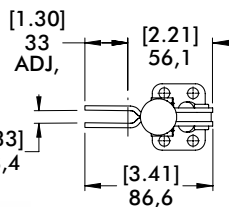
Open Bar Option

See page MC-ACC-7 for Complete offering of Open bar accessories

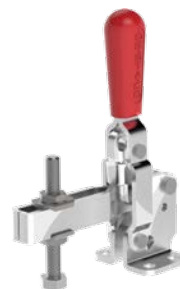


Flanged Base
Model

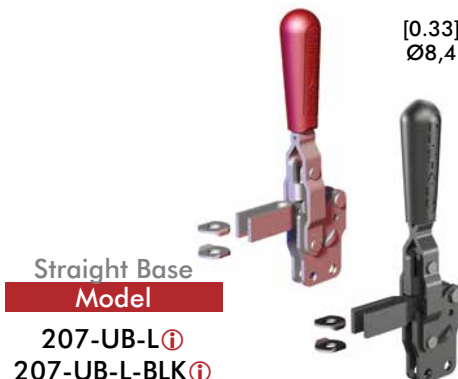
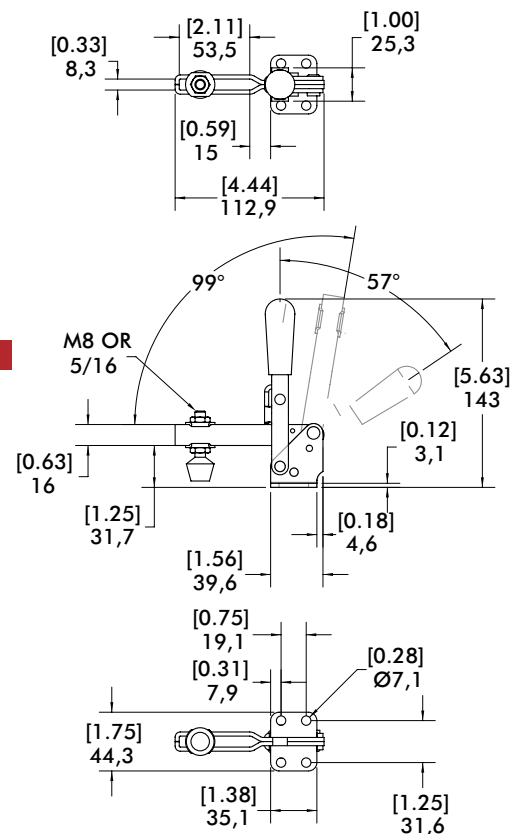
207-U-L ⓘ
207-U-L-BLK ⓘ



Stainless Steel

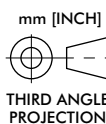


Model
207-USS



Straight Base
Model

207-UB-L ⓘ
207-UB-L-BLK ⓘ



210 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- DESTACO® Toggle Lock Plus versions available
- Available in stainless steel
- Accommodates M10 or 3/8 spindle accessories

Applications:

- Assembly & test
- Light machining
- Light welding

Also Available:

See page MC-ACC-1 for accessories
 810-U Pneumatic Toggle Clamp
 (See page MC-PTC-9)
 810-S Pneumatic Toggle Clamp
 (See page MC-PTC-9)

210-U
Flanged Base
U-Bar



210-USS
Flanged Base
U-bar, Stainless
Steel



210-S
Flanged Base
Solid Bar



210-UB
Straight Base
U-bar



210-SB
Straight Base,
Solid Bar



210-UR
Flanged Base
U Bar
with
DESTACO®
Toggle Lock
Plus



210-SR
Flanged Base
Solid Bar
with
DESTACO®
Toggle Lock
Plus



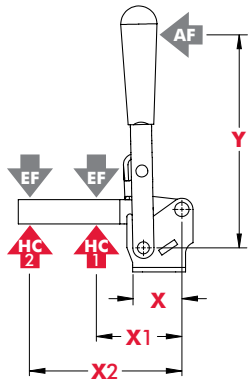
210-TU
Flanged Base
U Bar,
T-Handle



Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)		
					Bolt Retainer	Spindle Assembly	Flanged Washers
210-U	2670 N [600 lbf]	103°	58°	0,59kg [1.29lbs]	---	240208-M	235106
210-USS	3340 N [750 lbf]				---	237943-M	235906
210-S	3340 N [750 lbf]				210114	237943-M	---
210-UB	2670 N [600 lbf]				---	240208-M	235106
210-SB	3340 N [750 lbf]			210114	---	---	
210-UR	2670 N [600 lbf]			---	240208-M	235106	
210-SR	3340 N [750 lbf]			210114	---	---	
210-TU	2670 N [600 lbf]			---	---	235106	

Vertical Hold Down Clamps | Holding Capacities

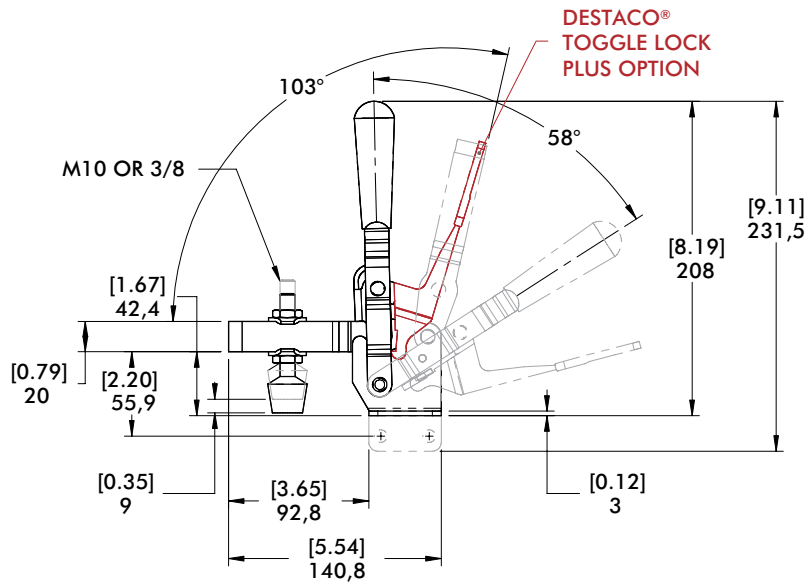
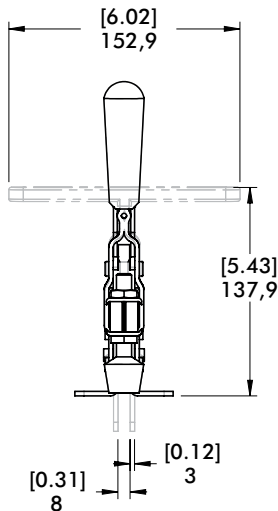
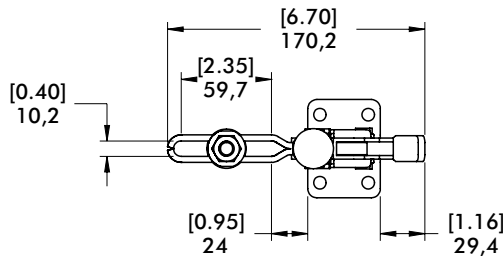


Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	EF(X2):AF
U/UB/UR	[1.54] 39	[2.38] 60,5	[4.88] 124	[6.75] 171,5	[600lbf.] 2670N	[290lbf.] 1290N	14:1	7:1
USS					[750lbf.] 3340N	[360lbf.] 1600N		
S/SR/SB		[3.62] 92,0	[5.25] 133	[4.50] 114,5	[750lbf.] 3340N	[500lbf.] 2220N	11:1	9:1
TU		[2.38] 60,5	[4.88] 124		[600lbf.] 2670N	[290lbf.] 1290N		5:1

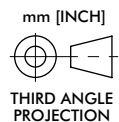
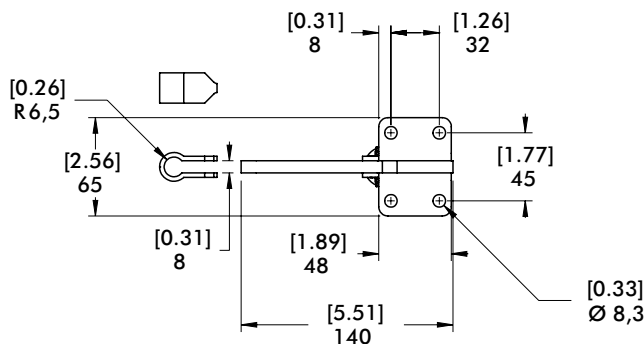
Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

Dimensions | -U/-USS/-S/-UB/-SB/-UR/-SR/-TU

210-U
Flanged Base
U-Bar



210-SR
Flanged Base
Solid Bar
with
DESTACO®
Toggle Lock
Plus



247, 267 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- Hardened steel bushings
- Large bar guides for greater lateral stability on Model 247
- Series 247 accommodates M12 or 1/2 spindle accessory
- Series 267 accommodates M16 or 5/8 spindle accessory

Applications:

- Assembly & test
- Light machining
- Welding

Also Available:

See page MC-ACC-1 for accessories
 847-U Pneumatic Toggle Clamp
 (See page MC-PTC-15)
 847-S Pneumatic Toggle Clamp
 (See page MC-PTC-15)

247-U
Flanged Base
U-Bar



247-S
Flanged Base
Solid Bar



247-UB ⓘ
Straight Base
U-Bar



267-U
Flanged Base
U-Bar



267-S ⓘ
Flanged Base
Solid Bar



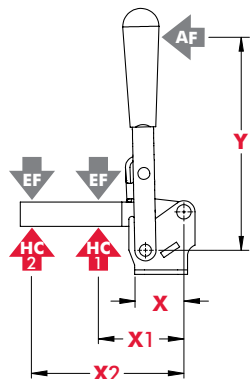
Note:
Clamps shown with included accessories.

Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)		
					Bolt Retainer	Spindle Assembly	Flanged Washers
247-U	4400 N [1000 lbf]	120°	67°	1,07kg [2.36lbs]	---	247208-M	247109
247-S				247110	---	---	
247-UB ⓘ				---	247208-M	247109	
267-U	5340 N [1200 lbf]	140°	72°	2,18kg [4.80lbs]	---	267203-M	267102
267-S ⓘ				110122	---	---	

ⓘ This item is available upon request

Holding Capacities



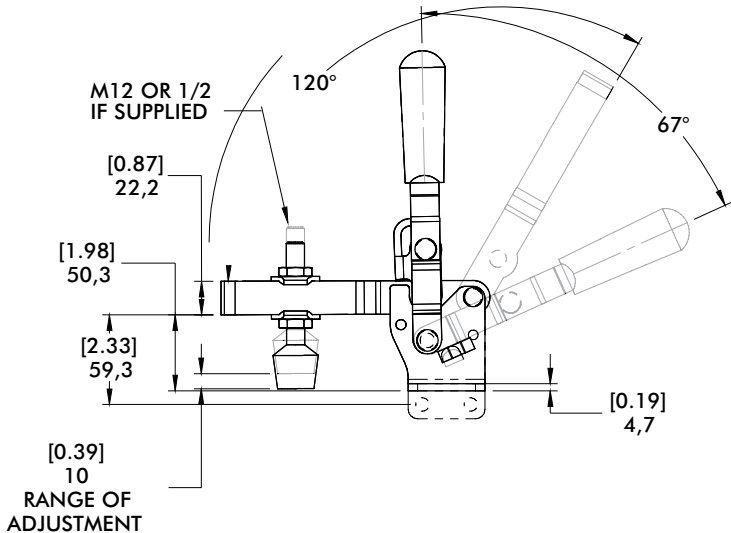
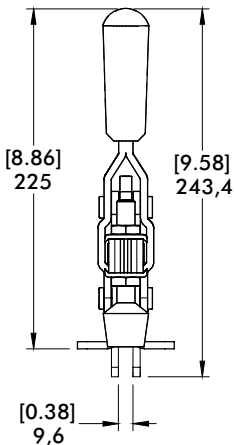
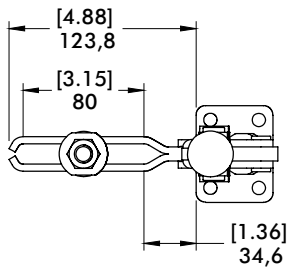
Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
247-U/ 247-UB ⓘ	[1.69]	[3.00] 76,2	[6.13] 155,7	[6.71] 170,5	[1000lbf.] 4450N	[480lbf.] 2140N	12:1	6:1
247-S	43	[4.56] 115,8	[7.00] 177,8			[650lbf.] 2900N	10:1	5:1
267-U	[2.50]	[4.00] 101,6	[8.00] 203,2	[9.25]	[1200lbf.] 5340N	[600lbf.] 2670N	18:1	8:1
267-S ⓘ	63,5	[6.00] 152,4	[8.75] 222,3	235		[820lbf.] 3650N	12:1	

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
 See page MC-TEC-4 for additional information. ⓘ This item is available upon request

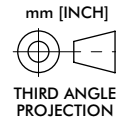
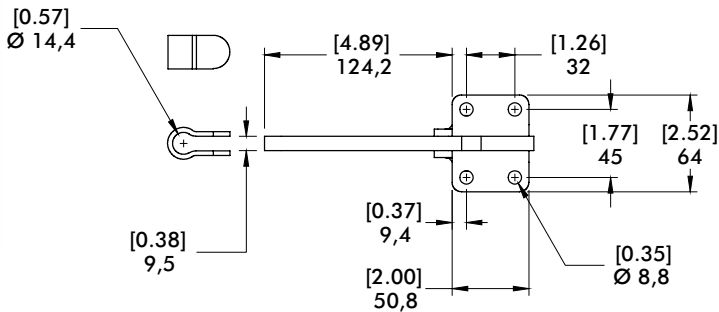
247, 267 SERIES

Vertical Hold Down Clamps | Dimensions | -U/-S/-UB

247-U
Flanged Base
U-Bar



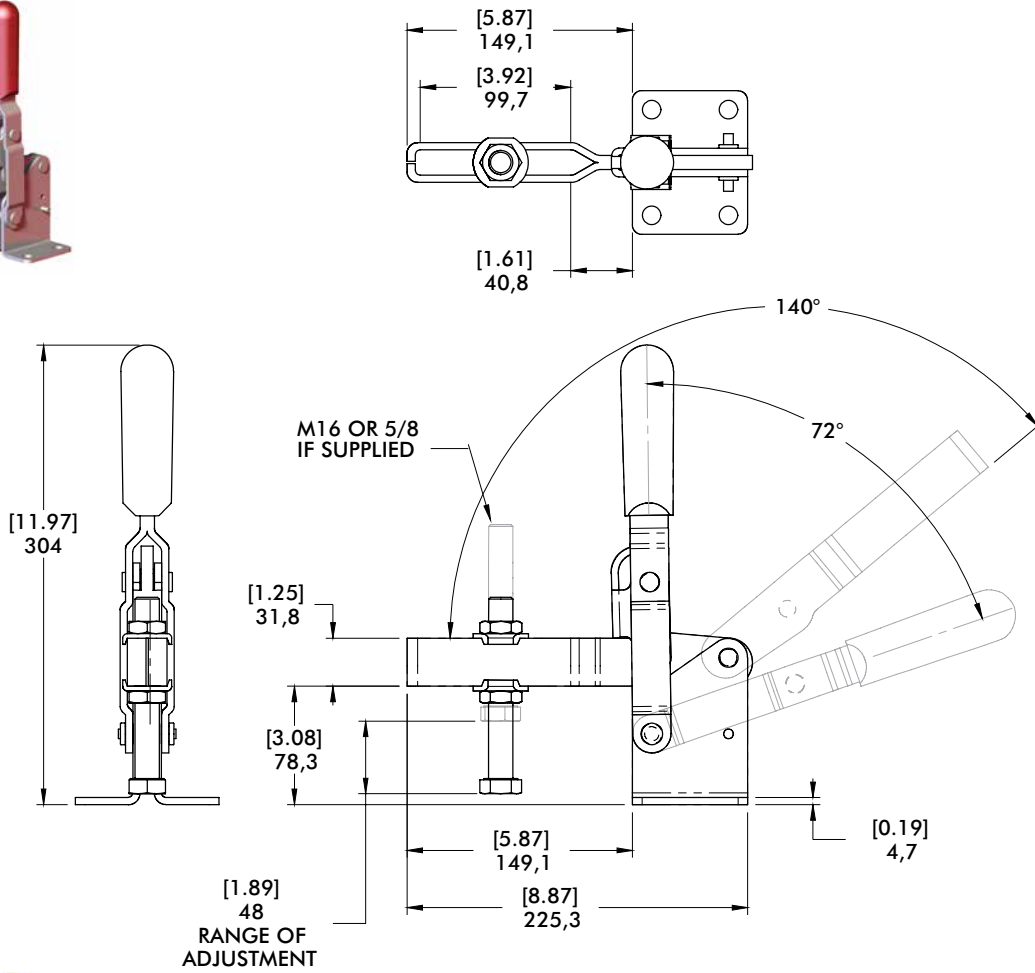
247-S
Flanged Base
Solid Bar



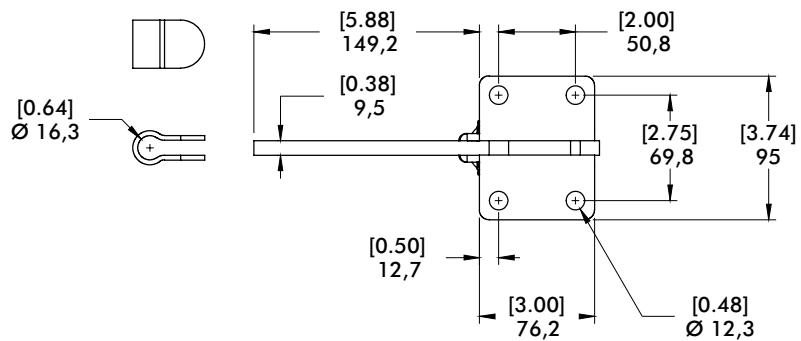
267 SERIES

Vertical Hold Down Clamps | Dimensions

267-U
Flanged Base
U-Bar



267-S
Flanged Base
Solid Bar



mm [INCH]
THIRD ANGLE PROJECTION

VERTICAL HOLD DOWN CLAMPS

Application Examples



Model 210-U
used in an airframe
assembly fixture

Model 210-U
shown being used
in a checking fixture
application.



Model 533-LB
and **227-UB** shown
with black finish in
a fixture for used for
optical inspection.

5905, 5910, 5915 SERIES

Heavy-Duty Vertical Hold Down Clamps | Product Overview

Features:

- High strength forged clamping arm for heavy-duty service
- Hardened steel pivot pins and bushings provide long life
- Black oxide finish

Applications:

- Welding fixtures
- Assembly fixtures



5905/5910/5915
Flanged Base



5905-B/5910-B/5915-B
Solid Base



Technical Information

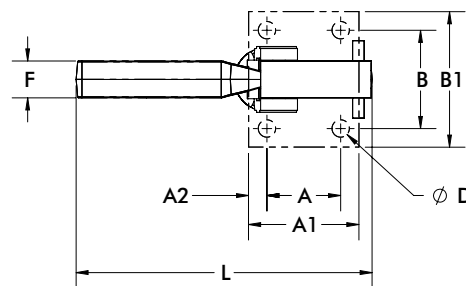
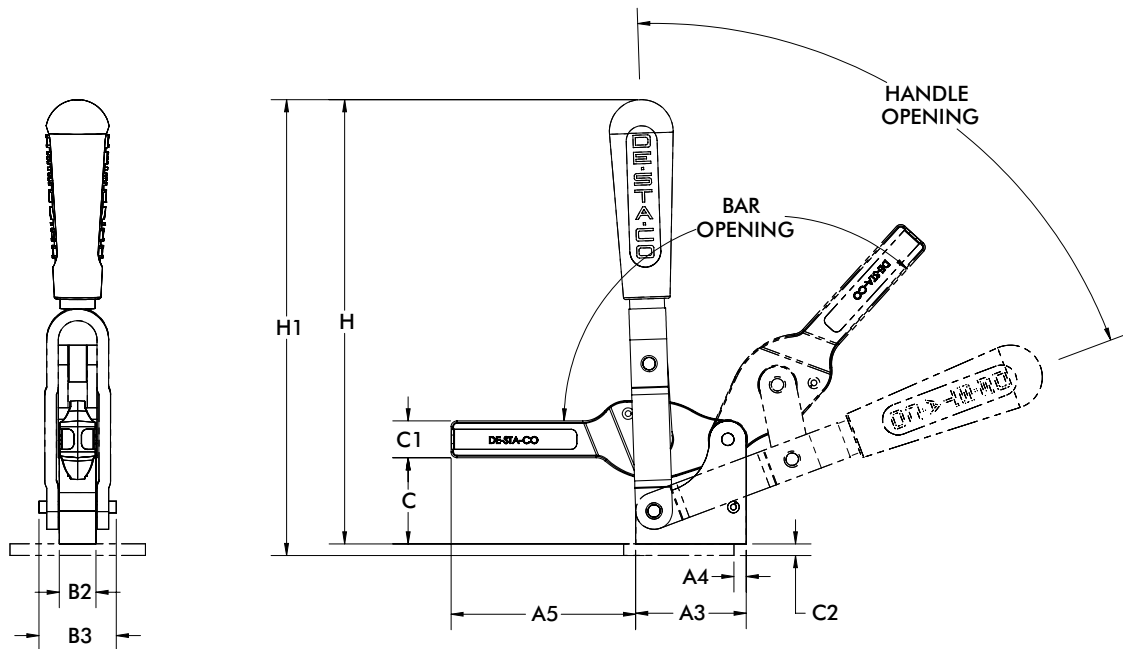
Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight
5905	[750lbf.] 3340N	135°	70°	[1.08lbs] 0,49kg
5905-B				[0.82lbs] 0,37kg
5910	[1600lbf.] 7120N	132°	71°	[2.84lbs] 1,29kg
5910-B				[2.24lbs] 1,02kg
5915	[2750lbf.] 12230N	147°	74°	[6.16lbs] 2,79kg
5915-B				[5.11lbs] 2,32kg



Removable handle stop can be repositioned to limit opening angle to 90°

5905, 5910, 5915 SERIES

Heavy-Duty Vertical Hold Down Clamps | Dimensions



mm [INCH]
THIRD ANGLE PROJECTION

Model	A	A1	A2	A3	A4	A5	B	B1	B2	B3	C	C1	C2	D	F	H	H1	L
5905	[1.00] 25,4	[1.50] 38,1	[0.25] 6,4	[1.51] 38,4	[0.25] 6,4	[2.49] 63,2	[1.50] 38,1	[2.13] 54,1	[0.59] 15,0	[1.02] 25,9	[1.27] 32,3	[0.51] 12,9	[0.24] 6,1	[0.29] 7,3	[0.56] 14,2	[6.51] 165,4	[6.75] 171,4	[4.02] 102,10
5910	[1.50] 38,1	[2.24] 56,9	[0.37] 9,4	[2.25] 57,2	[0.25] 6,4	[3.76] 95,5	[2.00] 50,8	[2.76] 70,1	[0.75] 19,1	[1.57] 39,9	[1.75] 44,5	[0.75] 19,1	[0.24] 6,1	[0.41] 10,5	[0.75] 19,1	[9.04] 229,5	[9.27] 235,5	[6.02] 152,88
5915	[2.00] 50,8	[2.95] 74,9	[0.48] 12,2	[2.99] 75,9	[0.38] 9,7	[5.00] 127,0	[2.75] 69,9	[3.88] 98,6	[0.98] 24,9	[1.97] 50,0	[2.37] 60,2	[1.00] 25,4	[0.35] 8,9	[0.55] 14,0	[1.00] 25,4	[10.89] 276,7	[11.25] 285,7	[7.50] 190,50

Model	A3	A5	B2	B3
5905-B	[1.51] 38,4	[2.49] 63,2	[0.59] 15,0	[1.02] 25,9
5910-B	[2.25] 57,2	[3.76] 95,5	[0.75] 19,1	[1.57] 39,9
5915-B	[2.99] 76	[4.92] 125	[0.98] 25	[1.97] 50

5105, 5110 SERIES

Heavy-Duty Vertical Hold Down Clamps | Product Overview

Features:

- High strength forged clamping arm for heavy-duty service
- Hardened steel pivot pins and bushings provide long life
- Black oxide finish
- Large clearance under the clamping bar
- DESTACO® Toggle Lock Plus versions available†

Applications:

- Welding fixtures
- Assembly fixtures



Covered under one or more U.S./International Patents

5105/5110
Flanged Base



5105-B/5110-B
Solid Base



5105-R/5110-R
Flanged Base
with
DESTACO®
Toggle Lock
Plus



5105-BR①/5110-BR①
Solid Base
with
DESTACO®
Toggle Lock
Plus



Technical Information

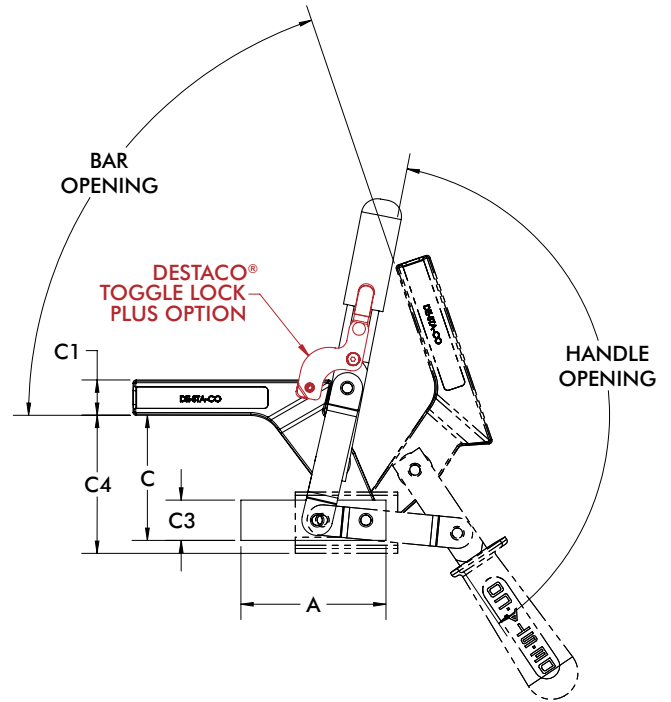
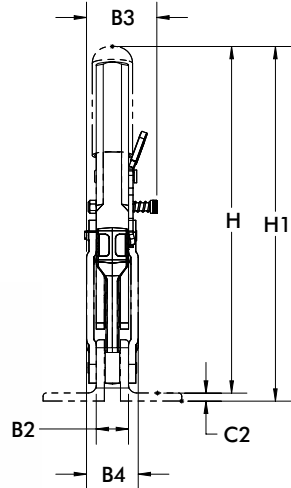
Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight
5105	[700lbf.] 3100N	89°	159°	[1.12lbs] 0,51kg
5105-B				[1.06lbs] 0,48kg
5105-R				[1.10lbs] 0,50kg
5105-BR①				[1.17lbs] 0,53kg
5110	[1150lbf.] 5100N	74°	138°	[2.98lbs] 1,35kg
5110-B				[2.95lbs] 1,34kg
5110-R				[3.00lbs] 1,36kg
5110-BR①				[3.02lbs] 1,37kg

① This item is available upon request.

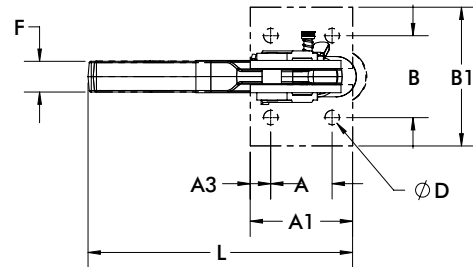
† Toggle Lock Plus locks the handle in the closed position only.

5105, 5110 SERIES

Heavy-Duty Vertical Hold Down Clamps | Dimensions



mm [INCH]
THIRD ANGLE PROJECTION



Model	A	A1	A2	B	B1	B2	B3	B4	C1	C2	C4	D	F	H1	L
5105	[1.00]	[1.62]	[0.31]	[1.46]	[2.24]	[0.59]	--	[0.98]	[0.51]	[0.16]	[2.54]	[0.26]	[0.56]	[6.54]	[4.13]
5105-R	25,4	41,2	7,9	37	57	15	[1.48] 37,5	25	13,0	4,0	64,6	6,6	14,3	166,1	104,9
5110	[1.50]	[2.50]	[0.50]	[2.00]	[2.76]	[0.79]	--	[1.26]	[0.87]	[0.20]	[3.37]	[0.35]	[0.75]	[8.70]	[6.33]
5110-R	38,1	63,5	12,7	50,8	70	20	[1.67] 42,5	32	22,0	5,0	85,6	9,0	19,1	221,1	160,9

Model	A3	B2	B3	B4	C	C1	C3	F	H
5105-B	[2.50]	[0.59]	--	[0.98]	[2.14]	[0.51]	[0.59]	[0.56]	[6.14]
5105-BR ⓘ	63,5	15	[1.48] 37,5	25	54,3	13,0	15,0	14,3	156,0
5110-B	[3.54]	[0.79]	--	[1.26]	[3.05]	[0.87]	[0.98]	[0.75]	[8.39]
5110-BR ⓘ	90	20	[1.67] 42,5	32	77,5	22,0	25,0	19,1	213,0

ⓘ This item is available upon request

528 SERIES

Heavy-Duty Vertical Hold Down Clamps | Product Overview

Features:

- Hardened steel bushings at pivot points for long life
- Solid bar may be modified to suit application requirements

Applications:

- Assembly & test
- Light machining
- Welding
- Medium to heavy duty clamping requirements

528
Flanged Base
Solid Bar



528-F ⓘ
Front Mount
Base Solid Bar

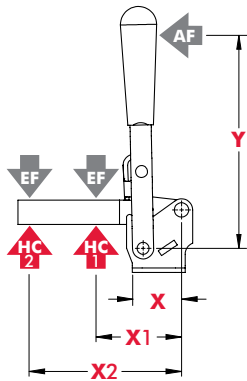


Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight
528	4450 N [1000 lbf]	180°	177°	[2.50lbs] 1,13kg
528-F ⓘ				

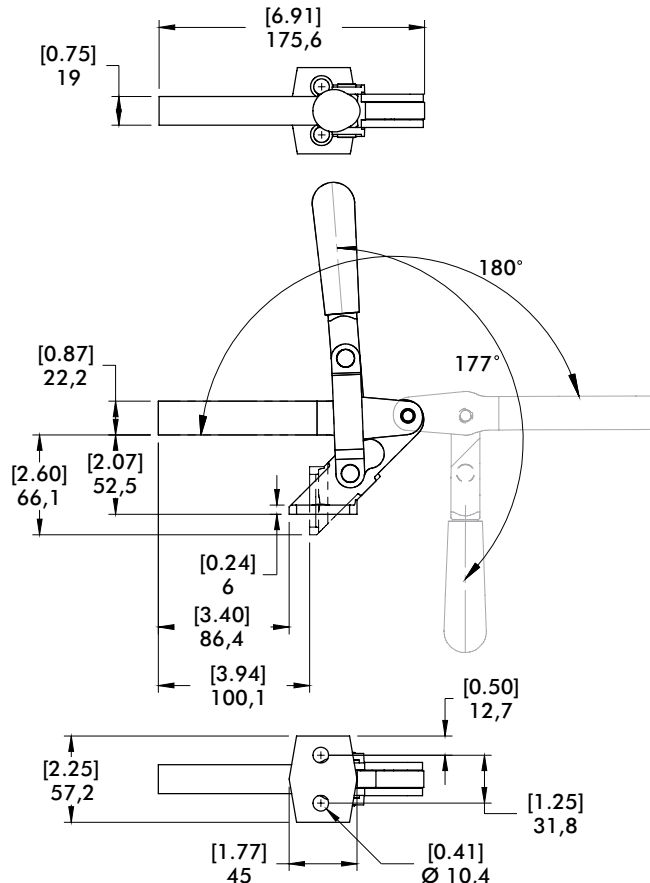
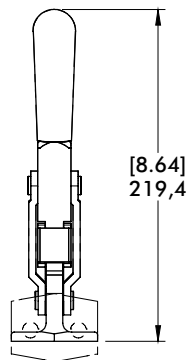
ⓘ This item is available upon request

Holding Capacities | Dimensions



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
528	[1.38]	[3.50]	[6.00]	[5.50]	[1000lbf.]	[580lbf.]	23:1	12:1
528-F	35	89	152	140	4450N	2580N		

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.



mm [INCH]
THIRD ANGLE PROJECTION

548, 578 SERIES

Heavy-Duty Vertical Hold Down Clamps | Product Overview

Features:

- Large bar guides for lateral stability
- Hardened steel pins and bushings for long life
- Replaceable pins

Applications:

- Assembly & test
- Light machining
- Welding
- Heavy duty clamping requirements

548
Straight Base
Solid Bar



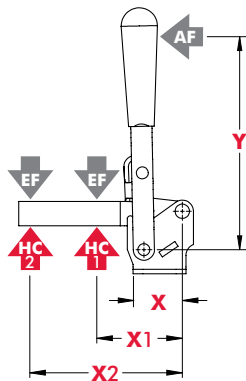
578
Straight Base
Solid Bar



Technical Information

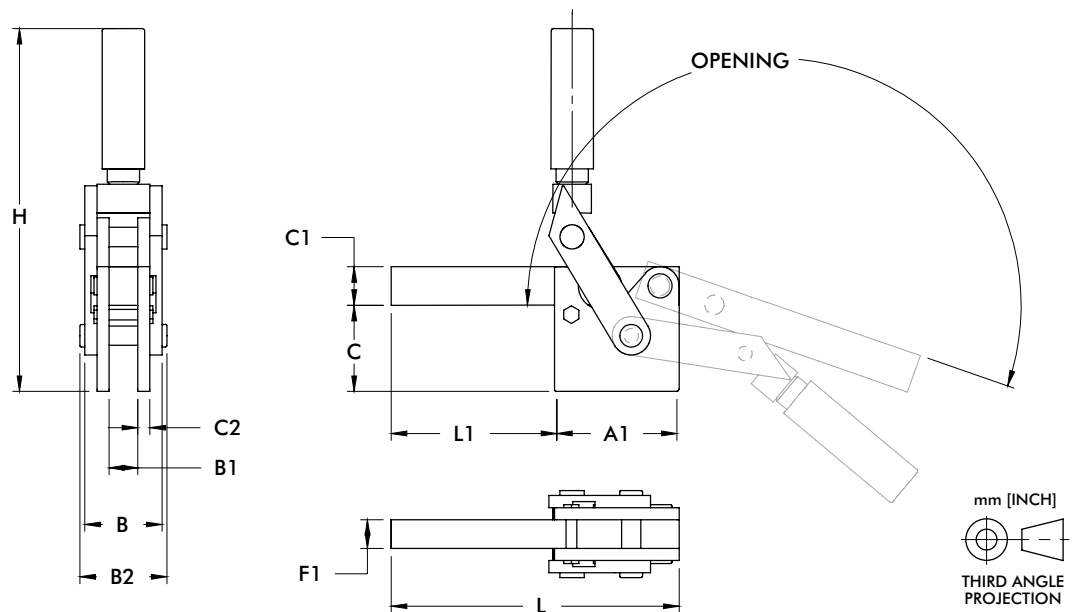
Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight
548	11100N [2500lbf]	199°	129°	2,40kg [5.30lbs]
578	17800N [4000lbf]			4,14kg [9.12lbs]

Holding Capacities | Dimensions



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
548	[2.75] 70	[3.50] 89	[6.00] 152	[7.50] 190	[2500lbf] 11100N	[1500lbf.] 6680N	4.5:1	3.4:1
578	[4.25] 108	[4.50] 114	[7.00] 178	[10.31] 262	[4000lbf] 17800N	[2500lbf.] 11100N	7.6:1	4.2:1

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.



Model	A1	B	B1	B2	C	C1	C2	F1	H	L	L1
548	[3.25] 82,6	[2.01] 51	[0.75] 19,1	[2.26] 57,5	[2.24] 56,9	[1.00] 25,4	[0.31] 7,9	[0.75] 19,1	[9.45] 240	[7.50] 190,5	[4.25] 107,9
578	[4.02] 102,1	[2.38] 60,5	[0.87] 22,1	[2.70] 68,6	[2.79] 70,9	[1.26] 32	[0.37] 9,5	[0.87] 22,1	[11.04] 280,3	[8.62] 219	[4.61] 117,1

533, 535 SERIES

Heavy-Duty Vertical Hold Down Clamps | Product Overview

Features:

- Hardened steel bushings and pivot pins
- Large bar guides for greater lateral support
- Solid clamping bar may be modified to suit application requirements

Applications:

- Welding
- Heavy duty clamping applications

Also Available:

See page MC-ACC-1 for accessories

533-L
Flanged Base
Solid Bar



533-LB
Straight Base
Solid Bar



535-L
Flanged Base
Solid Bar



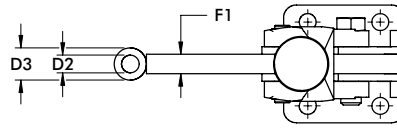
535-LB
Straight Base
Solid Bar



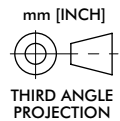
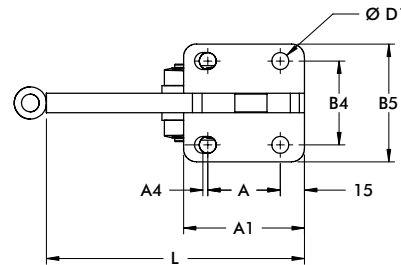
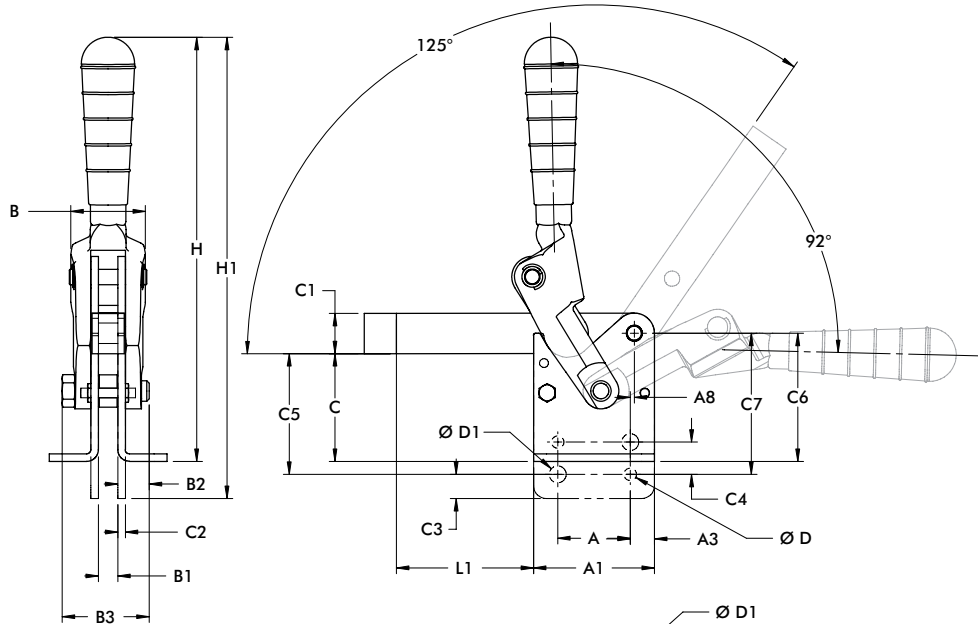
Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)
					Bolt Retainer
533-L	7000 N [1575 lbf]	120°	90°	1,00kg [2.20lbs]	533108-M
533-LB					
535-L	10000 N [2250 lbf]			1,85kg [4.087lbs]	535108-M
535-LB					

533-L
Flanged Base
Solid Bar



535-L
Flanged Base
Solid Bar



Model	A	A1	A3	A4	A8	B	B1	B2	B3	B4	B5	C	C1	C2
533-L	[1.18]	[2.36]		[0.08] 2	[0.20]	[1.52]	[0.39]	[0.69]	[1.75]	[1.77]	[2.44]	[1.86]	[0.79]	
533-LB	30	59,9			5.1	38,6	9,9	15,5	44,5	--	--	--	20,1	
535-L	[1.77]	[2.95]	[0.59] 15	--	[0.18]	[1.89]	[0.47]	[0.89]	[2.13]	[2.05]	[2.87]	[2.63]	[0.98]	[0.19] 4,8
535-LB	45	74,9			4,6	48	11,9	22,6	54,1	--	--	--	24,9	

Model	C3	C4	C5	C6	C7	D	D1	D2	D3	F1	H	H1	L	L1
533-L	--	--	--	[2.24] 56,9	--	--	[0.33] 8,4	[0.35] 8,9	[0.59] 15	[0.39] 9,9	[8.6] 218,4	--	[4.92] 125	[2.56] 65
533-LB	[0.39] 9,9	[0.59] 15	[1.86] 55,1	--	[2.56] 65	[0.22] 5.6						[9.31] 236,5		
535-L	--	--	--	[3.13] 79,5	--	--	[0.41] 10,4	[0.43] 10,9	[0.79] 20,1	[0.47] 11,9	[10.35] 262,9	--	[6.30] 160	[3.35] 85,1
535-LB	[0.59] 15	[0.79] 20,1	[2.95] 74,9	--	[3.44] 87,4	[0.30] 7,6						[11.26] 286		

558 SERIES

Heavy-Duty Vertical Hold Down Clamps | Product Overview

Features:

- Forged alloy steel handle and links for rugged service
- Hardened steel pins and bushings
- Hold down bar can be machined to suit application requirements

Applications:

- Welding
- Heavy duty clamping requirements

Also Available:

Model 858 Pneumatic Toggle clamp
See page MC-PTC-17

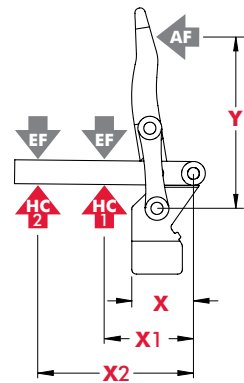
558



Technical Information

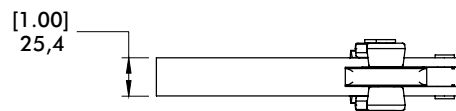
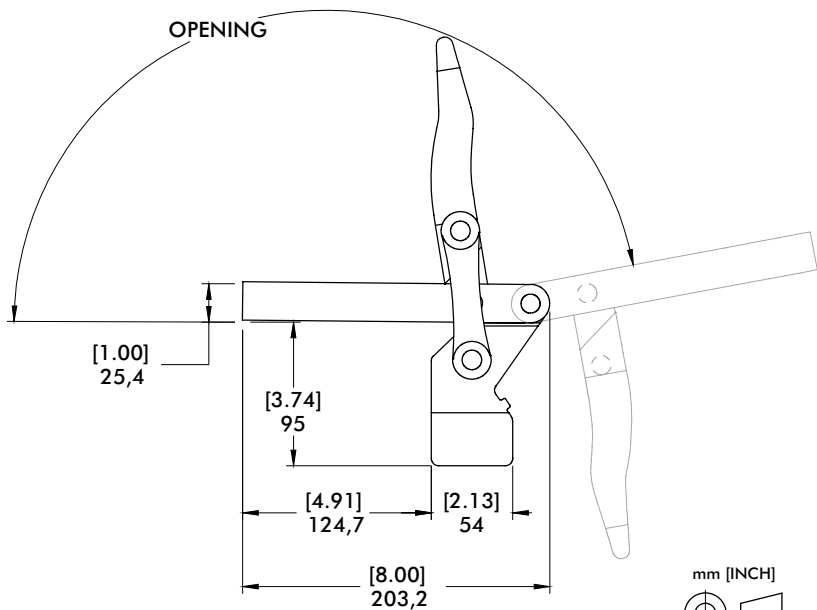
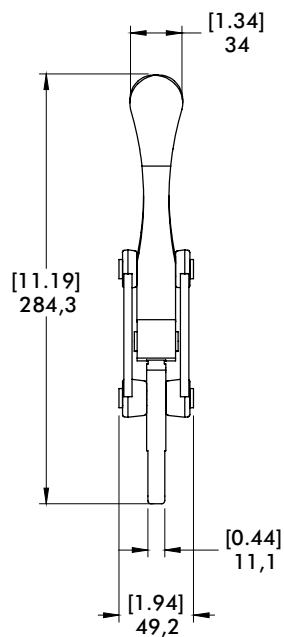
Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight
558	11100 N [2500 lbf]	192°	64°	2,27kg [5.0lbs]

Holding Capacities | Dimensions



Model	X	X1	±HC1	±HC2
558	65,8 [2.59]	76,2 [3.00]	[2500 lbf] 11100 N	[1500 lbf] 6680 N

Dimensions shown "mm [inch]", ± HC = Holding Capacity



mm [INCH]
THIRD ANGLE PROJECTION

Features:

- Front flange mount
- Accepts M8 or 5/16" spindle accessory (not supplied)

Applications:

- Assembly & test
- Checking fixtures
- Light machining
- Woodworking

Also Available:

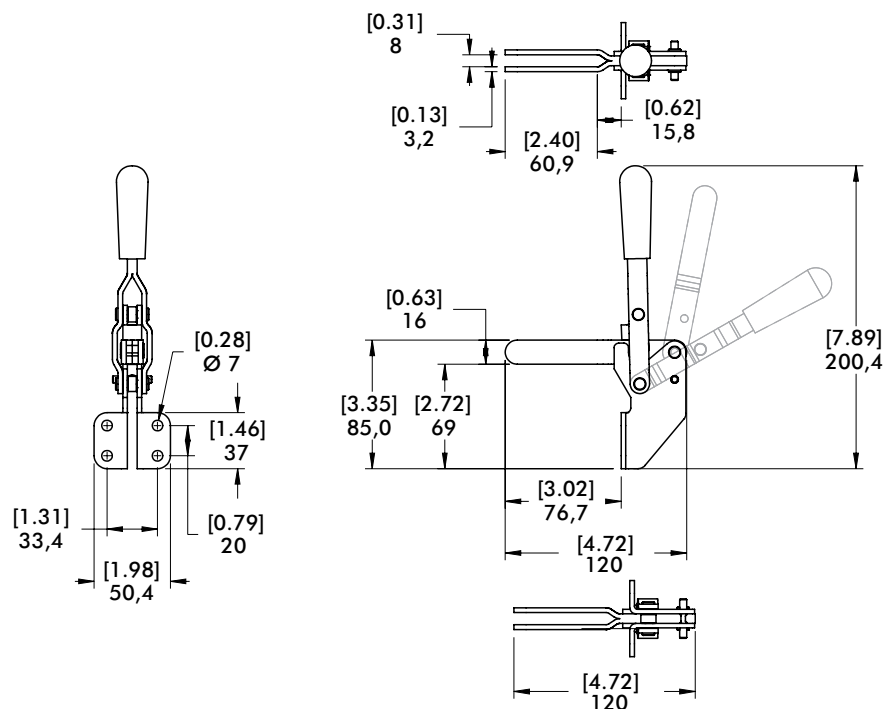
See page MC-ACC-1 for accessories

91090
Front Flanged Base
Open Bar



Technical Information | Dimensions

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Recommended Accessories		
					Bolt Retainer	Spindle Assembly	Flanged Washers
91090	1710 N [385 lbf]	100°	60°	0,37kg [0.81lbs]	---	507208-M	507107



317 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- Dual mounting surfaces
- Large bar opening angle
- Accommodates M8 or 5/16" spindle accessories

Applications:

- Assembly & test
- Checking fixtures
- Light machining
- Woodworking

Also Available:

See page MC-ACC-1 for accessories
 817-U Pneumatic Toggle Clamp
 (See page MC-PTC-21)
 817-S Pneumatic Toggle Clamp
 (See page MC-PTC-21)

317-U
U-Bar



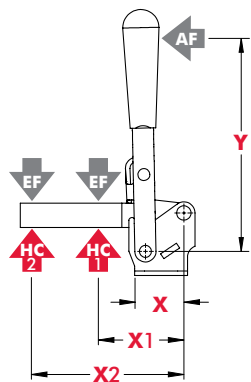
317-S
Solid Bar



Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)		
					Bolt Retainer	Spindle Assembly	Flanged Washers
317-U	1670 N [375 lbf]	185°	60°	0,34kg [0.75lbs]	---	507208-M	507107
317-S	1780 N [400 lbf]	---	---	---	207105	---	---

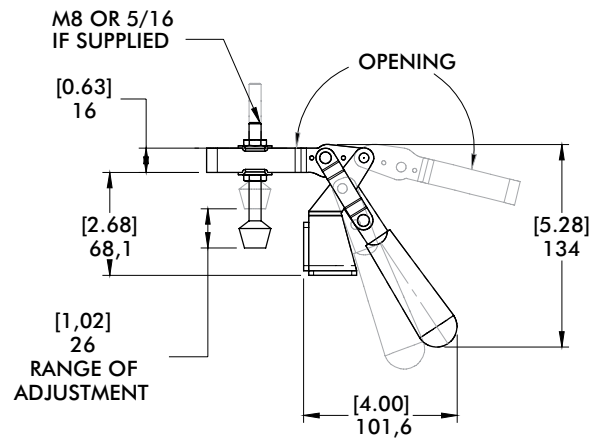
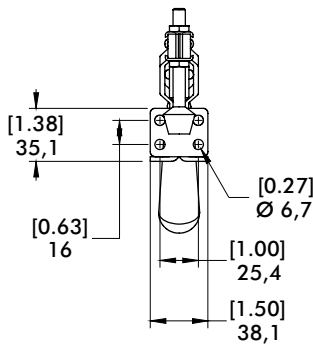
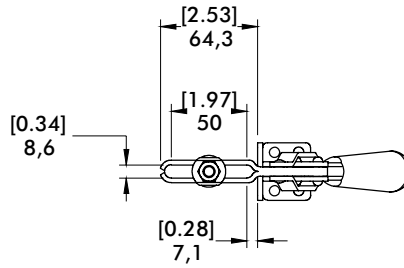
Holding Capacities



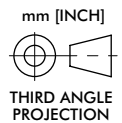
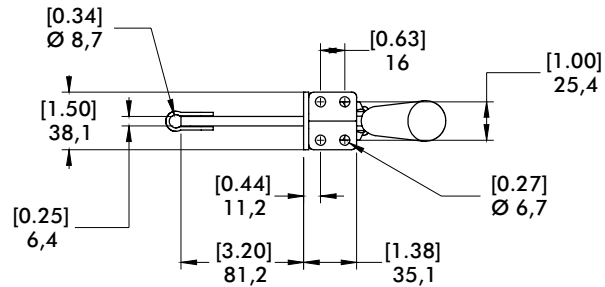
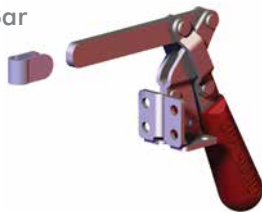
Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
317-U	[1.57]	[2.00] 50,8	[3.75] 95,3	[4.00]	[375 lbf] 1670 N	[200lbf.] 900N	17:1	8:1
317-S	40,0	[2.50] 63,5	[5.00] 127,0	101,6	[400 lbf] 1780 N	[190lbf.] 850N	13:1	5:1

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
 See page MC-TEC-4 for additional information.

317-U
U-Bar



317-S
Solid Bar



527 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- Hardened steel bushings at pivot points
- Solid bar can be modified to suit application requirements
- Thumb lever on link for easy opening

Applications:

- Assembly & test
- Light machining
- Woodworking

527
Flanged Base



527-F ⓘ
Front Mount

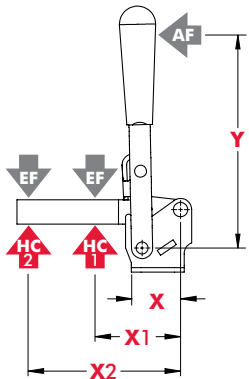


Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight
527	4450 N [1000 lbf]	195°	65°	[2.50lbs] 1,13kg
527-F ⓘ				

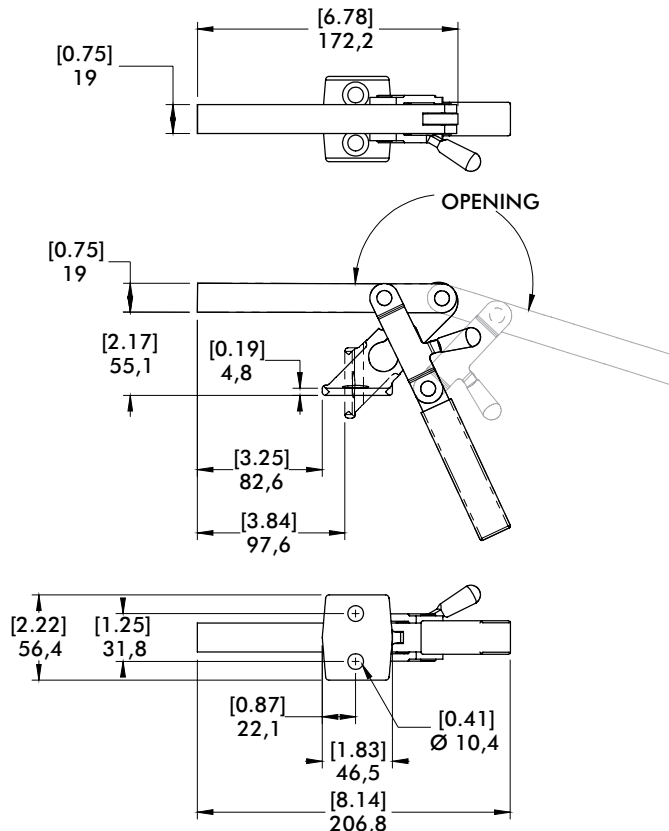
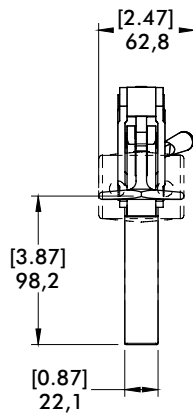
ⓘ This item is available upon request

Holding Capacities | Dimensions



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
527	[3.12] 79,2	[3.50] 89,0	[6.00] 152,4	[4.00] 101,6	[1000lbf.]	[580lbf.]	23:1	12:1
527-F	[2.53] 64,3				4450N	2580N		

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.



mm [INCH]
THIRD ANGLE PROJECTION

7-101, 7-58, 7-59, 7-60 SERIES

Heavy Duty Cam Action Series | Product Overview

Features:

- Cam action accommodates variable workpiece thickness
- Heavy duty construction
- Solid clamp arms may be modified to suit application requirements

Applications:

- Light machining
- Welding
- Assembly

Technical Information

7-101

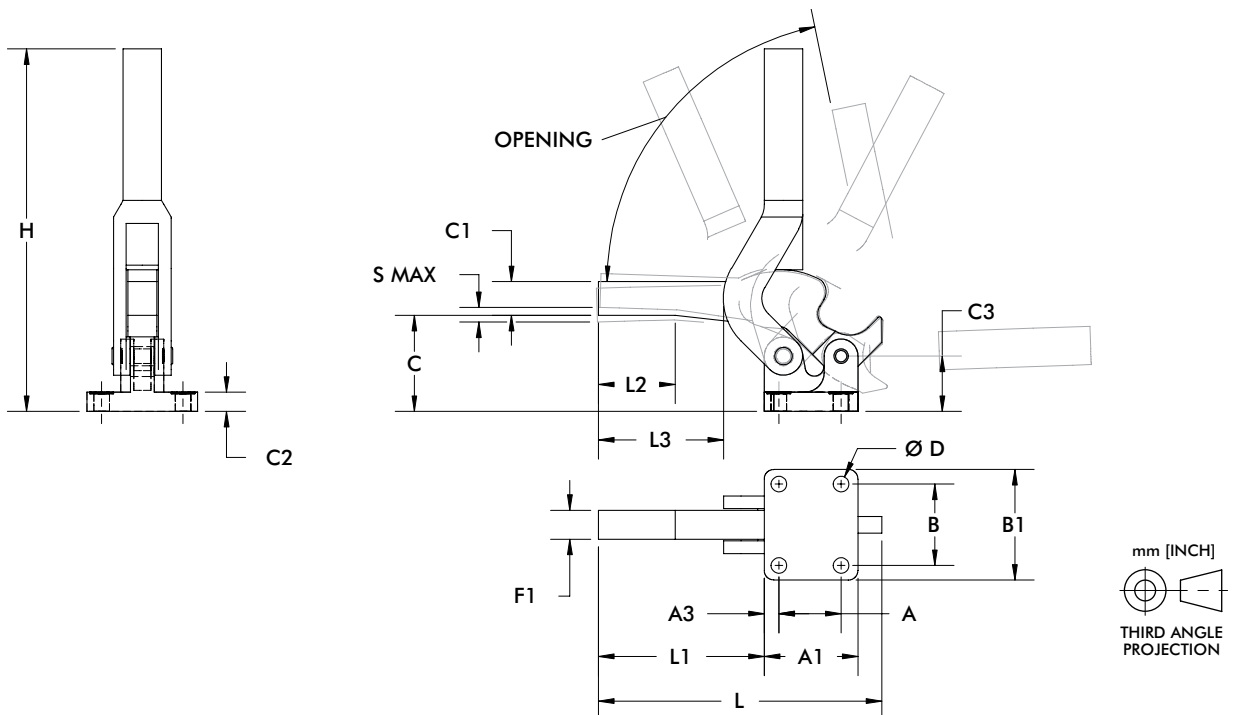


7-58



Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Weight
7-101	2110 N [475 lbf]	80°	0,45kg [1.0lbs]
7-58	2670 N [600 lbf]	95°	0,91kg [2.0lbs]
7-59	4450 N [1000 lbf]	95°	1,36kg [3.0lbs]
7-60	7120 N [1600 lbf]	80°	2,27kg [5.0lbs]

Dimensions



Model	A	A1	A3	B	B1	C	C1	C2	C3	D	F1	H	L	L1	L2	S max.
7-101	[0.75] 19,1	[1.25] 31,8	[0.25] 6,1	[1.25] 31,8	[1.75] 44,5	[1.44] 36,6	[0.50] 12,7	[0.31] 7,9	[1.00] 25,4	[0.22] 5,6	[0.50] 12,7	[5.00] 127	[4.63] 117,6	[3.12] 79,3	-	[0.13] 3,3
7-58	[1.00] 25,4	[1.69] 42,9	[0.34] 8,6	[1.62] 41,2	[2.25] 57,2	[1.87] 47,5	[0.56] 14,2	[0.38] 9,7	[1.12] 28,5	[0.28] 7,1	[0.50] 12,7	[7.00] 177,8	[6.99] 177,6	[2.55] 64,8	-	[0.13] 3,3
7-59	[1.38] 35,1	[2.06] 52,3	[0.39] 9,9	[1.88] 47,8	[2.50] 63,5	[2.19] 55,6	[0.63] 16	[0.44] 11,2	[1.25] 31,8	[0.34] 8,6	[0.63] 16	[8.50] 215,9	[6.00] 152,4	[3.50] 88,9	[1.24] 31,5	[0.19] 4,8
7-60	[1.62] 41,2	[2.44] 62	[0.44] 11,2	[2.12] 53,9	[2.88] 73,2	[2.50] 63,5	[0.88] 22,4	[0.50] 12,7	[1.44] 36,6	[0.41] 10,4	[0.75] 19,1	[9.50] 241,3	[7.40] 188	[4.38] 111,3	[1.97] 50	[0.25] 6,4

229 SERIES

Vertical Hold Down Clamps | Product Overview

Features:

- Cam action clamp holds workpieces of varying height
- Total clamping range of 8mm [.31in.]
- Accommodates M12 or 1/2" accessories

Applications:

- Assembly & test
- Light machining
- Welding

Also Available:

See page MC-ACC-1 for accessories

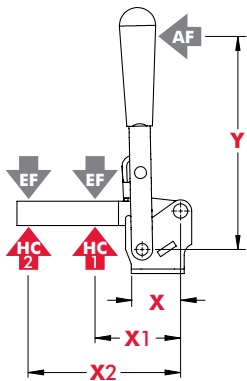
229
Flanged Base
Open Bar



Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
229	4450 N [1000 lbf]	115°	180°	1,17kg [2.59lbs]	229203	247109

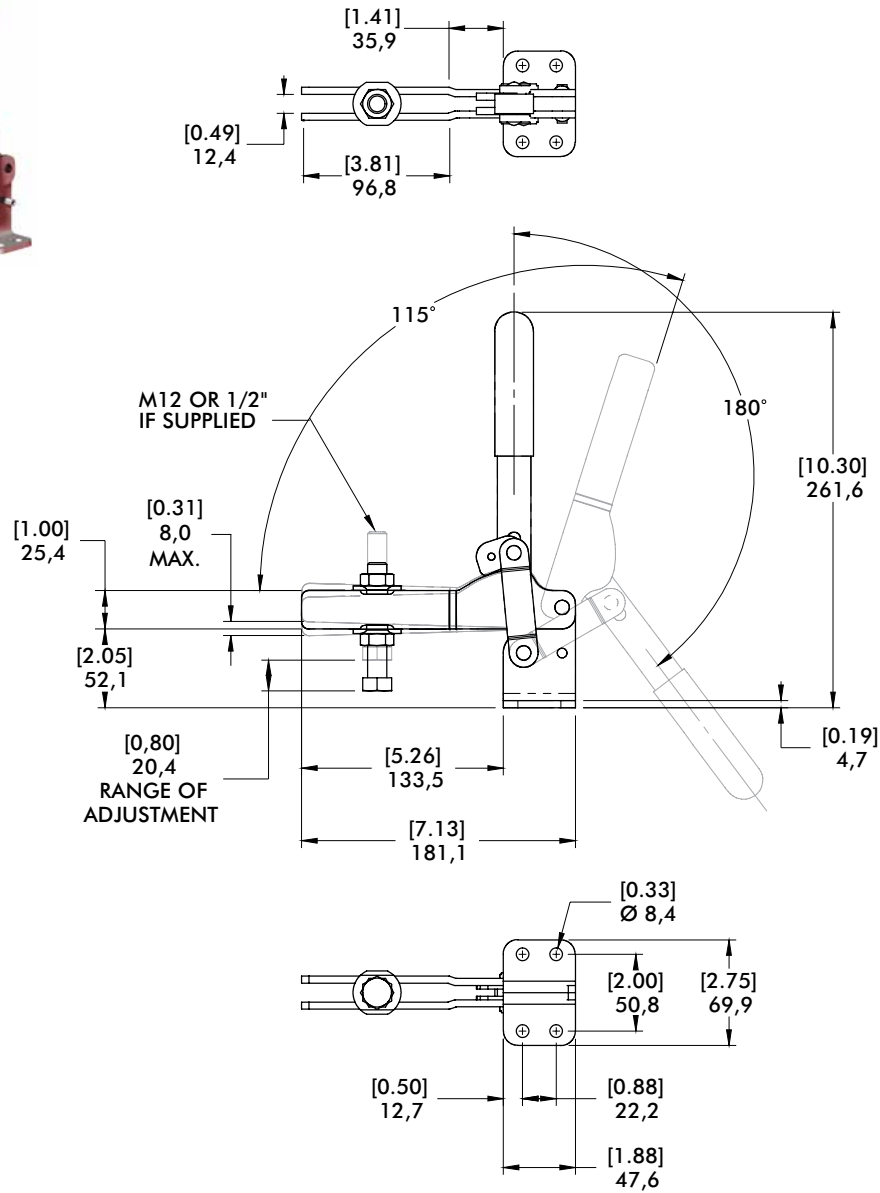
Holding Capacities



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
229	[1.53] 38,9	[3.00] 76,2	[6.12] 155,4	[7.06] 179,3	[1000lbf.] 4450N	[500lbf.] 2230N	7:1	3:1

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

229
Flanged Base
Open Bar



500 SERIES

Weldable Vertical Hold Down Clamps | Product Overview

Features:

- Hardened pivot pins and bushings
- Weldable clamping bar
- LSC version with locking spring clip for securing the handle in the open position
- Modular design allows you to set up the clamp to meet application requirements

Applications:

- Welding
- Assembly
- Heavy duty, production clamping applications

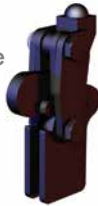
Also Available:

See page MC-VHD-46 for accessories

501-B ⓘ
Swivel Base



501-LB ⓘ
Long Base



503-MB
Swivel Base



503-MLB
Long Base



503-MBLSC ⓘ
Swivel Base
with Locking
Spring Clip



503-MLBLSC ⓘ
Long Base
with Locking
Spring Clip



505-MB
Swivel Base



505-MLB
Long Base



505-MBLSC ⓘ
Swivel Base
with Locking
Spring Clip



505-MLBLSC ⓘ
Long Base
with Locking
Spring Clip



506-MB
Swivel Base



506-MLB ⓘ
Long Base



506-MBLSC ⓘ
Swivel Base
with Locking
Spring Clip

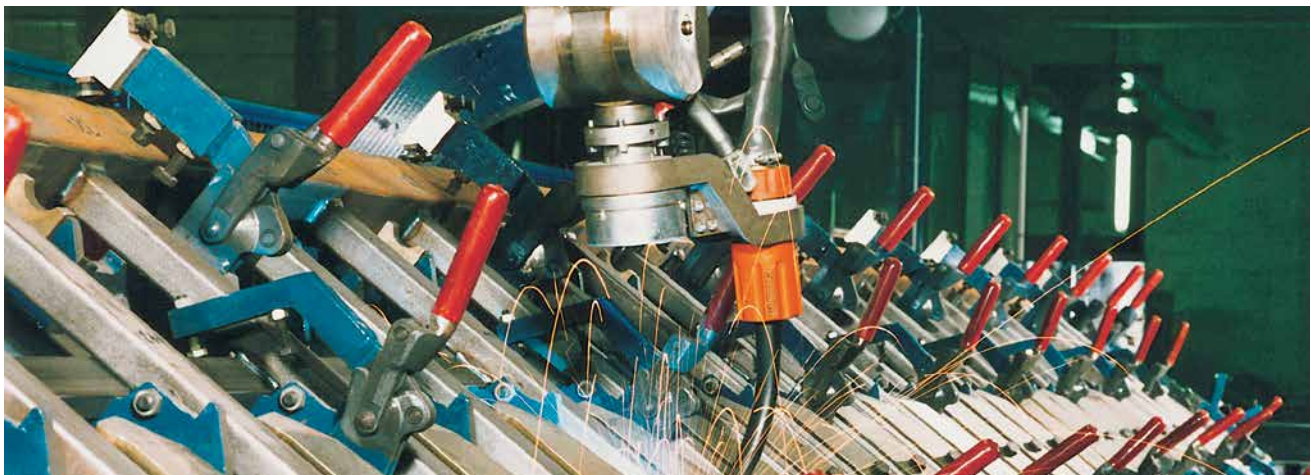


506-MLBLSC ⓘ
Long Base
with Locking
Spring Clip



Model 505-MLB in a robotic welding fixture

ⓘ This item is available upon request



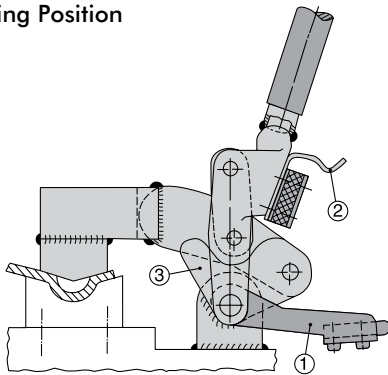
Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Weight	
501-B ⓘ	2000 N [450 lbf]	200°	0,18kg [0.40lbs]	
501-LB ⓘ			0,20kg [0.44lbs]	
503-MB	7000 N [1575 lbf]		0,70kg [1.54lbs]	
503-MLB			0,80kg [1.76lbs]	
503-MBLSC ⓘ				0,90kg [1.98lbs]
503-MLBLSC ⓘ				
505-MB	11000 N [2475 lbf]		1,40kg [3.09lbs]	
505-MLB			1,50kg [3.31lbs]	
505-MBLSC ⓘ				1,60kg [3.53lbs]
505-MLBLSC ⓘ				
506-MB	22500 N [5060 lbf]		2,60kg [5.73lbs]	
506-MLB ⓘ			2,80kg [6.17lbs]	
506-MBLSC ⓘ		3,00kg [6.61lbs]		
506-MLBLSC ⓘ				

Note:

The clamping bars are made from forged alloy steel and must be heated to 200°C(400°F) prior to welding. We recommend welding the handles, clamp arms, and mounting bases when disassembled. Welding of non pre-heated parts may only be done with the addition of welding fillers.

ⓘ This item is available upon request

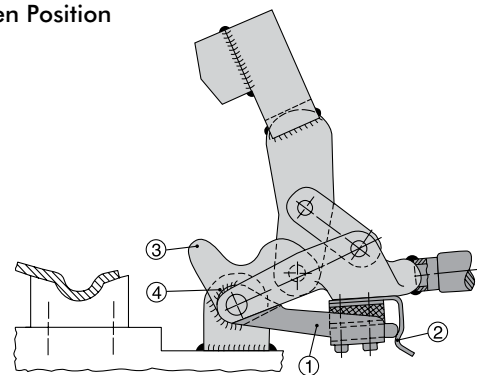
Clamping Position



Patented spring latch hold-open device

1. Mount the clamp and place it in the closed position
2. Position the bracket in the leaf spring

Open Position

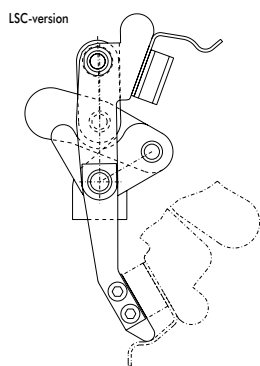
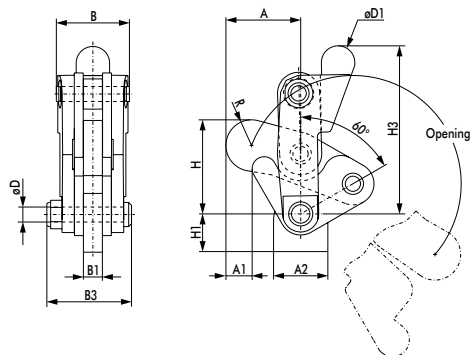


3. Swivel the clamp into the open position
4. In this position, weld the bracket with the bar guide feature at point

500 SERIES

Weldable Vertical Hold Down Clamps | Dimensions | -B/-LB/-MB/-MLB/-MBLSC/-MLBLSL

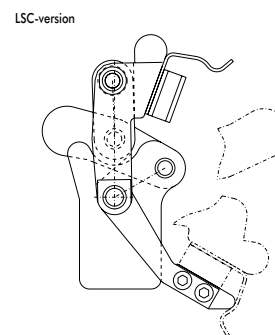
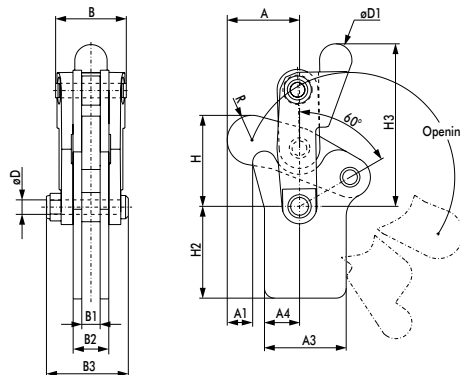
Swivel Base



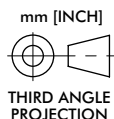
503-MB
Swivel Base



Long Base



503-MLB
Long Base



Swivel Base Dimensions

Model	A	A1	A2	B	B1	B3	ØD	ØD1	H	H1	H3	R
501-B ⓘ	[1.13] 28,6	[0.56] 14,3	[0.75] 19,1	[0.79] 20,0	[0.25] 6,4	[1.09] 27,8	[0.19] 4,8	[0.50] 12,7	[1.12] 28,5	[0.79]	[2.20] 56	[0.37] 9,5
503-MB	[1.54]	[0.50]	[1.12]	[1.52]	[0.39]	[1.82]	[0.31]	[0.69]	[1.96]	20	[3.51]	[0.53]
503-MBLSC ⓘ	39,2	12,8	28,5	38,5	10	46,2	8	17,5	49,8		89,1	13,5
505-MB	[2.22]	[1.02]	[1.38]	[1.89]	[0.48]	[2.31]	[0.37]	[0.87]	[2.79]	[1.10]	[4.33]	[0.72]
505-MBLSC ⓘ	56,5	25,9	35	48	12,3	58,6	9,5	22,2	70,8	28	110,1	18,3
506-MB	[2.82]	[1.27]	[1.97]	[1.91]	[0.63]	[2.72]	[0.47]	[0.94]	[3.45]	[1.29]	[5.30]	[0.84]
506-MBLSC ⓘ	71,7	32,3	50	48,4	16	69	12	24	87,7	32,8	134,6	21,4

Long Base Dimensions

Model	A	A1	A3	A4	B	B1	B2	B3	ØD	ØD1	H	H2	H3	R
501-LB ⓘ	[1.13] 28,6	[0.50]	[1.13] 28,6	[0.56] 14,3	[0.79] 20	[0.25] 6,4	[0.51] 13	[1.09] 27,8	[0.19] 4,8	[0.50] 12,7	[1.12] 28,5	[1.32] 33,5	[2.21] 56,1	[0.37] 9,5
503-MLB	[1.54]	12,8	[1.75]	[0.75]	[1.52]	[0.39]	[0.79]	[1.82]	[0.31]	[0.69]	[1.96]	[1.97]	[3.51]	[0.53]
503-MLBLSL ⓘ	39,2		44,5	19	38,5	10	20	46,2	8	17,5	49,8	50	89,1	13,5
505-MLB	[2.22]	[1.02]	[2.09]	[1.08]	[1.89]	[0.48]	[0.88]	[2.31]	[0.37]	[0.87]	[2.79]	[2.50]	[4.33]	[0.72]
505-MLBLSL ⓘ	56,5	25,9	53	27,5	48	12,3	22,3	58,6	9,5	22,2	70,8	63,5	110,1	18,3
506-MLB	[2.82]	[1.27]	[2.58]	[1.45]	[1.91]	[0.63]	[1.10]	[2.72]	[0.47]	[0.94]	[3.45]	[3.00]	[5.30]	[0.84]
506-MLBLSL ⓘ	71,7	32,3	65,5	36,9	48,4	16	28	69	12	24	87,7	76,2	134,6	21,4 [8.43] 214

Features:

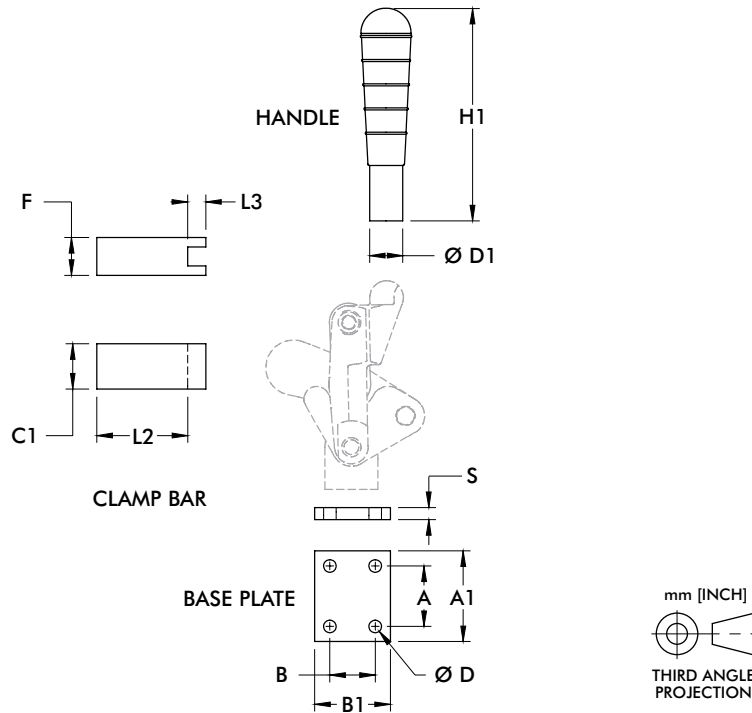
- Used with 500 Series Vertical Clamps
- Allows you to customize the clamp to suit application requirements

Applications:

- Welding
- Assembly
- Heavy duty, production clamping applications

Also Available:

See page MC-VHD-43 for clamp linkage



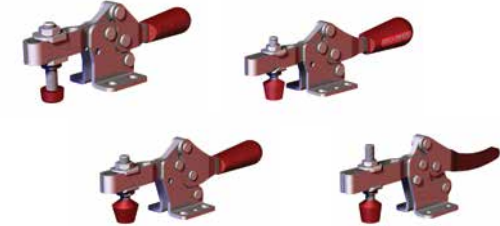






Use with	Part No.	Handle						Clamping Bar				Base Plate			
		ØD1	H1	C1	F	L2	L3	A	A1	B	B1	ØD	S		
501	501503 ⓘ	6x10	61	-	-	-	-	-	-	-	-	-	-		
	501501 ⓘ	-	-	15	15	40	10	-	-	-	-	-	-		
	503502	-	-	-	-	-	-	25	40	35	50	6.3	8		
503	503503-L	Ø18	129.5	-	-	-	-	-	-	-	-	-	-		
	503501	-	-	25	20	50	8	-	-	-	-	-	-		
	503502	-	-	-	-	-	-	25	40	35	50	6.3	8		
505	505503-L	Ø22	159	-	-	-	-	-	-	-	-	-	-		
	505501	-	-	30	25	60	12	-	-	-	-	-	-		
	505502	-	-	-	-	-	-	40	60	30	50	8.1	8		
506	506503-L	Ø28	188	-	-	-	-	-	-	-	-	-	-		
	506501	-	-	35	30	75	15	-	-	-	-	-	-		
	506502	-	-	-	-	-	-	50	70	45	65	8.1	8		

ⓘ This item is available upon request Note: Dimensions shown in millimeters.

HORIZONTAL HOLD DOWN CLAMPS

Sizing and Application Chart

	Series	Page: MC-HHD-#	Max. Holding Capacity N[lbf.]						Height Under Clamping Bar mm [inch]						Overall Height mm [inch]					
			0 to 1000 [0 to 225]	1000 to 2000 [225 to 450]	2000 to 3000 [450 to 675]	3000 to 5000 [675 to 1125]	5000 to 7000 [1125 to 1575]	7000 to 10000 [1575 to 2250]	0 to 10 [0 to 0.39]	10 to 20 [0.39 to 0.79]	20 to 30 [0.79 to 1.18]	30 to 40 [1.18 to 1.57]	40 to 50 [1.57 to 1.97]	50 to 60 [1.97 to 2.36]	0 to 25 [0 to 0.98]	25 to 40 [0.98 to 1.57]	40 to 55 [1.57 to 2.17]	55 to 70 [1.57 to 2.76]	70 to 85 [2.76 to 3.35]	85 to 100 [3.35 to 3.94]
	2013	3																		
	2017	5																		
	2027	7																		
	213	9																		
	217	11																		
	227	13																		
	237	15																		
	245	17																		
	205	19																		
	215	21																		
	225	23																		
	235	25																		
	305	27																		
	307	27																		
	309	27																		
	206	29																		
	5305	31																		
	5310	31																		

HORIZONTAL HOLD DOWN CLAMPS

Sizing and Application Chart

Overall Length mm [inch]		Overall Width mm [inch]		Suitable Application Area										Standard Material	Arm Style	Mounting Style			Service Environment												
50 to 75 [1.97 to 2.95]	75 to 100 [2.95 to 3.94]	100 to 125 [3.94 to 4.92]	125 to 150 [4.92 to 5.91]	150 to 175 [5.91 to 6.89]	175 to 200 [6.89 to 7.87]	200 to 225 [7.87 to 8.86]	225 to 250 [8.86 to 9.84]	250+ [9.84+]	0 to 25 [0 to 0.98]	25 to 40 [0.98 to 1.57]	40 to 55 [1.57 to 2.17]	55 to 70 [1.57 to 2.76]	Welding	Assembly	Checking Fixtures	Machining	Woodworking	Closures	Food Processing	Duty Cycle	Steel	Stainless Steel	Toggle Lock Plus	U-Bar Version	Solid Arm Version	Straight Base	Flanged Base	Weird-On Mounting	Normal	Harsh/Dirty	
			■							■			○	●	●	●	●	●	●	⊗	○	✓		✓	✓			✓	✓		✓
						■					■		○	●	●	●	●	●	●	⊗	○	✓		✓	✓			✓		✓	
							■				■		○	●	●	○	●	●	●	⊗	○	✓		✓	✓			✓		✓	
		■						■				■	○	●	●	●	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
			■						■				○	●	●	●	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
				■						■			○	●	●	●	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
					■				■				○	●	○	○	●	●	○	○	○	✓	✓	✓	✓		✓	✓		✓	
						■				■			○	●	○	○	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
							■				■		○	●	○	○	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
								■				■	○	●	○	○	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
									■				○	●	○	○	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
										■			○	●	○	○	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
											■		○	●	○	○	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
												■	○	●	○	○	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
													○	●	○	○	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓
													○	●	○	○	●	●	○	○	○	✓	✓		✓	✓		✓	✓		✓

● Excellent/High ○ Fair/Medium ● Poor/Low ⊗ Not Recommended

2013 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Increased handle clearance reduces pinch points
- Common mounting hole pattern to Model 213
- Fixed handle pivot provides smooth action
- Nearly 2 times the holding capacity Model 213
- BLK models feature a black, non-reflective finish

Applications:

- Checking fixtures
- Assembly & test
- Light machining
- Woodworking
- Closures

Also Available:

See page MC-ACC-1 for accessories

Accommodates M5 or #10 spindle accessory

Covered under one or more U.S./International Patents

2013-U
Flanged Base
U-Bar



2013-U-LS-BLK ⓘ
Blackout Series
Flanged Base, U-Bar



2013-UR
Flanged Base, U-Bar
with DESTACO®
Toggle Lock
Plus



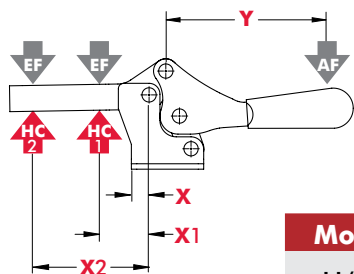
ⓘ This item is available upon request

Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
2013-U	1310 N [295 lbf]	71°	58°	0,17kg [0.37lb]	2013208-M	102111
2013-U-LS-BLK ⓘ					--	102111-BLK
2013-UR					2013208-M	102111

ⓘ This item is available upon request

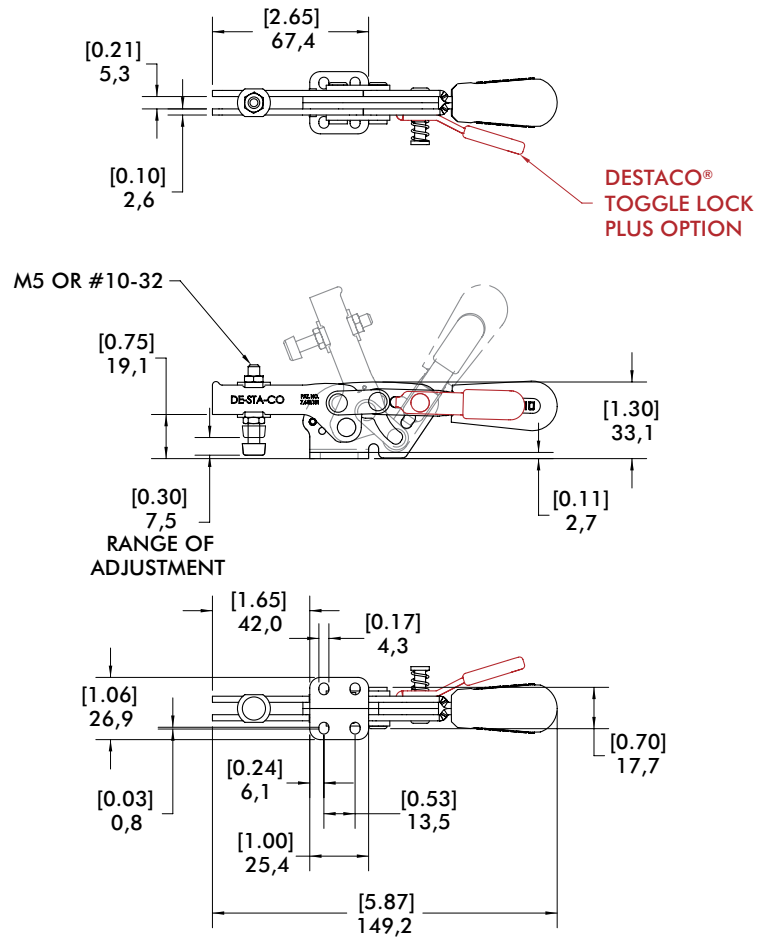
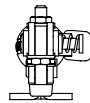
Holding Capacities



Model	X	X1	X2	Y	‡HC1	‡HC2	‡EF(X1):AF	‡EF(X2):AF
U/UR	[0.63] 16	[0.95] 24	[1.95] 49,5	[2.34] 59,5	[295lbf.] 1310N	[175lbf.] 780N	6:1	4:1

Dimensions shown "mm [inch]" ‡ HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

2013-U
Flanged Base
U-Bar



2017 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Increased handle clearance reduces pinch points
- Common mounting hole pattern to Model 217
- Fixed handle pivot provides smooth action
- Over 2½ times the holding capacity Model 217
- BLK models feature a black, non-reflective finish

Applications:

- Checking fixtures
- Assembly & test
- Light machining
- Woodworking
- Closures

Also Available:

See page MC-ACC-1 for accessories
Accommodates M6 or ¼" spindle accessory

Covered under one or more U.S./International Patents

2017-U
Flanged Base
U-Bar



2017-U-LS-BLK ⓘ
Blackout Series
Flanged Base
U-Bar



2017-UR
Flanged Base, U-Bar
with DESTACO®
Toggle Lock
Plus



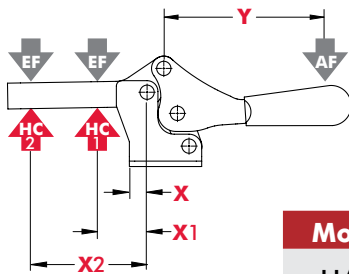
ⓘ This item is available upon request

Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
2017-U	2500 N [560 lbf]	73°	69°	0,44kg [0.97lb]	215208-M	215105
2017-U-LS-BLK ⓘ					--	215105-BLK
2017-UR					215208-M	215105

ⓘ This item is available upon request

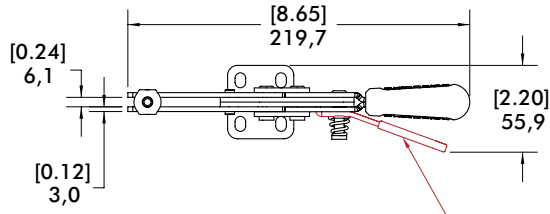
Holding Capacities



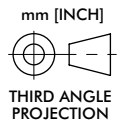
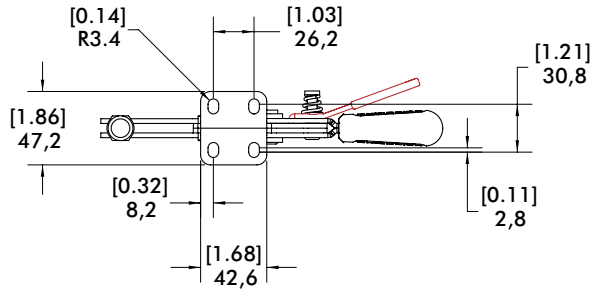
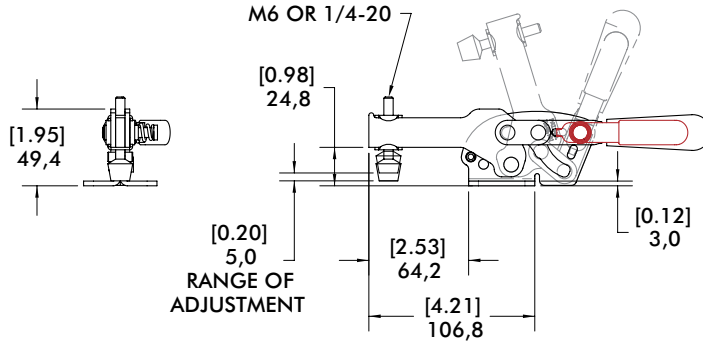
Model	X	X1	X2	Y	‡HC1	‡HC2	‡EF(X1):AF	‡EF(X2):AF
U/UR	[1.08] 27,4	[1.65] 42	[3.15] 80	[2.54] 64,5	[560lbf.] 2500N	[245lbf.] 1090N	5:1	2.5:1

Dimensions shown "mm [inch]" ‡ HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

2017-U
Flanged Base
U-Bar



DESTACO®
TOGGLE LOCK
PLUS OPTION



2027 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Increased handle clearance reduces pinch points
- Common mounting hole pattern to Model 227
- Fixed handle pivot provides smooth action
- Over 1½ times the holding capacity Model 227
- BLK models feature a black, non-reflective finish

Applications:

- Checking fixtures
- Assembly & test
- Light machining
- Woodworking
- Closures

Also Available:

See page MC-ACC-1 for accessories
Accommodates M8 or 5/16" spindle accessory

Covered under one or more U.S./International Patents

2027-U
Flanged Base
U-Bar



2027-U-LS-BLK ⓘ
Blackout Series
Flanged Base
U-Bar



2027-UR
Flanged Base, U-Bar
with DESTACO®
Toggle Lock
Plus



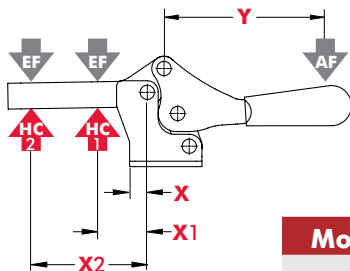
ⓘ This item is available upon request

Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
2027-U	3740 N [840 lbf]	68°	70°	0,61 kg [1.34lb]	2007208-M	507107
2027-U-LS-BLK ⓘ					--	507107-BLK
2027-UR					2007208-M	507107

ⓘ This item is available upon request

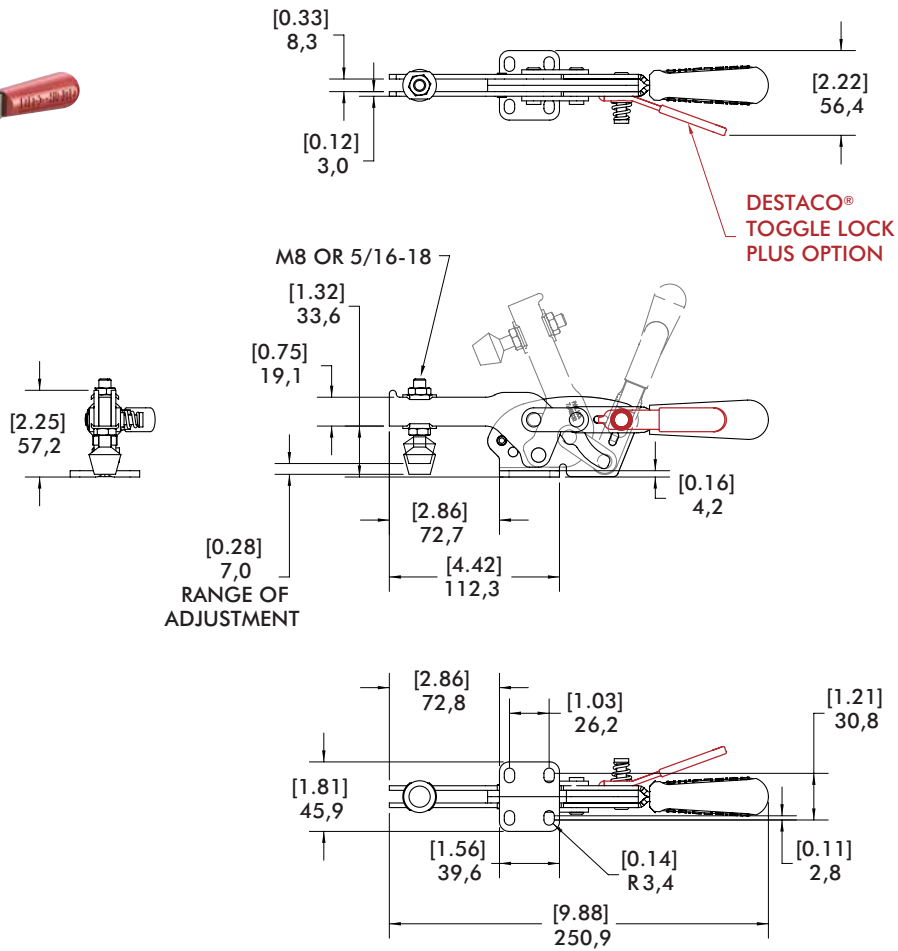
Holding Capacities



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U/UR	[1.02] 25,8	[1.75] 44,5	[3.30] 83,8	[2.54] 64,5	[840lbf.] 3740N	[480lbf.] 2140N	5:1	3:1

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

2027-U
Flanged Base
U-Bar



213 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Low profile
- Large handle clearance in the open position
- Available in stainless steel
- BLK models feature a black, non-reflective finish

Applications:

- Assembly
- Checking fixtures
- Closures
- Woodworking

Also Available:

See page MC-ACC-1 for accessories
Accommodates M5 or #10 spindle accessory

213-U
Flanged Base
U-Bar



213-U-LS-BLK ⓘ
Blackout Series
Flanged Base
U-Bar



213-USS
Flanged Base
U-Bar, Stainless
Steel



213-UB
Straight Base
U-Bar



213-UB-LS-BLK ⓘ
Blackout Series
Straight Base
U-Bar



213-U-L ⓘ
Flanged Base
Open Bar



213-U-L-BLK ⓘ
Flanged Base
Open Bar



213-UB-L ⓘ
Straight Base
Open Bar



213-UB-L-BLK ⓘ
Blackout Series
Straight Base
Open Bar

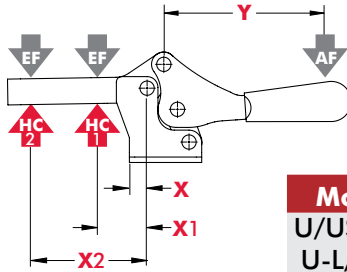


ⓘ This item is available upon request

Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
213-U	670 N [150 lbf]	90°	60°	0,08kg [0.17lb]	213208-M	102111
213-U-LS-BLK ⓘ					--	102111-BLK
213-USS					201943-M	102911
213-UB					213208-M	102111
213-UB-LS-BLK ⓘ					--	102111-BLK
213-U-L ⓘ						102111
213-U-L-BLK ⓘ						102111-BLK
213-UB-L ⓘ						102111
213-UB-L-BLK ⓘ						102111-BLK

ⓘ This item is available upon request

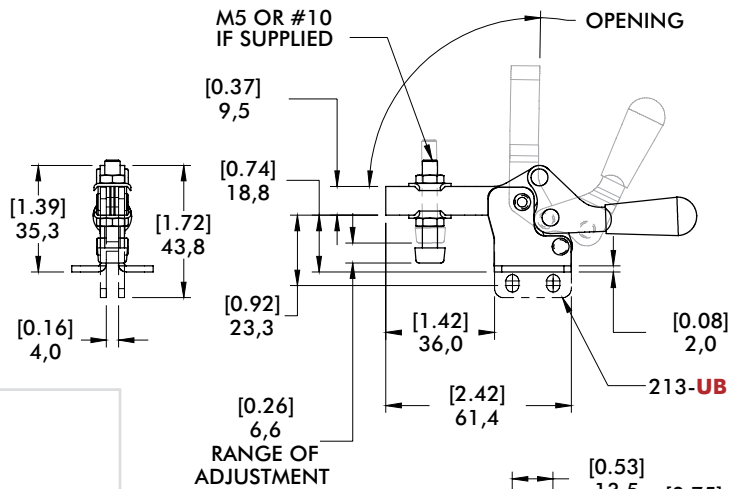
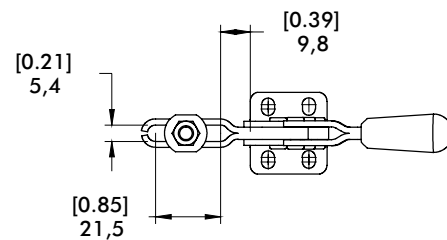


Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U/USS/UB	[0.36]	[0.75]	[1.63]	[1.81]	[150lbf.]	[70lbf.]	7:1	3:1
U-L/UB-L	9,3	19	41,4	46	670N	310N		

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

Dimensions | -U/-USS/-UB

213-U Flanged Base U-Bar

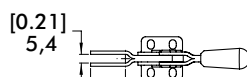


Series 213 Open Bar Options

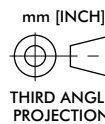
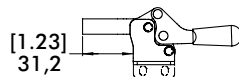


Flanged Base Model 213-U-L ⓘ

See page MC-ACC-7 for Complete offering of Open bar accessories



Straight Base Model 213-UB-L ⓘ



217 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Low profile
- Large handle clearance in the open position
- Available in stainless steel
- BLK models feature a black, non-reflective finish

Applications:

- Assembly
- Checking fixtures
- Closures
- Woodworking

Also Available:

See page MC-ACC-1 for accessories
Accommodates M6 or 1/4" spindle accessory

217-U
Flanged Base
U-Bar



217-U-LS-BLK ⓘ
Blackout Series
Flanged Base
U-Bar



217-USS
Flanged Base
U-Bar, Stainless
Steel



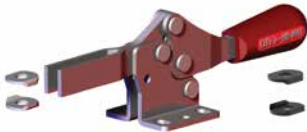
217-UB
Straight Base
U-Bar



217-UB-LS-BLK ⓘ
Blackout Series
Straight Base
U-Bar



217-U-L ⓘ
Flanged Base
Open Bar



217-U-L-BLK ⓘ
Flanged Base
Open Bar



217-UB-L ⓘ
Straight Base
Open Bar



217-UB-L-BLK ⓘ
Blackout Series
Straight Base
Open Bar

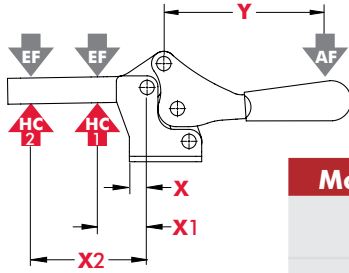


ⓘ This item is available upon request

Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
217-U	900 N [200 lbf]	91°	61°	0,18kg [0.40lb]	202208-M	215105
217-U-LS-BLK ⓘ					--	215105-BLK
217-USS	1110 N [250 lbf]				202943-M	215105
217-UB					202208-M	215105
217-UB-LS-BLK ⓘ						215105-BLK
217-U-L ⓘ	900 N [200 lbf]					215105
217-U-L-BLK ⓘ					--	215105-BLK
217-UB-L ⓘ						215105
217-UB-L-BLK ⓘ			215105-BLK			

ⓘ This item is available upon request



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U					[200lbF.] 900N	[80lbF.] 360N		
USS	[0.53] 13,5	[1.13] 28,6	[2.63] 66,8	[2.93] 74,5	[250lbF.] 1110N	[100lbF.] 440N	7:1	3:1
UB/U-L/ UB-L					[200lbF.] 900N	[80lbF.] 360N		

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

Dimensions | -U/-USS/-UB

Series 217 Open Bar Options

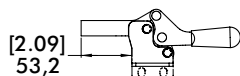
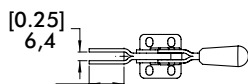


Flanged Base
Model
217-U-L ⓘ

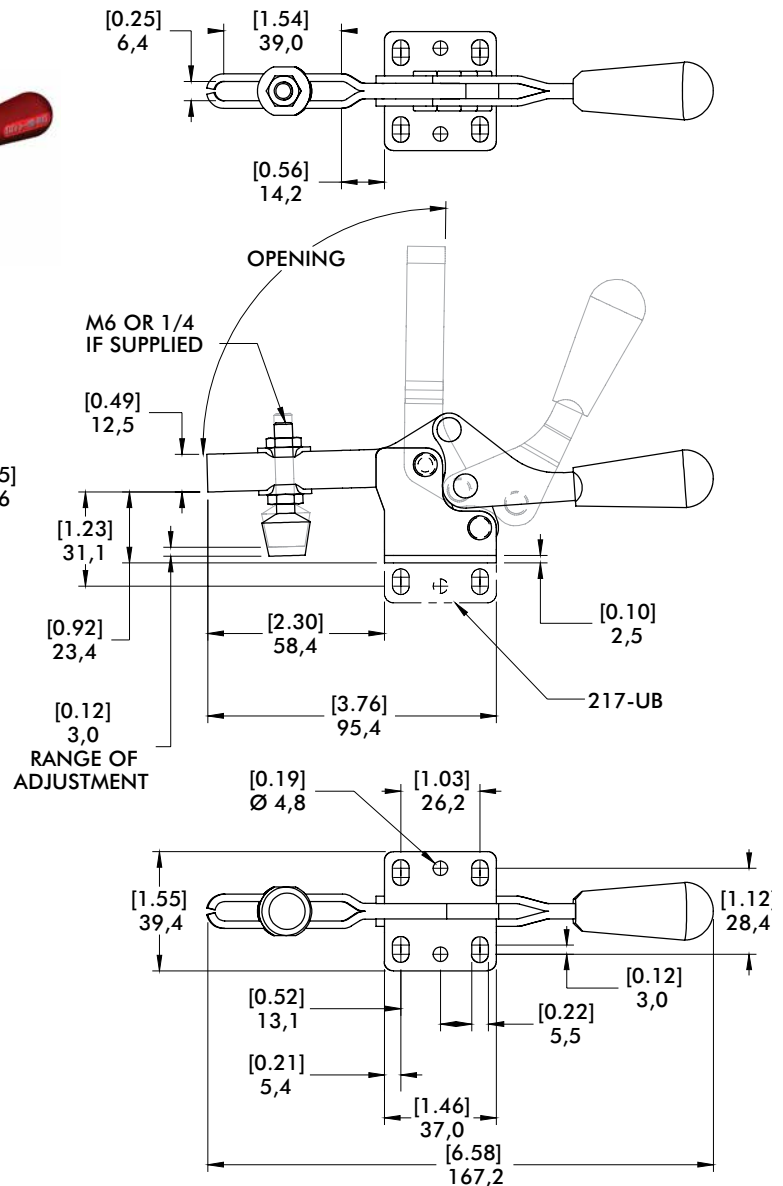
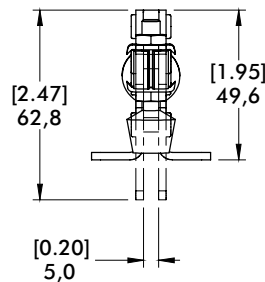


Straight Base
Model
217-UB-L ⓘ

See page MC-ACC-7 for
Complete offering of
Open bar accessories



217-U Flanged Base U-Bar



mm [INCH]
THIRD ANGLE
PROJECTION

227 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Low profile
- Large handle clearance in the open position.
- Available in stainless steel
- BLK models feature a black, non-reflective finish

Applications:

- Assembly
- Checking fixtures
- Closures
- Woodworking

Also Available:

See page MC-ACC-1 for accessories
Accommodates M6 or 5/16" spindle accessory

227-U
Flanged Base
U-Bar



227-U-LS-BLK ⓘ
Blackout Series
Flanged Base
U-Bar



227-USS
Flanged Base
U-Bar, Stainless
Steel



227-UB
Straight Base
U-Bar



227-UB-LS-BLK ⓘ
Blackout Series
Straight Base
U-Bar



227-U-L ⓘ
Flanged Base
Open Bar



227-U-L-BLK ⓘ
Blackout Series
Flanged Base
Open Bar



227-UB-L ⓘ
Straight Base
Open Bar



227-UB-L-BLK ⓘ
Blackout Series
Straight Base
Open Bar

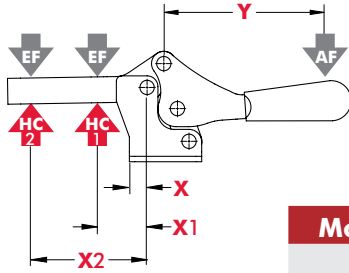


ⓘ This item is available upon request

Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
227-U	2220 N [500 lbf]	91°	56°	0,31kg [0.68lb]	225208-M	507107
227-U-LS-BLK ⓘ					--	507107-BLK
227-USS	2670 N [600 lbf]				-207943-M	507907
227-UB	2220 N [500 lbf]				225208-M	507107
227-UB-LS-BLK ⓘ					--	507107-BLK
227-U-L ⓘ					--	507107
227-U-L-BLK ⓘ					--	507107-BLK
227-UB-L ⓘ					--	507107
227-UB-L-BLK ⓘ		--	507107-BLK			

ⓘ This item is available upon request

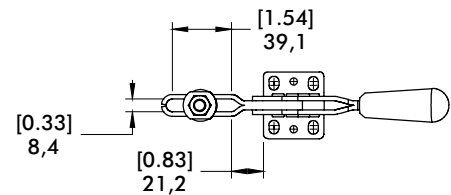


Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U					[500lbf.] 2220N	[225lbf.] 1000N		
USS	[0.39] 10,0	[1.25] 31,8	[2.75] 70,0	[3.58] 91,0	[600lbf.] 2670N	[270lbf.] 1200N	8:1	3:1
UB/U-L/ UB-L					500lbf.] 2220N	[225lbf.] 1000N		

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

Dimensions | -U/-USS/-UB

227-U
Flanged Base
U-Bar

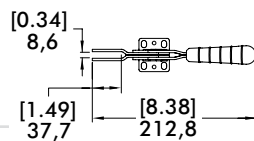


Series 227 Open Bar Options

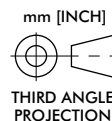
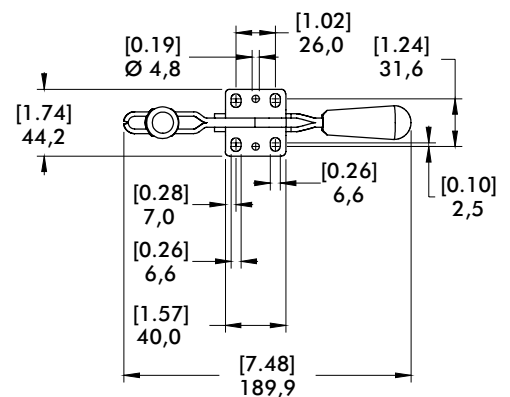
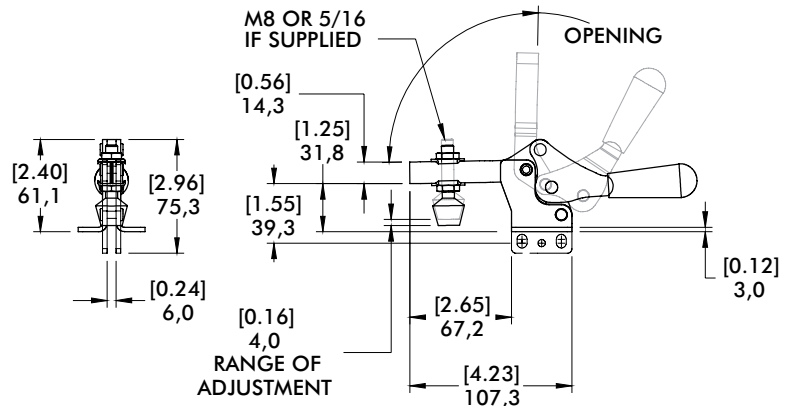
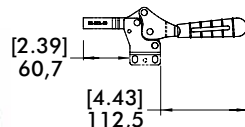


Flanged Base
Model
227-U-L

See page MC-ACC-7 for Complete offering of Open bar accessories



Straight Base
Model
227-UB-L



237 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Low profile
- Large handle clearance in the open position.
- Available in stainless steel

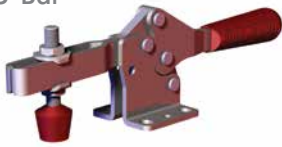
Applications:

- Assembly
- Checking fixtures
- Welding

Also Available:

See page MC-ACC-1 for accessories
Accommodates M10 or 3/8" spindle accessory

237-U
Flanged Base
U-Bar



237-USS ⓘ
Flanged Base
U-Bar, Stainless
Steel

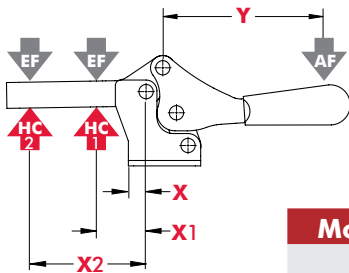


Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening(+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
237-U	3340 N [750 lbf]	93°	59°	0,73kg [1.60lb]	240208-M	235106
237-USS ⓘ	3780 N [850 lbf]				237943-M	235906

ⓘ This item is available upon request

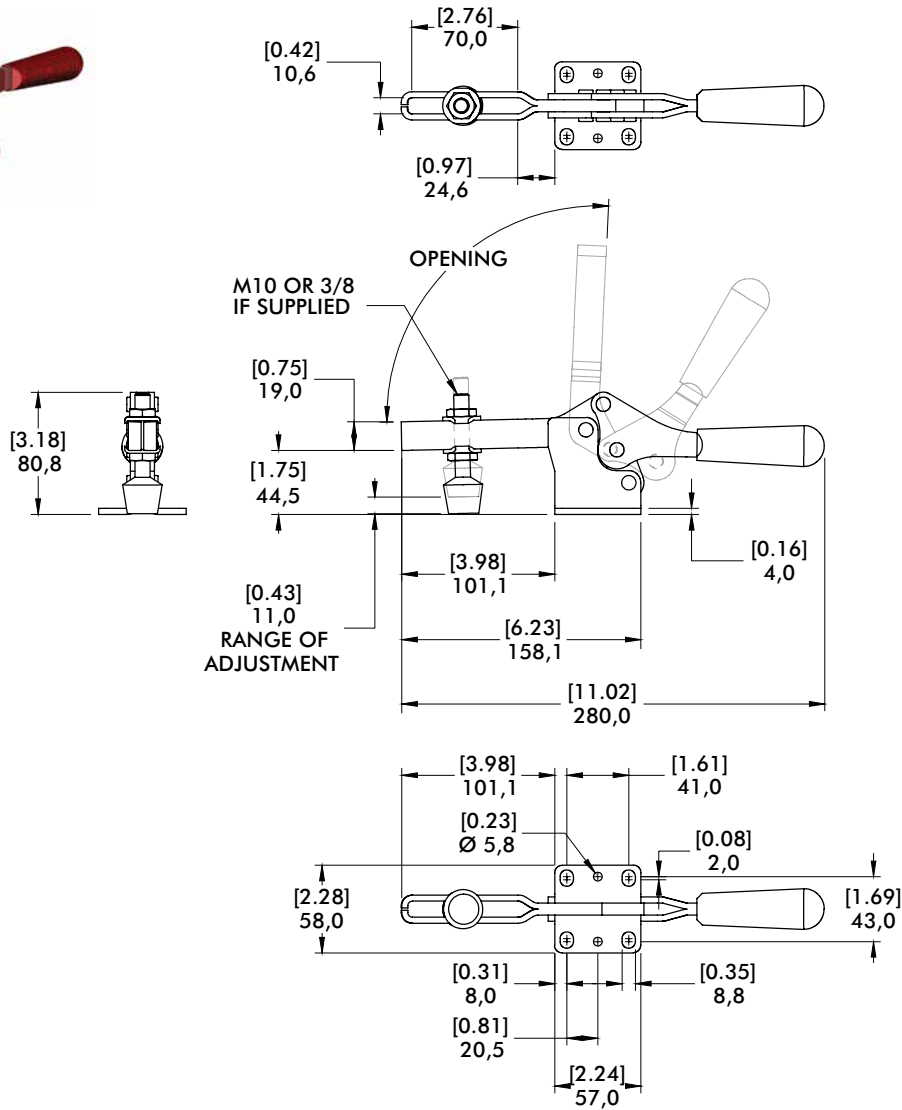
Holding Capacities



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U	[0.81]	[1.75]	[4.50]	[5.25]	[750lbf.] 3340N	[290lbf.] 1290N	6:1	2:1
USS	20,6	44,5	114,3	133,3	[850lbf.] 3780N	[330lbf.] 1470N		

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

237-U
Flanged Base
U-Bar



245 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Low profile
- Large handle clearance in the open position.

Applications:

- Assembly
- Checking fixtures
- Welding

Also Available:

See page MC-ACC-1 for accessories
Accommodates M12 or 1/2" spindle accessory

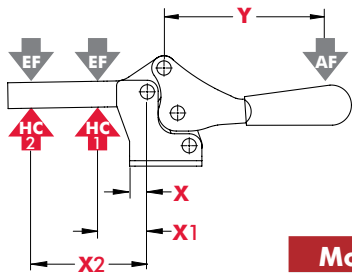
245-U Flanged Base U-Bar



Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
245-U	4450 N [1000 lbf]	105°	74°	1,32kg [2.90lb]	247208-M	247109

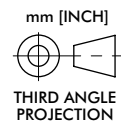
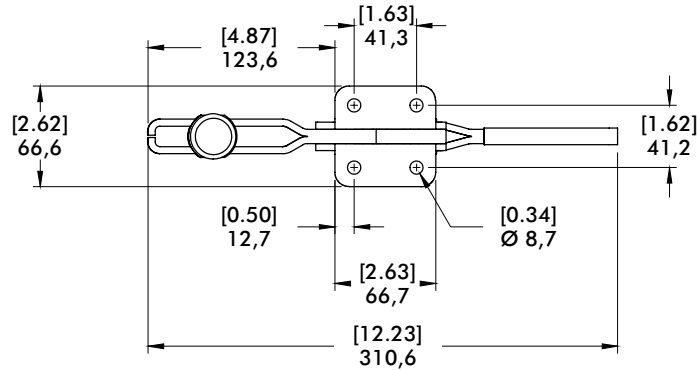
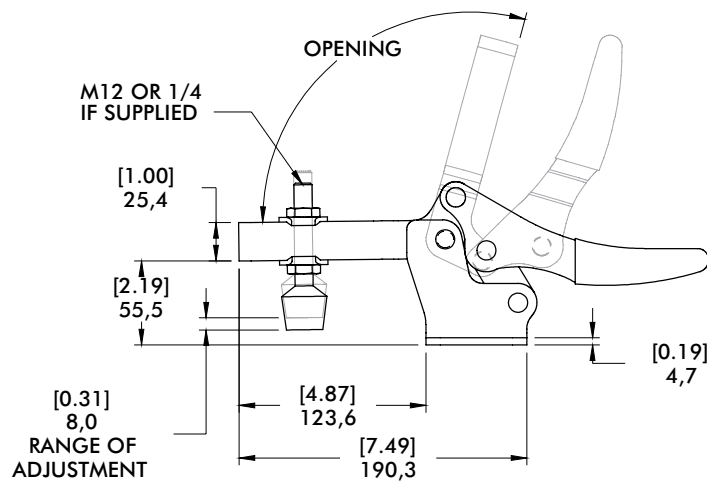
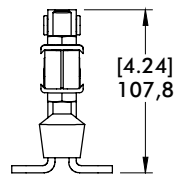
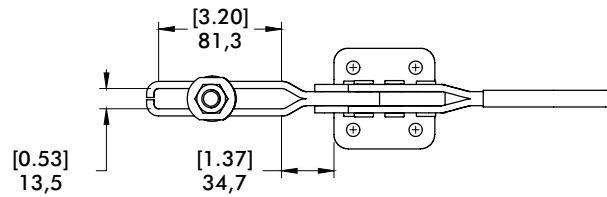
Holding Capacities



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U	[0.50] 12,7	[2.00] 50,8	[5.00] 127	[6.09] 154,7	[1000lbf.] 4450N	[400lbf.] 1780N	11:1	5:1

Dimensions shown "mm [inch]" ‡ **HC** = Holding Capacity, **EF** = Exerting Force, **AF** = Applied Force
See page MC-TEC-4 for additional information.

245-U
Flanged Base
U-Bar



205 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Smallest of the Horizontal Hold Down clamps
- Ideal for light duty clamping in tight spaces
- Stainless steel models furnished without plastic grip

Applications:

- Assembly
- Closures
- Woodworking
- Light duty clamping

Also Available:

See page MC-ACC-1 for accessories
Accommodates M4 or #8 spindle accessory

205-U
Flanged Base
U-Bar



205-UB ⓘ
Straight Base
U-Bar



205-UL ⓘ
Left Flanged
Base, U-Bar



205-UR ⓘ
Right Flanged
Base, U-Bar



205-USS
Flanged Base
U-Bar, Stainless
Steel



205-S
Flanged Base
Solid Bar



205-SB ⓘ
Straight Base
Solid Bar



205-SL ⓘ
Left Flanged Base,
Solid Bar



205-SR ⓘ
Right Flanged
Base, Solid Bar



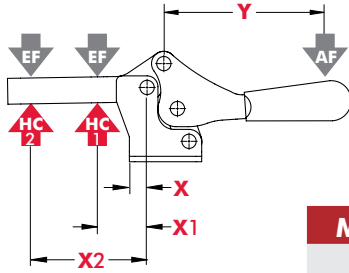
205-SSS
Flanged Base
Solid Bar, Stainless
Steel



Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
205-U	270N [60 lbf]	90°	80°	0,03kg [0.06lb]	205208-M	105106
205-UB ⓘ						
205-UL ⓘ						
205-UR ⓘ	340N [75 lbf]	94°	82°		205943-M	105906
205-USS						
205-S						
205-SB ⓘ	270N [60 lbf]	94°	82°	205208-M	--	
205-SL ⓘ						
205-SR ⓘ						
205-SSS	340N [75 lbf]				205943-M	

ⓘ This item is available upon request

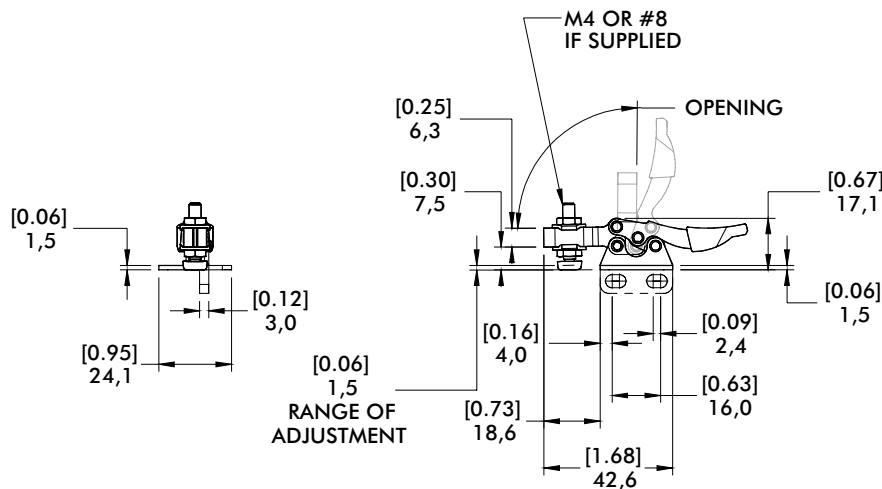
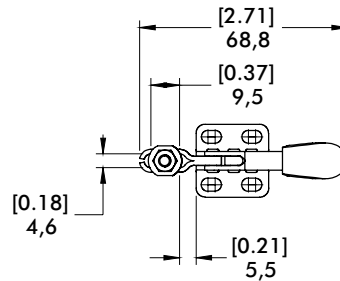


Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U		[0.43] 11			[60lbf.] 270N	[50lbf.] 220N	9:1	5:1
USS	[0.22] 5,6		[0.81] 20,5	[1.31] 33,2	[75lbf.] 340N	[65lbf.] 290N		
S		--			--	[60lbf.] 270N	--	4:1
SSS						[75lbf.] 340N		

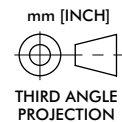
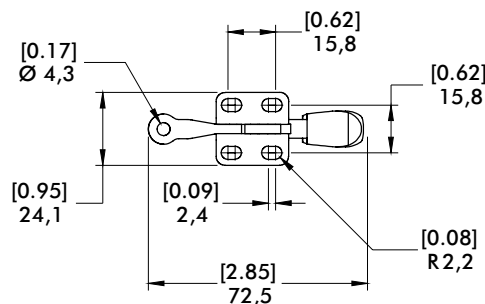
Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

Dimensions | -U/-UB/-UL-/-UR/-USS/-S/-SB/-SL/-SR/-SSS

205-U
Flanged Base
U-Bar



205-S
Flanged Base
Solid Bar



215 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Low profile
- Stainless steel model furnished without plastic grip

Applications:

- Assembly
- Checking fixtures
- Closures
- Woodworking

Also Available:

See page MC-ACC-1 for accessories
Accommodates M6 or 1/4" spindle accessory

215-U
Flanged Base
U-Bar



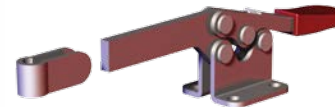
215-USS
Flanged Base
U-Bar, Stainless
Steel



215-UB①
Straight Base
U-Bar



215-S
Flanged Base
Solid Bar

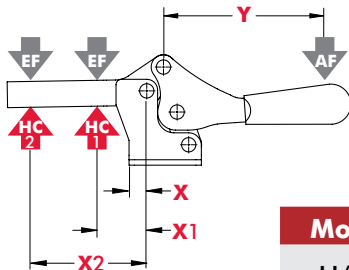


Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)		
					Spindle Assembly	Flanged Washers	Bolt Retainer
215-U	890 N [200 lbf]	87°	78°	0,15kg [0.34lb]	202208-M	215105	--
215-USS	1110 N [250 lbf]				202943-M	215905	
215-UB①	890 N [200 lbf]	202208-M	215105				
215-S		--	--		205105		

① This item is available upon request

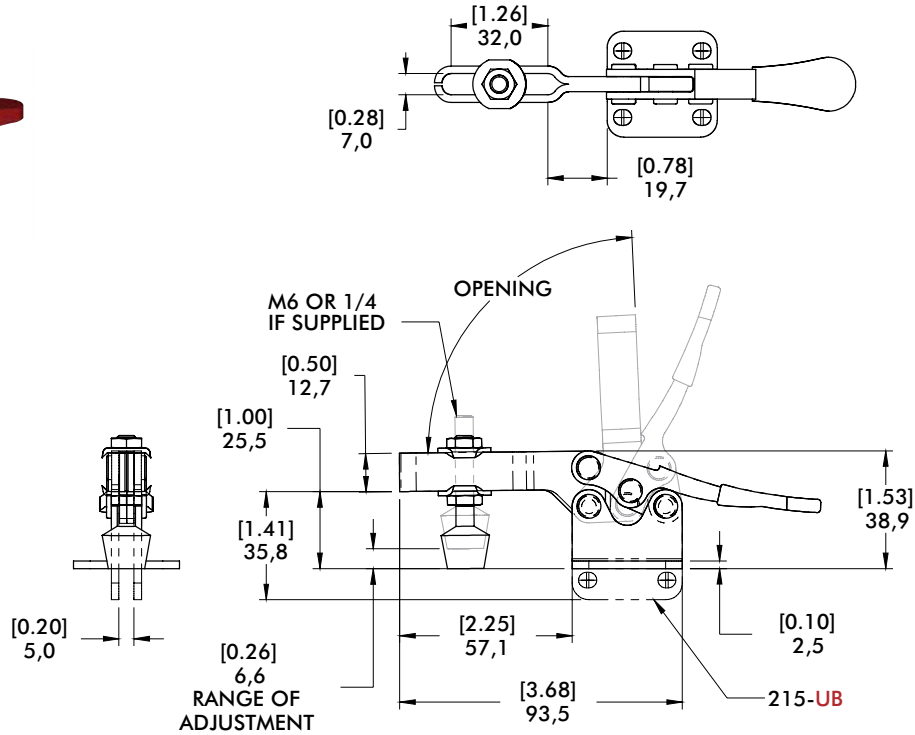
Holding Capacities



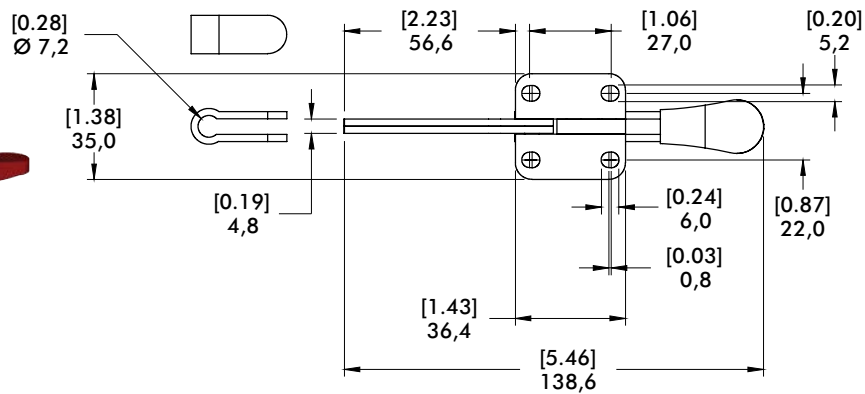
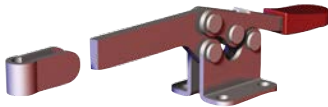
Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U/UB		[1.00] 25,4	[2.25] 57		[200lbf.] 890N	[80lbf.] 360N	9:1	4:1
USS	[0.22] 5,6			[2.72] 69	[250lbf.] 1110N	[110lbf.] 490N		
S		[1.63] 41,4	[2.88] 73		[200lbf.] 890N		6:1	

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

215-U
Flanged Base
U-Bar



215-S
Flanged Base
Solid Bar



225 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Low profile
- Stainless steel model furnished without plastic grip
- Available with DESTACO® Toggle Lock Plus

Applications:

- Assembly
- Checking fixtures
- Closures
- Woodworking

Also Available:

See page MC-ACC-1 for accessories
Accommodates M8 or 5/16" spindle accessory

Covered under one or more U.S./International Patents

225-U
Flanged Base
U-Bar



225-USS
Flanged Base, U-Bar,
Stainless Steel



225-UR
Flanged Base, U-Bar
with DESTACO®
Toggle Lock
Plus



225-UB ⓘ
Straight Base
U Bar



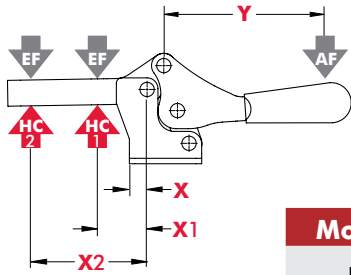
225-UBSS ⓘ
Straight Base, U Bar,
Stainless Steel



Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
225-U	2220 N [500 lbf]	92°	70°	0,25kg [0.55lb]	225208-M	507107
225-USS	2670 N [600 lbf]				207943-M	507907
225-UR	2220 N [500 lbf]			225208-M	507107	
225-UB ⓘ				0,25kg [0.55lb]	207943-M	507907
225-UBSS ⓘ	2670 N [600 lbf]					

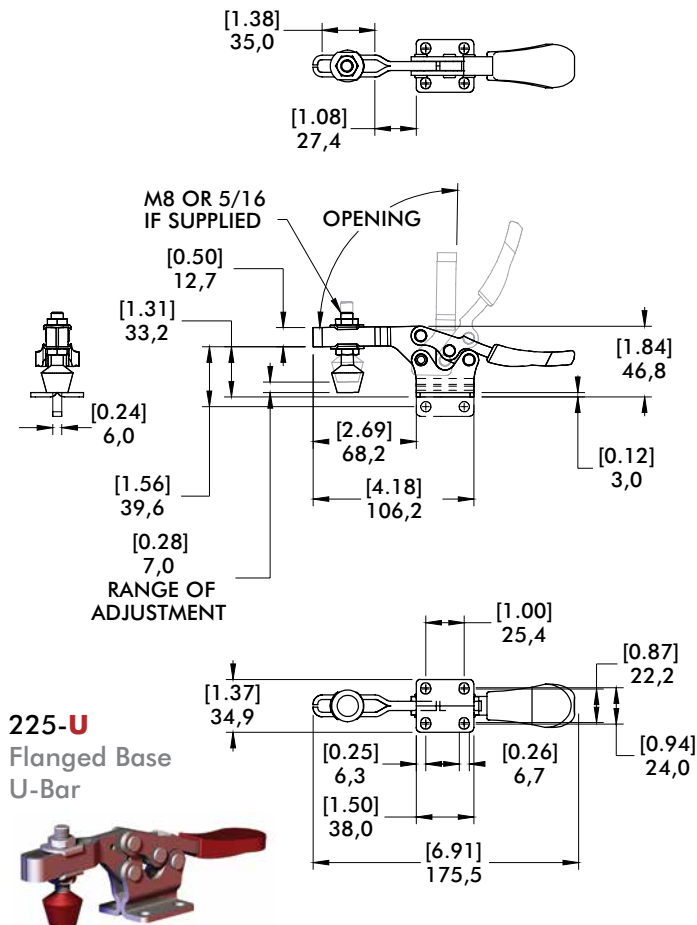
ⓘ This item is available upon request



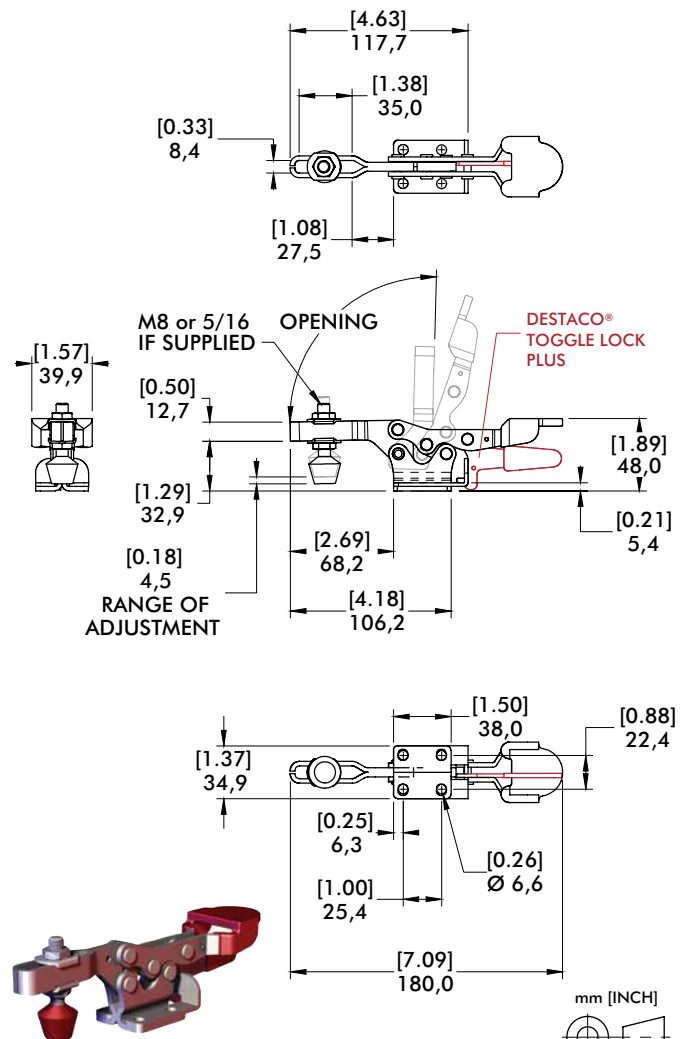
Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
U					[500lbf.] 2220N	[250lbf.] 1110N		
USS	[0.12] 3,0	[1.25] 31,8	[2.50] 63,5	[3.56] 90,4	[600lbf.] 2760N	[300lbf.] 1340N	12:1	5:1
UR/UB					[500lbf.] 2220N	[250lbf.] 1110N		
UBSS					[600lbf.] 2760N	[300lbf.] 1340N		

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

Dimensions | -U/-USS-/UB-/UBSS



Dimensions | -UR



235 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Low profile
- Available with DESTACO® Toggle Lock Plus
- Available in stainless steel

Applications:

- Assembly
- Checking fixtures
- Welding
- Closures
- Woodworking

Also Available:

See page MC-ACC-1 for accessories
Accommodates M10 or 3/8" spindle accessory

Covered under one or more U.S./International Patents

235-U
Flanged Base
U-Bar



235-USS
Flanged Base, U-Bar,
Stainless Steel



235-UR
Flanged Base, U-Bar
with DESTACO®
Toggle Lock
Plus



235-UB ⓘ
Straight Base
U-Bar

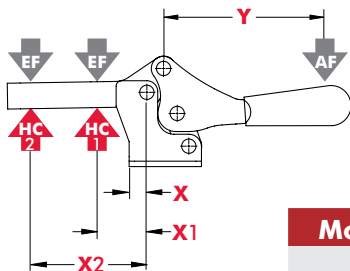


Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
235-U	3340 N [750 lbf]	92°	70°	0,67kg [1.47lb]	240208-M	235106
235-USS	3780 N [850 lbf]				237943-M	235906
235-UR	3340 N [750 lbf]			0,74kg [1.64lb]	240208-M	235106
235-UB ⓘ				0,67kg [1.47lb]		

ⓘ This item is available upon request

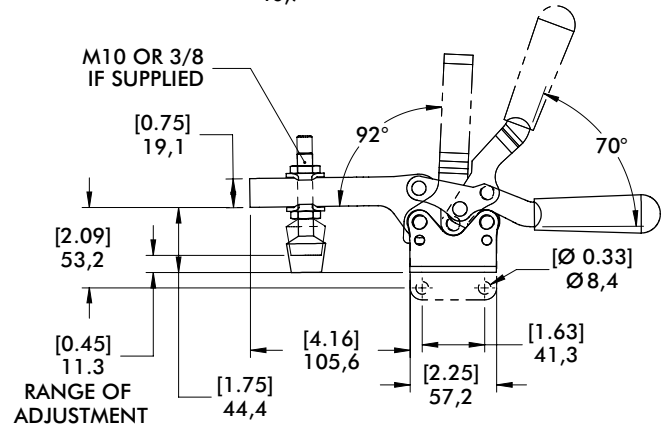
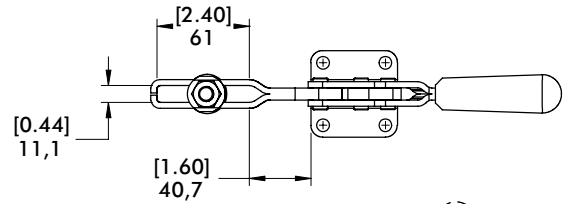
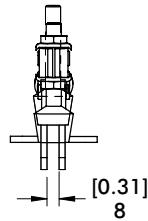
Holding Capacities



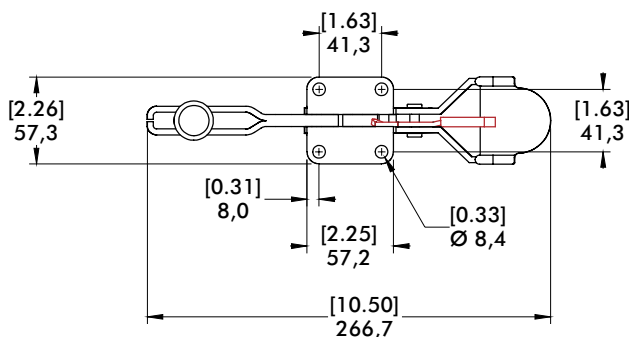
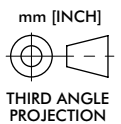
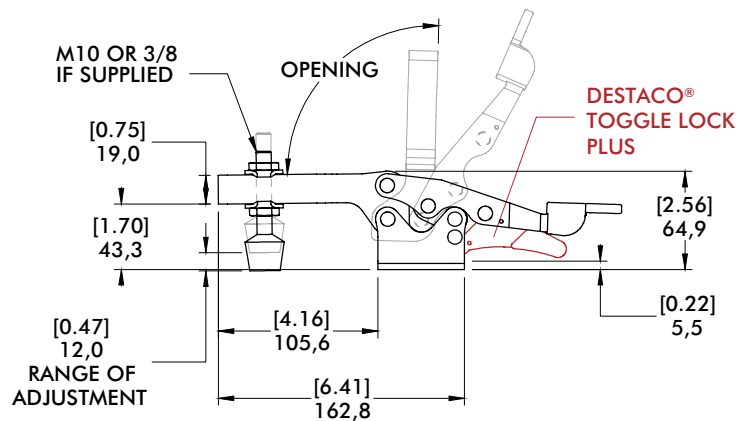
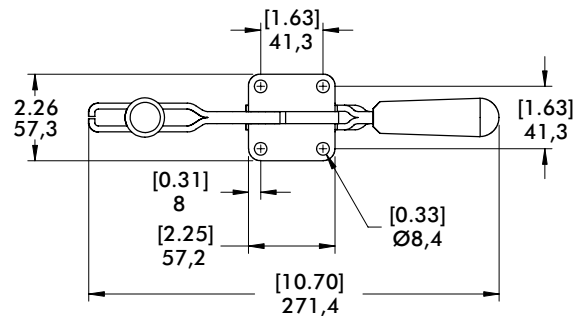
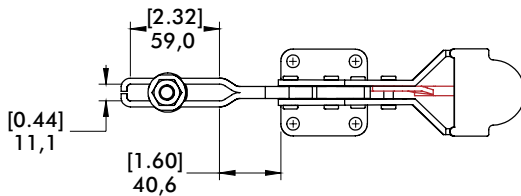
Model	X	X1	X2	Y	‡HC1	‡HC2	‡EF(X1):AF	‡EF(X2):AF
U					[750lbf.] 3340N	[300lbf.] 1330N	9:1	5:1
USS	[0.25] 6,4	[1.75] 44,5	[4.13] 105	[5.75] 146	[850lbf.] 3780N	[360lbf.] 1600N		
UR/UB					[750lbf.] 3340N	[300lbf.] 1330N		

Dimensions shown "mm [inch]" ‡ HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

235-U Flanged Base U-Bar



Dimensions | -UR



235-UR Flanged Base, U-Bar with DESTACO® Toggle Lock Plus



305, 307, 309 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- Compact design suitable for use in confined spaces
- Available with DESTACO® Toggle Lock Plus
- Stainless steel models available

Applications:

- Assembly & Test
- Light Machining
- Closures
- Woodworking

Also Available:

See page MC-ACC-1 for accessories

305-U
Flanged Base
U-Bar



305-USS
Flanged Base
U-Bar, Stainless
Steel



305-UR
Flanged Base,
U-Bar with
DESTACO®
Toggle
Lock
Plus



307-U
Flanged Base
U-Bar



307-USS
Flanged Base
U-Bar, Stainless
Steel



307-UR
Flanged Base,
U-Bar with
DESTACO®
Toggle
Lock
Plus



309-U
Flanged Base
U-Bar



309-USS
Flanged Base
U-Bar, Stainless
Steel



309-UR ⓘ
Flanged Base,
U-Bar with
DESTACO®
Toggle
Lock
Plus



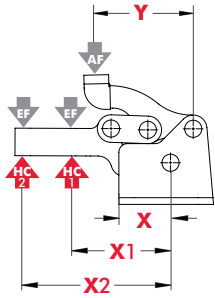
Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
305-U	670 N [150 lbf]	90°	170°	0,06kg [0.13lb]	305208-M	102111
305-USS	900 N [200 lbf]				201943-M	102911
305-UR	670 N [150 lbf]				305208-M	102111
307-U	1560 N [350 lbf]	92°	173°	0,24kg [0.54lb]	307208-M	507107
307-USS					207943-M	507907
307-UR					307208-M	507107
309-U	3340 N [750 lbf]	90°	168°	1,30kg [0.59lb]	309208	235106
309-USS					237943-M	235906
309-UR ⓘ					309208	235106

ⓘ This item is available upon request

305, 307, 309 SERIES

Horizontal Hold Down Clamps | Holding Capacities

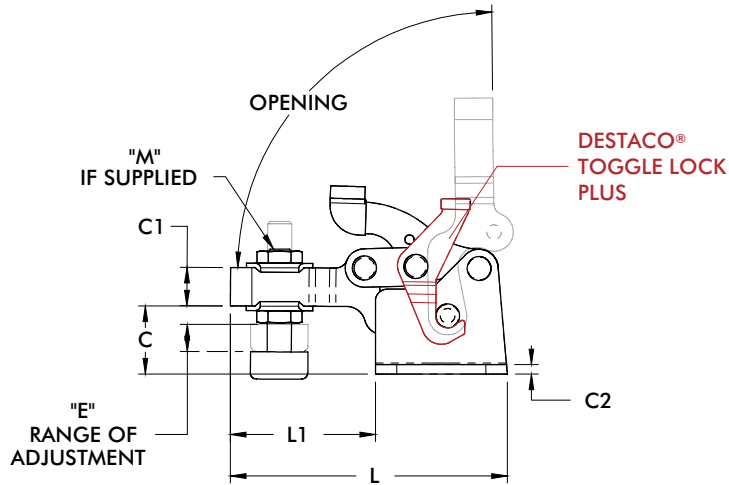
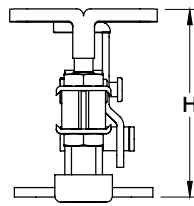
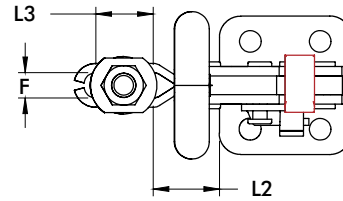


Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
305-U/UR	[0.58] 14,6	[1.38] 35	[1.88] 47,7	[1.14] 29	[150lbf.] 670N	[110lbf.] 490N	3:1	2:1
305-USS					[200lbf.] 900N	[150lbf.] 670N		
307-U/UR/USS	[0.94] 24	[1.88] 47,7	[2.50] 63,5	[1.77] 45	[350lbf.] 1560N	[260lbf.] 1160N	4:1	
309-U/UR/USS	[1.34] 34	[2.50] 63,5	[3.50] 89	[2.70] 68,5	[750lbf.] 3340N	[530lbf.] 2360N		

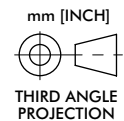
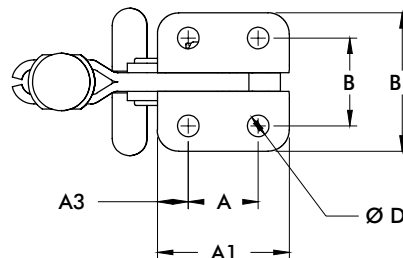
Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

Dimensions | -U/-USS/-UR

305-U
Flanged Base
U-Bar



307-UR
Flanged Base,
U-Bar with
DESTACO®
Toggle
Lock
Plus



Model	A	A1	A3	B	B1	C	C1	C2	D	E	F	H	L	L1	L2	L3	M
305-U/UR	[0.53] 13,5	[1.035] 26,3	[0.25] 6,4	[0.63] 16,0	[1.02] 25,9	[0.48] 12,2	[0.31] 7,9	[0.08] 2,0	[0.18] 4,6	[0.31] 8	[0.21] 5,3	[1.43] 36,3	[2.21] 56,1	[1.19] 30,2	[0.51] 13,0	[0.50] 12,7	[#10] M5
307-U/UR	[0.91] 23,1	[1.72] 43,7	[0.40] 10,2	[1.14] 29,0	[1.80] 45,7	[0.89] 22,6	[0.50] 12,7	[0.12] 3,0	[0.28] 7,1	[0.37] 9,5	[0.33] 8,4	[2.36] 59,9	[3.61] 91,7	[1.89] 48,0	[0.86] 21,8	[0.75] 19,1	[5/16] M8
309-U/UR	[1.38] 35,1	[2.52] 64,0	[0.58] 14,7	[1.50] 38,1	[2.47] 62,7	[1.31] 33,3	[0.75] 19,1	[0.12] 3,0	[0.33] 8,4	[0.72] 18,5	[0.44] 10,4	[3.53] 89,7	[5.19] 131,8	[2.68] 68,1	[1.28] 32,5	[1.06] 26,9	[3/8-16] M10

206 SERIES

Horizontal Hold Down Clamps | Product Overview

Features:

- All stainless steel construction
- Offers good bar clearance under clamping bar while maintaining low profile

Applications:

- Assembly
- Chemical processing
- Closures
- Light duty clamping

Also Available:

See page MC-ACC-1 for accessories
Accommodates M4 or #8 spindle accessory

206-SS

Flanged Base
Low U-Bar,
Stainless Steel



206-HSS

Flanged Base
High U-Bar,
Stainless Steel

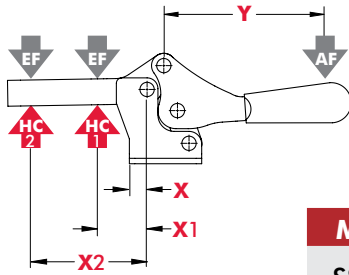


Technical Information

Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)	
					Spindle Assembly	Flanged Washers
206-SS	440 N [100 lbf]	90°	90°	0,03kg [0.07lb]	205943-M	105906
206-HSS						

Model 206-HSS shown securing a platen on a prototyping machine.

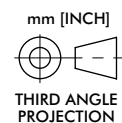
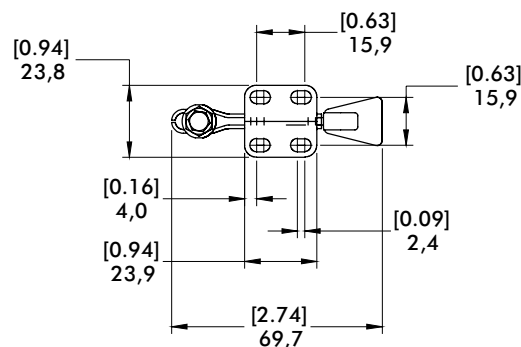
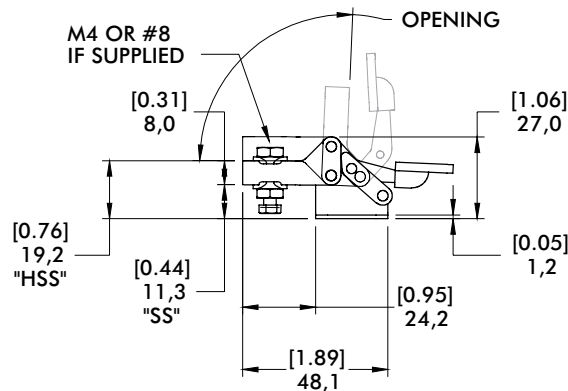
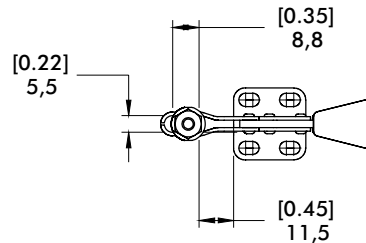




Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
SS/HSS	[0.20] 5	[0.43] 11	[1.06] 27	[1.14] 29	[100lbf.] 440N	[50lbf.] 220N	5:1	3:1

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.

Dimensions | -SS/-HSS



5305, 5310 SERIES

Heavy Duty Horizontal Hold Down Clamps | Product Overview

Features:

- Solid clamping arm may be modified to suit requirements
- Hardened steel pivot pins and bushings provide long life
- Black oxide finish
- DESTACO® Toggle Lock Plus versions available†

Applications:

- Welding fixtures
- Assembly fixtures
- Light machining



5305/5310
Flanged Base

5305-B/5310-B
Solid Base

5305-R/5310-R
Flanged Base with DESTACO® Toggle Lock Plus

5305-BRⓘ/5310-BRⓘ
Solid Base with DESTACO® Toggle Lock Plus



Technical Information

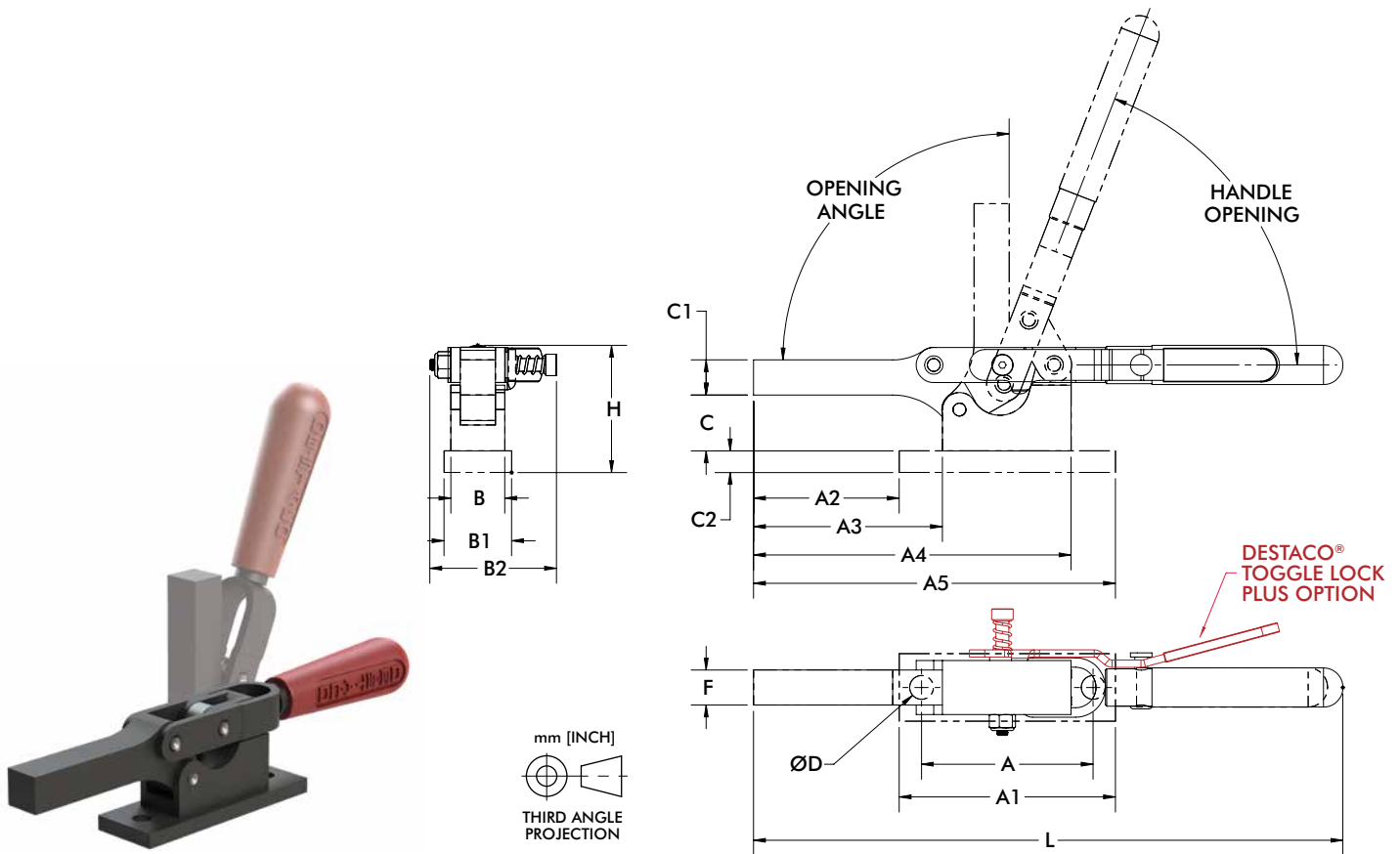
Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight
5305				[1.08lbs] 0,49kg
5305-B	[600lbf.] 2670N	90°	69°	[0.82lbs] 0,37kg
5305-R				[1.09lbs] 0,49kg
5305-BRⓘ				[0.83lbs] 0,37kg
5310				[2.84lbs] 1,29kg
5310-B	[1300lbf.] 5780N	90°	69°	[2.24lbs] 1,02kg
5310-R				[2.87lbs] 1,30kg
5310-BRⓘ				[2.27lbs] 1,03kg

ⓘ This item is available upon request.

† Toggle Lock Plus locks the handle in the closed position only.

5305, 5310 SERIES

Heavy Duty Horizontal Hold Down Clamps | Dimensions



Model	A	A1	A2	A3	A4	A5	B	B1	B2	C	C1	C2	D	F	H	L
5305	[2.50] 63,5	[3.15] 80,0	[2.12] 53,8	[2.75] 69,9	[4.63] 117,6	[5.27] 133,9	[0.79] 20,1	[0.98] 24,9	--	[0.81] 20,6	[0.51] 13,0	[0.31] 7,9	[0.35] 8,9	[0.51] 13,0	[1.51] 38,4	[8.36] 212,4
5305-R									[1.84] 46,7							
5310	[3.63] 92,2	[4.63] 117,6	[2.63] 66,8	[3.63] 92,2	[6.25] 158,8	[7.25] 184,2	[1.13] 28,7	[1.50] 38,1	--	[1.00] 25,4	[0.75] 19,1	[0.31] 7,9	[0.41] 10,4	[0.79] 20,1	[2.00] 50,8	[11.13] 282,6
5310-R									[2.31] 58,7							[11.02] 279,8

Model	A3	A4	B2	C	C1	F	H	L
5305-B	[2.75] 69,9	[4.63] 117,6	--	[0.81] 20,6	[0.51] 13,0	[0.51] 13,0	[1.51] 38,4	[8.36] 212,4
5305-BR ⓘ			[1.84] 46,7					
5310-B	[3.63] 92,2	[6.25] 158,8	--	[1.00] 25,4	[0.75] 19,1	[0.79] 20,1	[2.00] 50,8	[11.13] 282,6
5310-BR ⓘ			[2.31] 58,7					[11.02] 279,8

ⓘ This item is available upon request

STRAIGHT LINE ACTION CLAMPS

Sizing and Application Chart

		Max. Holding Capacity N[lbf.]						Plunger Travel mm [inch]					
		0 to 1000 [0 to 225]	1000 to 2000 [225 to 450]	2000 to 3000 [450 to 675]	3000 to 5000 [675 to 1125]	5000 to 7000 [1125 to 1575]	7000 to 10000 [1575 to 2250]	10000+ [2250+]	0 to 20 [0 to 0.79]	20 to 40 [0.79 to 1.57]	40 to 60 [1.57 to 2.36]	60 to 80 [2.36 to 3.15]	80 to 105 [3.15 to 4.13]
Series	Page: MC-SLA-#												
	6001	3											
	601	4											
	6015	5											
	603	7											
	608	7											
	605	9											
	606	10											
	607	11											
	609	12											
	610	13											
	615	14											
	620	15											
	630	16											
	640	17											
	650	18											
	95030	19											
	95040	19											
	95050	19											
	95060	19											
	5130	21											
	5131	21											
	5133	21											
	5150	23											
	602	25											
	604	25											
	624	25											
	6004	27											
	614	29											
	670	31											
	675	31											
	690	31											
	695	31											

6001 SERIES

Straight Line Action Clamps | Product Overview

Features:

- Heavier duty version of Model 601 with 50% more holding capacity
- Mounting pattern interchangeable with Model 601
- Allow handle to fall below mounting plane to lock in retracted position

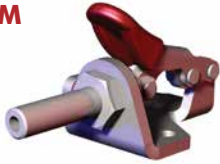
Applications:

- Assembly
- Testing
- Soldering
- Gluing

Also Available:

See page MC-ACC-1 for accessories

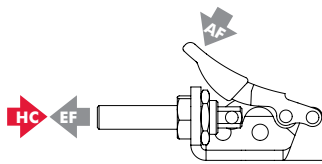
6001
6001-M



6001-SS
6001-MSS

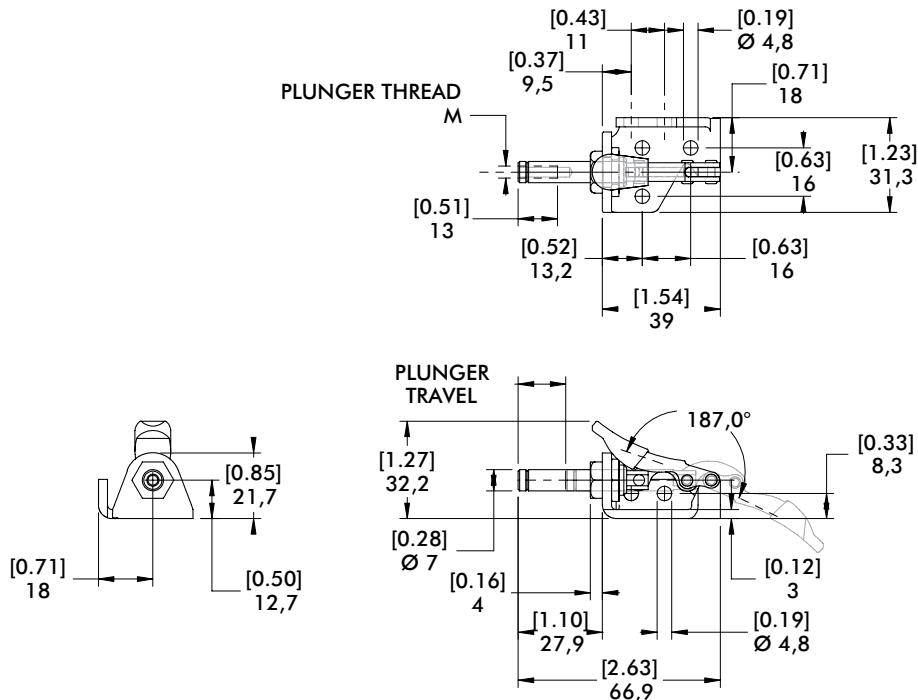


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel	(M) Plunger Thread	Spindle (Recommended)	Spindle Included
6001					#8-32	105203	No
6001-M	[150 lbf] 670 N	[0.12lb] 0,05kg	14:1/25:1	[0.63] 16	M4	205208-M	
6001-SS					#8-32	205943	Yes
6001-MSS					M4	205943-M	

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



Features:

- Compact straight line action clamp

Applications:

- Assembly
- Testing
- Soldering
- Gluing

Also Available:

See page MC-ACC-1 for accessories

601



601-M



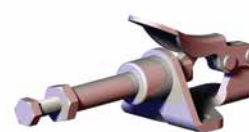
601-O

Straight Base
U-Bar



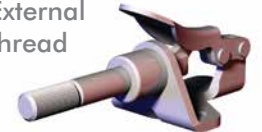
601-SS

Stainless steel

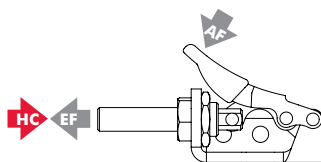


601-OSS ⓘ

Stainless steel
External
thread

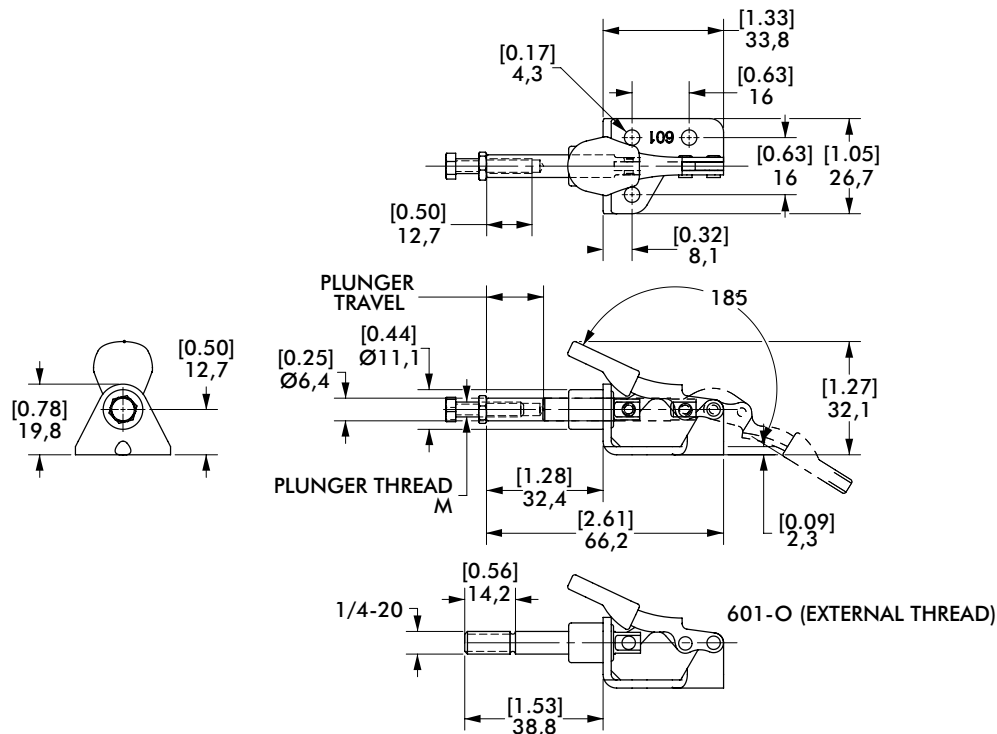


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel (M)	Plunger Thread (M)	Spindle (Recommended)	Spindle Included
601					#8-32	105203	Yes
601-M					M4	205208-M	No
601-O	[100 lbf] 440 N	[0.09lb] 0,04kg	14:1/25:1	[0.63] 16	1/4-20	--	No
601-SS					#8-32	205943	Yes
601-OSS ⓘ					1/4-20	--	No

ⓘ This item is available upon request HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



6015 SERIES

Straight Line Action Clamps | Product Overview

Features:

- Smallest of the solid base Straight Line Action clamps
- Compact design combined with high holding capacity
- Allow handle to fall below mounting plane to lock in retracted position

Applications:

- Assembly
- Checking fixtures
- Tensioning devices

Also Available:

See page MC-ACC-1 for accessories

Covered under one or more U.S./International Patents

6015
6015-M



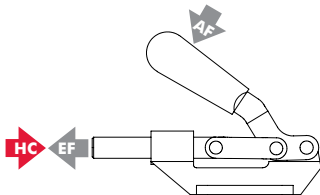
6015-SS,
6015-MSS
Stainless
Steel



6015-R,
6015-MR
with DESTACO®
Toggle Lock
Plus



Technical Information | Holding Capacities



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
6015	[560 lbf] 2500 N	[0.35lb] 0,15kg	35:1	[0.70] 17,8	1/4-20	205203
6015-M					M6	205203-M
6015-SS	[630 lbf] 2800 N				1/4-20	202943 (supplied)
6015-MSS					M6	202916-M (supplied)
6015-R	[560 lbf] 2500 N				1/4-20	205203
6015-MR					M6	205203-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force

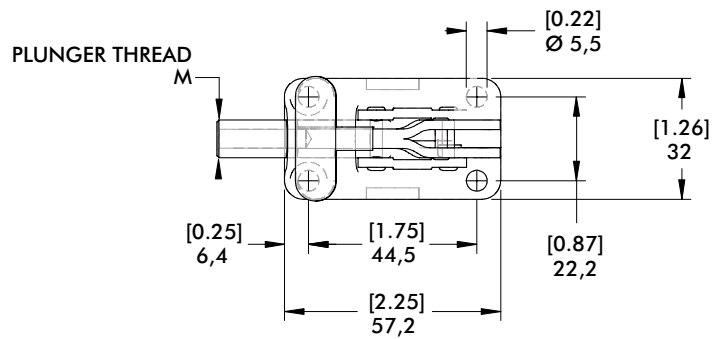
6015
6015-M



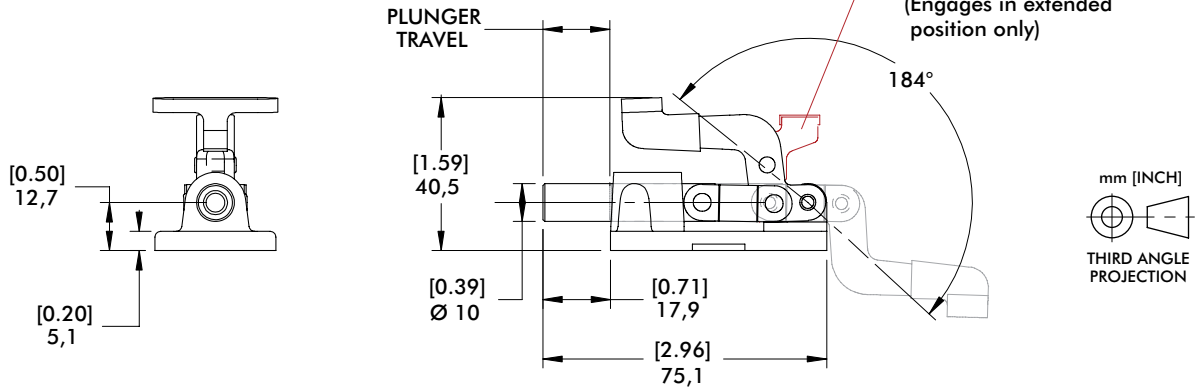
6015-SS,
6015-MSS
Stainless
Steel



6015-R,
6015-MR
with DESTACO®
Toggle Lock Plus



DESTACO®
TOGGLE LOCK
PLUS OPTION
6015-R / 6015-MR
(Engages in extended
position only)



603, 608 SERIES

Straight Line Action Clamps | Product Overview

Features:

- Allow handle to rotate and fall below mounting plane to lock in retracted position
- Large holding capacities for their size
- Available with DESTACO® Toggle Lock Plus

Applications:

- Assembly & test
- Checking fixtures
- Welding fixtures
- Tensioning devices

Also Available:

See page MC-ACC-1 for accessories

803 Pneumatic Toggle Clamp
See page MC-PTC-27

803-ME Pneumatic Toggle Clamp
See page MC-PTC-27

Covered under one or more U.S./International Patents

603
603-M



603-SS
603-MSS
Stainless
Steel



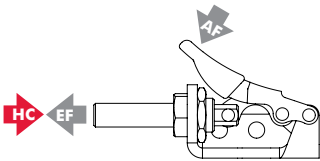
603-R
603-MR
with
DESTACO®
Toggle Lock
Plus



608
608-M



Technical Information | Holding Capacities



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
603	[600 lbf] 2670 N				5/16-18	207203
603-M					M8	207203-M
603-SS	[840 lbf] 3740 N	[0.83lb] 0,38kg	23:1/34:1	[1.25] 31,8	5/16-18	207943
603-MSS					M8	207943-M (supplied)
603-R	[600 lbf] 2670 N				5/16-18	207203
603-MR					M8	207203-M
608	[850 lbf] 3780 N	[1.25lb] 0,57kg	44:1/50:1	[1.63] 41,3	3/8-16	210203
608-M					M10	210203-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force

603, 608 SERIES

Straight Line Action Clamps | Dimensions | -M/-SS/-MSS/-R/-MR

603
603-M



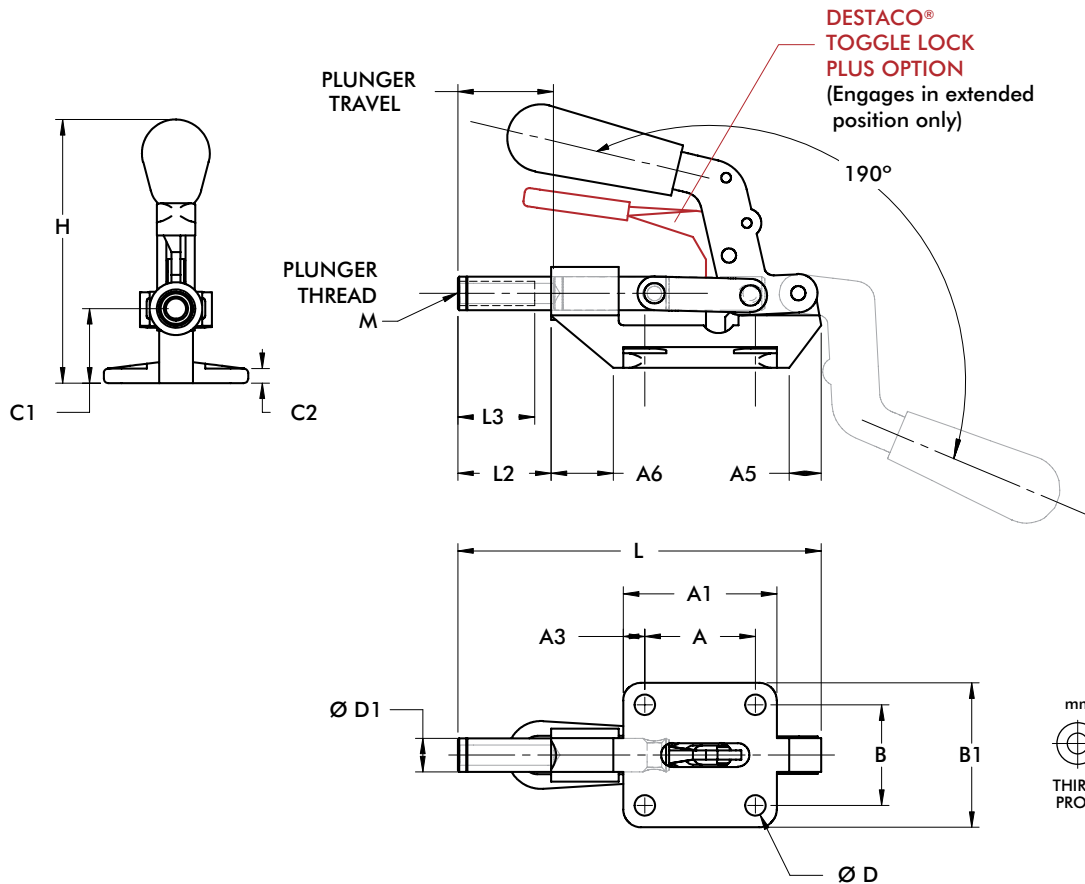
603-SS
603-MSS
Stainless Steel



603-R
603-MR
with
DESTACO®
Toggle Lock
Plus



608
608-M



Model	A	A1	A3	A5	A6	B	B1	C1	C2	D	D1	H	L	L2	L3
603		[2.17]	[0.34]	[0.51]	[0.82]				[0.19]		[0.44]	[3.43]	[4.77]		
603-M		55	8,5	13	21				4,8		11,1	87	121,2		
603-SS	[1.44]			[0.54]	[0.65]	[1.31]	[1.88]	[0.97]	[0.25]	[0.27]	[0.47]	[3.28]	[4.69]	[1.28]	[1.00]
603-MSS	36,6	[2.20]	[0.30]	13,6	16,5	33,3	48	24,6	6,4	6,8	12	83,4	119,2	32,5	25,4
603-R			7,5	[0.51]	[0.82]						[0.44]	[3.43]	[4.77]		
603-MR				13	21				[0.19]		11,1	87	121,2		
608	[1.63]	[2.25]	[0.31]	[0.75]	[1.40]	[1.63]	[2.25]	[1.25]	4,8	[0.33]	[0.62]	[4.04]	[6.00]	[1.59]	[1.25]
608-M	41,4	57,2	8	19	36	41,4	57,2	31,8		8,4	15,8	102,6	152,3	40,5	31,8

605 SERIES

Straight Line Action Clamps | Product Overview

Features:

- For push/pull clamping
- Allow handle to rotate and fall below mounting plane to lock in retracted position

Applications:

- Assembly & test
- Woodworking
- Tensioning devices

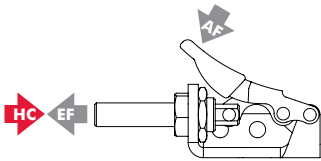
Also Available:

See page MC-ACC-1 for accessories
Reverse action version Model 615/615-M

605
605-M

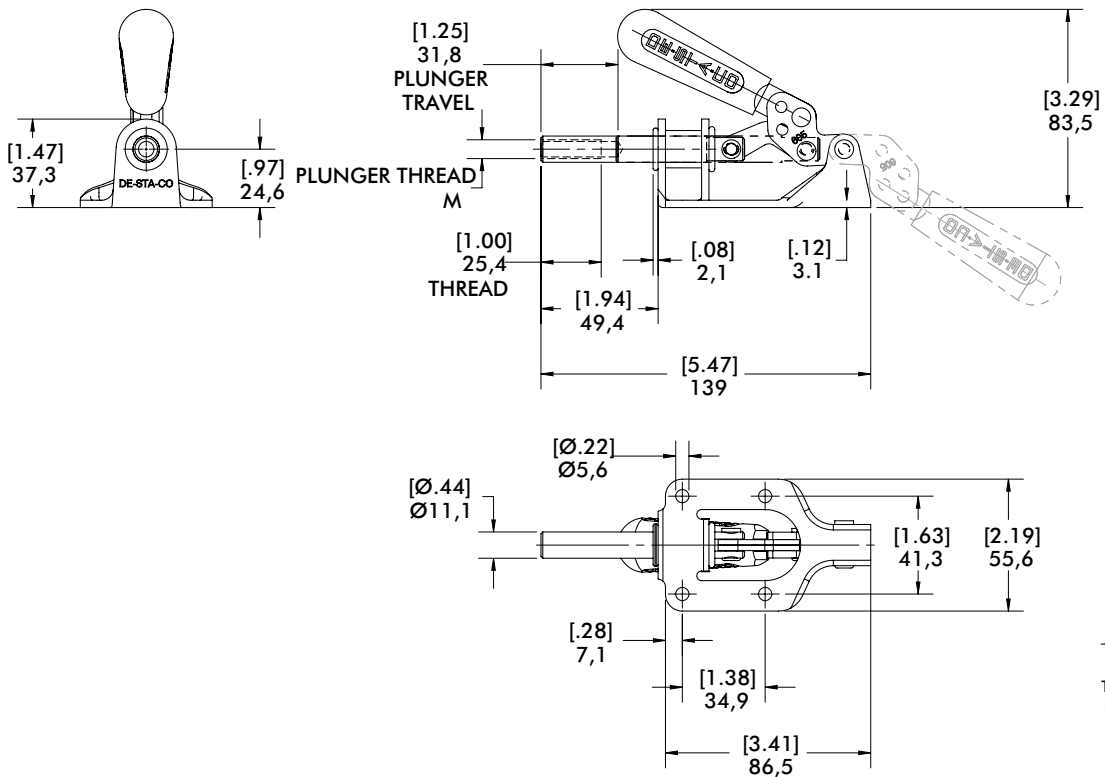


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
605	[300 lbf] 1330 N	[0.69lb] 0,31kg	45:1/40:1	[1.25] 31,8	5/16-18	207203
605-M					M8	207203-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



Features:

- Handle and linkage swivel 125° for mounting flexibility
- Narrow base for tight spaces
- Plunger locks in extended position only

Applications:

- Assembly & test
- Woodworking
- Tensioning devices

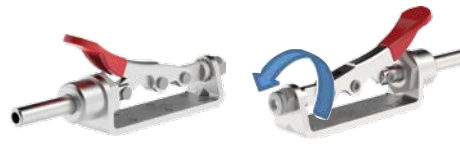
Also Available:

See page MC-ACC-1 for accessories

606
606-M



Mounting configuration:

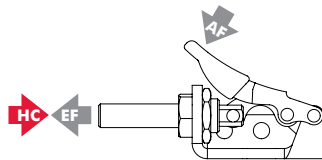


Bottom Mount



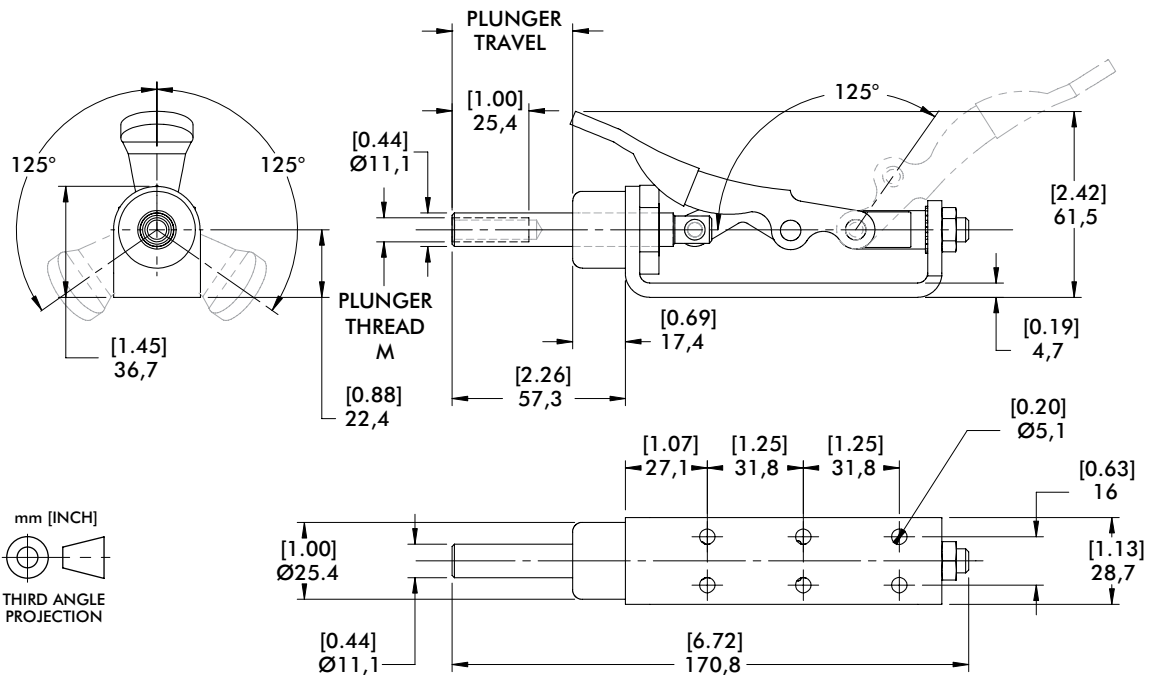
Side Mount

Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
606	[450 lbf] 2000 N	[0.81 lb] 0,37kg	33:1	40 [1.57]	5/16-18 M8	207203 207203-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



607 SERIES

Straight Line Action Clamps | Product Overview

Features:

- Low profile and high holding capacity for its size
- Available with round or square plunger to resist torsional loads
- Allow handle to rotate and fall below mounting plane to lock in retracted position

Applications:

- Assembly & test
- Welding
- Tensioning devices

Also Available:

See page MC-ACC-1 for accessories

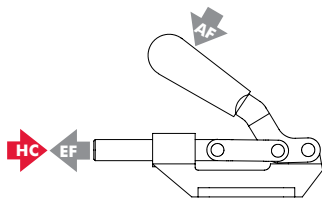
607
607-M



607-SQ
607-SQM
with Square
Plunger

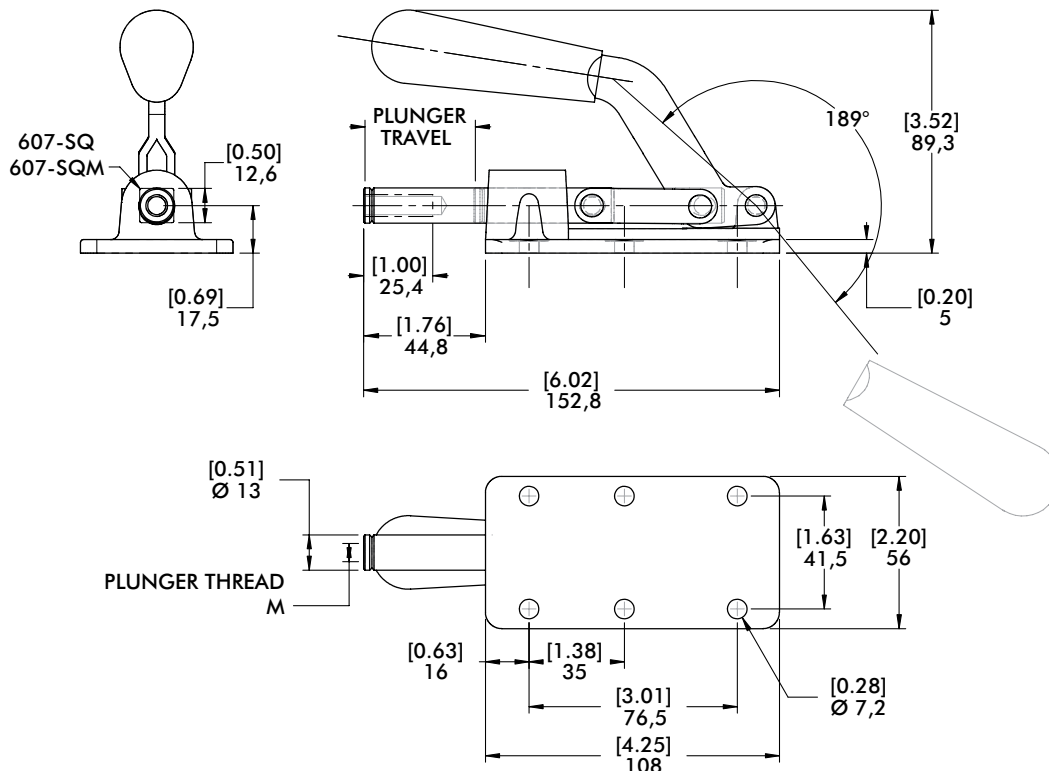


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
607					5/16-18	207203
607-M	[800 lbf] 3560 N	[1.63lb] 0,74kg	37:1/64:1	[1.63] 41,4	M8	207203-M
607-SQ					5/16-18	207203
607-SQM					M8	207203-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



Features:

- Low profile and high holding capacity for its size
- Flanged or straight base
- Allow handle to rotate and fall below mounting plane to lock in retracted position

Applications:

- Assembly & test
- Welding
- Tensioning devices

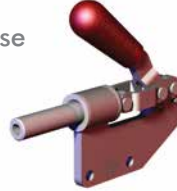
Also Available:

See page MC-ACC-1 for accessories

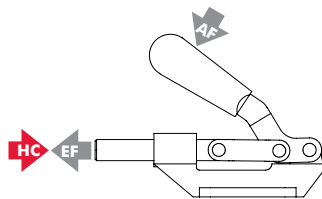
609
Flanged Base



609-B
Straight Base

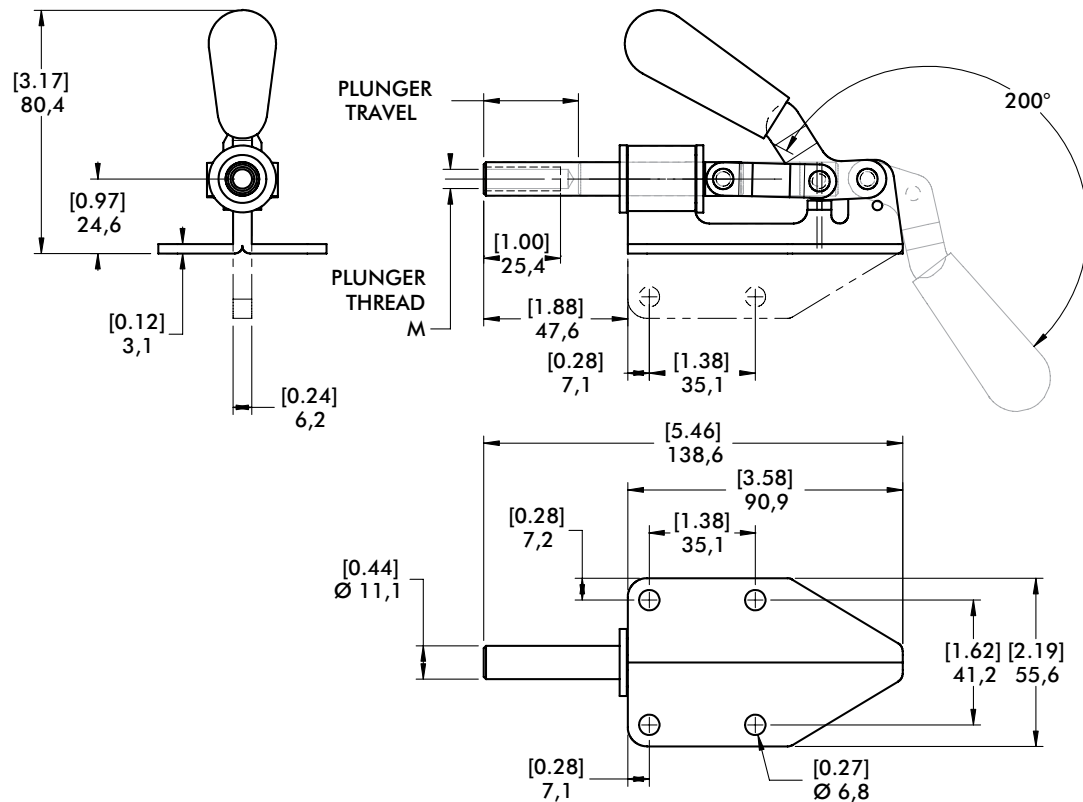


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
609	[300 lbf] 1330 N	[0.88lb] 0,40kg	36:1/47:1	[1.25] 31,8	5/16-18	207203
609-B						

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



610 SERIES

Straight Line Action Clamps | Product Overview

Features:

- For push/pull clamping
- Allow handle to rotate and fall below mounting plane to lock in retracted position

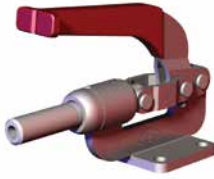
Applications:

- Assembly & test
- Woodworking
- Tensioning devices

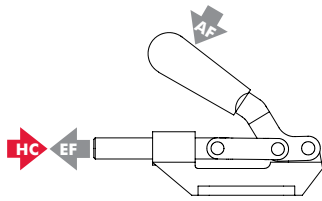
Also Available:

See page MC-ACC-1 for accessories

610
610-M

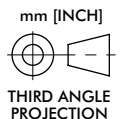
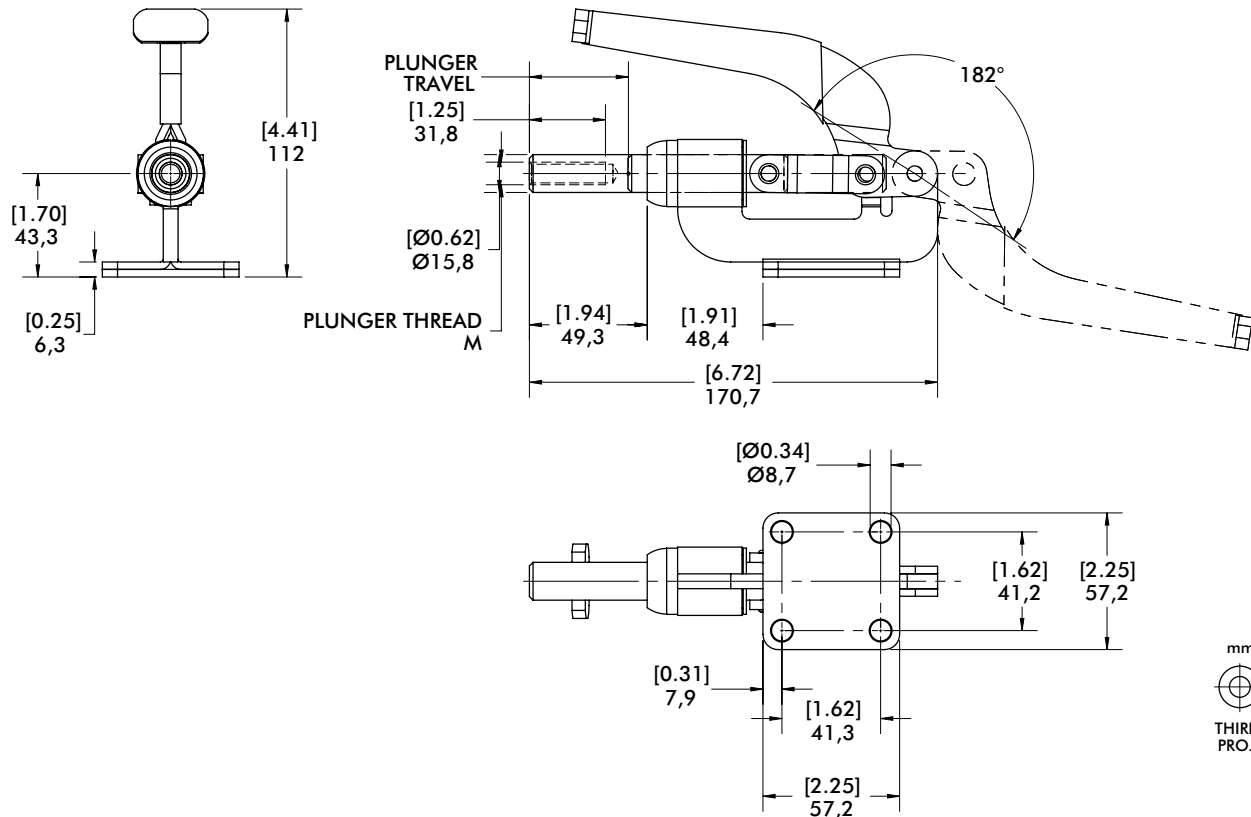


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
610	[800 lbf]	[1.69lb]	51:1/70:1	[1.63]	3/8-16	210203
610-M	3560 N	0,77kg		41,4	M10	210203-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



Features:

- Reverse handle action.
- Plunger locks in the extended position only as the handle is moved downward

Applications:

- Assembly & test
- Woodworking
- Tensioning devices

Also Available:

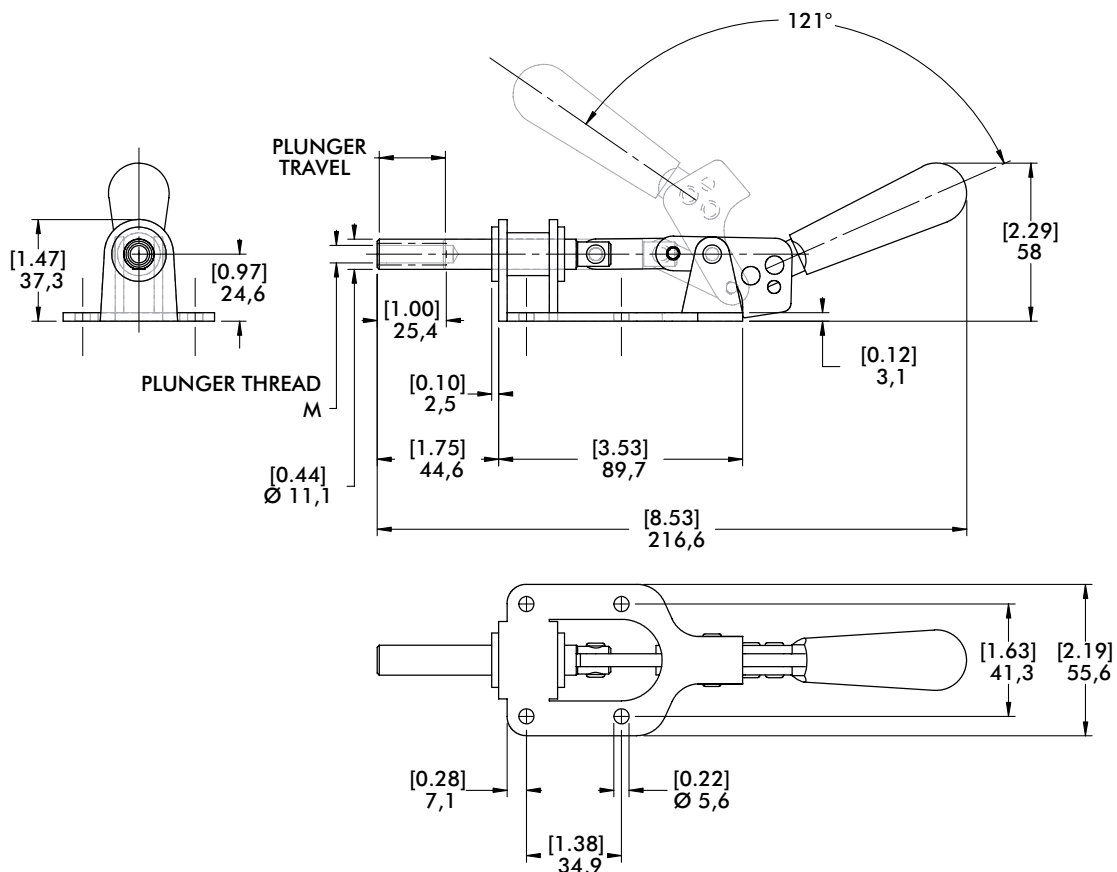
See page MC-ACC-1 for accessories

615



Technical Information | Holding Capacities | Dimensions

Model	Max. Holding Capacity	Weight	Plunger Travel (M)	Plunger Thread	Recommended Spindle (Not Supplied)
615	[300 lbf] 1330 N	[0.69lb] 0,31kg	[0.97] 24,6	5/16-18	207203



620 SERIES

Straight Line Action Clamps | Product Overview

Features:

- Reverse handle action
- Plunger locks in the extended position only as the handle is moved downward

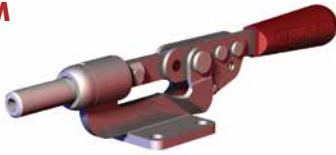
Applications:

- Assembly & test
- Woodworking
- Tensioning devices

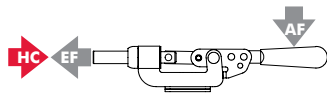
Also Available:

See page MC-ACC-1 for accessories

620
620-M

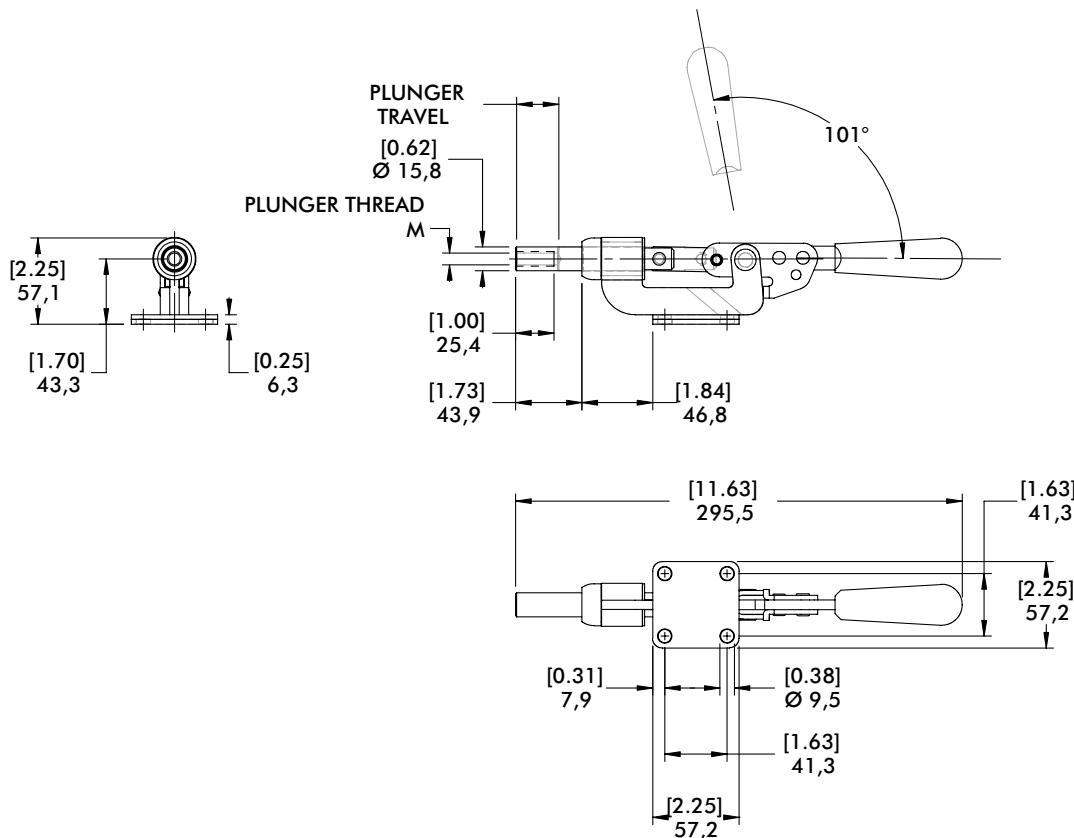


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
620	[600 lbf] 2670 N	[1.50lb] 0,68kg	44:1	[1.11] 28,2	3/8-16	210203
620-M					M10	210203-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



Features:

- For push/pull clamping
- Allow handle to rotate and fall below mounting plane to lock in retracted position
- Available with DESTACO® Toggle Lock Plus

Applications:

- Assembly & test
- Welding
- Tensioning devices

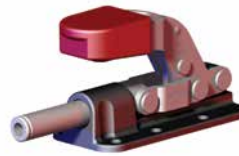
Also Available:

See page MC-ACC-1 for accessories
830, 830-ME Pneumatic Toggle Clamp
(See page MC-PTC-27)

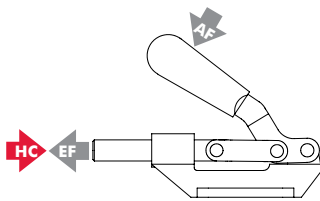
630
630-M



630-R
630-MR
with
DESTACO®
Toggle Lock
Plus

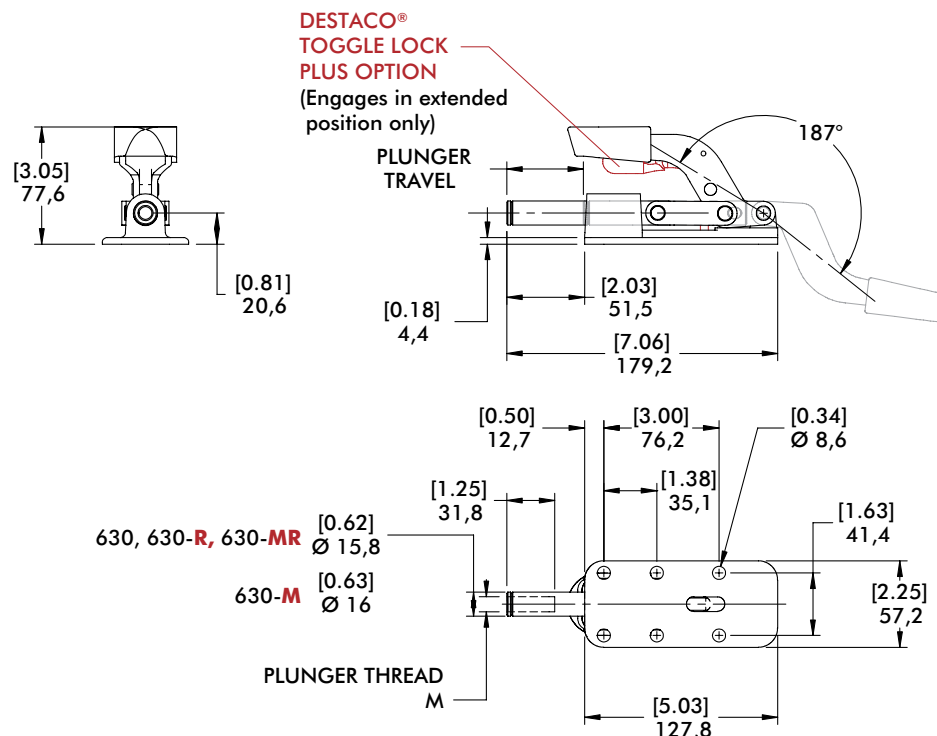


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
630					3/8-16	210203
630-M	[2,500 lbf] 11100 N	[1.90lb] 0,89kg	36:1/23:1	[2.00] 50,8	M10	210203-M
630-R					3/8-16	210203
630-MR					M10	210203-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



640 SERIES

Straight Line Action Clamps | Product Overview

Features:

- For heavy duty push/pull clamping
- Longest stroke of our Straight Line Action Clamps
- Allow handle to rotate and fall below mounting plane to lock in retracted position
- Available with DESTACO® Toggle Lock Plus

Applications:

- Assembly & test
- Welding
- Tensioning devices

Also Available:

See page MC-ACC-1 for accessories

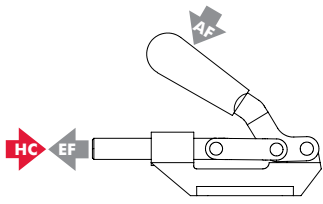
640
640-M



640-R
640-MR
with
DESTACO®
Toggle Lock
Plus

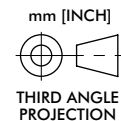
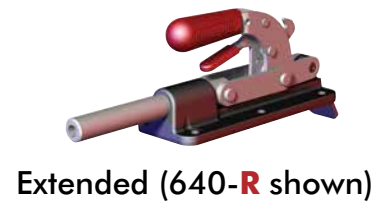
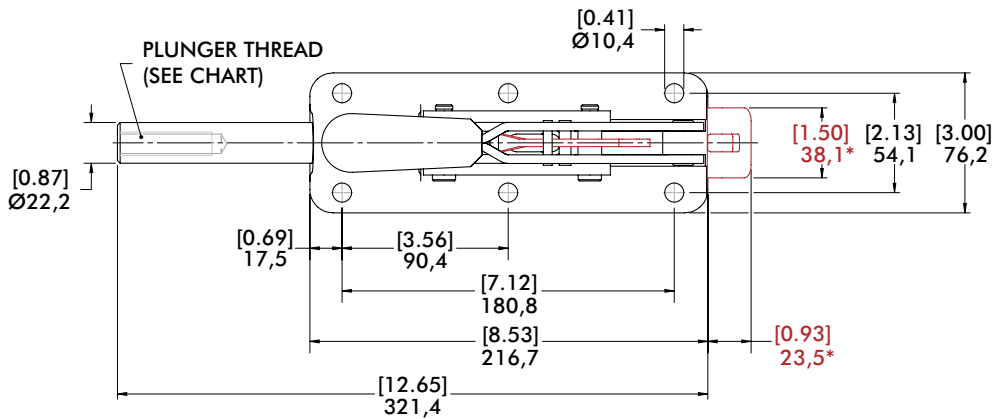


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
640					1/2-13	220203
640-M	[7,500 lbf] 33400 N	[6.78lb] 3,08kg	35:1	[4.00] 101,6	M12	220203-M
640-R					1/2-13	220203
640-MR					M12	220203-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



(* Dimensions above in RED applies to the 640-R/640-MR only

Features:

- For heavy duty push/pull clamping
- Largest of our Straight Line Action Clamps
- Forged steel base and handle
- Allow handle to rotate and fall below mounting plane to lock in retracted position

Applications:

- Assembly
- Welding
- Staking, light presswork
- Tensioning devices

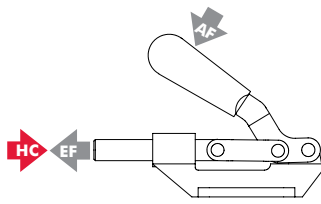
Also Available:

See page MC-ACC-1 for accessories

650
650-M

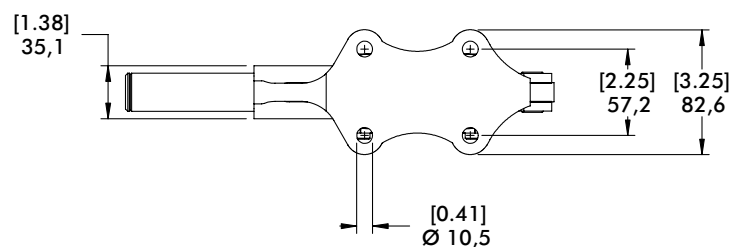
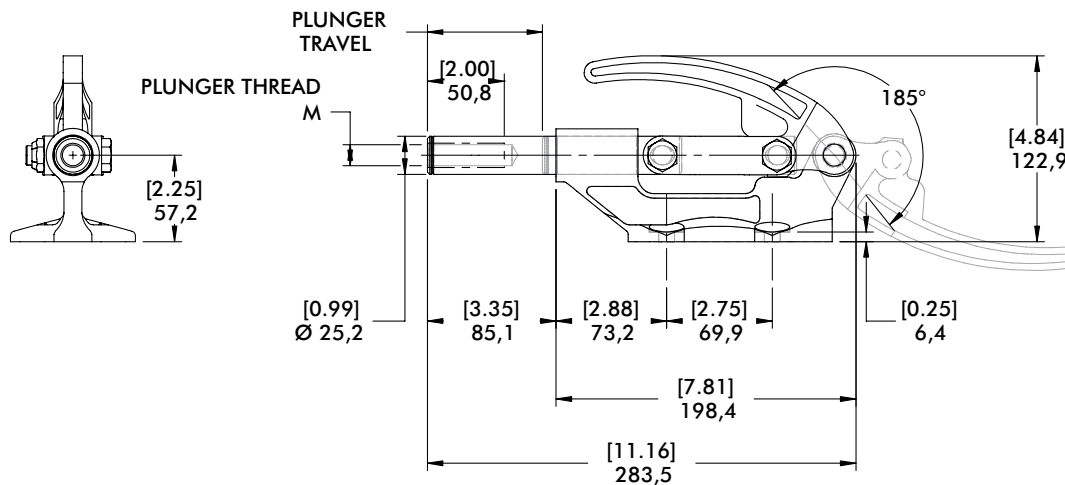


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing)	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
650	[16,000 lbf] 71200 N	[5.69lb] 2,58kg	25:1	[3.00] 76,6	5/8-11	250203
650-M					M16	250203-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



mm [INCH]
THIRD ANGLE PROJECTION

95030, 95040, 95050, 95060 SERIES

Straight Line Action Clamps | Product Overview

Features:

- Low profile with high holding capacities
- Cast steel base and handle
- Allow handle to rotate and fall below mounting plane to lock in retracted position

Applications:

- Assembly
- Testing
- Tensioning devices

Also Available:

See page MC-ACC-1 for accessories

95030

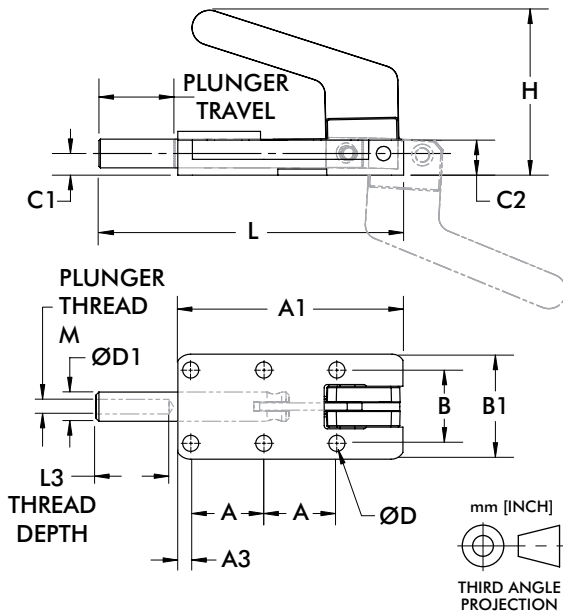
95040

95050 ⓘ

95060 ⓘ



Technical Information | Holding Capacities



Model	Max. Holding Capacity	Weight	Plunger Travel	(M) Plunger Thread	Recommended Spindle (Not Supplied)
95030	[550 lbf] 2450 N	[0.80lb] 2,58kg	[0.98] 24,9	M6	205203-M
95040	[1100 lbf] 4900 N	[1.60lb] 0,73kg	[1.50] 38,1	M8	207203-M
95050 ⓘ	[1650 lbf] 7340 N	[2.10lb] 0,95kg	[1.97] 50	M12	220203-M
95060 ⓘ	[3960 lbf] 17600 N	[6.4lb] 2,9kg	[2.36] 60		

ⓘ This item is available upon request

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force

Part No.	A	A1	A3	B	B1	C1	C2	ØD	ØD1	H	L	L3
95030	25 [0.98]	77 [3.03]	4.4 [0.17]	25 [0.98]	35.9 [1.41]	7.5 [0.30]	12.2 [0.48]	5.5 [0.22]	10 [0.39]	56 [2.20]	105 [4.13]	25 [0.98]
95040	35 [1.38]	109 [4.29]	7.9 [0.31]	35 [1.38]	50.7 [2.00]	10 [0.39]	18.3 [0.72]	6.5 [0.26]	14 [0.55]	77 [3.03]	149.1 [5.87]	65 [2.56]
95050 ⓘ	45 [1.77]	138.5 [5.45]	8.7 [0.34]	45 [1.77]	66 [2.60]	14 [0.55]	23.8 [0.94]	8.5 [0.33]	19 [0.75]	78 [3.07]	189.8 [7.47]	60 [2.36]
95060 ⓘ	56 [2.20]	167 [6.57]	10.2 [0.40]	55 [2.17]	77 [3.03]	16 [0.63]	27.4 [1.08]	10.5 [0.41]	22 [0.87]	92 [3.62]	229 [9.02]	78.8 [3.10]

ⓘ This item is available upon request

5130, 5131, 5133 SERIES

Heavy-Duty Straight Line Action Clamps | Product Overview

Features:

- Reverse action allows the handle to stay out of the work zone
- Hardened steel pivot pins and bushings provide long life
- Black oxide finish with hardened plungers
- DESTACO® Toggle Lock Plus versions available

Applications:

- Welding fixtures
- Assembly fixtures
- Light machining

5130/-M
5131/-M
5133/-M
Flanged Base

5130-B/-MB
5131-B/-MB
5133-B/-MB
Solid Base

5130-R/-MR
5131-R/-MR
5133-R/-MR
Flanged Base
with DESTACO®
Toggle Lock Plus

5130-BR①/-MBR①
5131-BR①/-MBR①
5133-BR①/-MBR①
Solid Base
with DESTACO®
Toggle Lock Plus



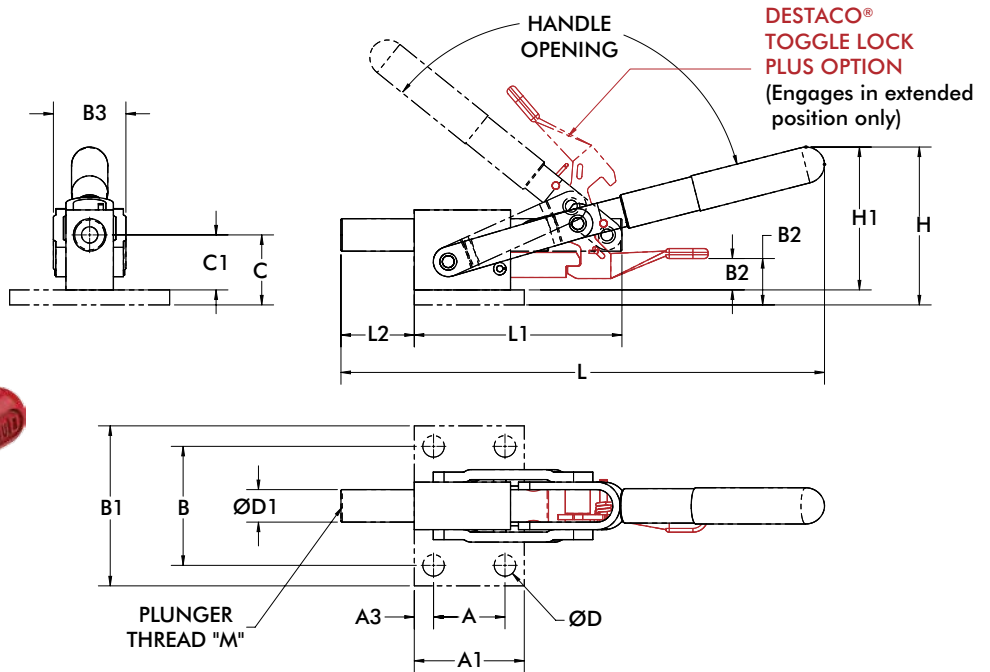
Model	Max. Holding Capacity	Weight	Plunger Travel mm[in.]	Handle Opening	Plunger Thread (M)	Recommended Spindle (not supplied)
5131	[2500lbf.] 11120N	[1.12lbs] 0,51kg	[1.00] 25,4	113°	5/16-18	461203
5131-M					M8	461203-M
5131-B		[0.85lbs] 0,39kg			5/16-18	461203
5131-MB					M8	461203-M
5131-R		[1.15lbs] 0,52kg			5/16-18	461203
5131-MR					M8	461203-M
5131-BR①		[0.88lbs] 0,40kg			5/16-18	461203
5131-MBR①		M8	461203-M			
5130	[5800lbf.] 25800N	[2.87lbs] 1,30kg	[1.75] 44,5	125°	1/2-13	325203
5130-M					M12	220203-M
5130-B		[2.40lbs] 1,09kg			1/2-13	325203
5130-MB					M12	220203-M
5130-R		[3.03lbs] 1,37kg			1/2-13	325203
5130-MR					M12	220203-M
5130-BR①		[2.56lbs] 1,16kg			1/2-13	325203
5130-MBR①		M12	220203-M			
5133	[4600lbf.] 20460N	[3.12lbs] 1,41kg	[3.13] 79,5	139°	1/2-13	325203
5133-M					M12	220203-M
5133-B		[2.65lbs] 1,20kg			1/2-13	325203
5133-MB					M12	220203-M
5133-R		[3.36lbs] 1,52kg			1/2-13	325203
5133-MR					M12	220203-M
5133-BR①		[2.89lbs] 1,31kg			1/2-13	325203
5133-MBR①		M12	220203-M			

① This item is available upon request

5130, 5131, 5133 SERIES

Heavy-Duty Straight Line Action Clamps | Dimensions

mm [INCH]
THIRD ANGLE PROJECTION



Model	A	A1	A3	B	B1	B2	B3	C	D	D1	H	L	L1	L2
5131						-								
5131-M	28.6	44	7.7	47.6	64	-	29	28	8.6	13	63.1	193.4	83	29.3
5131-R	[1.13]	[1.73]	[0.30]	[1.87]	[2.52]	18.5	[1.14]	[1.10]	[0.34]	[0.51]	[2.49]	[7.61]	[3.27]	[1.15]
5131-MR						[0.73]								
5130						-								
5130-M	44.5	64	9.8	58.7	76	-	40	35	10.5	19	92.3	283	132	49.7
5130-R	[1.75]	[2.52]	[0.38]	[2.31]	[2.99]	27.2	[1.57]	[1.38]	[0.41]	[0.75]	[3.63]	[11.14]	[5.20]	[1.96]
5130-MR						[1.07]								
5133						-								
5133-M	44.5	64	9.8	58.7	76	-	39	35	10.5	19	97.5	331.4	167	82.2
5133-R	[1.75]	[2.52]	[0.38]	[2.31]	[2.99]	31.4	[1.54]	[1.38]	[0.41]	[0.75]	[3.84]	[13.05]	[6.58]	[3.24]
5133-MR						[1.24]								

Model	B2	B3	C1	D1	H1
5131-B	-				
5131-MB	-	29	22	13	57.1
5131-BR ⓘ	12.4	[1.14]	[0.87]	[0.51]	[2.25]
5131-MBR ⓘ	[0.49]				
5130-B	-				
5130-MB	-	40	29	19	86.3
5130-BR ⓘ	21.2	[1.57]	[1.14]	[0.75]	[3.40]
5130-MBR ⓘ	[0.84]				
5133-B	-				
5133-MB	-	39	29	19	91.5
5133-BR ⓘ	25.4	[1.54]	[1.14]	[0.75]	[3.60]
5133-MBR ⓘ	[1.00]				

ⓘ This item is available upon request

5150 SERIES

Heavy-Duty Straight Line Action Clamps | Product Overview

Features:

- Square plunger provides positive radial location
- Reverse action allows the handle to stay out of the work zone
- Hardened steel pivot pins and bushings provide long life
- Black oxide finish with hardened plungers

Applications:

- Welding fixtures
- Assembly fixtures
- Light machining

5150/5150-M
Flanged Base



5150-B/5150-MB
Solid Base



5150-R/5150-MR
Flanged Base with
DESTACO®
Toggle Lock
Plus



5150-BR①/5150-MBR①
Solid Base with
DESTACO®
Toggle Lock
Plus

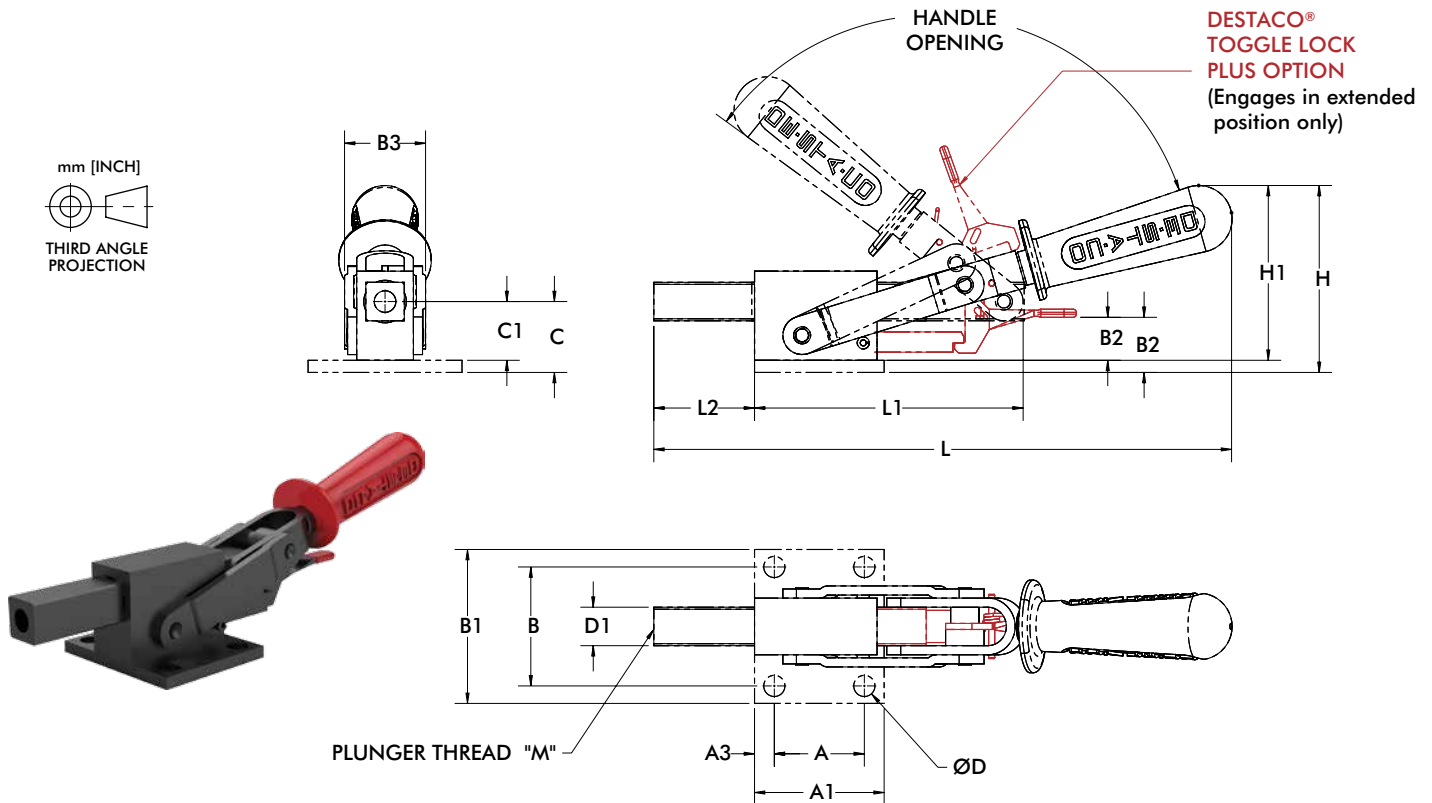


Technical Information

Model	Max. Holding Capacity	Weight	Plunger Travel mm[in.]	Handle Opening	Plunger Thread (M)	Recommended Spindle (not supplied)
5150	[5800lbf.] 25800N	[3.00lbs]	[1.91] 48.4	125°	1/2-13	325203
5150-M		1,36kg			M12	220203-M
5150-B		[2.50lbs]			1/2-13	325203
5150-MB		1,13kg			M12	220203-M
5150-R		[3.15lbs]			1/2-13	325203
5150-MR		1,43kg			M12	220203-M
5150-BR①		[2.68lbs]			1/2-13	325203
5150-MBR①		1,22kg			M12	220203-M

① This item is available upon request

Heavy-Duty Straight Line Action Clamps | Product Overview



Model	A	A1	A3	B	B1	B2	B3	C	C1	D	D1
5150	44.5	64	9.8	58.7	76			35	-	10.5	
5150-M	[1.75]	[2.52]	[0.38]	[2.31]	[2.99]			[1.57]	-	[0.41]	
5150-B	-	-	-	-	-			-	29	-	
5150-MB							40		[1.14]		19
5150-R	44.5	64	9.8	58.7	76	27.2	[1.57]	35	-	10.5	[0.75]
5150-MR	[1.75]	[2.52]	[0.38]	[2.31]	[2.99]	[1.07]		[1.57]	-	[0.41]	
5150-BR	-	-	-	-	-	21.2		-	29	-	
5150-MBR						[0.84]			[1.14]		

Model	H	H1	L	L1	L2	M
5150	92.3	-				1/2-13
5150-M	[3.63]	-				M12
5150-B	-	86.3				1/2-13
5150-MB		[3.40]	285.3	72.6	49.7	M12
5150-R	92.3	-	[11.23]	[2.86]	[1.96]	1/2-13
5150-MR	[3.63]	-				M12
5150-BR ⓘ	-	86.3				1/2-13
5150-MBR ⓘ		[3.40]				M12

ⓘ This item is available upon request

602, 604, 624 SERIES

Straight Line Action Clamps | Product Overview

Features:

- Versatile and compact straight line action clamps
- Threaded body for through hole mounting
- **-SS** models are stainless steel

Applications:

- Assembly
- Checking fixtures
- Welding fixtures
- Tensioning devices

Also Available:

See page MC-ACC-1 for accessories

602
602-**SS**
602-**MM**
602-**MMSS**



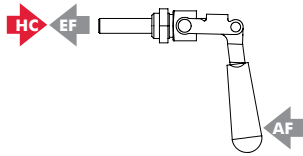
604
604-**SS**
604-**MM**
604-**MMSS** ⓘ



624
624-**SS**
624-**MM**



Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing/pulling)	Plunger Travel	(M) Plunger Thread	Spindle (Recommended)	Mounting Nut (Supplied)
602					1/4-20	205203	602105
602-SS	[200 lbf] 900 N	[0.12lb] 0,05kg	31:1/28:1	[0.75] 19	M6	202943	602905
602-MM						205203-M	602105-M
602-MMSS ⓘ						202943-M	602905-M
604	[300 lbf] 1330 N				5/16-18	207203	606104
604-SS	[400 lbf] 1780 N	[0.44lb] 0,20kg	45:1/26:1	[1.50] 38	M8	--	606904
604-MM	[300 lbf] 1330 N					207943	606104-M
604-MMSS ⓘ	[400 lbf] 1780 N					207943-M (included)	606904-M
624					3/8-16	210203	624105
624-SS	[700 lbf] 3110 N	[1.63lb] 0,74kg	49:1/21:1	[2.63] 66	M10	237943 (included)	624905
624-MM						210203-M	624105-M

ⓘ This item is available upon request **HC** = Holding Capacity, **EF** = Exerting Force, **AF** = Applied Force

602, 604, 624 SERIES

Straight Line Action Clamps | Dimensions | -SS/-MM/-MMSS

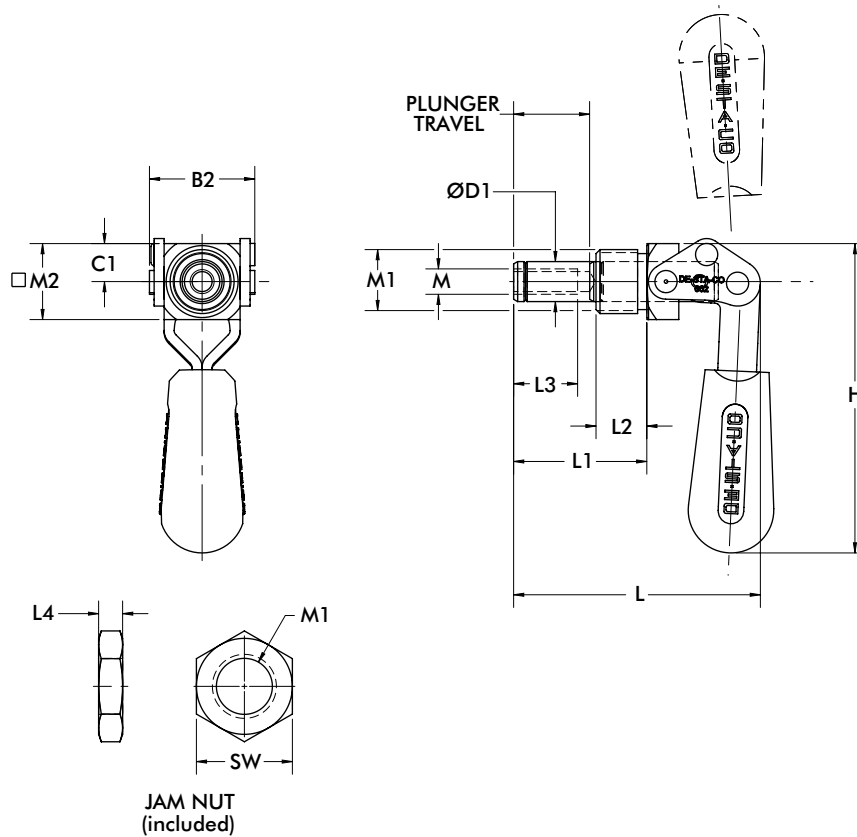
602
602-SS
602-MM
602-MMSS



604
604-SS
604-MM
604-MMSS ⓘ



624
624-SS
624-MM



Model no.	B2	C1	ØD1	H	L	L1	L2	L3	L4	M1	M2	SW
602			[0.39] 10									[0.88] 22,2
602-SS	[1.04] 26,3	[0.37] 9,5	[0.37] 9,5	[3.13] 80	[2.43] 61,7	[1.31] 33,3	[0.50] 12,7	[0.63] 16	[0.25] 6,4	5/8-18	[0.75] 19	[0.87] 22
602-MM			[0.39] 10							M16x1.5		
602-MMSS												
604												
604-SS	[1.30] 33	[0.44] 11	[0.44] 11	[4.16] 106	[4.27] 108,5	[2.18] 55	[0.63] 16	[1.00] 25		3/4-16	[0.88] 22	[1.00] 25,4
604-MM										M20x1.5		[1.18] 30
604-MMSS									[0.25] 6			
624												
624-SS	[1.81] 46	[0.75] 19	[0.62] 16	[5.60] 142	[6.68] 170	[3.62] 92	[0.88] 22	[1.25] 32		1-14	[1.25] 32	[1.50] 38,1
624-MM										M27x2		[1.61] 41

6004 SERIES

Straight Line Action Clamps | Product Overview

Features:

- Similar in size to Model 604, with a solid body
- 50% more holding capacity than 604
- May be mounted through a hole or in a tapped hole.
- Locks over center in the extended and retracted position

Applications:

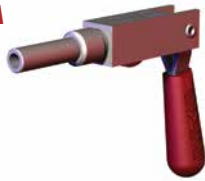
- Assembly
- Checking fixtures
- Welding fixtures
- Tensioning devices

Also Available:

See page MC-ACC-1 for accessories

Covered under one or more U.S./International Patents

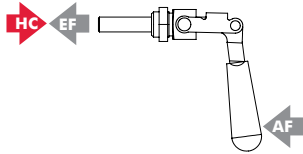
6004
6004-MM



6004-R
6004-MMR
with
DESTACO®
Toggle Lock
Plus

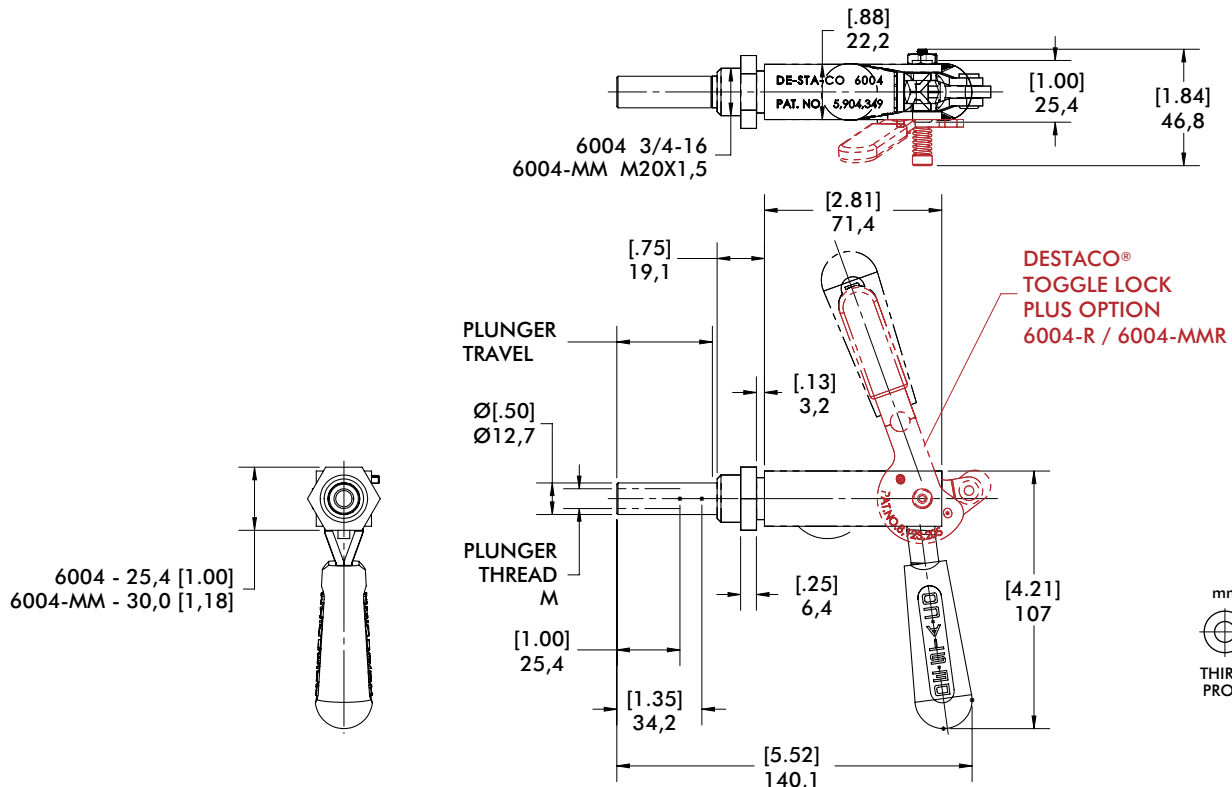


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF (pushing)	Plunger Travel	(M) Plunger Thread	Spindle (Recommended)	Mounting Nut (Supplied)
6004	[450 lbf] 2000 N	[0.81lb] 0,37kg	14.4:1	38 [1.50]	5/16-18	207203	606104
6004-MM		[0.89lb] 0,40kg			M8	207203-M	606104-M
6004-R	[450 lbf] 2000 N	[0.81lb] 0,37kg	14.4:1	38 [1.50]	5/16-18	207203	606104
6004-MMR		[0.89lb] 0,40kg			M8	207203-M	606104-M

HC = Holding Capacity, EF = Exerting Force, AF = Applied Force



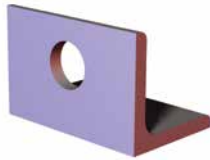
602, 604, 624, 6004 SERIES

Straight Line Action Clamps | Mounting Plates

Features:

- Mounting accessories for Threaded Body Straight Line Action Clamps

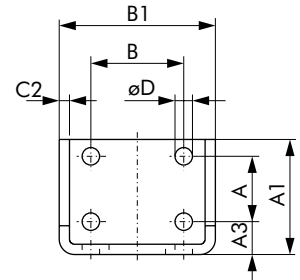
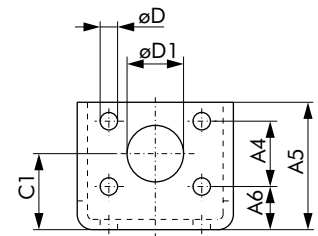
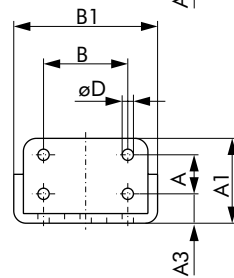
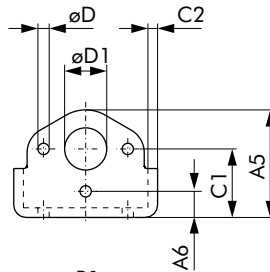
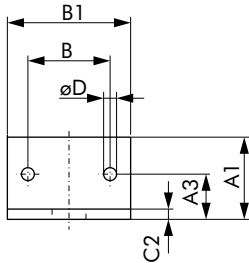
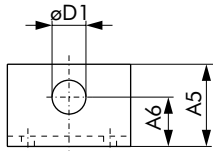
602106-M



604106,
604106-M



624106-M



Item Number	For Use With	A	A1	A3	A4	A5	A6	B	B1	C1	C2	D	D1
602106-M	602 602-MM	--	[1.57] 40	[0.87] 22	--	[1.57] 40	[0.94] 24	[1.57] 40	[2.36] 60	--	[0.20] 5	[0.25] 6,3	[0.65] 16,5
604106	604 6004	[0.75] 19,1	[1.60] 40,6	[0.55] 14	--	[2.05] 52,1	[0.50] 12,7	[1.62] 41,1	[2.80] 71,1	[1.30] 33	[0.19] 4,7	[0.22] 5,6	[0.75] 19,1
604106-M	604-MM 6004-MM												[0.81] 20,5
624106-M	624 624-MM	[1.25] 31,8	[2.20] 56	[0.63] 16	[1.25] 31,8	[2.44] 62	[0.83] 21	[1.78] 45,2	[2.99] 76	[1.46] 37	[0.20] 5	[0.33] 8,5	[1.08] 27,5

614 SERIES

Straight Line Action Clamps | Product Overview

Features:

- Single hole threaded mount or side mount
- Precision hardened and ground plunger is designed for anti-rotation under torsional loads
- Locks in the extended or retracted position, internal locking in the push direction

Applications:

- Assembly
- Checking fixtures
- Locaters and positioners

Also Available:

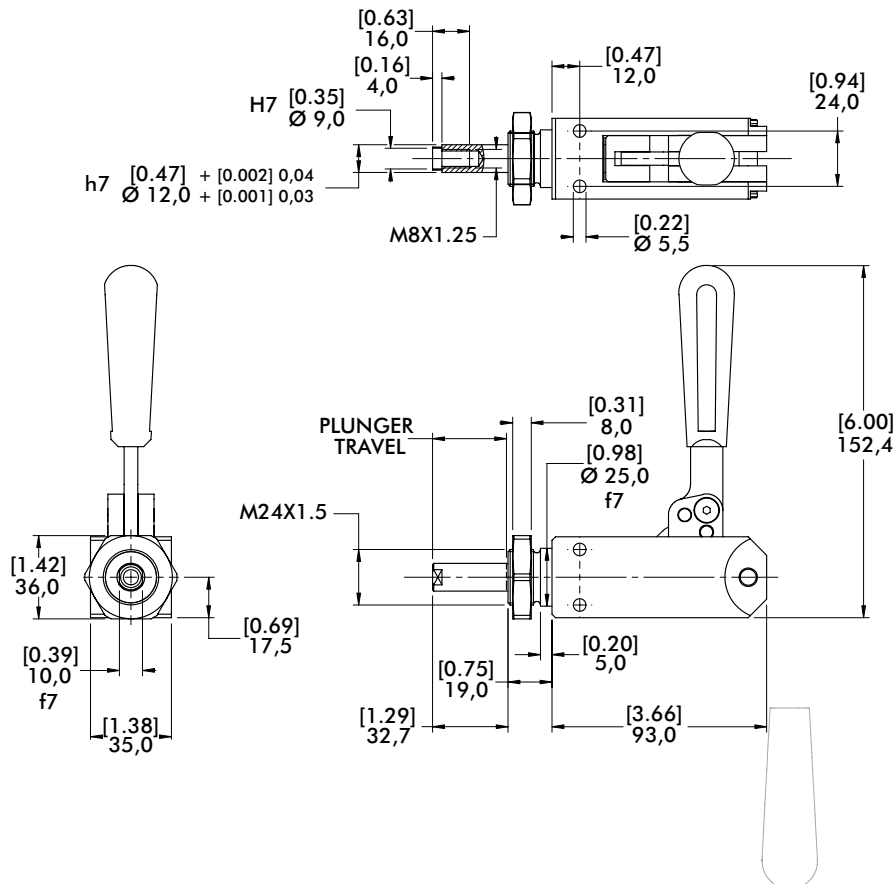
See page MC-ACC-1 for accessories

614-M



Technical Information | Holding Capacities | Dimensions

Model	Max. Holding Capacity	Weight	Plunger Travel	Plunger Thread	Mounting Nut (Supplied)
614-M	[1125 lbf] 5000 N	[1.81lb] 0,82kg	[1.26] 32	M8	614-1-10



mm [INCH]
THIRD ANGLE PROJECTION

670, 675, 690, 695 SERIES

Straight Line Action Clamps | Product Overview

Features:

- Precision clamping for high production
- Adjustable collet-type bushing minimizes radial plunger movement
- Plunger has a flat surface for anti rotation
- Pre-load nut and hold open device included

Applications:

- Assembly
- Welding

670-1MBPLS



675-1MBPLS



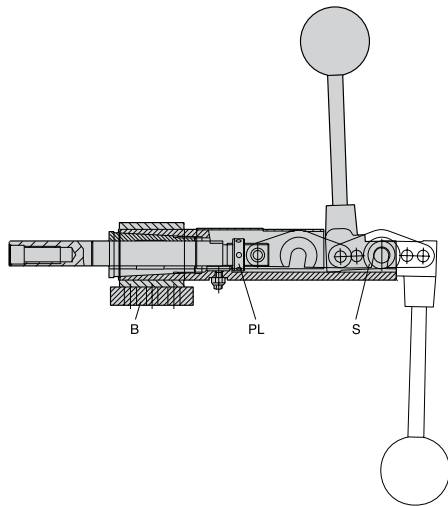
690-1MBPLS



695-1MBPLS ⓘ



Series 670, 675, 690, 695 Technical Information | Holding Capacities



Model	Max. Holding Capacity	Weight	Plunger Travel	Plunger Thread
670-1MBPLS	[2400 lbf] 10680 N	[4.2lb] 1,91 kg	[2.25] 57,2	M12
675-1MBPLS		[4.0lb] 1,81 kg	[1.10] 28	
690-1MBPLS	[5000 lbf] 22240 N	[8.2lb] 3,72 kg	[3.00] 76,2	M16
695-1MBPLS ⓘ		[7.2lb] 3,27 kg	[1.50] 38,1	

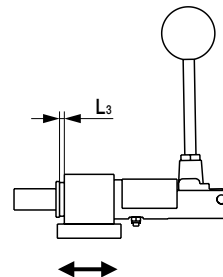
ⓘ This item is available upon request

The unique feature of these clamps is the collet-type bushing that can be adjusted to eliminate plunger end movement after long repeated use. The plunger also has a flat which prevents lateral movement and allows offset piloting and holding. The plunger is drilled and tapped for threaded spindles or custom fixturing.

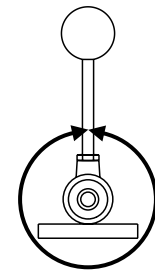
The adjustable pre-load nut (PL) can be used to lock the clamp against itself when not under pressure and therefore prevent opening when mounted vertically. The spring hold-open device (S) prevents the clamp from accidentally closing.

The mounting base (B) is supplied disassembled with the four models, to enable welding the base and the main assembly in any handle position.

Series 675 and 695 (shorter stroke) reach the over-center position only when clamping. Series 670 and 690 (longer stroke) lock in both the extended and retracted position.



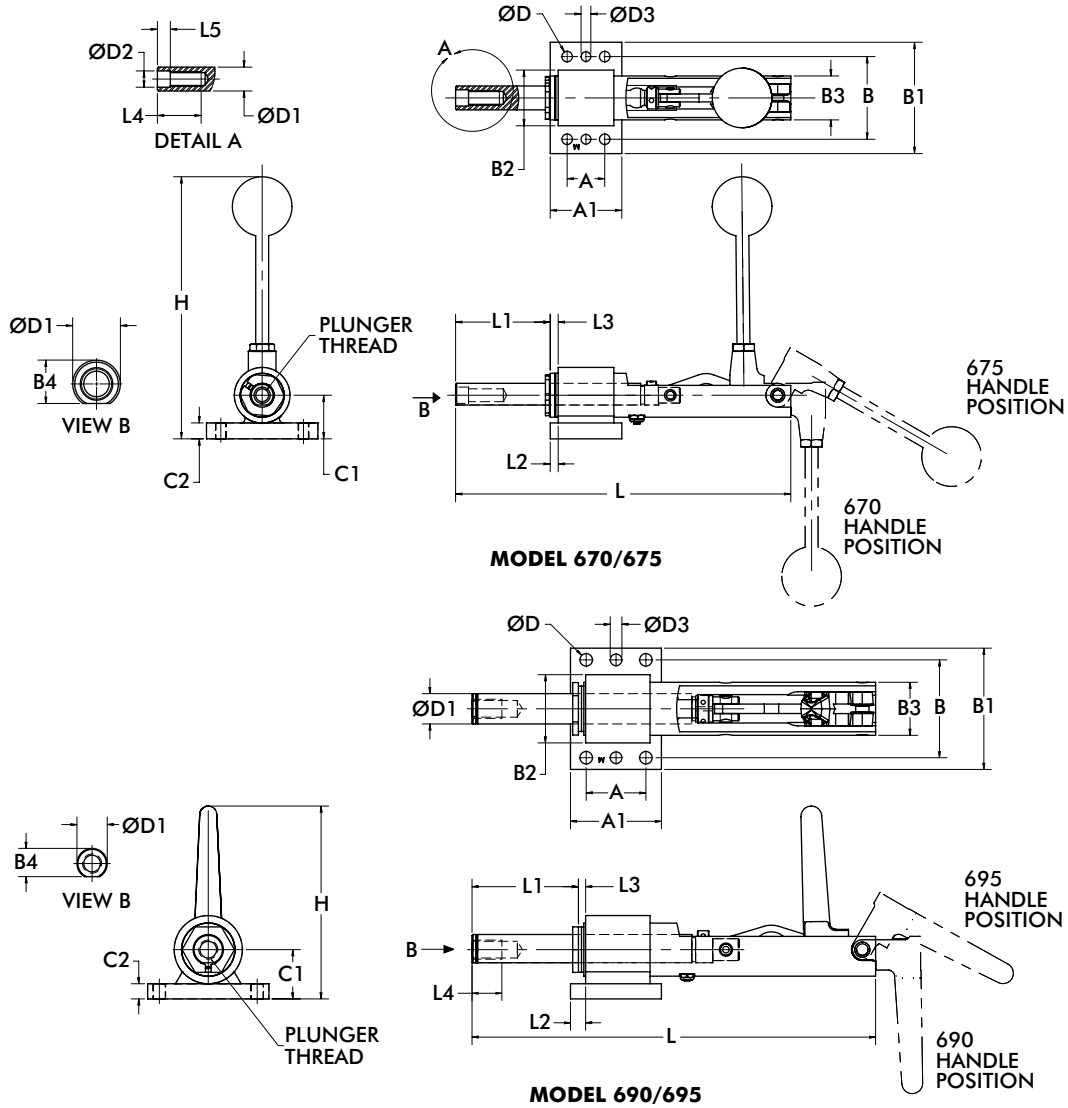
Welding range L_3 axial
0-8mm [0-0.31in.]



Welding range radial 360°

670, 675, 690, 695 SERIES

Straight Line Action Clamps | Dimensions



Model	A	A1	B	B1	B2	B3	B4	C1	C2	D	D1	D2H7	D3
670-1MBPLS	[1.18]	[2.24]	[2.60]	[3.50]	[1.75]	[1.38]	[0.68]	[1.37]	[0.50]	[0.33]	[0.75]	[0.51]	[0.31]
675-1MBPLS	30	57	66	89	44,5	35	17,3	34,8	12,7	8,4	19	13	7,8
690-1MBPLS	[1.97]	[3.00]	[3.23]	[4.00]	[2.25]	[1.75]	[0.93]	[1.63]	[0.50]	[0.41]	[1.00]	--	[0.39]
695-1MBPLS	50	76,2	82	101,6	57,2	44,4	23,7	41,3	12,7	10,5	25,4	--	9,8

Model	H	L	L1	L2	L3	L4	L5
670-1MBPLS	[8.11]	[10.55]	[2.97]	[0.25]	[0-0.31]	[1.38]	[0.41]
675-1MBPLS	206	[7.68]	[1.74]	6,4	0-8	35	10,3
690-1MBPLS	[6.37]	[13.31]	[3.69]	[0.50]	[0-0.31]	[0.98]	--
695-1MBPLS	162	[9.45]	[2.25]	12,7	0-8	25	--

FO, FL, G SERIES

Variable Stroke Straight Line Action Clamps | Product Overview

FO Series

Type of Mounting:

- Foot mount

Type of Actuation:

- Hand wheel or hand lever (one-handed operation)
- Locking lever and Plunger (two-handed operation)



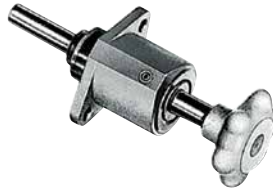
FL Series

Type of Mounting:

- Flange mount

Type of Actuation:

- Locking lever or hand wheel (one-handed operation)
- Locking lever and Plunger (two-handed operation)



G Series

Type of Mounting:


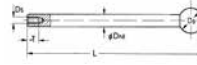


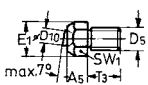

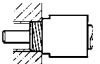

- Through hole mount

Type of Actuation:

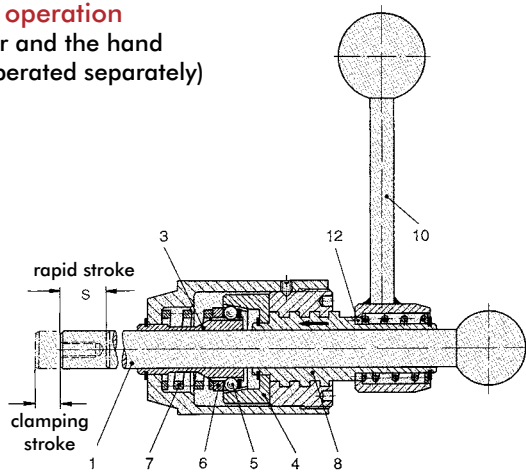
- Locking lever and Plunger (two-handed operation)
- Hand wheel or hand lever (one-handed operation)



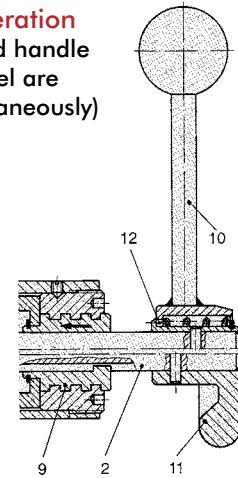
Technical Information

		Model	Holding Capacity Max. [lbs] N	Page MC-VSC-#	Accessories	Model	Page MC-VSC-#			
Flanged base		FO-082-40 FO-120 FO-121-45 FO-122-45	[335] 1500 [675] 3000 [675] 3000 [675] 3000	3	Plunger		4			
		FO-160 FO-161-60 FO-162-60 FO-220 FO-221-80	[2020] 9000 [2020] 9000 [2020] 9000 [4045] 18000 [4045] 18000					12/100 12/200 12/300 16/100 16/200 16/300 16/400 16/500 22/100 22/200 22/300		
Front flange		FL-120 FL-121-45 FL-122-45	[675] 3000		3			Swivel thrust pad		7
		FL-160 FL-161-60 FL-162-60	[2020] 9000							
Threaded mount		G-082-40 G-120	[335] 1500 [675] 3000		3					
		G-121-45 G-122-45	[675] 3000							
		Model	Holding Capacity Max. [lbs] N		Page MC-VSC-#					
		F-160	[4,040] 18000		3					

Two-hand operation
(the plunger and the hand lever are operated separately)



One-hand operation
(the plunger and handle lever/hand wheel are operated simultaneously)



DESTACO's variable stroke Straight Line clamps are used in applications where workpiece thicknesses and workpiece tolerances vary. These clamps are suitable for clamping between ribs and hollow spaces difficult to reach.

Compact design and different types of operation allow for application of the Straight Line clamps in fixtures for mass production as well as for single part production.

Mounting types

- Foot base (FO Series)
- Flange mount (FL Series)
- Through hole mount (G Series)

Type of operation

- Two hand operation
- The hand lever (10) and the plunger (1) are separate. The hand lever is connected to the clamping mechanism. The plunger can be removed from the clamp
- One-hand operation
- The hand lever (10) or the hand wheel (11) and the plunger (2) are linked. The plunger is retained within the clamp.

Clamping operation

The plunger (1) or (2) which is guided within the clamp body contacts the workpiece. By rotating the hand lever (10) or the hand wheel (11) clock-wise the clamping stroke, S_1 is engaged and the plunger is tightly gripped by the slotted clamping sleeve (3).

Operating principle

The hand lever's (10) clock-wise rotation causes the threaded sleeve (8) and the conical sleeve (4) to which it is connected to move in the direction of the arrow shown in the drawing. The conical sleeve produces a force-locking connection between the slotted clamping sleeve (3) and the plunger by means of the ball bearings (5) located at the clamping sleeve's perimeter.

Due to the force-locking connection, the plunger rotates and produces the clamping stroke S_1 . The plungers rotation may be compensated for by means of a swivel hold-down piece.

The clamping strokes S_1 specified in this catalog were measured with no opposing forces present while measurements were taken. When clamping this product against a workpiece, the clamping stroke S_1 is reduced by the force-locking connection between the plunger and the workpiece. The straight-action clamp is unlocked by turning the hand lever or the hand wheel counter-clockwise. This method is used for both the one-hand and the two-hand operation types. This counter-clockwise rotation makes the conical sleeve (4) and the threaded sleeve (8) or (9) move backward. The pressure spring (7) pushes back the relieved ball bearings (5) via the pressure ring (6).

The force-locking connection between the slotted clamping sleeve and the plunger can be moved freely again. Straight Line clamps which are two-hand operated can also be applied to pull actions when the plunger is inserted in the clamp's housing in the opposite direction. On the one hand operated clamp, the rotation inducing the clamping stroke S_1 is directly transmitted from the plunger (2) or the hand wheel to the threaded sleeve (9) via a groove/spring connection. The clamping and unclamping operations are executed in the same way as described before.

Handling

To change the position of the handle while in the clamped or the unclamped position, pull the hand lever off its spline (12) and set it in the desired position.

Important

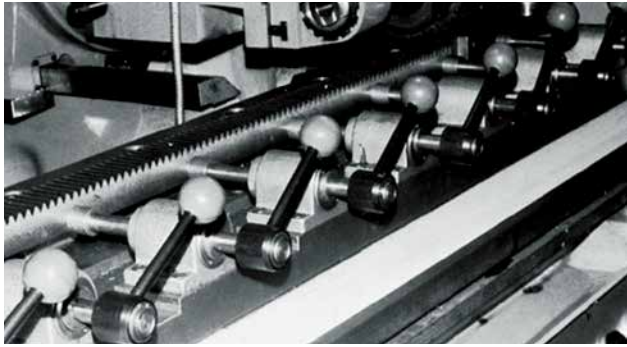
The holding forces specified in the catalog refer to the maximum load exerted on the clamp by counter-forces. For details concerning the clamping force F_S exerted on the workpiece by the clamp and depending on the operation force F_B (manual force), please see the chart on the next page.

The clamping force is proportional to the operation force. The achieved clamping force must not exceed the maximum holding force.

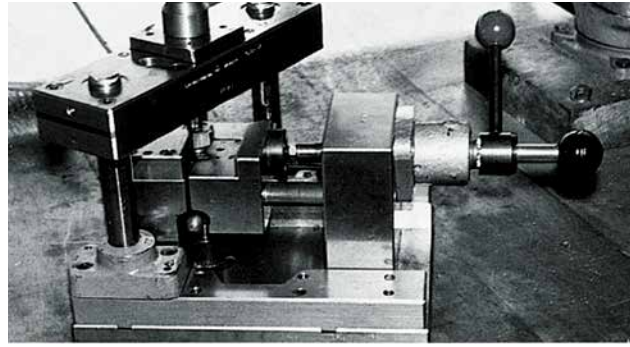
As the Straight Line clamps, with the exception of the F-160 model, are designed only for axial load, we recommend to use an additional radial support for the plunger in the event of side load.

FO, FL, G SERIES

Variable Stroke Straight Line Action Clamps | Technical Information



Model FO-161/60 on a milling machine



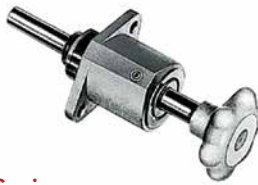
Model FL-160 with plunger 16/100 on a punching fixture

Different Designs



FO Series

Mounting type: flange base foot mount
Operating method: one-hand or two-hand operation













FL Series

Mounting type: front flange mount
Operating method: one-hand or two-hand operation



G Series

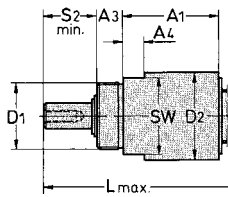
Mounting type: through hole mount
Operating method: one-hand or two-hand operation

Mounting type	Operating method			Model	Max. holding capacity [lbs.] N	Clamping force F_s with an operating force F_B		Rapid stroke S [mm]	Max. clamping stroke S1 [mm]	Weight	
	Two-hand operation Plunger and hand lever	One-hand operation Hand lever	One-hand operation Hand wheel			FB [lbs.] N	FS [lbs.] N			[lbs]	Kg
Foot mount 		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	FO-082-40	[335] 1500	[22] 100	[100] 450	40	2,5	[0.72] 0,325
		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	FO-120 ¹⁾	[675] 3000		[425] 1900	100, 200, 300	3	[1.19] 0,540
		<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	FO-121-45	[675] 3000		[425] 1900	45	3	[1.47] 0,665
		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	FO-122-45	[675] 3000		[100] 450	40	3	[1.34] 0,610
		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	FO-160 ¹⁾	[2020] 9000		[560] 2500	100, 200, 300	4	[2.73] 1,240
		<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	FO-161-60	[2020] 9000		[560] 2500	60	4	[3.40] 1,540
Flange mount 		<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	FO-162-60	[2020] 9000	[190] 850	60	4	[3.15] 1,430	
		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	FO-220 ¹⁾	[4045] 18000	[675] 3000	100, 200, 300	4	[5.85] 2,655	
		<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	FO-221-80	[4045] 18000	[675] 3000	80	4	[7.46] 3,385	
		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	FL-120 ¹⁾	[675] 3000	[425] 1900	100, 200, 300	3	[1.07] 0,485	
		<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	FL-121-45	[675] 3000	[425] 1900	45	3	[1.34] 0,610	
		<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	FL-122-45	[675] 3000	[100] 450	40	3	[1.21] 0,550	
Through hole mount 		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	FL-160 ¹⁾	[2020] 9000	[560] 2500	100, 200, 300	4	[2.49] 1,130	
		<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	FL-161-60	[2020] 9000	[560] 2500	60	4	[3.15] 1,430	
		<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	FL-162-60	[2020] 9000	[190] 850	60	4	[2.92] 1,325	
		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	G-082-40	[335] 1500	[100] 450	40	2,5	[0.66] 0,300	
Through hole mount 		<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	G-120 ¹⁾	[675] 3000	[425] 1900	100, 200, 300	3	[1.01] 0,470	
		<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	G-121-45	[675] 3000	[425] 1900	45	3	[1.31] 0,595	
		<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	G-122-45	[675] 3000	[100] 450	40	3	[1.18] 0,335	
		<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>							

Variable Stroke Straight Line Action Clamps | Technical Information | Dimensions

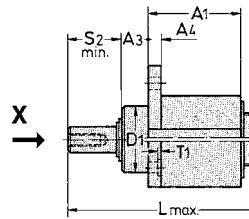
Two-hand operation (the plunger and the hand lever are operated separately)

Through hole mount

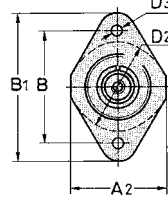


Part no. G-121/45

Flange mount

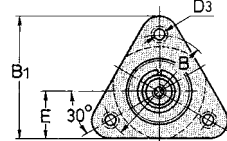


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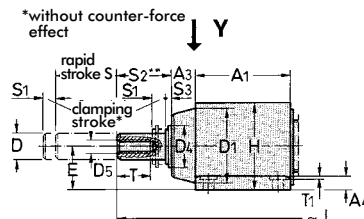
Part no. FL-120/--

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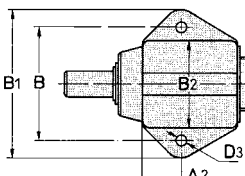


Part no. FL-160/--

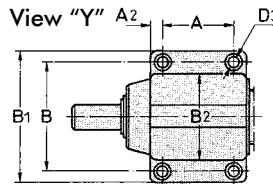
Foot mount



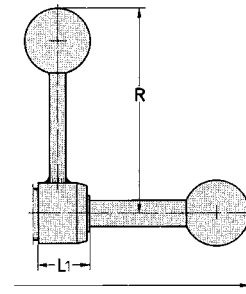
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Part no. FO-120/--



Part no. FO-160/--
FO-220/--



Accessories

(order separately)

Plunger



Part no. Ø length	For rapid stroke S	Weight ~ [lbs.] kg	For clamps
12/100	100	[0.30] 0,135	FO-120
12/200	200	[0.62] 0,280	FL-120
12/300	300	[0.82] 0,370	G-120
16/100	100	[0.88] 0,400	FO-160
16/200	200	[1.10] 0,500	FL-160
16/300*	300	[1.54] 0,700	
22/100	100	[2.20] 1,000	
22/200	200	[2.40] 1,090	FO-220
22/300	300	[3.06] 1,390	

*400 and 500 mm lengths available upon request.

Important
The Straight Line clamps are designed only for **axial load**. In case of side load, we recommend an additional radial support of the plunger.

Mounting type	Part no. without plunger	Available rapid strokes S (order plunger separately)	A	A1	A2	A3	A4	A8	B	B1	B2	Dh8	D1	D2	D3	D4
Foot mount	FO-120	100, 200, 300	-	44	19	12	6,3	8,5	52	68	40	12	35	-	6,5	20
	FO-160	100, 200, 300	40	62	11	12	12	10	70	90	52	16	46	-	9	25
	FO-220	100, 200, 300	50	75	13	20	15	12	90	115	69	22	60	-	11	36
Flange mount	FL-120	100, 200, 300	-	44	44	12	6	8,5	52	68	-	12	30f7	40	6,5	20
	FL-160	100, 200, 300	-	60	-	14	14	10	68	73	-	16	40f7	52	9	25
Through hole mount	G-120	100, 200, 300	-	44	-	12	10	8.5	-	-	-	12	M30 x1,5	40	-	20

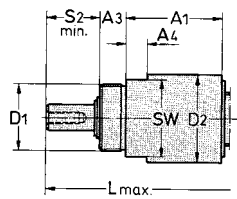
Mounting type	Part no. without plunger	D5	D6	E	E1	H	~ L L with rapid strokes:			L1	R	S2	S3	SW	SW1	T	T1	T3
							100	200	300									
Foot mount	FO-120	M6	30	20	12,5	42	228	328	428	24	95	2,5	2,5	-	11	12	-	10
	FO-160	M8	35	30	14,8	58	280	380	480	33	130	3	3	-	13	15	1	14
	FO-220	M12	40	35	19,5	71	295	395	495	35	197	3	3	-	17	25	1	18
Flange mount	FL-120	M6	30	-	12,5	-	228	328	428	24	95	2,5	2,5	-	11	12	-	10
	FL-160	M8	35	28	14,8	-	280	380	480	33	130	3	3	-	13	15	1	14
Through hole mount	G-120	M6	30	-	12,5	-	228	328	428	24	95	2,5	2,5	35	11	12	-	12

FO, FL, G SERIES

Variable Stroke Straight Line Action Clamps | Technical Information | Dimensions

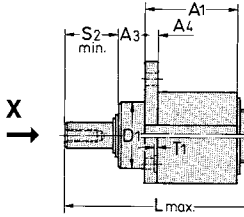
One-hand operation (the plunger and the hand wheel are operated simultaneously)

Through hole mount

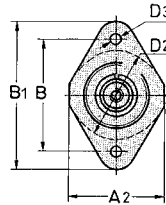


Part no. G-082/40
G-122/45

Flange mount

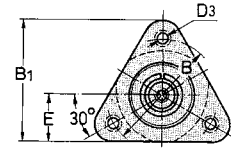


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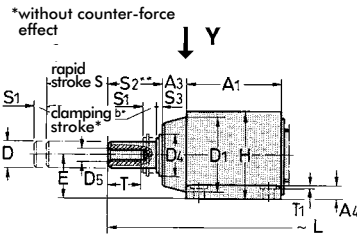
Part no. FL-122/45

View "X"

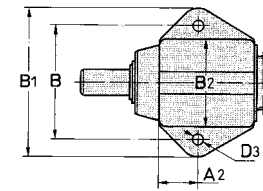


Part no. FL-162/60

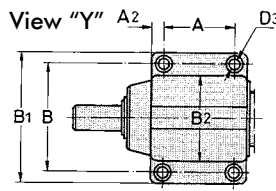
Foot mount



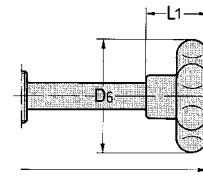
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Part no. FO-082/40
FO-122/45



Part no. FO-162/60



Important

The Straight Line clamps are designed only for **axial load**. In case of side load, we recommend an additional radial support of the plunger.

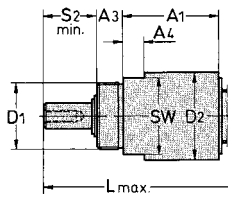
Mounting type	Part no. with plunger	A	A ₁	A ₂	A ₃	A ₄	A ₅	B	B ₁	B ₂	D _{h8}	D ₁	D ₂	D ₃	D ₄
Foot mount	FO-082-40	-	37	15,3	10	5	6	44	56	35	8	30	-	4,5	16
	FO-122-45	-	44	19	12	6,3	8,5	52	68	40	12	35	-	6,5	20
	FO-162-60	40	62	11	12	12	10	70	90	52	16	46	-	9	25
Flange mount	FL-122-45	-	44	44	12	6	85	52	68	-	12	30f7	40	6,5	20
	FL-162-60	-	60	-	14	14	10	68	73	-	16	40f7	52	9	25
Through hole mount	G-082-40	-	37	-	10	8	6	-	-	-	8	M24x1,5	35	-	16
	G-122-45	-	44	-	12	10	8,5	-	-	-	12	M30x1,5	40	-	20

Mounting type	Part no. with plunger	D ₅	D ₆	E	E ₁	H	L	L ₁	S ₂	S ₃	SW	SW ₁	T	T ₁	T ₃
Foot mount	FO-082-40	M5	40	18	9,2	36	128	26	9	2,5	-	8	8	-	8
	FO-122-45	M6	75	20	12,5	42	153	27	15	2,5	-	11	12	-	10
	FO-162-60	M8	75	30	14,8	58	196	35	18	3	-	13	15	1	14
Flange mount	FL-122-45	M6	52	-	12,5	-	153	27	15	2,5	-	11	12	-	10
	FL-162-60	M8	75	28	14,8	-	196	35	18	3	-	13	15	1	14
Through hole mount	G-082-40	M5	40	-	9,2	-	128	26	9	2,5	30	8	12	-	8
	G-122-45	M6	52	-	12,5	-	153	27	15	2,5	35	11	12	-	10

Variable Stroke Straight Line Action Clamps | Technical Information | Dimensions

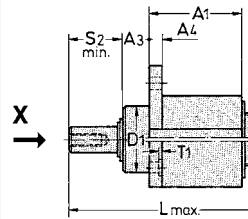
One-hand operation (the plunger and the hand lever are operated simultaneously)

Through hole mount

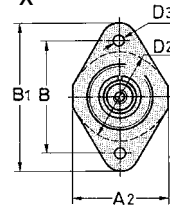


Part no. G-121/45

Flange mount

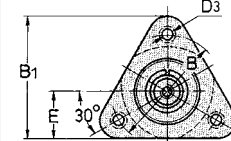


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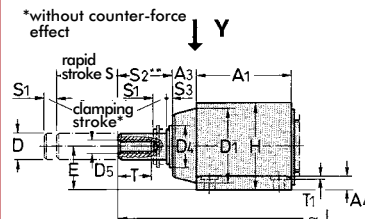
Part no. FL-121/45

View "X"

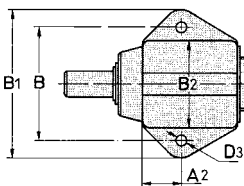


Part no. FL-161/60

Foot mount

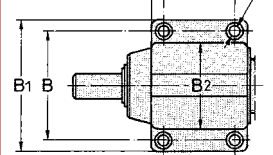


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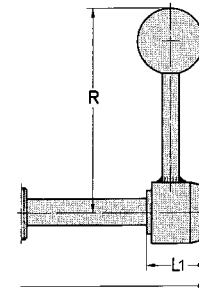


Part no. FO-121/45

View "Y"



Part no. FO-161/60
FO-221/80



Important

The Straight Line clamps are designed only for **axial load**. In case of side load, we recommend an additional radial support of the plunger.

Mounting type	Part no. with plunger	A	A ₁	A ₂	A ₃	A ₄	A ₅	B	B ₁	B ₂	D _{h8}	D ₁	D ₂	D ₃	D ₄
Foot mount	FO-121-45	-	44	19	12	6,3	8,5	52	68	40	12	35	-	6,5	20
	FO-161-60	40	62	11	12	12	10	70	90	52	16	46	-	9	25
	FO-221-80	50	75	13	20	15	12	90	115	69	22	60	-	11	36
Flange mount	FL-121-45	-	44	44	12	6	8,5	52	68	-	12	30f7	40	6,5	20
	FL-161-60	-	60	-	14	14	10	68	73	-	16	40f7	52	9	25
Through hole mount	G-121-45	-	44	-	12	10	8,5	-	-	-	12	M30x1,5	40	-	20

Mounting type	Part no. with plunger	D ₅	E	E ₁	H	L	L ₁	R	S ₂	S ₃	SW	SW ₁	T	T ₁	T ₃
Foot mount	FO-121-45	M6	20	12,5	42	153	27	95	15	2,5	-	11	12	-	10
	FO-161-60	M8	30	14,8	58	196	35	130	18	3	-	13	15	1	14
	FO-221-80	M12	35	19,5	71	245	40	197	20	3	-	17	25	1	18
Flange mount	FL-121-45	M6	-	12,5	-	153	27	95	15	2,5	-	11	12	-	10
	FL-161-60	M8	28	14,8	-	196	35	130	18	3	-	13	15	1	14
Through hole mount	G-121-45	M6	-	12,5	-	153	27	95	15	2,5	35	11	12	-	10

F-160 SERIES

Variable Stroke Straight Line Action Clamps | Technical Information | Dimensions

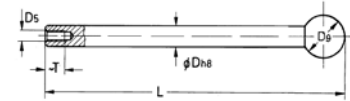


Technical features:

- High holding capacity of [4040 lbf] 18000N lbs.
- High side load capacity
- Plunger guide
- Wiper ring avoiding contamination of clamping mechanism
- Block style base provides for variable mounting
- Low weight due to the aluminium housing
- 50 mm horizontal and vertical hole pattern

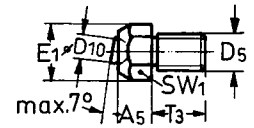
Accessories (order separately)

Plunger



Part no.	For rapid stroke S	D _{H8}	D ₅	D ₉	L ~	T ~	Weight ~ [lbs.] kg
16/100	100	16	M8	35	280	15	[0.90] 0,4
16/200	200	16	M8	35	380	15	[1.10] 0,5
16/300*	300	16	M8	35	480	15	[1.54] 0,7

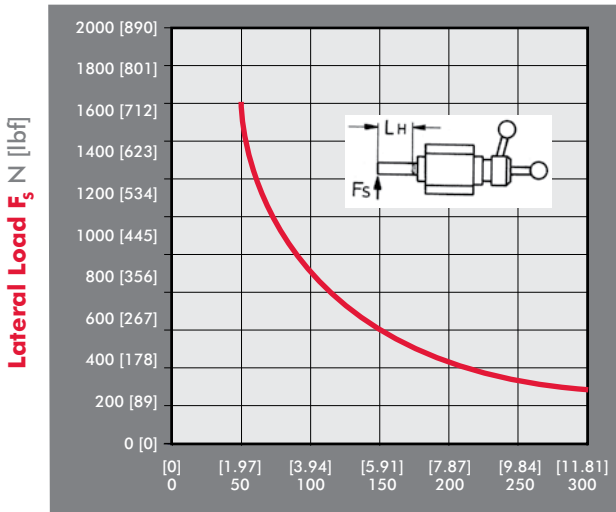
*400 and 500 mm strokes available on request



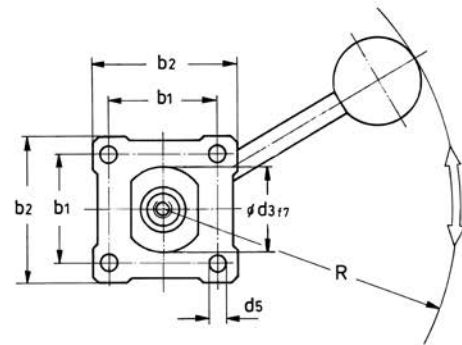
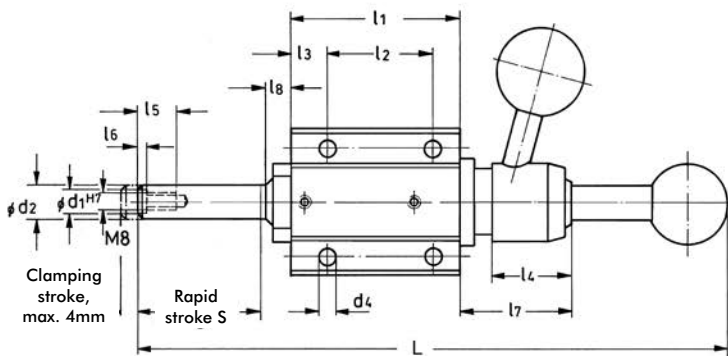
Swivel thrust pad

Part no.	Use with plunger diameter	A ₅	D ₅	D ₁₀	E ₁	T ₃	SW ₁
K-508	8	6	M5	5	9,2	8	8
K-612	12	8,5	M6	6	12,5	10	11
K-816	16	10	M8	8	14,8	14	13
K-1222	22	12	M12	9,5	19,5	18	17

Allowable side load F_s depending on the stroke length L_H



Stroke Length L_H mm [in]


















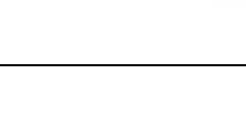


Part no. without plunger	Max. holding cap. [lbs] N	F _s * [lbs] N	b ₁	b ₂	~L For rapid strokes: 100 200 300	11	12	13	14	15	16	17	18	d ₁ ^{H7}	d ₂ ^{H8}	d ₃	d ₄	d ₅	R	Weight ~ [lbs.] kg
						80	50	18	35	20	2	50	12	10	16	40	8,3	8,5	165	[3.30] 1,5
F-160	[4040] 18000N	[1110] 500N	50	68	250 350 451	80	50	18	35	20	2	50	12	10	16	40	8,3	8,5	165	[3.30] 1,5

*F_s=exerting force at an operating force of [22lbf] 100N.

PULL ACTION LATCH CLAMPS

Sizing and Application Chart

Series	Page: MC-PAL-#	Max. Holding Capacity N[lbf.]					Drawing Movement mm [inch]						
		0 to 2000 [0 to 450]	2000 to 4000 [450 to 900]	4000 to 6000 [900 to 1350]	6000 to 10000 [1350 to 2250]	10000 to 20000 [2250 to 4500]	20000+ [4500+]	0 to 50 [0 to 1.97]	50 to 75 [1.4.97 to 2.95]	75 to 100 [2.95 to 3.94]	100 to 125 [3.94 to 4.92]	125 to 150 [4.92 to 5.91]	150+ [5.91+]
	3051												
	330												
	351												
	371												
	381												
	323												
	331												
	341												
	375												
	385												
	324												
	334												
	344												
	374												
	301												
	311												
	3011												
	353												

PULL ACTION LATCH CLAMPS

Sizing and Application Chart

Overall Height mm [inch]						Overall Length mm [inch]						Overall Width mm [inch]						Standard Material			Hook Style			Service Environment			
0 to 50 [0 to 1.97]	50 to 75 [1.97 to 2.95]	75 to 100 [2.95 to 3.94]	100 to 125 [3.94 to 4.92]	125 to 150 [4.92 to 5.91]	150+ [5.91+]	50 to 100 [1.97 to 3.94]	100 to 150 [3.94 to 5.91]	150 to 200 [5.91 to 7.87]	200 to 250 [5.91 to 9.84]	250 to 300 [5.91 to 11.81]	300 to 350 [11.81 to 13.78]	0 to 40 [0 to 1.57]	40 to 50 [1.57 to 1.97]	50 to 60 [1.97 to 2.36]	60 to 70 [2.36 to 2.76]	70 to 80 [2.76 to 3.15]	80 to 90 [3.15 to 3.54]	Duty Cycle	Steel	Stainless Steel	Toggle Lock Plus	Fixed	Adjustable U-Hook	Adjustable J-Hook	Normal	Harsh/Dirty	
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3051 SERIES

Pull Action Latch Clamps | Product Overview

Features:

- Safe, single handed operation
- Innovative controlled motion
- Secure toggle locking action
- Simple set-up and adjustment
- Clamp hook/arm moves and stays safely out of the way

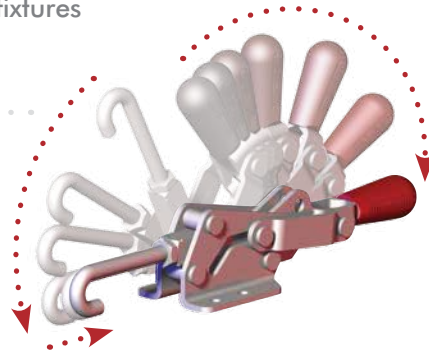
Applications:

- Molding
- Closures for doors, lids, covers
- Assembly
- Checking fixtures

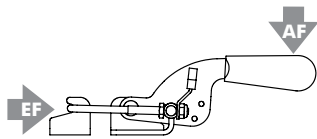
3051



3051-R

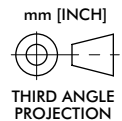
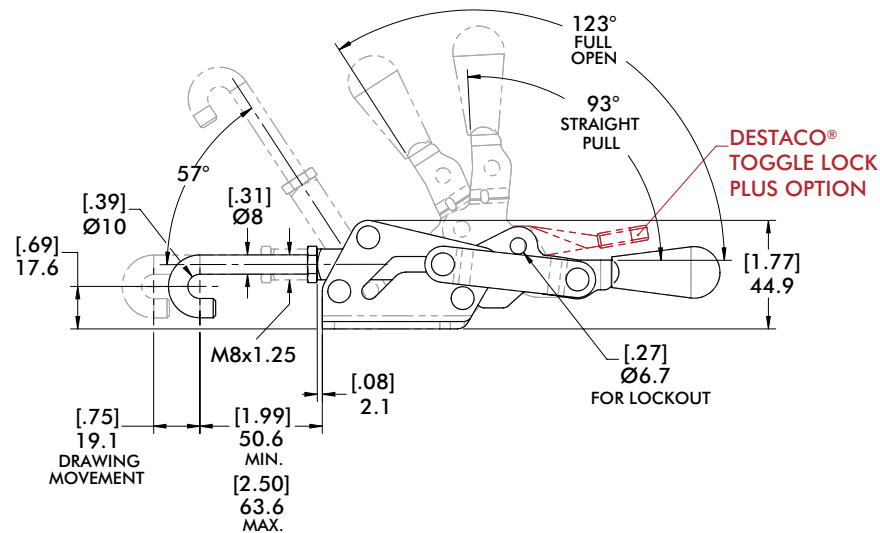
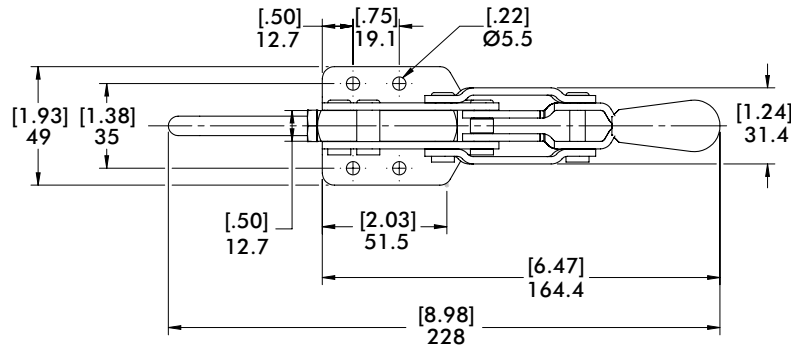


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF	Drawing Movement	Replacement Hook Assembly	Hook Adj. Range
3051	6700N	0,50kg	12:1	19,1	3051208	14
3051-R	[1500lbf]	[1.0lb]		[0.75]		[0.55]

EF = Exerting Force, AF = Applied Force



330, 351, 371, 381 SERIES

Pull Action Latch Clamps | Product Overview

Features:

- J-hook style latch clamps are supplied with threaded J-hooks for easy adjustment
- Supplied with patented thumb control lever for one handed operation
- DESTACO® Toggle Lock Plus versions available
- Stainless steel version available as **-SS** models

Applications:

- Molding
- Closures for doors, lids, covers
- Assembly

Also Available:

- Clamps with longer hooks available Upon Request that are 25mm, 50mm, 100mm longer than standard length
- To order clamp with longer hook, add **-M-25**, **-M-50**, or **-M-100** to the end of the model. Example: 330-**M-50**

Covered under one or more U.S./International Patents

330
330-SS



351
351-SS



351-B
351-BSS
Narrow Base



351-R
with
DESTACO®
Toggle Lock
Plus



371
371-SS



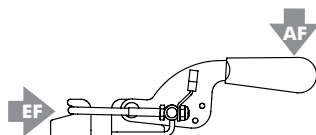
371-R
with DESTACO®
Toggle Lock
Plus



381
381-SS



Technical Information | Holding Capacities



Model	Max. Holding Capacity	Weight	EF:AF	Drawing Movement	Replacement Hook Assembly	Hook Adj. Range
330	900 N [200 lbf]	0,11kg [0.24lb]	17:1	59,7 [2.35]	330215	7.4 [0.29]
330-SS					330915	
351	1670 N [375 lbf]	0,28kg [0.61lb]	21:1	101,6 [4.00]	351215	12.4 [0.49]
351-SS	2000 N [450 lbf]				351915	
351-B	1670 N [375 lbf]				351215	
351-BSS					351915	
351-R	1670 N [375 lbf]	0,36kg [0.8lb]			351215	
371	3340 N [750 lbf]	0,69kg [1.53lb]	36:1	136,7 [5.38]	371215	23.9 [0.94]
371-SS		0,85kg [1.88lb]			371915	
371-R		0,85kg [1.88lb]			371215	
381	4450 N [1000 lbf]	1,16kg [2.56lb]	37:1	155,7 [6.13]	381215	29.7 [1.17]
381-SS					381915	

EF = Exerting Force, AF = Applied Force

330, 351, 371, 381 SERIES

Pull Action Latch Clamps | Dimensions | -SS/-B/-BSS

330
330-SS



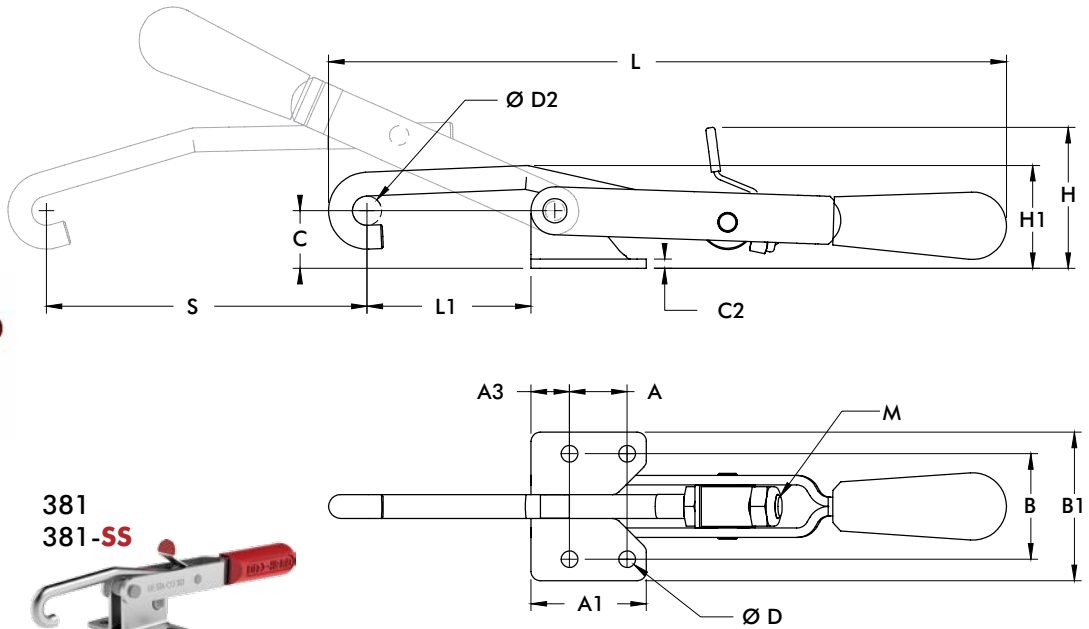
351
351-SS



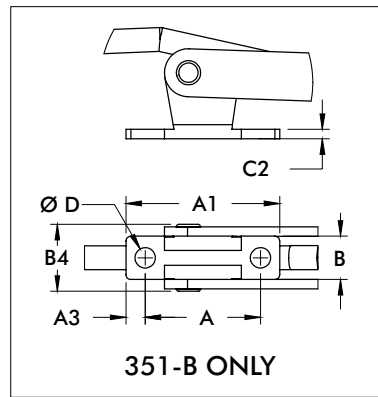
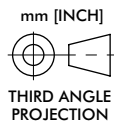
371
371-SS



381
381-SS



351-B
351-BSS
Narrow Base



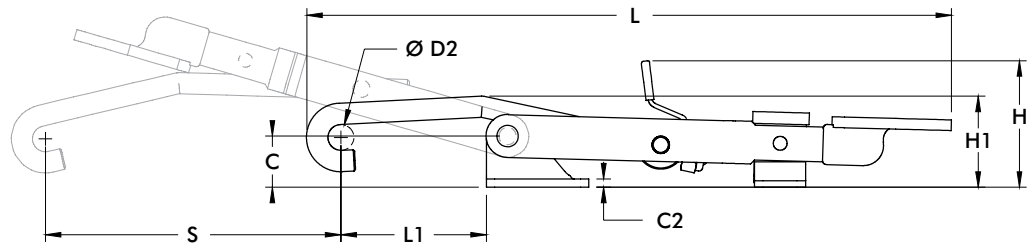
Model	A	A1	A3	B
330	[0.50]	[1.00]	[0.25]	[1.22]
330-SS	12,7	25,4	6,4	30,9
351	[0.75]	[1.50]	[0.50]	[1.37]
351-SS	19,1	38,1	12,7	34,8
351-B	[1.50]	[2.00]	[0.25]	[0.56]
351-BSS	38,1	38,1	6,4	14,3
371	[1.25]	[1.94]	[0.34]	[1.94]
371-SS	31,8	49,2	8,7	49,2
381	[1.13]	[2.13]	[0.50]	[2.37]
381-SS	28,6	54,1	12,7	60,3

Model	B1	B4	C	C2	ØD	ØD2	H	H1	L	L1 Max	M	S
330	[1.69]	-	[0.56]	[0.12]	[0.22]	[0.32]	[1.43]	[0.89]	[6.01]	[1.70]	M5	[2.35]
330-SS	42,9	-	14,2	3,1	5,6	8,1	36,2	22,6	152,7	43,3		59,7
351	[1.93]	-	[0.75]		[0.22]		[1.83]	[1.34]		[2.13]		
351-SS	49,1	-	19,1	[0.12]	5,5	[0.38]	46,6	34	[8.82]	54,2	M8	[4.00]
351-B		[0.87]	[0.86]		[0.27]		[1.94]	[1.45]		[1.63]		
351-BSS		22,1	21,8		6,7		49,3	36,8		41,4		
371	[2.63]	-	[1.42]	[0.16]	[0.34]	[0.50]	[2.58]	[2.23]	[11.89]	[2.81]	M10	[5.38]
371-SS	66,7	-	36,1	4	8,7	12,7	65,6	56,5	302	71,5		136,7
381	[3.38]	-	[1.81]	[0.19]	[0.41]	[0.62]	[2.90]	[2.71]	[13.45]	[3.13]	M12	[6.13]
381-SS	85,9	-	46	4,7	10,3	15,7	73,6	68,8	341,7	79,5		155,7

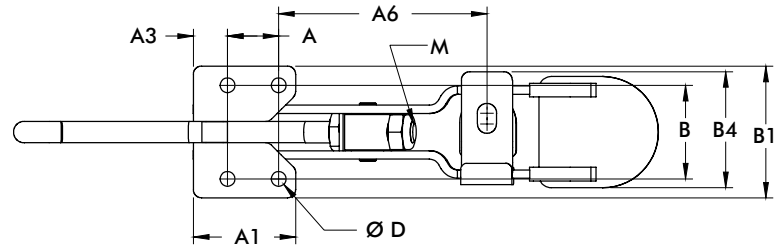
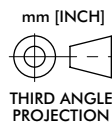
351-R, 371-R SERIES

Pull Action Latch Clamps | Dimensions

371-R
with
DESTACO®
Toggle Lock
Plus

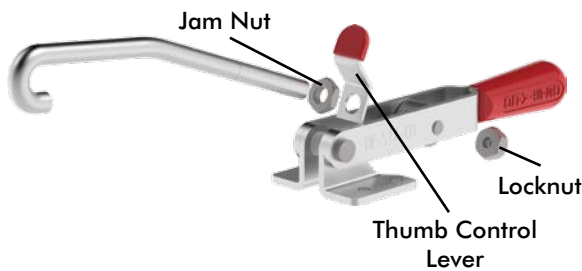


351-R
with
DESTACO®
Toggle Lock
Plus

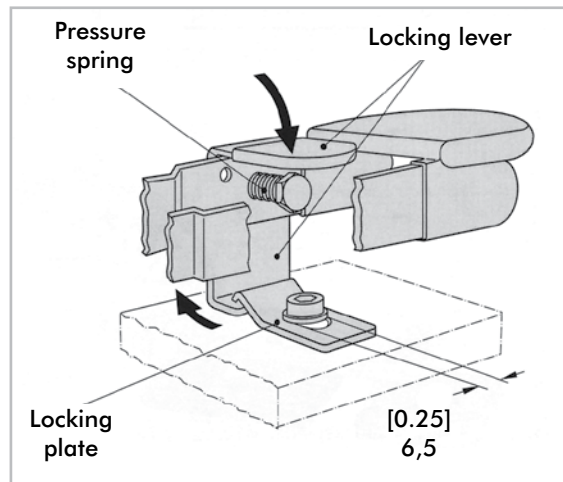


Model	A	A1	A3	A6	B	B1	B4	C	C2	ØD	H	H1
351-R	[0.75] 19,1	[1.50] 38,1	[0.50] 12,7	[3.06] 77,7	[1.37] 34,8	[1.93] 49,1	[1.70] 19,1	[0.75] 19,1	[0.12] 3,1	[0.22] 5,5	[1.85] 47,1	[1.34] 33,9
371-R	[1.25] 31,8	[1.94] 49,2	[0.34] 8,7	[4.73] 120,1	[1.94] 49,2	[2.63] 66,7	[2.25] 57,2	[1.42] 36,1	[0.16] 4	[0.34] 8,7	[2.65] 67,4	[2.22] 56,3

Model	L	L1	M	S
351-R	[9.45] 240	[2.13] 54,2	M8	[4.33] 110
371-R	[12.74] 323,6	[2.81] 71,4	M10	[5.59] 142



For added convenience, DESTACO Pull Action Toggle Clamps are supplied with a thumb control lever.



Model 351-R, 371-R

Information concerning the assembly and function of the clamps locking mechanism

The locking plate which is supplied with the unit must be fastened with a screw (M6 or 1/4-20) as shown in this illustration. The screw head should be flat.

Function

When closing the latch clamp, the locking lever engages automatically. Actuate the locking lever to open the clamp.

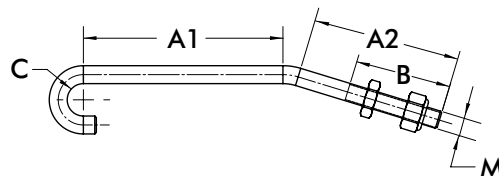
Replacement Thumb Control Lever	Used on Clamp Model
330-ZB1	330
351-ZB1	351, 351-B 351-R, 351-SS
371-ZB1	371, 371-R 371-SS
381-ZB1	381, 381-SS

351-R, 371-R SERIES

Pull Action Latch Clamps | Replacement Hook Assembly Dimensions

Replacement Hook Assembly	Used on Clamp Model	A1	A2	B	ØC	M	Material				
330215	330	[2.00] 50,8	[1.50] 38,1	[0.75] 19,1	[0.32] 8,1	M5 x 0.8	Steel				
330215-M-25 ⓘ	330-M-25	[3.00] 76,2									
330215-M-50 ⓘ	330-M-50	[4.00] 101,6									
330215-M-100 ⓘ	330-M-100	[6.00] 152,4					[3.38] 85,9	[1.63] 41,4	[0.38] 9,6	M8 x 1.25	Steel
330915	330-SS	[2.00] 50,8									
330915-M-25 ⓘ	330-SS-M-25	[3.00] 76,2									
330915-M-50 ⓘ	330-SS-M-50	[4.00] 101,6									
330915-M-100 ⓘ	330-SS-M-100	[6.00] 152,4	[4.16] 105,7	[2.22] 56,4	[0.50] 12,7	M10 x 1.50	Stainless Steel				
351215	351 351-B 351-R	[2.09] 53,1									
351215-M-25 ⓘ	351-M-25 351-B-M-25 351-R-M-25	[3.09] 78,5									
351215-M-50 ⓘ	351-M-50 351-B-M-50 351-R-M-50	[4.09] 103,9									
351215-M-100 ⓘ	351-M-100 351-B-M-100 351-R-M-100	[6.09] 154,7									
351915	351-SS	[2.09] 53,1					[2.94] 74,7	[3.94] 100	[0.50] 12,7	M12 x 1.75	Steel
351915-M-25 ⓘ	351-SS-M-25	[3.09] 78,5									
351915-M-50 ⓘ	351-SS-M-50	[4.09] 103,9									
351915-M-100 ⓘ	351-SS-M-100	[6.09] 154,7									
371215	371 371-R	[2.94] 74,7									
371215-M-25 ⓘ	371-M-25 371-R-M-25	[3.94] 100									
371215-M-50 ⓘ	371-M-50 371-R-M-50	[4.94] 125,5									
371215-M-100 ⓘ	371-M-100 371-R-M-100	[6.94] 176,3									
371915	371-SS	[2.94] 74,7	[4.63] 117,6	[2.50] 63,5	[0.62] 15,8	M12 x 1.75	Stainless Steel				
371915-M-25 ⓘ	371-SS-M-25	[3.94] 100									
371915-M-50 ⓘ	371-SS-M-50	[4.94] 125,5									
371915-M-100 ⓘ	371-SS-M-100	[6.94] 176,3									
381215	381	[3.00] 76,2									
381215-M-25 ⓘ	381-M-25	[4.00] 101,6									
381215-M-50 ⓘ	381-M-50	[5.00] 127									
381215-M-100 ⓘ	381-M-100	[7.00] 177,8									
381915	381-SS	[3.00] 76,2	[7.00] 177,8				Steel				
381915-M-25 ⓘ	381-SS-M-25	[4.00] 101,6									
381915-M-50 ⓘ	381-SS-M-50	[5.00] 127									
381915-M-100 ⓘ	381-SS-M-100	[7.00] 177,8									

ⓘ This item is available upon request.



323, 331, 341 SERIES

Pull Action Latch Clamps | Product Overview

Features:

- U-hook style latch clamps are supplied with threaded U-hooks for easy adjustment
- Supplied with latch plate and patented thumb control lever for one handed operation
- DESTACO® Toggle Lock Plus versions available
- Stainless steel version available as **-SS** models

Applications:

- Molding
- Closures for doors, lids, covers
- Assembly

Also Available:

- Clamps with longer hooks available Upon Request that are 25mm, 50mm, 100mm longer than standard length
- To order clamp with longer hook, add **-M-25**, **-M-50**, or **-M-100** to the end of the model. Example: 323-**M-50**

Covered under one or more U.S./International Patents

323
323-SS



323-R
323-RSS
with DESTACO®
Toggle Lock
Plus



331
331-SS



331-R
331-RSS
with
DESTACO®
Toggle Lock
Plus



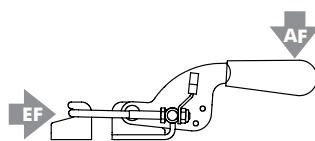
341
341-SS



341-R
341-RSS
with DESTACO®
Toggle Lock
Plus



Technical Information | Holding Capacities



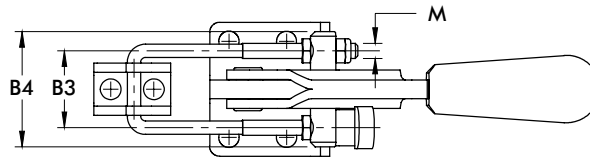
Model	Max. Holding Capacity	Weight	EF:AF	Drawing Movement	Latch Plate (Supplied)	Replacement Hook Assembly	Hook Adj. Range
323				30 [1.18]	323104-M	323215	
323-SS	1600 N [360 lbf]	0,07kg [0.15lb]	27:1	29,7 [1.17]	323104-MSS	323915	[0.36] 9,1
323-R					323104-M	323215	
323-RSS					323104-MSS	323915	
331					331005	331215	
331-SS	3200 N [720 lbf]	0,25kg [0.56lb]	32:1	44,5 [1.75]	331905	331915	[0.87] 22,1
331-R					331005	331215	
331-RSS					331905	331915	
341					341005	341215	
341-SS	8900 N [2000 lbf]	0,65kg [1.43lb]	29:1	63,5 [2.50]	341905	341915	[0.97] 24,6
341-R					341005	341215	
341-RSS					341905	341915	

EF = Exerting Force, AF = Applied Force

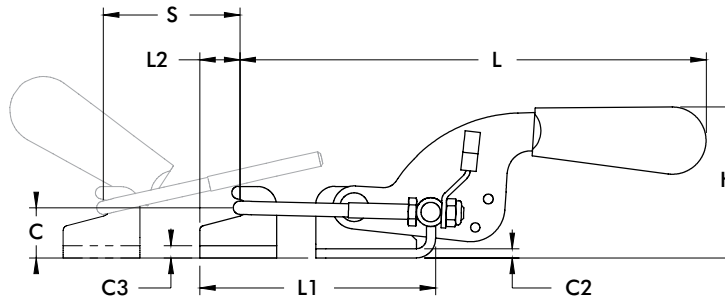
323, 323-R, 331, 341 SERIES

Pull Action Latch Clamps | Dimensions | -R/-RSS

323
323-SS



323-R
323-RSS
with DESTACO®
Toggle Lock
Plus



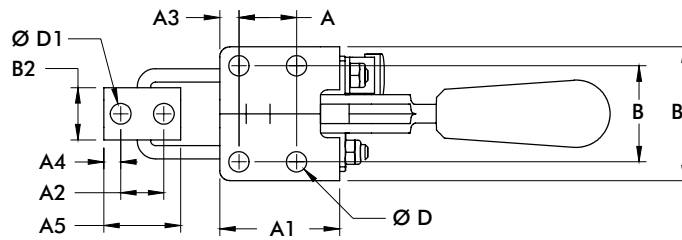
331
331-SS



341
341-SS



mm [INCH]
THIRD ANGLE
PROJECTION



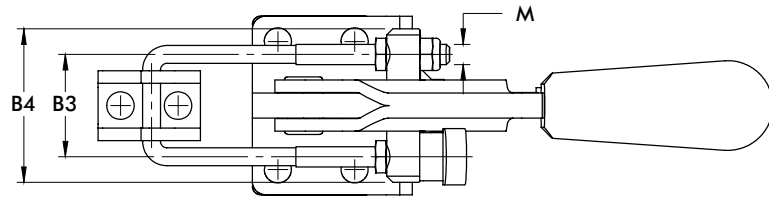
Model	A	A1	A2	A3	A4	A5	B	B1	B2	B3	B4	C	C2
323													
323-SS	[0.63]	[1.02]	[0.39]	[0.20]	[0.24]	[0.79]	[0.75]	[1.10]	[0.52]	[0.75]	[1.10]	[0.47]	[0.08]
323-R	16	26	10	5	6	20	19	28	13,2	19,1	28	12	2
323-RSS													
331	[0.75]	[1.56]	[0.56]	[0.25]	[0.22]	[1.00]	[1.25]	[1.74]	[0.68]	[1.00]	[1.50]	[0.66]	[0.12]
331-SS	19,1	39,7	14,3	6,4	5,6	25,4	31,8	44,3	17,3	25,4	38,1	16,7	3,1
341	[1.63]	[2.38]	[0.75]	[0.38]	[0.38]	[1.50]	[1.50]	[2.12]	[1.19]	[1.75]	[2.38]	[0.94]	[0.16]
341-SS	41,3	60.5	19.1	9.7	9.5	38.1	38.1	53.8	30.1	44.5	60.5	23.8	4

Model	C3	ØD	ØD2	H	L	L1 MAX	L2	M	S
323									
323-SS	[0.08]	[0.17]	[0.17]	[1.19]	[3.88]	[2.32]	[0.37]	M4	[1.18]
323-R	2	4,2	4,2	30,3	98,6	58,9	9,3	M4	30
323-RSS									
331	[0.12]	[0.27]	[0.27]	[1.97]	[6.07]	[3.07]	[0.52]	M5	[1.75]
331-SS	3,1	6,7	6,9	50	154,2	78	13,3	M5	45,5
341	[0.16]	[0.33]	[0.33]	[2.89]	[8.20]	[4.59]	[0.75]	M8	[2.50]
341-SS	4	8,5	8,5	73,4	208,3	116,6	19,1	M8	63,5

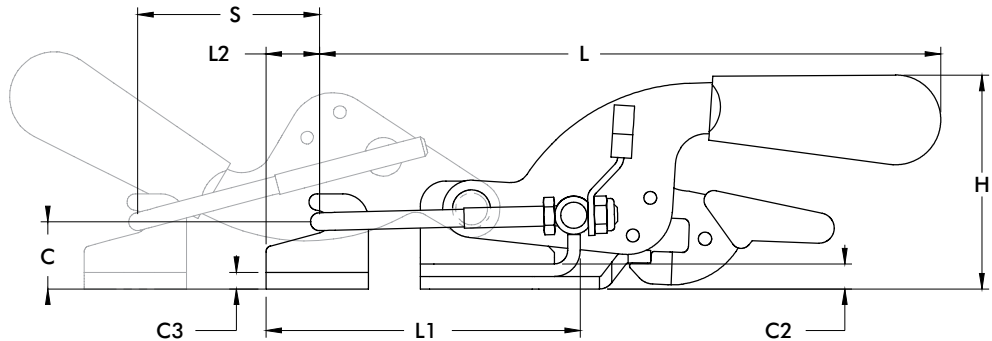
331-R, 341-R SERIES

Pull Action Latch Clamps | Dimensions | -R/-RSS

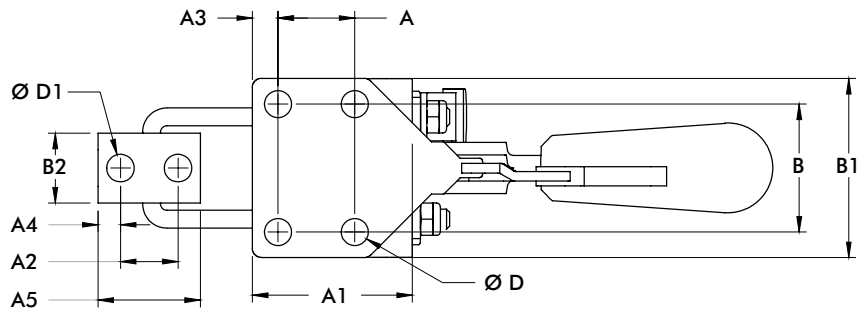
331-R
331-RSS
with
DESTACO®
Toggle Lock
Plus



341-R
341-RSS
with DESTACO®
Toggle Lock
Plus



mm [INCH]
THIRD ANGLE
PROJECTION



Model	A	A1	A2	A3	A4	A5	B	B1	B2	B3	B4	C	C2
331-R	[0.75]	[1.56]	[0.56]	[0.25]	[0.22]	[1.00]	[1.25]	[1.74]	[0.68]	[1.00]	[1.50]	[0.66]	[0.12]
331-RSS	19,1	39,7	14,3	6,4	5,6	25,4	31,8	44,3	17,3	25,4	38,1	16,7	3,1
341-R	[1.63]	[2.38]	[0.75]	[0.38]	[0.38]	[1.50]	[1.50]	[2.12]	[1.19]	[1.75]	[2.38]	[0.94]	[0.16]
341-RSS	41,3	60,5	19,1	9,7	9,5	38,1	38,1	53,8	30,1	44,5	60,5	23,8	4

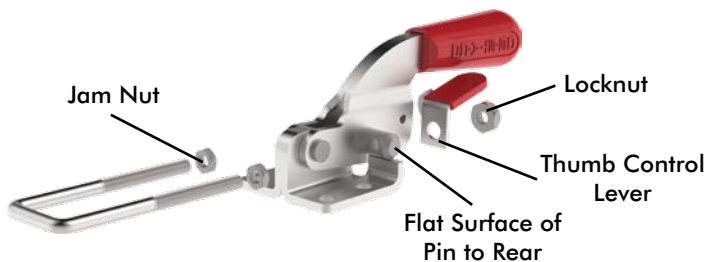
Model	C3	ØD	ØD2	H	L	L1 MAX	L2	M	S
331-R	[0.12]	[0.27]	[0.27]	[2.01]	[6.07]	[3.07]	[0.52]	M5	[1.75]
331-RSS	3,1	6,7	6,9	53,1	154,2	78	13,3	M5	45,5
341-R	[0.16]	[0.33]	[0.33]	[2.89]	[8.20]	[5.24]	[0.77]	M8	[2.50]
341-RSS	4	8,5	8,5	73,4	208,3	133,2	19,4	M8	63,5

323, 331, 341 SERIES

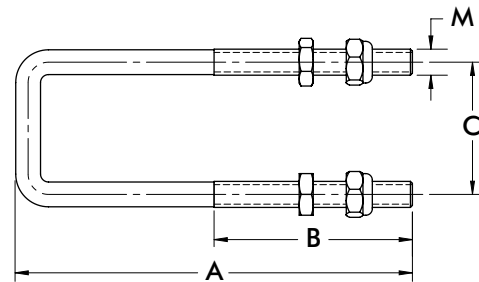
Pull Action Latch Clamps | Replacement Hook Assembly | Dimensions

Replacement Hook Assembly	Used on Clamp Model	A	B	C	M	Material
323215	323, 323-R	[2.12] 53,8	[0.94] 23,8	[0.75] 19,1	M4 x 0.7	Steel
323215-M-25 ⓘ	323-M-25, 323-R-M-25	[3.12] 79,2				
323215-M-50 ⓘ	323-M-50, 323-R-M-50	[4.12] 104,6				
323215-M-100 ⓘ	323-M-100, 323-R-M-100	[6.12] 155,4				
323915	323-SS, 323-RSS	[2.12] 53,8				
323915-M-25 ⓘ	323-SS-M-25, 323-RSS-M-25	[3.12] 79,2				
323915-M-50 ⓘ	323-SS-M-50, 323-RSS-M-50	[4.12] 104,6	[1.50] 38,1	[1.00] 25,4	M5 x 0.8	Stainless Steel
323915-M-100 ⓘ	323-SS-M-100, 323-RSS-M-100	[6.12] 155,4				
331215	331, 331-R	[3.00] 76,2				
331215-M-25 ⓘ	331-M-25, 331-R-M-25	[4.00] 101,6				
331215-M-50 ⓘ	331-M-50, 331-R-M-50	[5.00] 127				
331215-M-100 ⓘ	331-M-100, 331-R-M-100	[7.00] 177,8				
331915	331-SS, 331-RSS	[3.00] 76,2	[1.97] 50	[1.75] 44,5	M8 x 1.25	Steel
331915-M-25 ⓘ	331-SS-M-25, 331-RSS-M-25	[4.00] 101,6				
331915-M-50 ⓘ	331-SS-M-50, 331-RSS-M-50	[5.00] 127				
331915-M-100 ⓘ	331-SS-M-100, 331-RSS-M-100	[7.00] 177,8				
341215	341, 341-R	[4.31] 109,5				
341215-M-25 ⓘ	341-M-25, 341-R-M-25	[5.31] 135				
341215-M-50 ⓘ	341-M-50, 341-R-M-50	[6.31] 160,2	[8.31] 211	[8.31] 211	M8 x 1.25	Stainless Steel
341215-M-100 ⓘ	341-M-100, 341-R-M-100	[8.31] 211				
341915	341-SS, 341-RSS	[4.31] 109,5				
341915-M-25 ⓘ	341-SS-M-25, 341-RSS-M-25	[5.31] 135				
341915-M-50 ⓘ	341-SS-M-50, 341-RSS-M-50	[6.31] 160,2				
341915-M-100 ⓘ	341-SS-M-100, 341-RSS-M-100	[8.31] 211				

ⓘ This item is available upon request.



For added convenience, DESTACO Pull Action Toggle Clamps are supplied with a thumb control lever that allows the clamp to be operated with one hand.



Replacement Thumb Control Lever	Used on Clamp Model
324-ZB1	323, 323-SS
330-ZB1	331, 331-SS 331-R, 331-RSS
341-ZB1	341, 341-SS 341-R, 341-RSS

Features:

- Heavy duty U-hook style latch clamps are supplied with threaded U-hooks for easy adjustment
- Supplied patented thumb control lever for one handed operation
- DESTACO® Toggle Lock Plus versions available

Applications:

- Molding
- Closures for doors, lids, covers
- Assembly

Also Available:

- Clamps with longer hooks available Upon Request that are 25mm, 50mm, 100mm longer than standard length
- To order clamp with longer hook, add **-M-25**, **-M-50**, or **-M-100** to the end of the model. Example: 375-**M-50**

Covered under one or more U.S./International Patents

375



375-R
with
DESTACO®
Toggle Lock
Plus



375-B
Weld-on
Mounting



375-BR ⓘ
Weld-on
Mounting
with DESTACO®
Toggle Lock
Plus



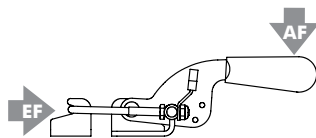
375509
Cleat



385102
Optional
Latch Plate
for 375 and
375-R



Technical Information | Holding Capacities



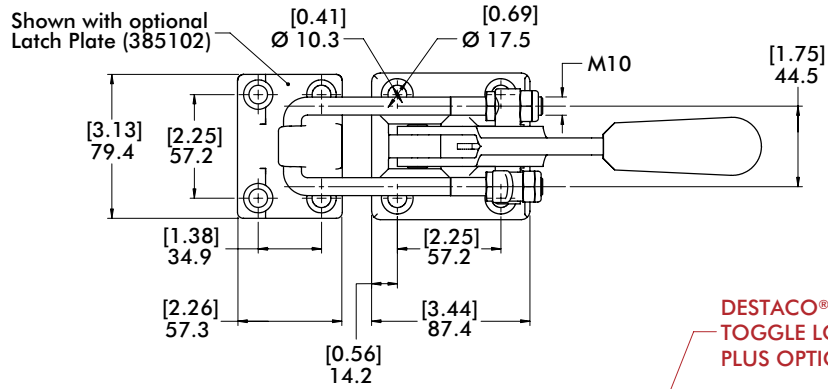
Model	Max. Holding Capacity	Weight	EF:AF	Drawing Movement	Latch Plate	Replacement Hook Assembly	Hook Adj. Range
375	[4000 lbf] 17800 N	[2.94lb] 1,33kg	44:1	88,9 [3.50]	385102 (Optional)	375215	[0.81] 20,5
375-R		[3.0lb] 1,36kg					
375-B		[2.56lb] 1,16kg			375509 (Supplied)		
375-BR ⓘ		[2.62lb] 1,19kg					

ⓘ This item is available upon request. **EF** = Exerting Force, **AF** = Applied Force

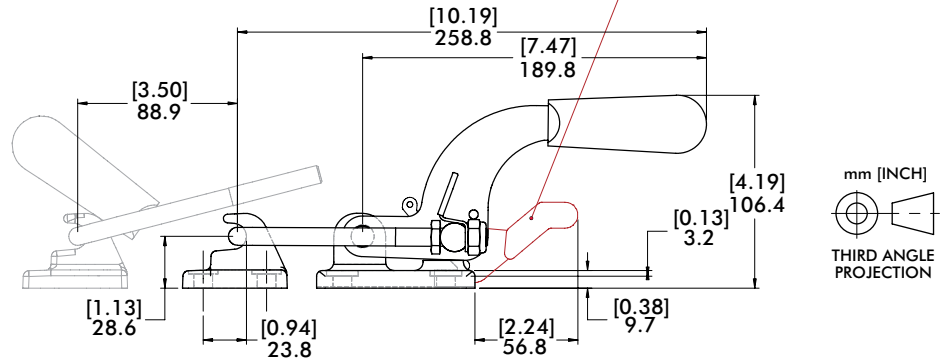
375, 375-R, 5-B, 375-BR SERIES

Pull Action Latch Clamps | Dimensions

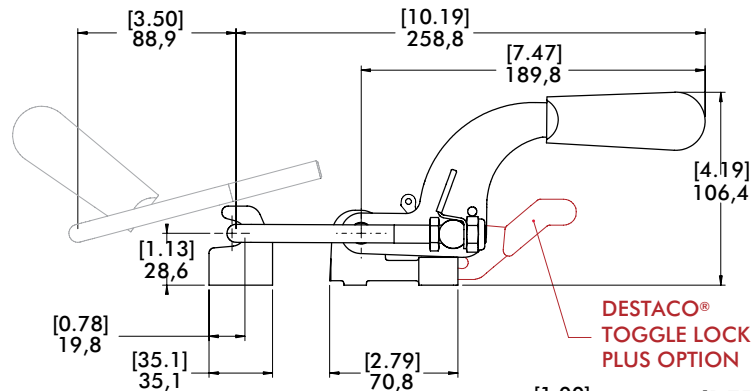
375



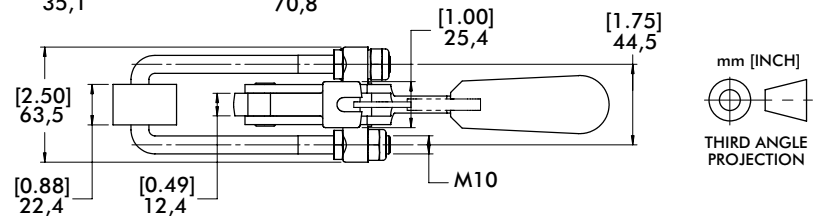
375-R
with
DESTACO®
Toggle Lock
Plus



375-B
Weld-on
Mounting



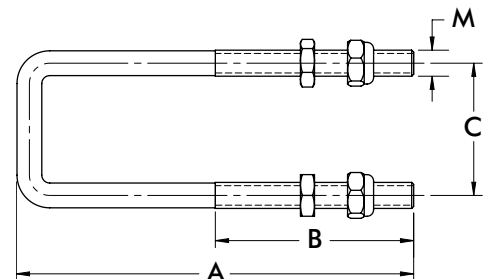
375-BR^①
Weld-on
Mounting
with DESTACO®
Toggle Lock
Plus



Replacement Hook Assembly

	A	B	C	M
375215	[5.72] 145	50,8 [2.00]	[1.75] 44,5	M10 x 1.50

Hook assembly includes (2) jam nuts and (2) locknuts. Longer hook lengths available Upon Request. 375215-M-25, 375215-M-50, 375215-M-100



Features:

- Heavy duty U-hook style latch clamps are supplied with threaded U-hooks for easy adjustment
- Supplied with patented thumb control lever for one handed operation
- DESTACO® Toggle Lock Plus versions available

Applications:

- Molding
- Closures for doors, lids, covers
- Assembly

Also Available:

- Clamps with longer hooks available Upon Request that are 25mm, 50mm, 100mm longer than standard length
- To order clamp with longer hook, add **-M-25**, **-M-50**, or **-M-100** to the end of the model. Example: 385-**M-50**

Covered under one or more U.S./International Patents

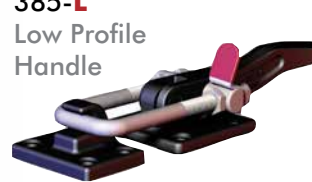
385



385-R
with DESTACO®
Toggle Lock
Plus



385-L
Low Profile
Handle



385-V2A ⓘ
Stainless Steel



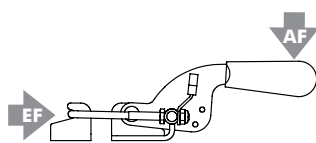
375509
Cleat



385102
Optional
Latch Plate
for 385, 385-R
and 385-L



Technical Information | Holding Capacities



Model	Max. Holding Capacity	Weight	EF:AF	Drawing Movement	Latch Plate	Replacement Hook Assembly	Hook Adj. Range
385		[3.3lb] 1,50kg					
385-R	[7500 lbf] 33300 N	[3.4lb] 1,54kg	44:1	55,6 [2.19]	385102 (Optional)	385215	[1.36] 34,5
385-L		[3.3lb] 1,50kg			375509 (Optional)		
385-V2A ⓘ	[6000 lbf] 26700 N				Supplied	ⓘ 385915	[1.77] 45

ⓘ This item is available upon request. **EF** = Exerting Force, **AF** = Applied Force

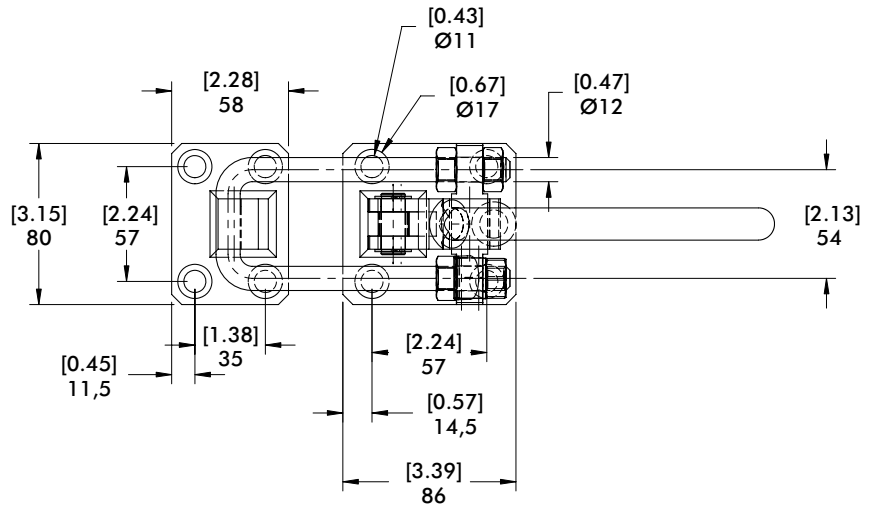
385-V2A SERIES

Pull Action Latch Clamps | Dimensions

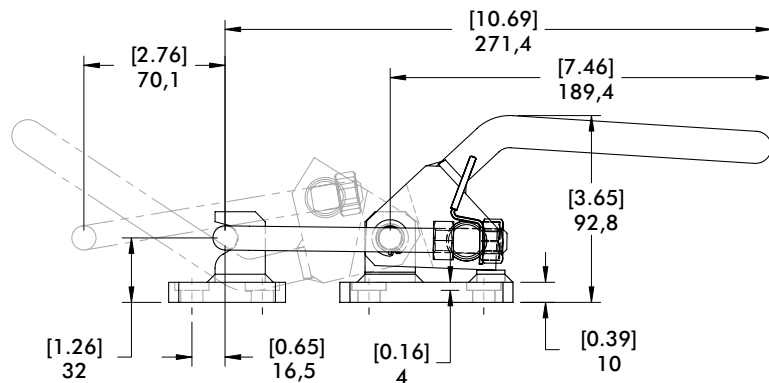
385-V2A ⓘ



ⓘ This item is available upon request



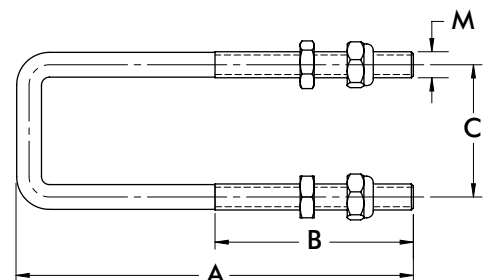
mm [INCH]
THIRD ANGLE PROJECTION



Replacement Hook Assembly	Used on Clamp Model	A	B	C	M	Material
385215	385, 385-R, 385-L	[5.72] 145,3				Steel
385215-M-25 ⓘ	385-M-25, 385-R-M-25 385-L-M-25	[6.72] 170,7				
385215-M-50 ⓘ	385-M-50, 385-R-M-50 385-L-M-50	[7.72] 196				
385215-M-100 ⓘ	385-M-100, 385-R-M-100 385-L-M-100	[9.72] 247	[2.75] 70	[2.12] 53,8	M12 x 1.75	
385915	385-V2A	[5.72] 145,3				Stainless Steel
385915-M-25 ⓘ	385-V2A-M-25	[6.72] 170,7				
385915-M-50 ⓘ	385-V2A-M-50	[7.72] 196				
385915-M-100 ⓘ	385-V2A-M-100	[9.72] 247				

ⓘ This item is available upon request.

Replacement Thumb Control Lever	Used on Clamp Model
375-ZB1	375, 375-B 375-R, 375-BR
385-ZB1	385, 385-R 385-L, 385-V2A



324, 334, 344, 374 SERIES

Pull Action Latch Clamps | Product Overview

Features:

- U-hook style latch clamps supplied with threaded U-hooks for easy adjustment
- Supplied with latch plate (except 374) and patented thumb control lever for one handed operation.
- DESTACO® Toggle Lock Plus versions available
- Stainless steel available as **-SS** models.

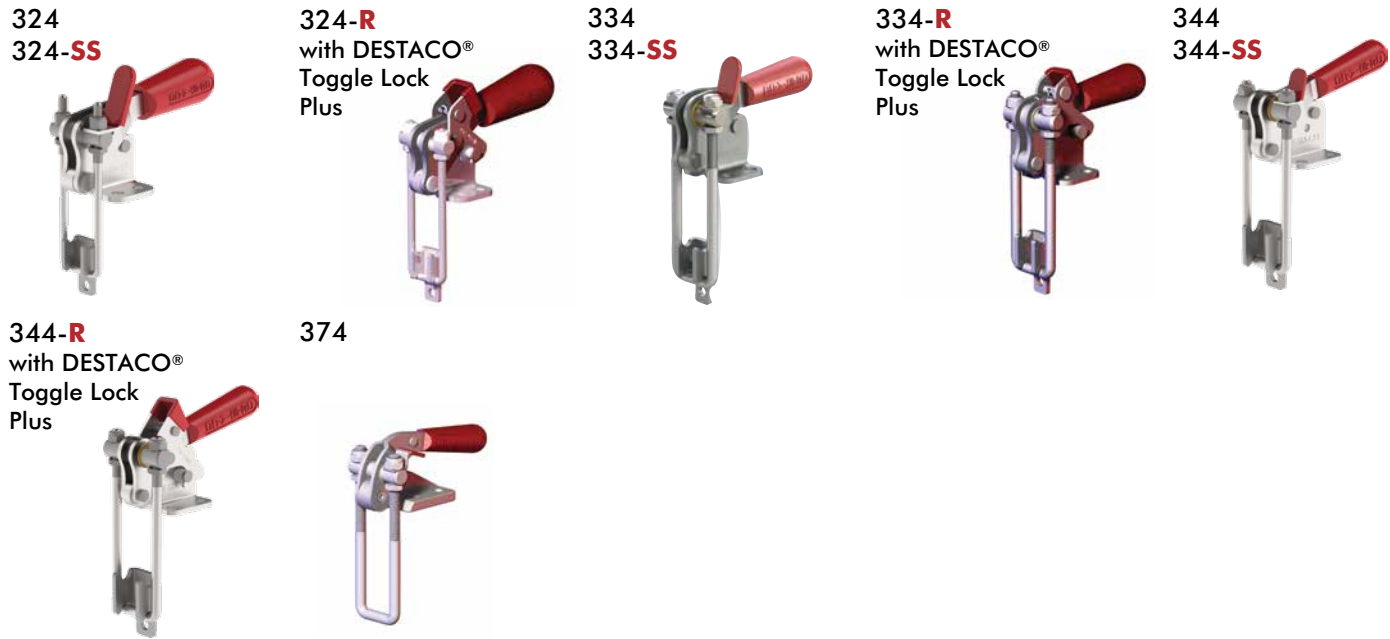
Applications:

- Molding
- Closures for doors, lids, covers
- Assembly

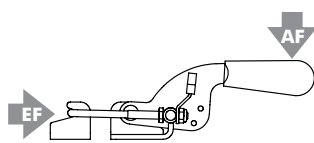
Also Available:

- Clamps with longer hooks available Upon Request that are 25mm, 50mm, 100mm longer than standard length
- To order clamp with longer hook, add **-M-25**, **-M-50**, or **-M-100** to the end of the model. Example: 324-**M-50**

Covered under one or more U.S./International Patents



Technical Information | Holding Capacities



Model	Max. Holding Capacity	Weight	EF:AF	(S) Drawing Movement	Latch Plate (Supplied)	Replacement Hook Assembly	Hook Adj. Range
324	[500 lbf] 2200 N	[0.25lb] 0,11kg	31:1	38,7 [1.53]	324101	324215	11.9 [0.47]
324-SS					324901	324915	
324-R					324101	324215	
334	[1000 lbf] 4450 N	[0.60lb] 0,27kg	31:1	51,7 [2.04]	334101	334915	19.3 [0.76]
334-SS					334901	334915	
334-R					334101	334215	
344	[2000 lbf] 8900 N	[1.50lb] 0,68kg	45:1	62,4 [2.46]	344101	344215	31 [1.22]
344-SS					344901	344915	
344-R					344101	344215	
374	[4000 lbf] 17800 N	[2.10lb] 0,95kg	36:1	44,5 [1.75]	None*	374215	53.8 [2.12]

EF = Exerting Force, AF = Applied Force *375509 Latch Plate may be used as an alternate.

324, 334, 344, 374 SERIES

Pull Action Latch Clamps | Dimensions | -SS

324
324-SS



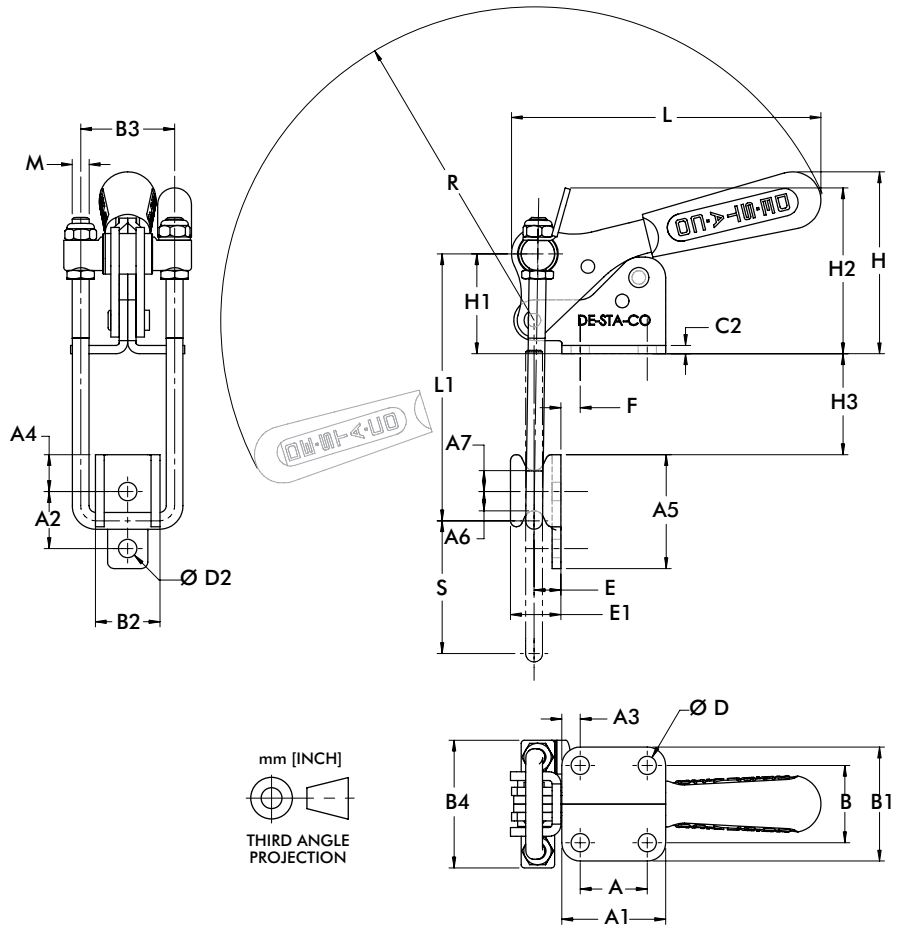
334
334-SS



344
344-SS



374



Model	A	A1	A2	A3	A4	A5	A6	A7	B	B1	B2	B3	B4	C2
324	[0.50]	[1.00]	[0.56]	[0.25]	[0.28]	[1.00]	[0.19]	[0.19]	[0.88]	[1.38]	[0.53]	[0.81]	[1.19]	[0.09]
324-SS	12,7	25,4	14,2	6,4	7,1	25,4	4,8	4,8	22,4	35,1	13,5	20,7	30,2	2,4
334	[0.75]	[1.31]	[0.81]	[0.28]	[0.41]	[1.50]	[0.28]	[0.28]	[1.00]	[1.56]	[0.68]	[1.13]	[1.63]	[0.12]
334-SS	19,1	33,3	20,6	7,1	10,4	38,1	7,1	7,1	25,4	39,6	17,4	28,7	41,4	3,1
344		[1.94]	[1.06]	[0.35]	[0.69]	[2.13]	[0.36]	[0.39]	[1.44]	[2.12]	[1.20]		[2.38]	[0.16]
344-SS	[1.25]	49,3	27	8,0	17,5	54	9,1	9,9	36,6	53,8	30,6		60,5	4
374	31,8	[2.43]	--	[0.68]	--	--	--	--	[1.50]	[2.50]	--	44,5	[2.36]	[0.37]
		61,7		17,3					38,1	63,5			60	9,4

Model	ØD	ØD2	F	H	H1	H2	H3	E	E1	L	L1 MAX	R	M	S
324	[0.20]	[0.17]	[0.25]	[1.91]	[1.10]	[1.97]	[0.92]	[0.19]	[0.38]	[3.49]	[2.56]	[3.49]	M4	[1.53]
324-SS	5,1	4,3	6,4	48,5	28	50,1	[23,4]	4,4	9,7	88,7	65,1	88,8		38,7
334	[0.28]	[0.22]	[0.28]	[2,37]	[1.55]	[2.68]	[1.34]	[0.35]	[0.63]	[4.10]	[3.70]	[4.12]	M6	[2.04]
334-SS	7,1	5,6	7,1	60,1	39,3	68	34	8,8	16	104,2	94	104,5		51,8
344	[0.34]	[0.34]	[0.35]	[3.39]	[1.86]	[7.09]	[1.73]	[0.50]	[0.94]	[5.77]	[5.00]	[5.84]	M8	[2.46]
344-SS	8,6	8,6	8,9	86,1	47,3	78,6	49,1	12,7	23,8	146,6	126,9	148,4		62,4
374	[0.41]	--	--	[2.38]	[1.36]	--	--	--	--	[6.60]	[6.04]	[6.04]	M10	[1,75]
	10,3			60,5	34,5					167,8	153,5	153,5		44,5

324-R, 334-R, 344-R SERIES

Pull Action Latch Clamps | Dimensions | -R/-SS

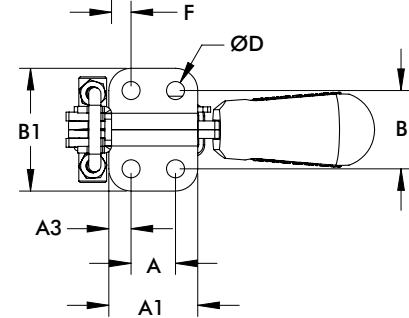
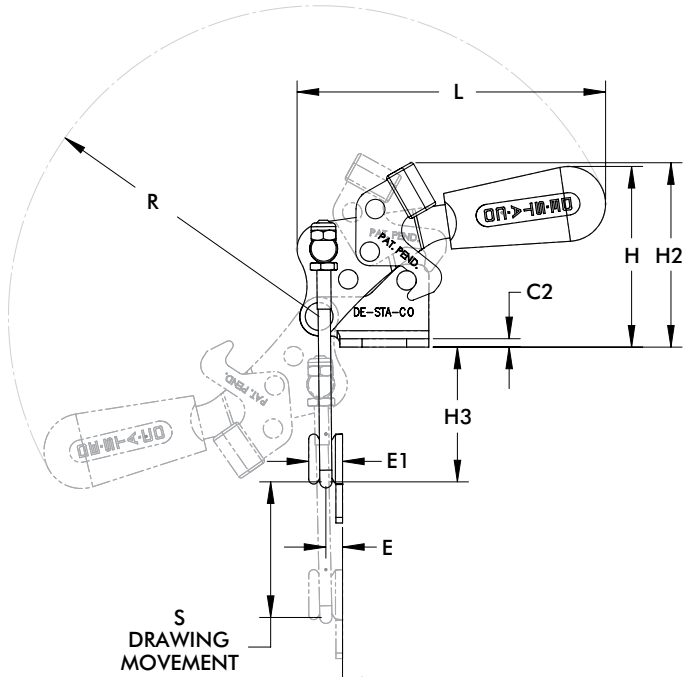
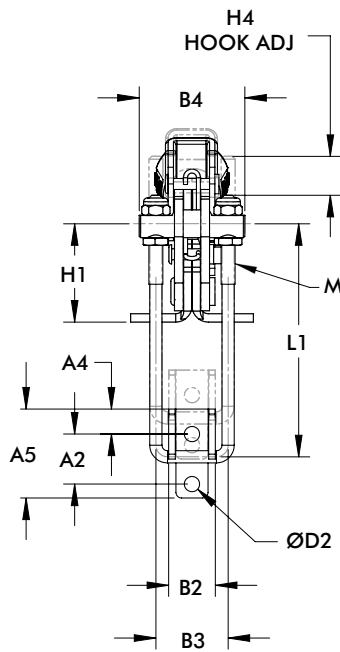
324-R
with DESTACO®
Toggle Lock
Plus



334-R
with DESTACO®
Toggle Lock
Plus



344-R
with DESTACO®
Toggle Lock
Plus



mm [INCH]
THIRD ANGLE PROJECTION

Model	A	A1	A2	A3	A4	A5	B	B1	B2	B3	B4	C2	D
324-R	[.50] 12.7	[1.00] 25.4	[.56] 14.3	[.25] 6.4	[.28] 7.1	[1.00] 25.4	[0.88] 22.4	[1.38] 35.1	[.52] 13.3	[0.81] 20.6	[0.44] 11.1	[0.09] 2.4	[0.20] 5.2
334-R	[.75] 19.1	[1.38] 34.9	[.81] 20.6	[.27] 7.0	[.41] 10.3	[2.13] 54.0	[1.00] 25.4	[1.56] 39.6	[0.68] 17.3	[1.13] 28.6	[1.63] 41.3	[0.12] 3.1	[0.28] 7.1
344-R	[1.25] 31,8	[1.94] 49.1	[1.06] 27.0	[.34] 8.7	[0.69] 17,5	[2.13] 54	[1.44] 36,6	[2.13] 54	[1.21] 30,6	[1.75] 44,5	[2.38] 60,5	[0.16] 4	[0.34] 8.6

Model	D2	E	E1	F	H	H1	H2	H3	H4	L	L1	M	S	R
324-R	[0.17] 4.4	[0.20] 5.2	[0.17] 4.4	[0.22] 5.6	[2.03] 51.6	[1.11] 28.1	[2.07] 52.7	[1.52] 38.5	[.44] 11.1	[3.47] 88.1	[2.62] 66.6	M4	[1.53] 38.7	[3.49] 88.8
334-R	[0.22] 5.6	[0.35] 8.8	[0.63] 15.9	[0.18] 4.5	[2.37] 60.2	[1.55] 39.3	[2.55] 64.7	[2.22] 56.3	[0.86] 21.8	[4.12] 104.6	[3.76] 95.6	M6	[2.04] 51.7	[4.10] 104.2
344-R	[0.34] 8,7	[0.50] 12,7	[0.94] 23,9	[0.36] 9,1	[3.40] 86,5	[1.86] 47,3	[3.39] 86.0	[3.17] 80.8	[1.22] 31	[5.77] 146.5	[5.04] 128.0	M8	[2.46] 62.4	[5.90] 150

324, 334, 344, 374 SERIES

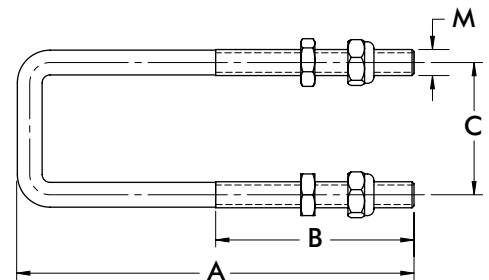
Pull Action Latch Clamps | Replacement Hook Assembly | Dimensions

Replacement Hook Assembly	Used on Clamp Model	A	B	C	M	Material			
324215	324 324-R	[3.00] 76	[1.00] 25,4	[0.81] 20,6	M4X0.7	Steel			
324215-M-25 ⓘ	324-M-25* 324-R-M-25*	[4.00] 101,6							
324215-M-50 ⓘ	324-M-50* 324-R-M-50*	[5.00] 127							
324215-M-100 ⓘ	324-M-100* 324-R-M-100*	[7.00] 178							
324915	334-SS	[3.00] 76							
324915-M-25 ⓘ	334-SS-M-25*	[4.00] 101,6							
324915-M-50 ⓘ	334-SS-M-50*	[5.00] 127							
324915-M-100 ⓘ	334-SS-M-100*	[7.00] 178							
334215	334 334-R	[4.31] 109,5				[1.50] 38,1	[1.13] 28,7	M6X1.0	Steel
334215-M-25 ⓘ	334-M-25* 334-R-M-25*	[5.31] 135							
334215-M-50 ⓘ	334-M-50* 334-R-M-50*	[6.31] 160,3							
334215-M-100 ⓘ	334-M-100* 334-R-M-100*	[8.31] 211							
334915	334-SS	[4.31] 109,5							
334915-M-25 ⓘ	334-SS-M-25*	[5.31] 135							
334915-M-50 ⓘ	334-SS-M-50*	[6.31] 160,3							
334915-M-100 ⓘ	334-SS-M-100*	[8.31] 211							
344215	344 344-R	[5.81] 147,5	[2.25] 57,2	[1.75] 44,5	M8X1.25				Steel
344215-M-25 ⓘ	344-M-25* 344-R-M-25*	[6.81] 173							
344215-M-50 ⓘ	344-M-50* 344-R-M-50*	[7.81] 198,5							
344215-M-100 ⓘ	344-M-100* 344-R-M-100*	[9.81] 249,2							
344915	344-SS	[5.81] 147,5							
344915-M-25 ⓘ	344-SS-M-25*	[6.81] 173							
344915-M-50 ⓘ	344-SS-M-50*	[7.81] 198,5							
344915-M-100 ⓘ	344-SS-M-100*	[9.81] 249,2							
374215	374	[6.50] 165				[3.25] 82,6		M10X1.50	Steel
374215-M-25 ⓘ	374-M-25*	[7.50] 190,5							
374215-M-50 ⓘ	374-M-50*	[8.50] 216							
374215-M-100 ⓘ	374-M-100*	[10.50] 266,5							

Hook assemblies are supplied with (2) jam nuts and (2) locknuts.

ⓘ This item is available upon request.

Replacement Thumb Control Lever	Used on Clamp Model
324-ZB1	324, 324-SS
334-ZB1	334, 334-SS
344-ZB1	344, 344-SS
375-ZB1	374



301, 311 SERIES

Pull Action Latch Clamps | Product Overview

Features:

- Fixed stop automatically limits handle travel at various clamping positions once the clamp is installed
- Model 301 available in stainless steel as 301-SS

Applications:

- Molding
- Closures for doors, lids, covers
- Assembly

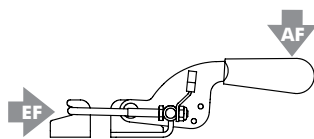
301
301-SS



311

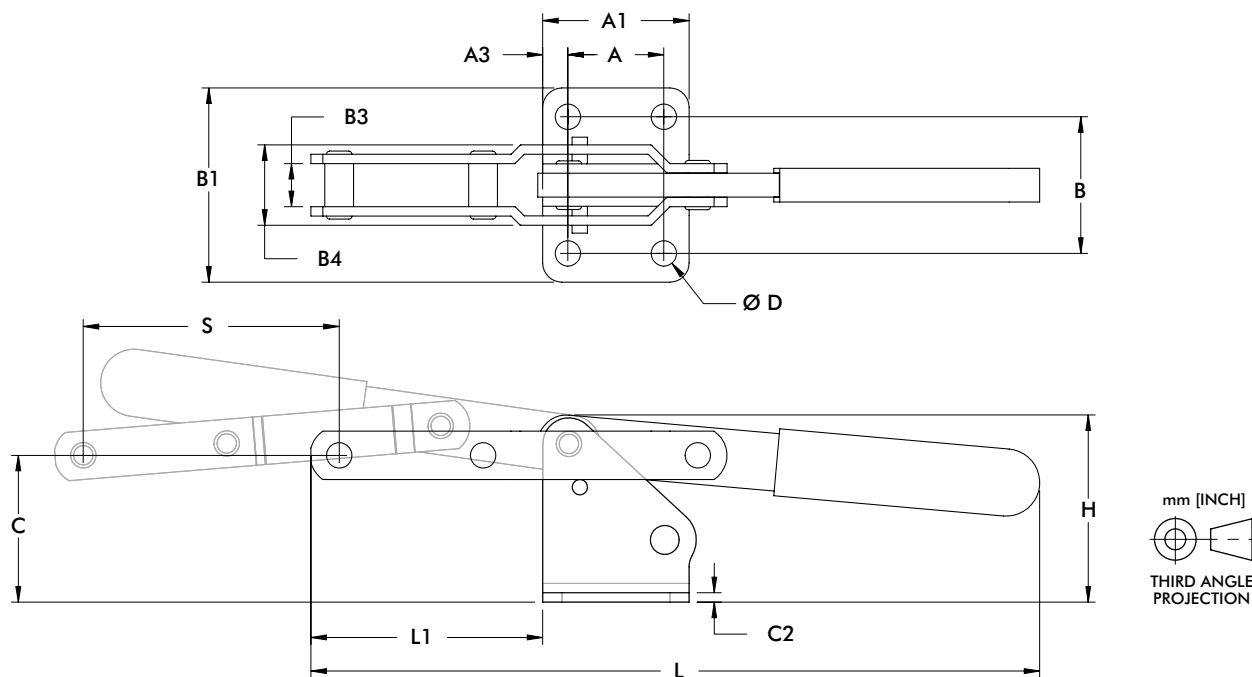


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF	Drawing Movement
301	1670 N [375 lbf]	0,32kg [0.70lb]	29:1	101,6 [4.00]
301-SS	2000 N [450 lbf]			
311	5340 N [1200 lbf]	0,53kg [1.16lb]	31:1	85,9 [3.38]

EF = Exerting Force, AF = Applied Force



Model	A	A1	A3	B	B1	B3	B4	C	C2	ØD	H	L	L1	S
301	[0.75]	[1.38]	[0.32]	[1.25]	[1.75]	[0.56]	[1.04]	[1.52]	[0.12]	[0.28]	[1.91]	[8.33]	[3.04]	[4.00]
301-SS	19,1	35,1	8	31,8	44,5	14,1	26,4	38,6	3,1	7,1	48,4	211,5	77,1	101,6
311	[1.25]	[1.91]	[0.33]	[1.78]	[2.53]	[0.56]	[1.05]	[1.91]	[0.12]	[0.33]	[2.44]	[9.49]	[3.02]	[3.88]
	31,8	48,4	8,3	45,2	64,3	14,3	26,6	48,6	3,1	8,4	61,9	241,2	76,7	85,9

Features:

- Heavy duty cast steel or stainless steel construction with ergonomic handle
- Replaceable stainless steel pivot pins

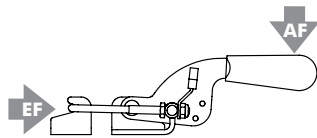
Applications:

- Molding
- Closures for doors, lids, covers
- Assembly

3011

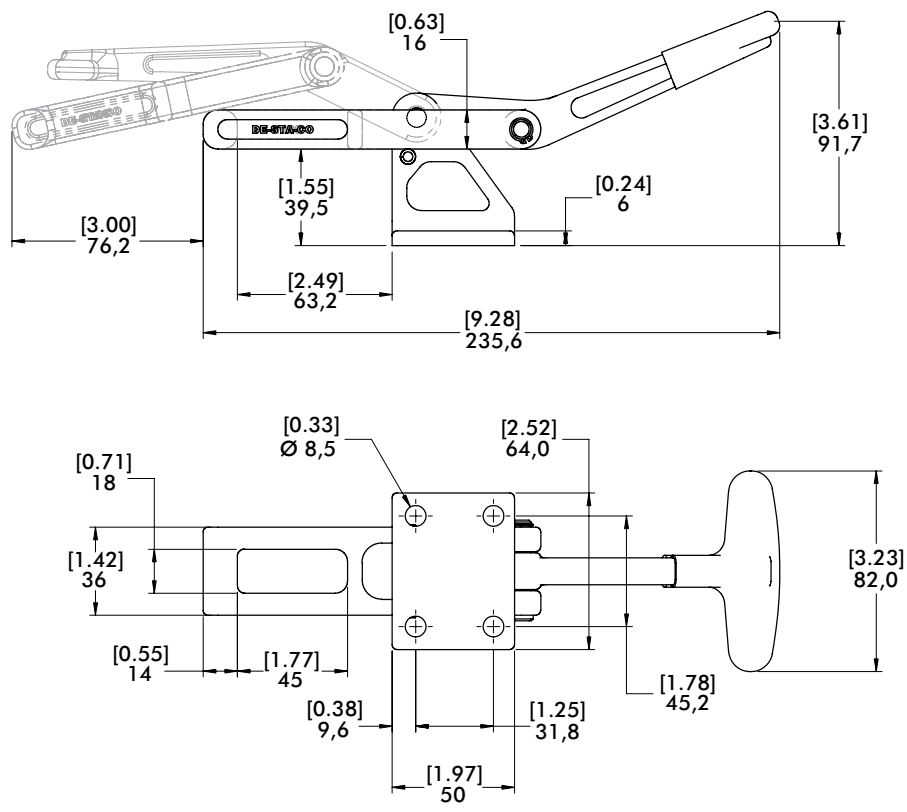


Technical Information | Holding Capacities | Dimensions



Model	Max. Holding Capacity	Weight	EF:AF	Drawing Movement
3011	8900 N [2000 lbf]	0,91kg [2.00lb]	31:1	76,2 [3.00]

EF = Exerting Force, AF = Applied Force



353 SERIES

Pull Action Latch Clamps | Product Overview

Features:

- Heavy duty cast steel clamps are designed to withstand the harshest environments
- Ideally suit for parting line clamping of rotational molds
- Replaceable stainless steel pivot pins

Applications:

- Molding
- Closures for doors, lids, covers

Also Available:

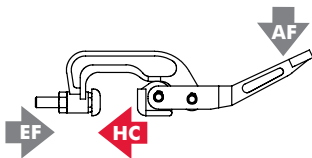
- Keeper plate
- Papered bolt assembly

353-35

353-65



Technical Information | Holding Capacities

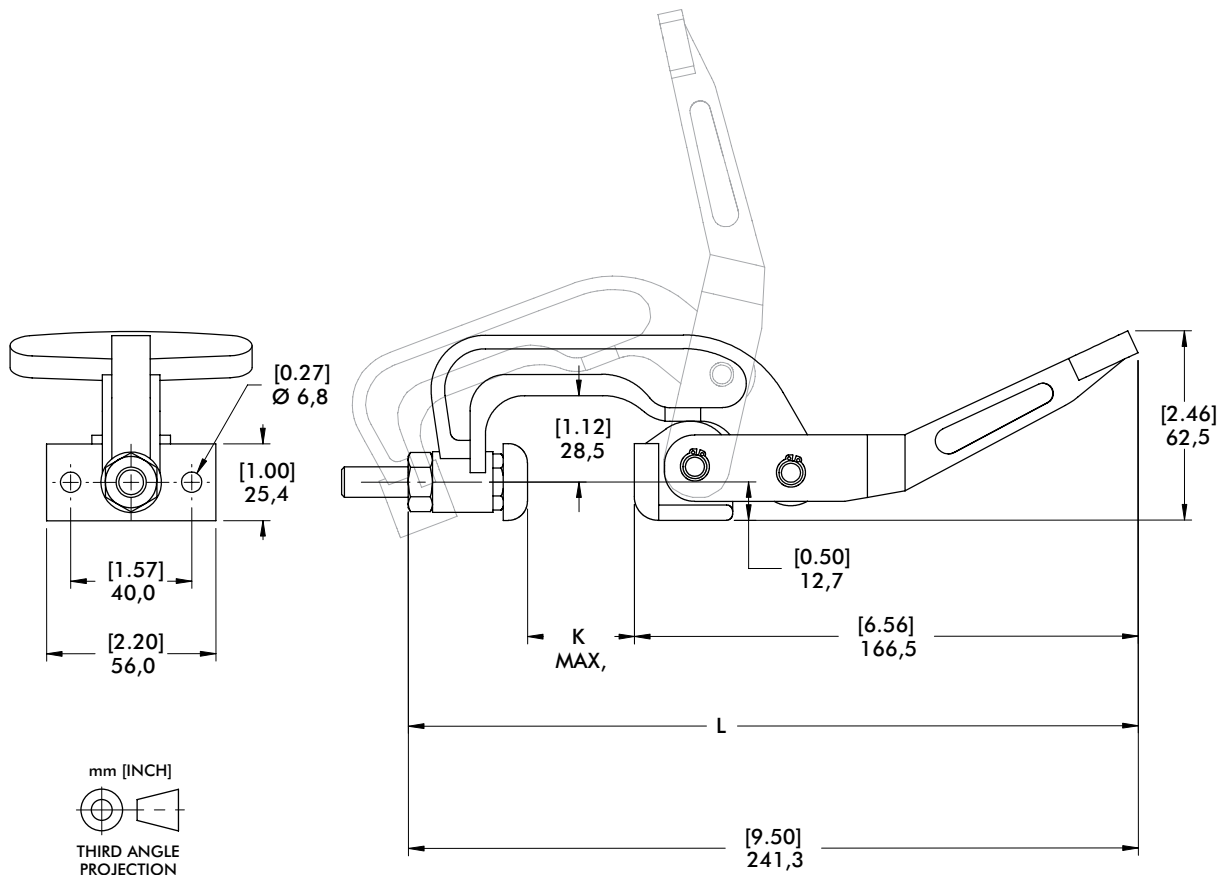
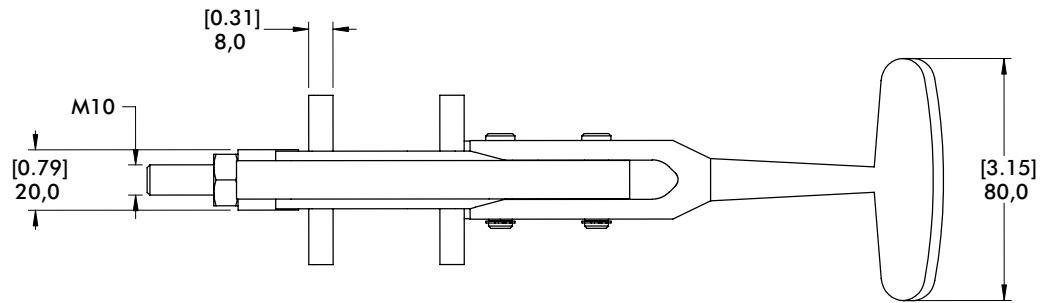


Model	Max. Holding Capacity	Weight	EF:AF	Drawing Movement	L	K	Keeper Plate (included)	Tapered Bolt Assembly (included)
353-35	[2800 lbf] 12460 N	[2.10lb] 0,95kg	23:1	12 [0.47]	[9.50] 241,5	[1.38] 35	353004	353908
353-65	[2100 lbf] 9350 N	[2.30lb] 1,04kg	27:1		[10.69] 271,5	[2.56] 65	353004	

EF = Exerting Force, AF = Applied Force

353-35






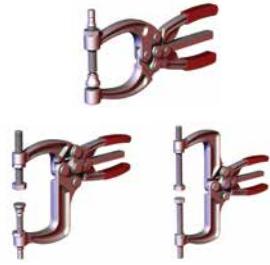
353-65



mm [INCH]
THIRD ANGLE PROJECTION

SQUEEZE ACTION PLIER CLAMPS

Sizing and Application Chart

	Series	Page: MC-SAP-#	Max. Holding Capacity N [lbf.]						Maximum Clamping Thickness mm [inch]						
			0 to 1000 [0 to 225]	1000 to 2000 [225 to 450]	2000 to 3000 [450 to 675]	3000 to 4000 [675 to 900]	4000 to 5000 [900 to 1125]	5000 to 6000 [1125 to 1350]	0 to 10 [0 to 0.39]	10 to 20 [0.39 to 0.78]	20 to 30 [0.78 to 1.18]	30 to 40 [1.18 to 1.57]	40 to 60 [1.57 to 2.36]	60 to 80 [1.57 to 3.15]	80+ [2.26+]
	325	2													
	345	3													
	424	4													
	441	4													
	431	5													
	425	6													
	435	6													
	462	7													
	463	7													
	482	7													
	484	7													
	486	7													

Features:

- Designed for attachment by welding or using mounting holes
- Available in stainless steel as **-SS** version

Applications:

- Molding
- Closures for doors, lids, covers

Also Available:

See page MC-ACC-1 for accessories

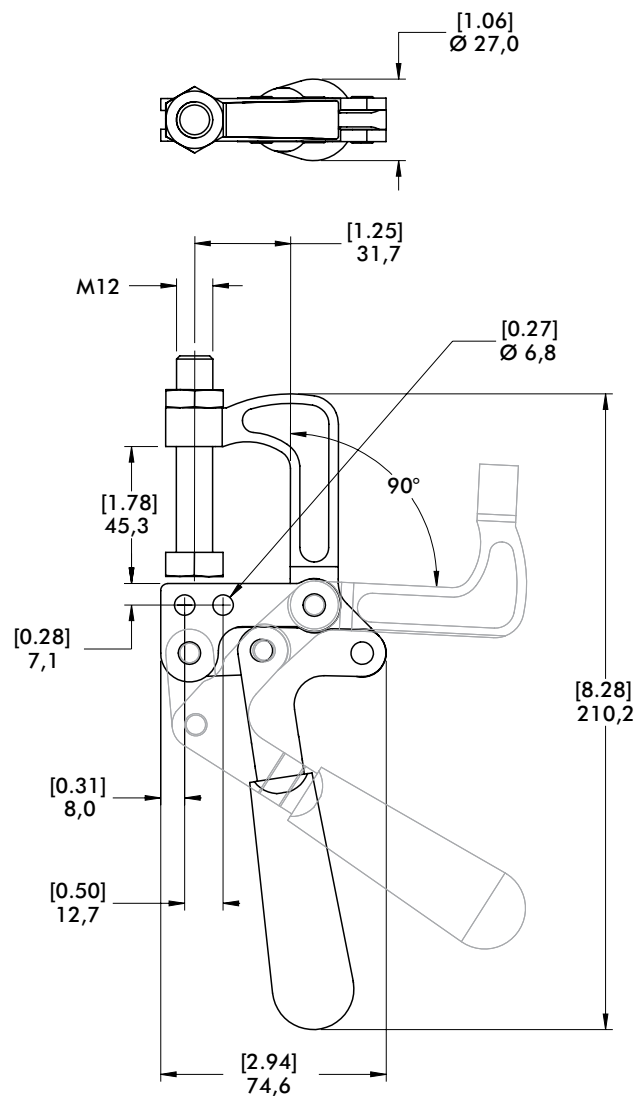
325,
325-SS



Technical Information | Holding Capacities

Model	Max. Holding Capacity	Weight	Jaw Opening	Spindle (Supplied)
325	3560 N [800 lbf]	0,54kg [1.18lb]	90°	325203-M
325-SS				325943-M

Dimensions



345 SERIES

Squeeze Action Plier Clamps | Product Overview

Features:

- Designed for welding or bolting at any point along the mounting bar
- Includes M10 swivel foot spindle
- Model 345-G includes sliding jaw with spindle

Applications:

- Welding fixtures
- Assembly fixtures
- Closures for doors, lids, covers

Also Available:

See page MC-ACC-1 for accessories

345,
345-G ⓘ

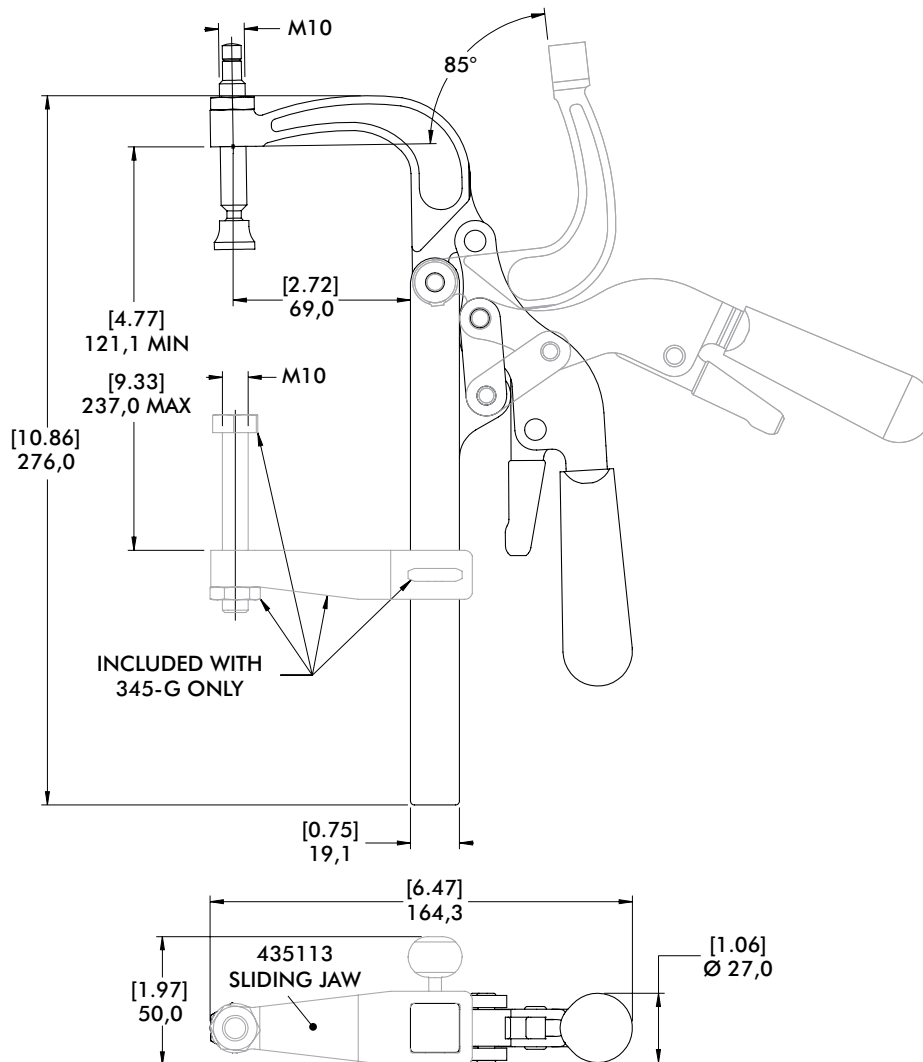


Technical Information | Holding Capacities

Model	Max. Holding Capacity	Weight	Jaw Opening	Spindle (Supplied)
345	3560 N [800 lbf]	1,22kg [2.69lb]	85°	468206-M
345-G ⓘ		1,40kg [3.09lb]		468206-M 210203-M

ⓘ This item is available upon request.

Dimensions



mm [INCH]
THIRD ANGLE PROJECTION

424, 441 SERIES

Squeeze Action Plier Clamps | Product Overview

Features:

- Compact clamps with forged alloy steel construction for high strength
- Versions ending with (-2) are supplied with two adjustable spindles

Applications:

- Welding
- Assembly

Also Available:

See page MC-ACC-1 for accessories

424



424-2
With Two
Adjustable
Spindles



441

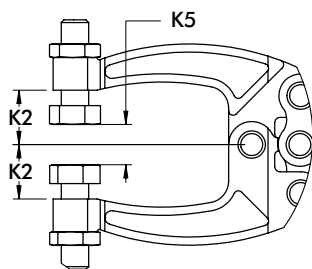


441-2
With Two
Adjustable
Spindles

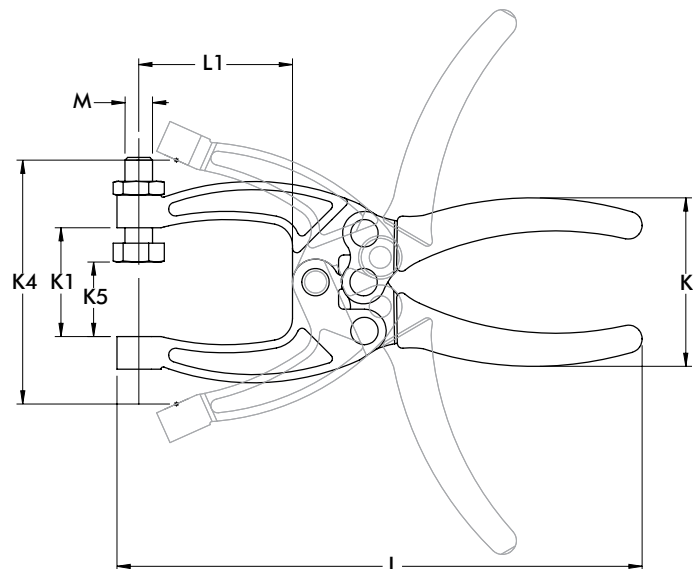
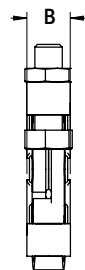


Technical Information | Holding Capacities | Dimensions

Model	Max. Holding Capacity	Weight	(K5) Maximum Clamping Thickness	Spindle (Supplied)
424	900 N [200 lbf]	0,14kg [0.31lb]	16 [0.63]	424208-M
424-2			7,4 [0.29]	(2X) 431208-M
441	1560 N [350 lbf]	0,29kg [0.63lb]	23,3 [1.03]	441203-M
441-2			20,8 [0.82]	(2X) 461203-M



MODEL 424-2 & 441-2 AS SHOWN



mm [INCH]
THIRD ANGLE PROJECTION

Model	B	K	K1	K2	K4	L	L1	M
424	[0.66]	[1.91]	[1.00]	[0.50]	[2.06]	[4.63]	[1.08]	M6
424-2	16.8	48.5	25.4	12.7	52.3	117.6	27.4	M6
441	[0.50]	[2.07]	[1.25]	[0.63]	[2.80]	[6.03]	[1.77]	M8
441-2	12.7	52.5	31.8	15.9	71.2	153.1	44.9	M8

431 SERIES

Squeeze Action Plier Clamps | Product Overview

Features:

- Tempered spring steel jaws provide exceptional jaw depth

Applications:

- Assembly
- Gluing, soldering

Also Available:

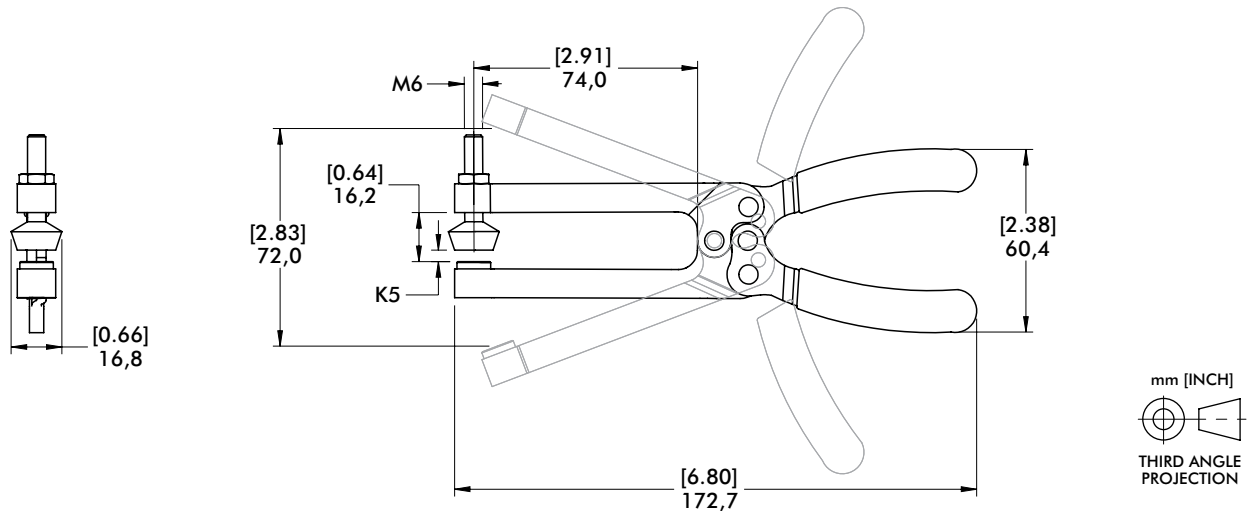
See page MC-ACC-1 for accessories

431



Technical Information | Holding Capacities | Dimensions

Model	Max. Holding Capacity	Weight	(K5) Maximum Clamping Thickness	Spindle (Supplied)
431	400 N [100 lbf]	0,14kg [0.31lb]	6,8 [0.27]	424208-M



425, 435 SERIES

Squeeze Action Plier Clamps | Product Overview

Features:

- Two way trigger release allows for fast and easy opening of clamp

Applications:

- Assembly
- Welding
- Gluing, soldering

Also Available:

See page MC-ACC-1 for accessories

425 ⓘ



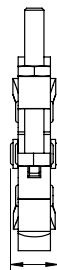
435



Technical Information | Holding Capacities | Dimensions

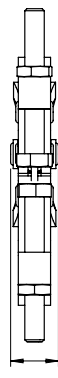
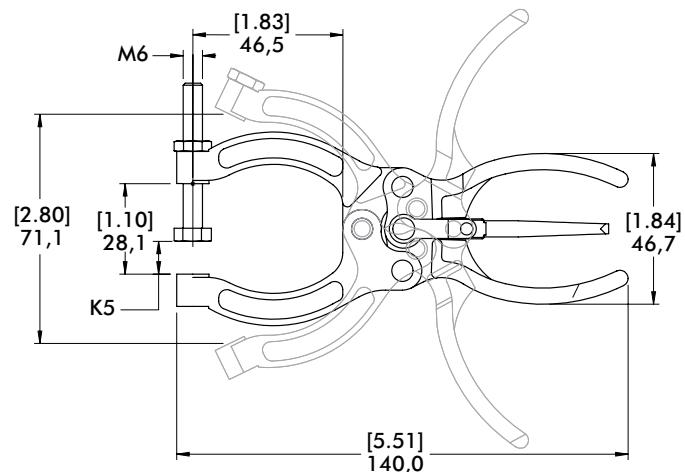
Model	Max. Holding Capacity	Weight	(K5) Maximum Clamping Thickness	Spindle (Supplied)
425 ⓘ	2220 N [500 lbf]	0,14kg [0.31lb]	24 [0.94]	205203-M
435		0,23kg [0.50lb]	36,3 [1.43]	(2X) 205203-M

ⓘ This item is available upon request



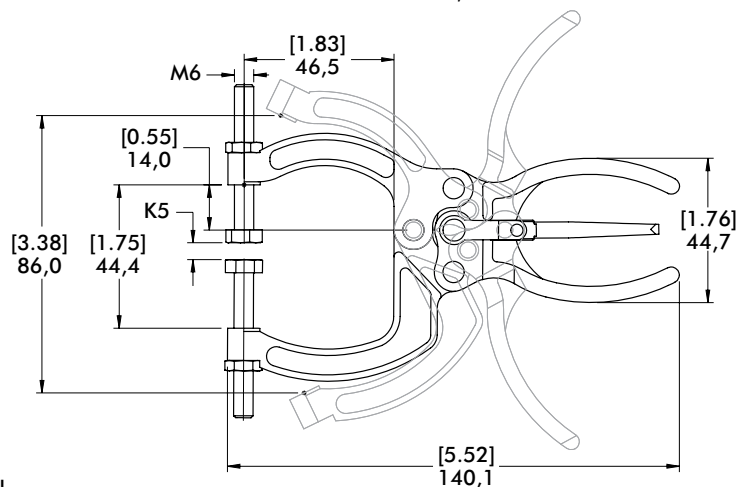
[0.58]
14,8

MODEL 425 AS SHOWN



[0.58]
14,8

MODEL 435 AS SHOWN



mm [INCH]
THIRD ANGLE PROJECTION

460, 480 SERIES

Squeeze Action Plier Clamps | Product Overview

Features:

- Drop forged alloy steel components for exceptional strength
- Two way trigger release allows for fast and easy opening of clamp

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1 for accessories

462



462-2

With Two Adjustable Spindles



463



482



484



486

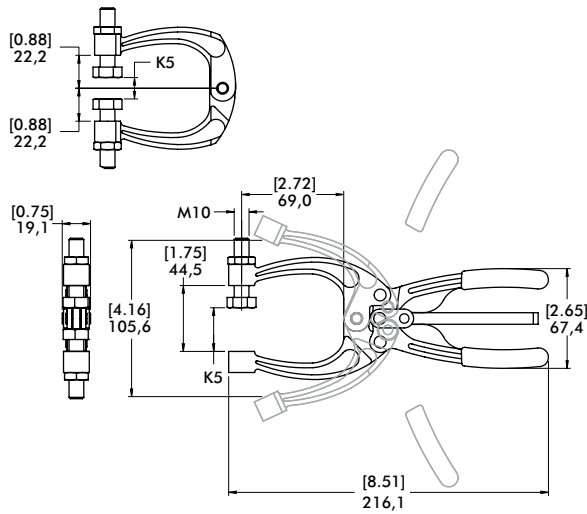


Technical Information | Holding Capacities

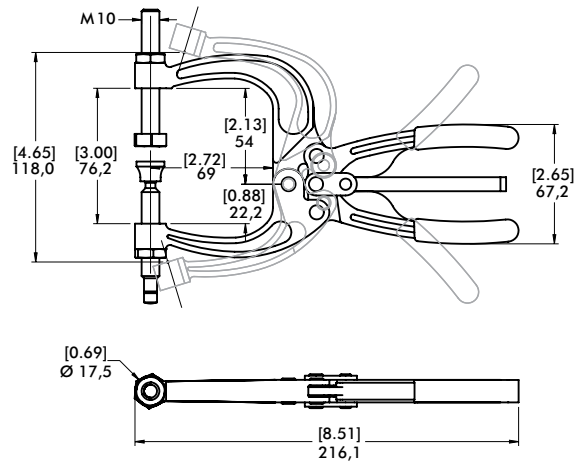
Model	Max. Holding Capacity	Weight	(K5) Maximum Clamping Thickness	Spindle (Supplied)
462	3110 N [700 lbf]	0,51kg [1.13lb]	29,5 [1.16]	468206-M 210206-M
462-2			30,5 [1.20]	(2X) 491203-M
463		0,54kg [1.19lb]	54,2 [2.13]	468206-M 210206-M
482	5340 N [1200 lbf]	0,79kg [1.75lb]	29,5 [1.16]	468206-M
484			0,91kg [2.00lb]	76,5 [3.01]
486		1,05kg [2.31lb]	138,4 [5.45]	(2X) 240203-M

460, 480 SERIES

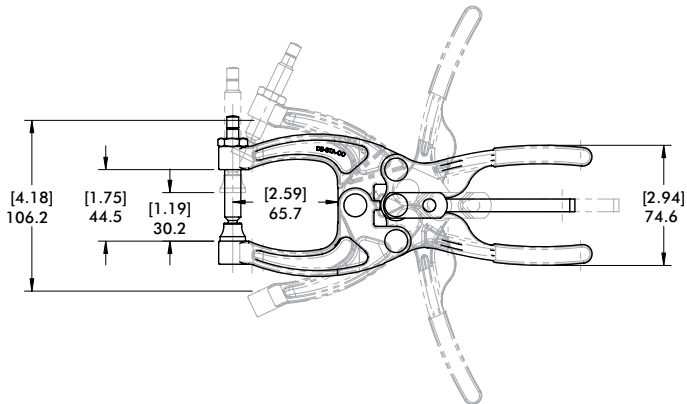
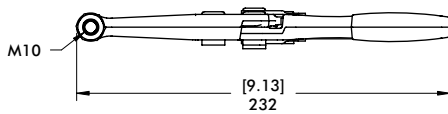
Squeeze Action Plier Clamps | Dimensions



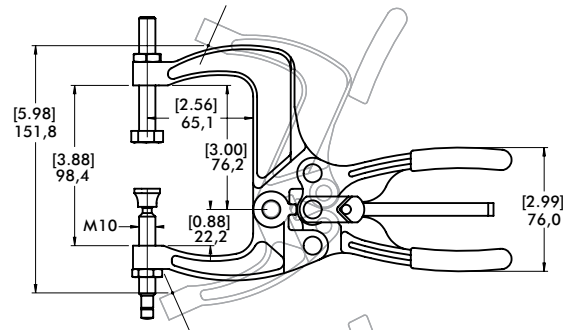
MODEL 462 AS SHOWN



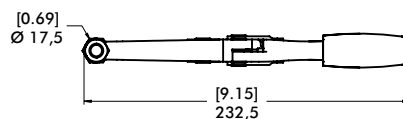
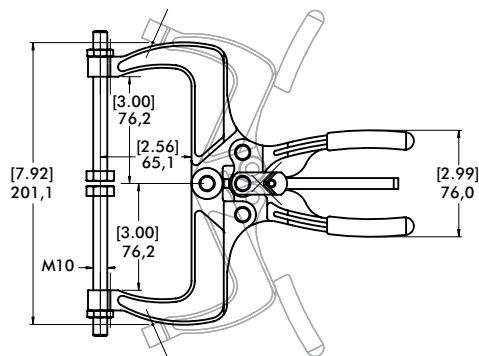
MODEL 463 AS SHOWN



MODEL 482 AS SHOWN

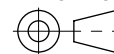


MODEL 484 AS SHOWN



MODEL 486 AS SHOWN

mm [INCH]



THIRD ANGLE PROJECTION

MANUAL CLAMPING ACCESSORIES

Manual Clamping Accessory Overview



Flat-Tip Bonded
Neoprene Spindle
– Inch



Large Diameter
Padded Swivel Foot
Spindle – Inch



Neoprene Caps



Bolt Retainers



Flat-Tip Bonded
Neoprene Spindle
– Metric



Swivel Foot
Spindle



Special Neoprene Caps



Flanged Washers



Round Bonded
Neoprene Spindle
– Metric



Hex Head
Spindle



Polyurethane Caps



Cone-Tip Bonded
Neoprene Spindle
– Metric



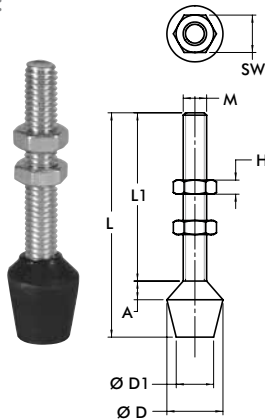
Plunger-matic
Assemblies



Cone-Tip
Polyurethane Caps

Flat-Tip Bonded Neoprene Spindle – Inch

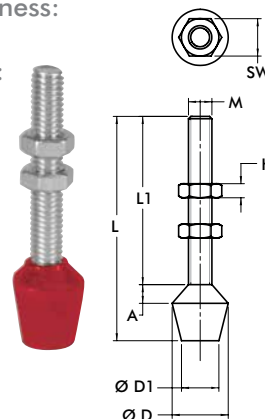
- Black neoprene, hardness: 70-80 Shore A
- Temperature Range: -20°C to 100°C [-22°F to 212°F]
- Oil resistant, LABS (silicone) free
- Includes jam nuts
- Stainless steel versions available upon request



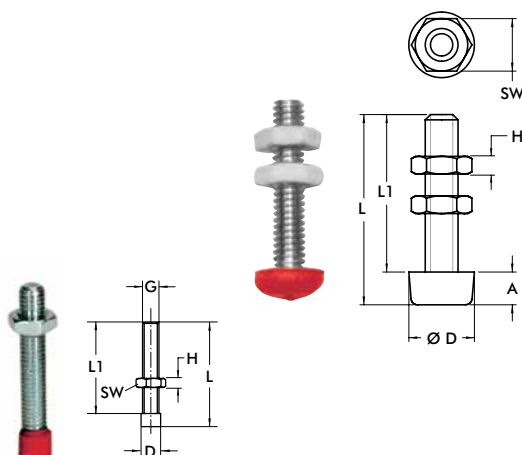
Part No.	M	L	L1	SW	H	A	ØD	ØD1
102208	#8-32	[1.25] 31,8	[0.94] 23,8	[0.34] 8,7	[0.13] 3,2	[0.06] 1,6	[0.56] 14,3	[0.44] 11,1
105208		[1.00] 25,4	[0.69] 17,4					
201208	#10-32	[1.38] 35,1	[1.01] 25,5	[0.38] 9,5		[0.13] 3,2		
202208	1/4-20	[1.63] 41,4	[1.08] 27,4	[0.44] 11,1	[0.16] 4	[0.12] 3	[0.63] 16	[0.47] 12
215208		2.13 54,1	[1.58] 40,1					
424208		[1.50] 38,1	[1.12] 28,5					
431208		[1.00] 25,4	[0.62] 15,8					
225208	5/16-18	[2.25] 57,2	[1.54] 39,1	[0.50] 12,7	[0.19] 4,8		[0.83] 21	[0.55] 14
507208		[3.00] 76,2	[2.29] 58,2			[0.20] 5	[1.02] 26	[0.79] 20
240208	3/8-16	[3.25] 82,6	[2.31] 58,5	[0.56] 14,3	[0.22] 5,6	[0.28] 7	[1.02] 26	[0.79] 20
527208		[3.50] 88,9	[2.50] 63,5					
235208		[5.75] 146,1	[4.77] 121,1					
247208	1/2-13	[3.87] 98,3	[2.73] 69,3	[0.75] 19,1	[0.31] 7,9	[0.28] 7	[1.18] 30	[0.95] 24
267208	5/8-11	[5.00] 127	[3.63] 92,1	[0.94] 23,8	[0.38] 9,5	[0.38] 9,5	[1.38] 35,1	[1.00] 25,4

Flat-Tip Bonded Neoprene Spindle – Metric

- Red neoprene, hardness: 80-85 Shore A
- Temperature Range: -20°C to 100°C [-22°F to 212°F]
- Oil resistant, LABS (silicone) free
- Includes jam nuts



Part No.	M	L	L1	SW	H	A	ØD	ØD1
431208-M	M6	[1.00] 25,4	[0.6] 15,8	[0.39] 10	[0.13] 3,2	[0.13] 3,3	[0.66] 16,8	[0.66] 16,8
424208-M		[1.63] 41,3	[1.25] 31,7					
202208-M		[1.73] 44	[1.18] 30					
215208-M		[2.13] 54	[1.57] 40			[0.12] 3	[0.63] 16	[0.47] 12
225208-M	M8	[2.09] 53	[1.38] 35	[0.51] 13	[0.16] 4	[0.20] 5	[0.83] 21	[0.55] 14
2007208-M		[2.48] 63	[1.77] 45					
507208-M		[3.27] 83	[2.56] 65					
240208-M	M10	[3.11] 79	[2.17] 55	[0.67] 17	[0.20] 5		[1.02] 26	[0.78] 20
235208-M		[4.72] 120	[3.74] 95					
247208-M	M12	[4.02] 102	[2.87] 73	[0.75] 19	[0.24] 6	[0.28] 7	[1.18] 30	[0.94] 24



Part No.	M	L	L1	SW	H	A	ØD
205208-M	M4	[0.87] 22	[0.79] 20	[0.28] 7	[0.09] 2,2	[0.11] 2,8	[0.32] 8
201208-M		[1.26] 32	[1.18] 30				
305208-M	M5	[1.14] 29	[0.98] 25	[0.32] 8	[0.11] 2,7	[0.20] 5	[0.39] 10
213208-M		[1.34] 34	[1.18] 30				
2013208-M		[1.54] 39	[1.38] 35				
307208-M	M8	[1.69] 43		[0.51] 13	[0.16] 4	[0.35] 9	[0.75] 19

Part No.	D	L	L1	ØG
213208-M-L [Ⓢ]	[0.24] 6	[1.34] 34	[1.18] 30	M5

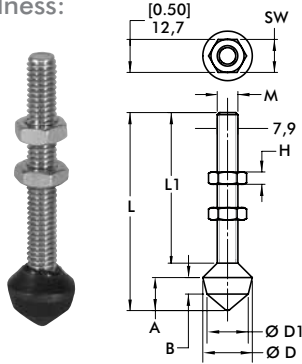
[Ⓢ] Item is available upon request.

SPINDLES

Manual Clamping Accessories | Technical Information | Dimensions

Cone-Tip Bonded Neoprene Spindle – Inch

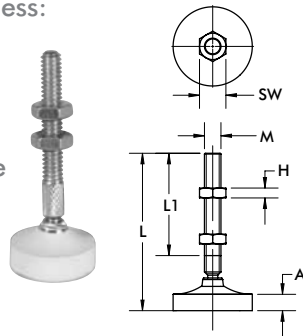
- Black neoprene, hardness: 70-80 Shore A
- Temperature Range: -20°C to 100°C [-22°F to 212°F]
- Oil resistant, LABS (silicone) free
- Includes jam nuts



Part No.	M	L	L1	SW	H	A	B	ØD	ØD1
305208	#10-32	[1.50] 38,1	[1.00] 25,4	[0.38] 9,5	[0.13] 3,3	[0.38] 9,5	[0.19] 4,8	[0.56] 14,2	[0.44] 11,2
213208	1/4-20	[2.25] 57,2	[1.56] 39,6	[0.44] 11,2	[0.16] 4,0				
509208	5/16-18	[3.00] 76,2	[2.28] 57,9	[0.50] 12,7	[0.19] 4,8	[0.50] 12,7	[0.25] 6,4	[0.75] 19,1	[0.63] 16
519208		[5.50] 139,7	[4.75] 120,7						
210208	3/8-16	[3.50] 88,9	[2.50] 63,5	[0.56] 14,2	[0.23] 5,8	[0.75] 19,1	[0.41] 10,4	[0.88] 22,4	[0.75] 19,1

Large Diameter Padded Swivel Foot Spindle-Inch

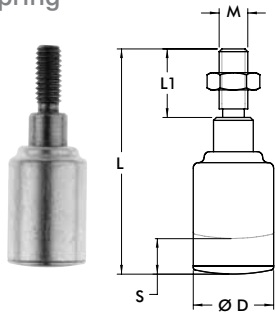
- White neoprene, hardness: 70-80 Shore A
- Temperature Range: -40°C to 105°C [-40°F to 220°F]
- Non-marking neoprene
- Includes jam nuts



Part No.	M	L	L1	SW	H	A	ØD	Swivel Angle
207209	1/4-20	[2.56] 65	[1.56] 39,6	[0.44] 11,2	[0.16] 4		[1.00] 25,4	14°
507209	5/16-18	[2.98] 75,7	[1.94] 49,3	[0.50] 12,7	[0.19] 4,8	[0.31] 8	[1.50] 38,1	24°
210209	3/8-16	[3.56] 90,4	[2.44] 62	[0.56] 14,2	[0.23] 5,8		[2.00] 50,8	26°

Plunger-matic Assemblies

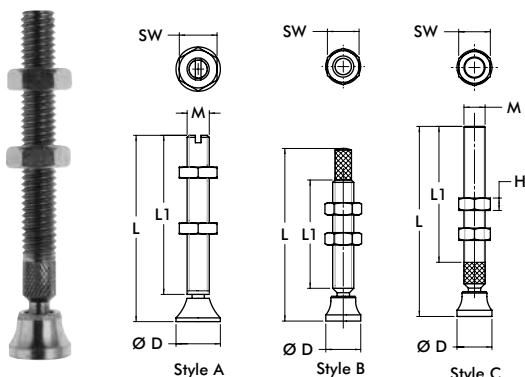
- For use with Straight Line Action clamps
- Internal compression spring compensates for variations in material thickness
- Zinc plated
- Includes jam nut



Part No.	M	L	L1	ØD	Max. Compression S	Spring Constant [lb./in] N/mm	Max. Force [lb.] N
905	5/16-18	[2.50] 63,5	[0.75] 19,1	[0.88] 22,2	[0.19] 4,8	[750] 131	[135] 600
905-M	M8						
920	3/8-16	[3.63] 92,2	[1.13] 28,6		[0.38] [9,6]	[822] 144	[308] 1370
920-M	M10						

Swivel Foot Spindle

- Includes jam nuts



Part No.	M	Style	L	L1	SW	H	ØD	Swivel Angle
207206-M	M6	A	[2.44] 62	[2.13] 54	[0.39] 10	[0.13] 3,2	[0.47] 12	30°
507206-M	M8		[2.87] 73	[2.46] 62,5	[0.51] 13	[0.16] 4	[0.63] 16	
468206-M	M10	B	[3.00] 76,2	[2.00] 50,8	[0.67] 17	[0.20] 5	[0.79] 20	24°
210206-M		A	[3.31] 84	[2.80] 71				
250206-M	M12	A	[4.72] 120	[4.13] 105	[0.75] 19	[0.24] 6	[0.98] 25	30°
207206	1/4-20	C	[2.38] 60,5	[1.56] 39,6	[0.44] 11,2	[0.16] 4	[0.50] 12,7	14°
507206	5/16-18		[2.75] 69,9	[1.94] 49,3	[0.50] 12,7	[0.19] 4,8	[0.56] 14,2	
468206	3/8-16	B	[3.06] 77,7	[1.92] 48,8	[0.56] 14,2	[0.23] 5,8	[0.63] 16	24°
210206		C	[3.38] 85,9	[2.41] 61,2				
250206	1/2-13	C	[4.63] 117,6	[3.44] 87,4	[0.75] 19,1	[0.31] 7,9	[1.00] 25,4	24°

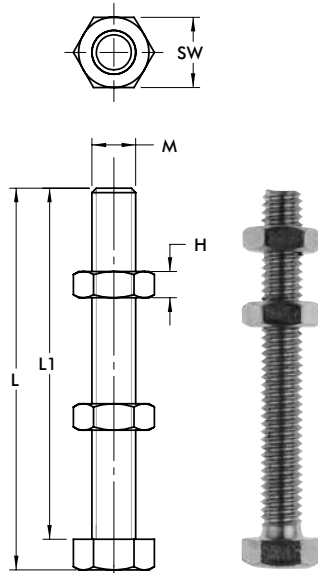
Hex Head Spindle – Stainless Steel

- Includes Plain hexagonal head
- Includes Fully threaded
- Includes Stainless steel, type 303
- Includes jam nuts

Part No.	M	L	L1	SW	H	Part No.	M	L	L1	SW	H
205943-M	M4	[0.89] 22	[0.79] 20	[0.28] 7	[0.09] 2,2	205943	#8-32	[0.86] 21,8	[0.75] 19,1	[0.25] 6,4	[0.13] 3,2
201943-M	M5	[1,32] 33,5	[1.18] 30	[0.31] 8	[0.11] 2,7	201943	#10-32	[1,37] 34,8	[1,37] 34,8	[0.31] 8	
202943-M	M6	[1.73] 42,4	[1.57] 40	[0.39] 10	[0.13] 3,2	202943	1/4-20	[1.67] 42,4	[1.50] 38,1	[0.44] 11,1	[0.16] 4
207943-M	M8	[2.77] 70,3	[2.56] 65	[0.51] 13	[0.16] 4	207943	5/16-18	[2.72] 69	[2.50] 63,5	[0.50] 12,7	[0.19] 4,8
237943-M	M10	[3.00] 76,4	[2.76] 70	[0.67] 17	[0.20] 5	237943	3/8-16	[2.75] 69,9	[2.56] 65,2	[0.56] 14,2	[0.22] 5,6
245943-M	M12	[2.87] 73	[2.56] 65	[0.75] 19	[0.24] 6	245943	1/2-13	[2.72] 69	[2.38] 60,5	[0.75] 19,1	[0.31] 8

Hex Head Spindle

- Plain hexagonal head
- Fully threaded
- Zinc plated
- Includes jam nuts



Part No.	M	L	L1	SW	H	Part No.	M	L	L1	SW	H
205203-M	M6	[1.93] 49	[1.77] 45	[0.39] 10	[0.13] 3,2	205203	1/4-20	[1.92] 48,8	[1.75] 44,5	[0.44] 11,2	[0.16] 4
461203-M	M8	[1.20] 30,5	[0.98] 25	[0.51] 13	[0.16] 4	202203	1/4-20	[3.17] 80,5	[3.00] 76,2	[0.44] 11,2	[0.16] 4
207203-M		[2.97] 75,5	[2.76] 70			461203		[1.22] 31	[1.00] 25,4		
491203-M	M10	[1.85] 47	[1.57] 40	[0.67] 17	[0.20] 5	441203	5/16-18	[1.97] 50	[1.75] 44,5	[0.50] 12,7	[0.19] 4,8
210203-M		[3.03] 77	[2.76] 70			207203	5/16-18	[2.72] 69,1	[2.50] 63,5	[0.50] 12,7	[0.19] 4,8
240203-M		[4.21] 107	[3.94] 100			491203		[1.75] 44,5	[1.50] 38,1		
220203-M	M12	[3.46] 88	[3.15] 80	[0.75] 19	[0.24] 6	210203	3/8-16	[3.00] 76,2	[2.75] 69,9	[0.56] 14,2	[0.23] 5,8
267203-M	M16	[5.12] 130	[4.72] 120	[0.94] 24	[0.28] 7	240203		[4.25] 108	[4.00] 101,6		
105203*	#8-32	[0.86] 21,8	[0.75] 19,1	[0.25] 6,4	[0.13] 3,3	527203	1/2-13	[5.25] 133,4	[5.00] 127	[0.75] 19,1	[0.31] 7,9
305203	#10-32	[1.12] 28,4	[1.00] 25,4	[0.31] 8		325203		[2.84] 72,1	[2.50] 63,5		
						220203		[3.34] 84,8	[3.00] 76,2		
						250203	5/8-11	[4.42] 111,6	[4.00] 101,6	[0.38] 9,5	[0.38] 9,5

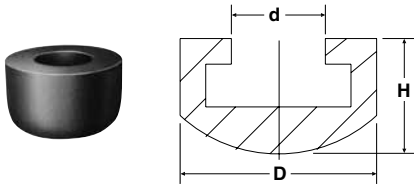
*Material: nylon

SPINDLE CAPS

Manual Clamping Accessories | Technical Information | Dimensions

Neoprene Caps

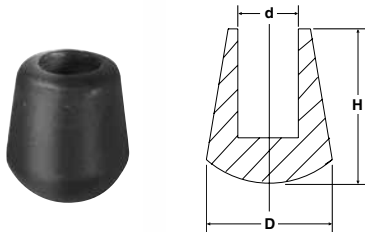
- Slip on head of hex-head spindles
- Hardness: 60-70 Shore A
- Temperature range:
-40°C to 105°C [-40°F to 220°F]



Part No.	D	d	H	For Spindle Diameter
215119	[0.63] 16	[0.25] 6,35	[0.44] 11,1	M6 or 1/4
225119	[0.75] 19,1	[0.31] 8	[0.50] 12,7	M8 or 5/16
235119	[0.88] 22,3	[0.38] 9,7	[0.53] 13,5	3/8

Special Neoprene Caps

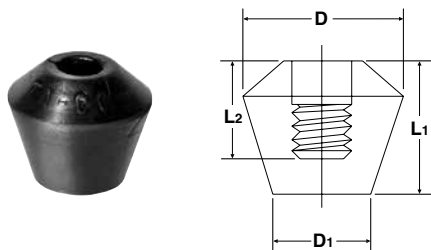
- Slip on threaded spindle rod
- Hardness: 60-70 Shore A
- Temperature range:
-40°C to 105°C [-40°F to 220°F]



Part No.	D	d	H	For Spindle Diameter
424107	[0.44] 11,1	[0.22] 5,6	[0.44] 11,1	M6 or 1/4
235110	[0.72] 18,3	[0.34] 8,6	[0.88] 22,3	M10 or 3/8

Polyurethane Caps

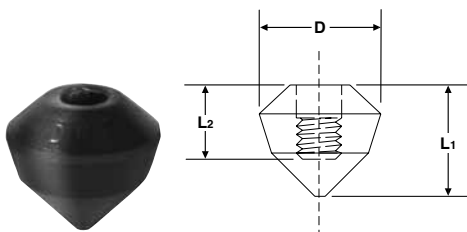
- Flat tip, internally threaded
- Hardness: 80 Shore A
- Temperature range:
-70°C to 95°C [-90°F to 200°F]



Part No.	D	D1	L1	L2	For Spindle Diameter
215219					1/4-20
215219-M	[0.79] 20	[0.50] 12,7	[0.69] 17,5	[0.50] 12,7	M6 x 1.0
225219					5/16-18
225219-M					M8 x 1.25
235219	[0.81] 20,5	[0.63] 16	[0.88] 22,3	[0.63] 16	3/8-16
235219-M					M10 x 1.5

Polyurethane Caps – Cone-tip

- Cone tip, internally threaded
- Hardness: 80 Shore A
- Temperature range:
-70°C to 95°C [-90°F to 200°F]



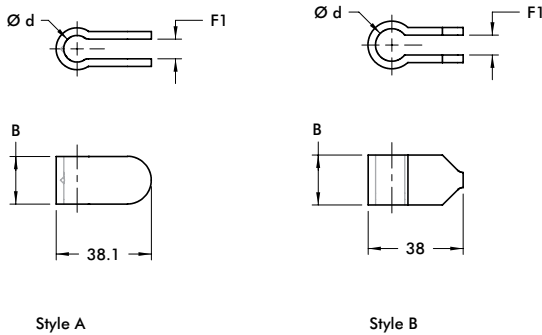
Part No.	D	L1	L2	For Spindle Diameter
215319				1/4
225319	[0.81] 20,5	[0.75] 19,1	[0.50] 12,7	5/16
235319		[0.94] 23,9	[0.63] 16	3/8

BOLT RETAINERS, WASHERS

Manual Clamping Accessories | Technical Information | Dimensions

Bolt Retainers –

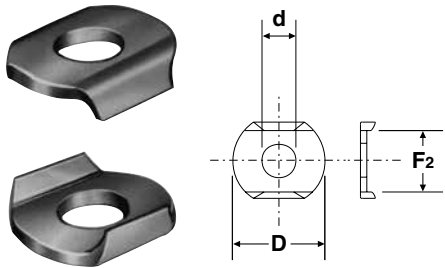
- For use with clamps featuring U-bar and open bar clamping arms



Part No.	A	B	Ød	F1	For Spindle Diameter	Style
207105	[1.25] 31,8	[0.63] 16	[0.33] 8,4	[0.25] 6,4	M8 or 5/16	A
207105-M	[1.26] 32		[0.32] 8,2	[0.24] 6		B
210114	[1.50] 38,1	[0.75] 19,1	[0.53] 13,5	[0.31] 8	M10 or 3/8	A
210114-M	[1.49] 38	[0.78] 20	[0.51] 13			B
247110	[1.63] 41,4	[0.88] 22,3	[0.56] 14,2	[0.38] 9,7	M12 or 1/2	A
247110-M	[1.61] 41	[0.87] 22,2	[0.57] 14,4			B
250121	[1.88] 47,8	[1.00] 25,4	[0.64] 16,3		M12 or 1/2	A
2002115-E	[0.97] 24,6	[0.50] 12,7	[0.26] 6,6	[0.23] 5,8	M6 or 1/4	B
2007115-E	[1.26] 32	[0.75] 19,1	[0.34] 8,6		M8 or 5/16	
2010115-E	[1.58] 40,1	[1.13] 28,7	[0.41] 10,4	[0.32] 8,1	M10 or 3/8	

Flanged Washers –

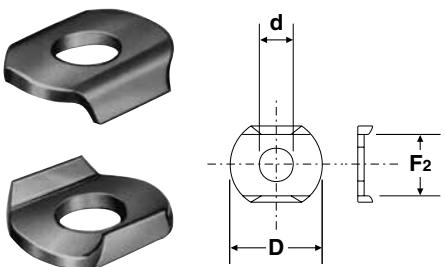
- For use with clamps featuring U-bar and open bar clamping arms
- Zinc plated



Part No.	ØD	Ød	F2	For Spindle Diameter
105106	[0.44] 11,2	[0.17] 4,3	[0.33] 8,3	M4 or #8
102111	[0.56] 14,2	[0.20] 5,1	[0.38] 9,6	M5 or #10
215105	[0.69] 17,5	[0.26] 6,7	[0.50] 12,7	M6 or 1/4
507107	[0.88] 22,4	[0.33] 8,4	[0.59] 15	M8 or 5/16
235106	[1.00] 25,4	[0.41] 10,5	[0.75] 19,1	M10 or 3/8
247109	[1.26] 32	[0.53] 13,5	[0.91] 23,2	M12 or 1/2
267102	[1.44] 36,5	[0.66] 16,8	[1.03] 26,2	M16 or 5/8

Flanged Washers-Stainless Steel

- For use with clamps featuring U-bar and open bar clamping arms



Part No.	ØD	Ød	F2	For Spindle Diameter
105906	[0.44] 11,2	[0.17] 4,3	[0.33] 8,3	M4 or #8
102911	[0.56] 14,2	[0.20] 5,1	[0.38] 9,6	M5 or #10
215905	[0.69] 17,5	[0.26] 6,7	[0.50] 12,7	M6 or 1/4
507907	[0.88] 22,4	[0.33] 8,4	[0.60] 15,2	M8 or 5/16
235906	[1.00] 25,4	[0.41] 10,5	[0.75] 19,1	M10 or 3/8
247909	[1.26] 32	[0.53] 13,5	[0.91] 23,2	M12 or 1/2
267902	[1.44] 36,6	[0.66] 16,8	[1.03] 26,2	M16 or 3/8

ADAPTERS & EXTENSIONS

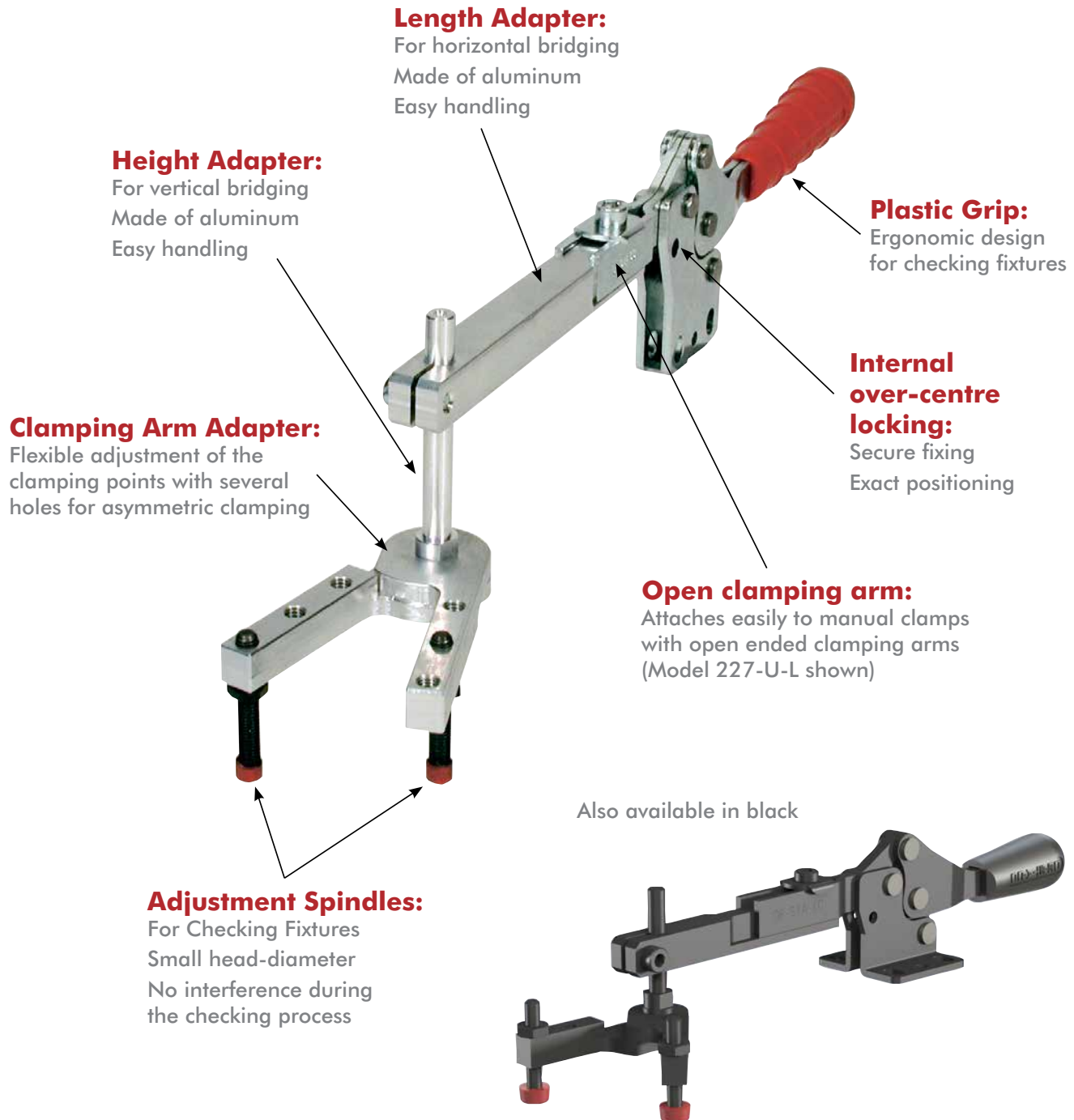
Manual Clamping Accessories | Product Overview

Features:

- Provides flexible adjustment of length and height
- Mounts to manual clamp models that feature open clamping arms
- Lightweight aluminum

Application Areas:

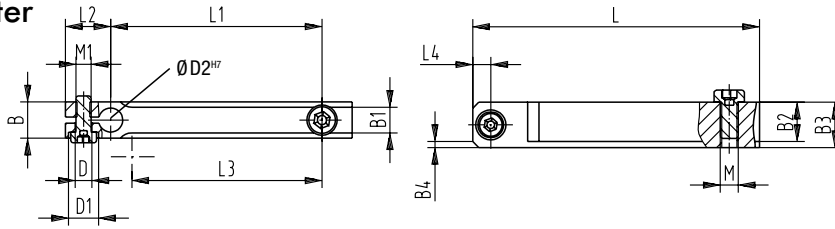
- Checking fixtures
- Areas requiring multiple clamping points



ADAPTERS & EXTENSIONS

Manual Clamping Accessories | Dimensions

Length Adapter

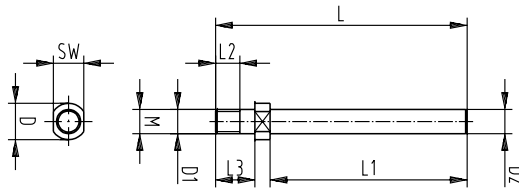


Model no.	Length adapter	B	B1 +0, -,1	B2	B3	B4	DØ	D1 Ø	D2 ^{H7}	L	L1 ±0,2	L2	L3	L4	M	M1
213-U-L / 213-UB-L 2013-U / 2013-UB 2013-UR / 2013-UBR	L-213-1-01 ①	[0.39] 10	[0.22] 5,5	[0.31] 8	[0.39] 10	2x 45°	[0.22] 5,5	--		[1.97] 50 [3.54] 90	[1.18] 30 [2.76] 70	[0.47] 12	[0.79] 20	[0.20] 5	M4	M5
	L-213-1-02 ①															
202-U-L / 202-UB-L 217-U-L / 217-UB-L 2002-U-L / 2002-UB-L 2017-U / 2017-UB 2017-UR / 2017-UBR	L-217-1-01 ①								[0.24] 6	[2.17] 55 [3.74] 95	[1.18] 30 [2.76] 70		[1.30] 33			
	L-217-1-02 ①		[0.26] 6,5	[0.35] 9	[0.47] 12	2x 45°	[0.22] 5,5			[5.31] 135	[4.33] 110		[1.89] 48		M5	M5
	L-217-1-03 ①															
207-U-L / 207-UB-L 227-U-L / 227-UB-L 2007-U-LS / 2007-U-LS 2027-U / 2027-UB 2027-UR / 2027-UBR	L-227-1-01 ①	[0.47] 12						[0.39] 10		[2.17] 55 [3.74] 95	[1.18] 30 [2.76] 70	[0.59] 15	[1.30] 33	[0.24] 6		
	L-227-1-02 ①		[0.33] 8,5	[0.51] 13	[0.59] 15	2x 45°	[0.22] 5,5		[0.31] 8	[5.31] 135 [6.89] 175	[4.33] 110 [5.91] 150		[2.87] 73		M6	M5
	L-227-1-03 ①															
	L-227-1-04 ①															

① Available upon request.

Also available in Black. Add **-BLK** to part number.

Height Adapter



Model no.	Height adapter	DØ	D1 Ø f7	D2 f7	L	L1	L2	L3	SW	M
213-U-L / 213-UB-L 2013-U / 2013-UB 2013-UR / 2013-UBR	L-213-2-01 ①		[0.20] 5	[0.24] 6	[2.05] 52	[1.38] 35				M5
	L-213-2-02 ①				[3.23] 82	[2.56] 65				
202-U-L / 202-UB-L 217-U-L / 217-UB-L 2002-U-LS / 2002-UB-LS 2017-U / 2017-UB 2017-UR / 2017-UBR	L-217-2-01 ①	[0.39] 10			[2.05] 52	[1.38] 35		[0.47] 12	[0.31] 8	M6
	L-217-2-02 ①		[0.24] 6	[0.24] 6	[3.23] 82	[2.56] 65	[0.31] 8			
	L-217-2-03 ①									
207-U-L / 207-UB-L 227-U-L / 227-UB-L 2007-U-LS / 2007-U-LS 2027-U / 2027-UB 2027-UR / 2027-UBR	L-227-2-01 ①		[0.31] 8	[0.31] 8	[2.09] 53	[1.38] 35		[0.51] 13	[0.39] 10	M8
	L-227-2-02 ①				[3.23] 82	[2.56] 65				

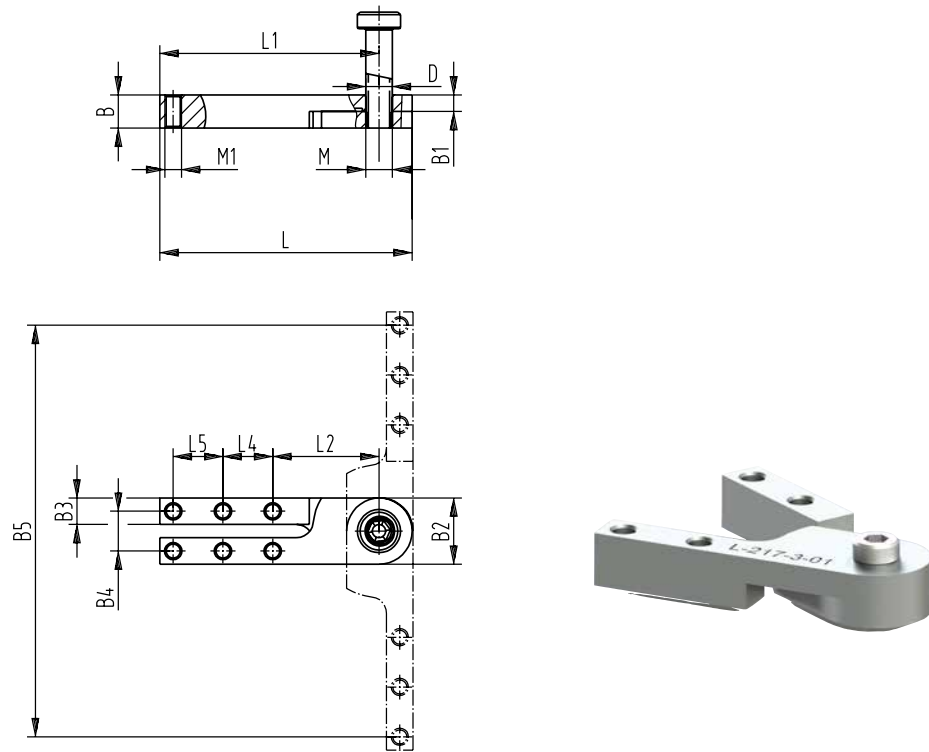
① Available upon request.

Also available in Black. Add **-BLK** to part number.

ADAPTERS & EXTENSIONS

Manual Clamping Accessories | Dimensions

Clamping Arm Adapter



Model no.	Clamping arm adapter	B	B1	B2	B3	B4	B5	DØ _{H7}	L	L1	L2	L4	L5	L6	M	M1
213-U-L / 213-UB-L 2013-U / 2013-UB 2013-UR / 2013-UBR	L-213-3-01 ⓘ							[0.20] 5					-		M5	M5
202-U-L / 202-UB-L 217-U-L / 217-UB-L 2002-U-LS / 2002-UB-LS 2017-U / 2017-UB 2017-UR / 2017-UBR	L-217-3-01 ⓘ	[0.39] 10	[0.20] 5	[0.79] 20	[0.31] 8	[0.47] 12	[3.70] 94	[0.24] 6	[2.40] 61	[2.01] 51	[1.26] 32	[0.59] 15		[0.39] 10	M6	M5
207-U-L / 207-UB-L 227-U-L / 227-UB-L 2007-U-LS / 2007-UB-LS 2027-U / 2027-UB 2027-UR / 2027-UBR	L-227-3-01 ⓘ						4.88 124	[0.31] 8	[2.99] 76	[2.60] 66			[0.59] 15		M8	M5

ⓘ Available upon request.

Also available in Black. Add **-BLK** to part number.

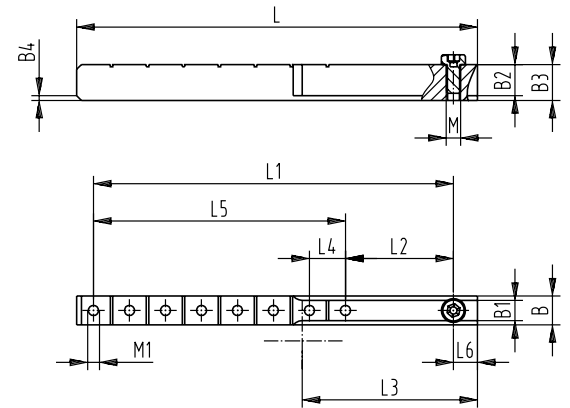
ADAPTERS & EXTENSIONS

Manual Clamping Accessories | Dimensions

Arm Extension:

- Easily cut to length
- Drilled & tapped for spindle attachment

Note: adding arm extension will reduce the clamp's holding capacity. Refer to Technical Appendix for details



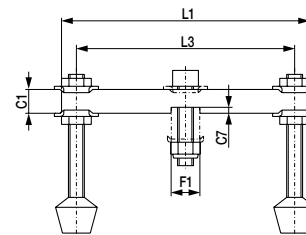
Model no.	Extension link	B	B1 +0, -1	B2	B3	B4	L ±0,2	L1	L2	L3	L4	L5	L6	M	M1
213-U-L / 213-UB-L 2013-U / 2013-UB 2013-UR / 2013-UBR	L-213-4-01 ⓘ	[0.39] 10	[0.22] 5,5	[0.31] 8	[0.39] 10	2x 45°	[2.95] 75	[2.36] 60	[0.94] 24	[0.79] 20	[0.47] 12	[1.42] 36	[0.31] 8	M4	M5
202-U-L / 202-UB-L 217-U-L / 217-UB-L 2002-U-LS / 2002-UB-LS 2017-U / 2017-UB 2017-UR / 2017-UBR	L-217-4-01 ⓘ		[0.26] 6,5	[0.35] 9	[0.47] 12	2x 45°	[5.00] 127	[4.33] 110	[1.38] 35	[1.89] 48		[2.95] 75	[0.39] 10	M5	M5
207-U-L / 207-UB-L 227-U-L / 227-UB-L 2007-U-LS / 2007-UB-LS 2027-U / 2027-UB 2027-UR / 2027-UBR	L-227-4-01 ⓘ	[0.47] 12									[0.59] 15				
			[0.33] 8,5	[0.51] 13	[0.59] 15	2x 45°	[6.57] 167	[5.91] 150	[1.77] 45	[2.87] 73		[4.13] 105	[0.39] 10	M6	M5

ⓘ Available upon request.

Also available in Black. Add **-BLK** to part number.

Cross Arm Set

- 1 x cross arm
- 2 x adjustment spindles with neoprene thrust pads vulcanized, resin-free, inc.
- 2 x fastening nuts
- 4 x flange washers
- 1 x screw incl. 1 x fastening nut, self-locking


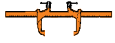





Model no.	For Models with U Arms	C1	C7	F	F1	L1	L3	Adjustable Spindles
207426-Q	207, 225, 227	[0.47] 12	[0.12] 3	[0.31] 35	[0.57] 14,5	[4.92] 125	[4.33] 110	507208-M
210440-Q	210, 235, 237	[0.63] 16	[0.16] 4	[0.43] 11	[0.75] 19	[5.87] 149	[5.12] 130	240208-M



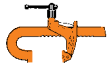
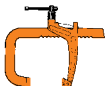
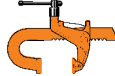
CARVER CLAMP SERIES

Product Overview

Bar-Style

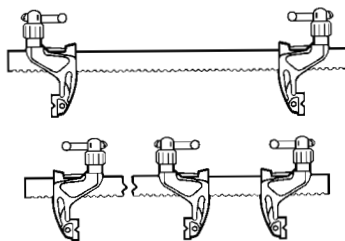
	Model	Holding Capacity max	Page MC-CVR-#
	T186-24 T186-36	[2500 lbf] 11300N	3-4
	T321-24 T321-36 T321-60	[1500 lbf] 5650N	
	T290-36 T290-60 T290-84	[4000 lbf] 18000N	
	T285-36 T285-60 T285-84	[2000 lbf] 9000N	
	T257-84	[6000 lbf] 27000N	

C-Style

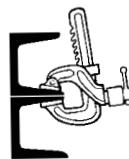
	Model	Holding Capacity max	Page MC-CVR-#
	T186-6 T186-12 T186-20	[2500 lbf] 11300N	5-6
	T321-10	[1270 lbf] 5650N	
	T290-9 T290-18 T290-40	[4000 lbf] 18000N	
	T285-9 T285-18	[2000 lbf] 9000N	
	T257-24 T257-36	[6000 lbf] 27000N	

Typical Applications

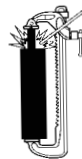
Bar Clamps



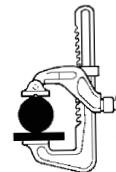
"C" Clamps



No obstruction from long screw. Ideal for structural steel fabrication.



Unaffected by weld spatter. Screw is shielded and out of work area.

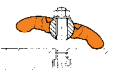
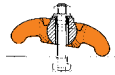
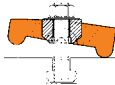


Holds rounds to flats. Limited movement of moveable jaw pad and grooved face ensure positive grip on round objects.





CARVER CLAMP SERIES

Product Overview

Buttress-Style

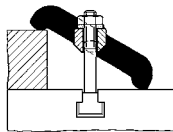
	Model	Holding Capacity max	Page MC-CVR-#
	T614-0	[2900 lbf] 13000N	7-8
	T614-1	[14000 lbf] 62500N	
	T614-2	[18000 lbf] 80000N	

T-Slot Style

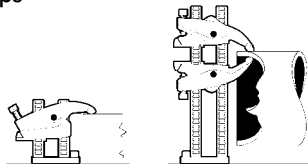
	Model	Holding Capacity max	Page MC-CVR-#
	T400-4 T400-6 T400-8	[5100 lbf] 22700N	9-12
	T600-4 T600-6 T600-8	[3600 lbf] 16000N	
	T402-6 T402-12 T402-18 T402-24	[8160 lbf] 36300N	
	T602-6 T602-12 T602-18	[5620 lbf] 25000N	

Typical Applications

Buttress Clamps



T-Slot Clamps



Ideal for use as manual die clamps. Eliminates the need for step blocks or riser blocks.

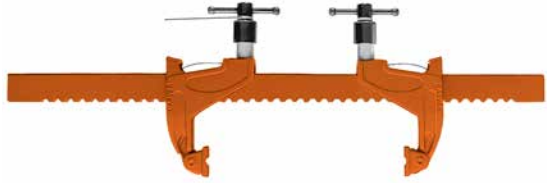
BAR-STYLE SERIES

CARVER Clamps | Product Overview

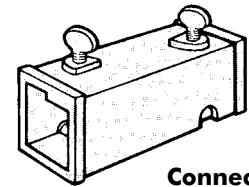
Features:

These rugged clamps, made from high-tensile, heat-treated steel, are designed for all types of applications requiring large holding capacities from 1270 lbf to 6000 lbf (5650N to 27000N). The clamps are highly versatile. For example, jaws can be reversed to provide spreading action, or several jaws can be used on a single bar both for fixturing and positive component location and clamping.

Available models include T321 Standard-Duty Deep Throat, T285 Medium-Duty Deep Throat, T186 Standard-Duty, T290 Medium-Duty and T257 Heavy-Duty. In addition, standard and medium-duty connectors are available to couple like bars together for increased clamping reaches.



Model	For Bar Clamps Model	Weight [lbs.] kg
186-13	T186-... and T321-...	[1.54] 0,7
290-13	T285-... and T290-...	[2.87] 1,3



Connector

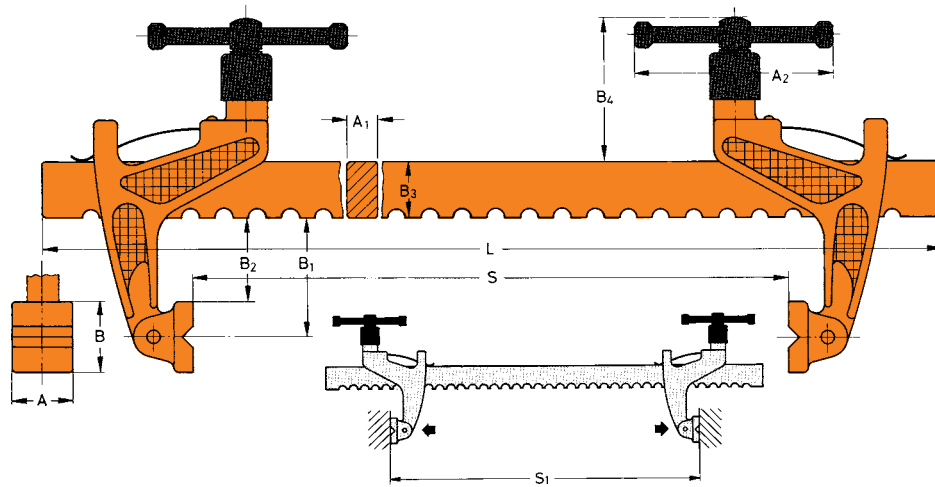
Technical Information | Holding Capacities

Holding Capacity	Throat Depth	Width Opening S		Width Opening S1		Model	Clamping Screw Ø	Weight [lbs.] kg	Consisting of:		
		min	max	min	max				1x	2x	
 [2500 lbf] 11300N	[2.38] 60	[8.50] 215	[24] 600	[36] 900	[2.95] 75	[26.8] 680	T186-24	M12	[7.50] 3,4	186-24-1	186-2
			[39] 990		[26.8] 680	[9.50] 4,4					
 [1270 lbf] 5650N	[4.7] 120	[5.50] 140	[24] 600	[36] 900	[3.15] 80	[27.2] 690	T321-24	M12	[7.70] 3,5	186-24-1	321-2
			[39] 990		[39.4] 1000	[9.00] 4,5					
			[60] 1500		[63] 1600	[13.00] 5,9					
 [4000 lbf] 18000N	[3.5] 90	[10.00] 250	[36] 900	[60] 1500	[4.72] 120	[36.9] 1005	T290-36	M16	[20.50] 10,5	290-36-1	290-2
			[48] 1200		[63.8] 1620	[28.50] 14,0					
			[60] 1500		[87.4] 2220	[36.50] 18,0					
 [2000 lbf] 9000N	[8.0] 200	[6.00] 150	[36] 900	[60] 1500	[4.72] 120	[42.7] 1085	T285-36	M16	[24.50] 10,5	290-36-1	285-2
			[48] 1200		[66.93] 700	[32.50] 15,0					
			[60] 1500		[90.6] 2300	[40.50] 19,0					
 [6000 lbf] 27000N	[4.5] 115	[12.00] 305	[84] 2100	[5.90] 150	[86.6] 2200	T257-84	M20	[61.00] 27,2	257-84-1	257-2	

① Available upon request

BAR-STYLE SERIES

CARVER Clamps | Dimensions



Model	[inch] mm								
	A	A1	A2	B	B2	B3	B4	L	
T186-24								[28] 710	
T186-36	[0.98] 25	[0.47] 12	[2.99] 76	[1.26] 32	[1.73] 44	[1.18] 30	[2.99] 76	[40.2] 1020	
T321-24								[28] 710	
T321-36	[0.98] 25	[0.47] 12	[2.99] 76	[1.26] 32	[4.09] 104	[1.18] 30	[2.99] 76	[40.2] 1020	
T321-60								[64] 1625	
T290-36								[42.1] 1070	
① T290-60	[1.50] 38	[0.79] 20	[5.51] 140	[2.00] 51	[2.56] 65	[1.57] 40	[4.13] 105	[66.5] 1690	
① T290-84								[90.2] 2290	
T285-36								[42.1] 1070	
① T285-60	[1.50] 38	[0.79] 20	[5.51] 140	[2.00] 51	[7.09] 180	[1.57] 40	[4.13] 105	[66.5] 1690	
① T285-84								[90.2] 2290	
① T257-84	[2.00] 51	[0.87] 22	[7.36] 187	[2.50] 63,5	[3.27] 83	[2.05] 52	[5.00] 127	[91.9] 2335	

① Available upon request

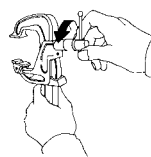
C-STYLE SERIES

CARVER Clamps | Product Overview

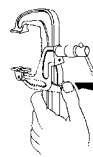
Features:

Operation is very simple. The operator slides the spring loaded moveable jaw toward the workpiece to the nearest notch where it locks into the detent. Hand tightening the screw advances the clamp jaw. The jaw advances the tilting pad directly into contact with the workpiece – there is no rotating to twist the work or the clamp out of position.

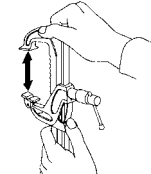
An unusual and very useful feature of these clamps is the ability to use the clamp for spreading or locating as well as squeezing..



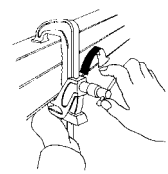
1. Loosen Screw



2. Push In Jaw Base



3. Slide Jaw Up or Down



4. Tighten Screw

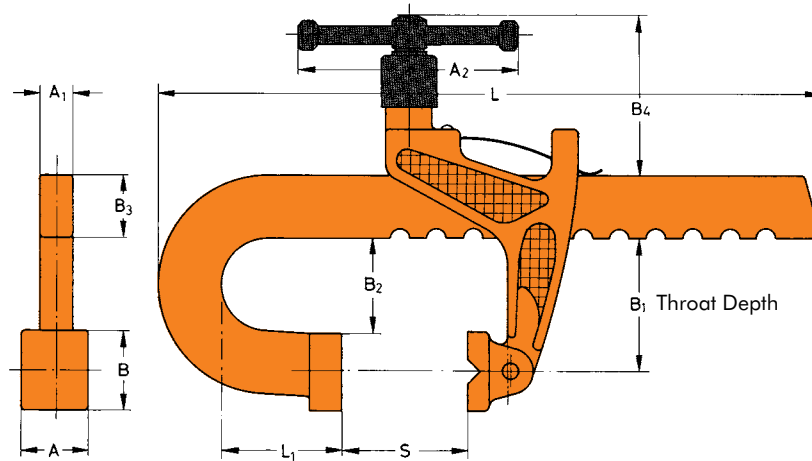
Technical Information | Holding Capacities

Holding Capacity	Throat Depth B1 [in] mm	Width Opening S [in] mm	Model	Clamping Screw Ø	Weight [lbs.] kg	Consisting of:			
						1 x	1 x		
 [2,500 lbf] 11300N	[2.38] 60	[0-6] 0-150	T186-6	M12	[2.75] 1,4	186-6-1	186-2		
		[0-12] 0-300	T186-12		[3.75] 1,8			186-12-1	186-2
		[0-20] 0-500	T186-20		[5.51] 2,5			186-20-1	186-2
 [1,270 lbf] 5650N	[4.7] 120	[0-10] 0-250	T321-10	M12	[4.4] 2,0	321-10-1	321-2		
 [4,000 lbf] 18000N	[3.5] 90	[0-9] 0-225	T290-9	M16	[10.00] 5,5	290-9-1	290-2		
		[0-18] 0-450	T290-18		[13.50] 7,0			290-18-1	290-2
		[0-40] 0-1000	T290-40		[23.15] 10,5			290-40-1	290-2
 [2,000 lbf] 9000N	[8.0] 200	[0-9] 0-225	T285-9	M16	[12.00] 7,1	285-9-1	285-2		
		[0-18] 0-450	T285-18		[13.50] 8,5			285-18-1	285-2
 [6,000 lbf] 27000N	[4.5] 115	[0-24] 0-600	T257-24	M20	[27.50] 13,1	257-24-1	257-2		
		[0-36] 0-900	T257-36		[32.50] 15,8			257-36-1	257-2

① Available upon request

C-STYLE SERIES

CARVER Clamps | Dimensions



Model	[inch] mm								
	A	A1	A2	B	B2	B3	B4	L	L1
T186-6				[1.26] 32		[1.30] 33		[9.65] 245	[.79] 20
T186-12	[0.98] 25	[0.51] 13	[3.00] 76	[1.26] 38	[1.69] 43	[1.30] 33	[3.00] 76	[15.55] 395	[.79] 20
Ⓜ T186-20				[1.38] 35		[1.18] 30		[24.61] 625	[1.18] 30
T321-10	[0.98] 25	[0.51] 13	[3.00] 76	[1.38] 35	[4.02] 102	[1.32] 33,5	[3.00] 76	[14.2] 360	[1.00] 25
T290-9								[16.53] 420	
T290-18	[1.57] 40	[0.79] 20	[5.51] 140	[2.36] 60	[2.56] 65	[1.57] 40	[4.13] 105	[25.78] 655	[2.56] 65
Ⓜ T290-40								[47.44] 1205	
T285-9								[16.53] 420	
T285-18	[1.57] 40	[0.79] 20	[5.51] 140	[2.36] 60	[7.09] 180	[1.57] 40	[4.13] 105	[25.78] 655	[2.56] 65
T257-24								[33.46] 850	
T257-36	[2.00] 51	[0.87] 22	[7.36] 187	[2.36] 60	[3.35] 85	[2.00] 51	[5.00] 127	[45.87] 1165	[3.94] 100

Ⓜ Available upon request

BUTTRESS-STYLE SERIES

CARVER Clamps | Product Overview

Features:

These workholding clamps are designed for use on thin or low-profile workpieces replacing ordinary strap clamps. They feature a self-aligning swiveling pivot which allows the tightening bolt to always remain vertical, preventing any side forces. The two-point contact offered by Models T614-0 and T614-1 also provides greater stability to the workpiece. Ideally suited for manual die clamping. Eliminates the need for step blocks or riser blocks.



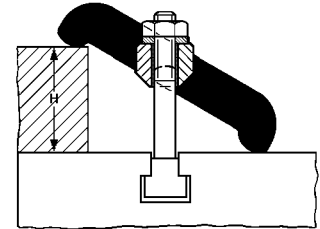
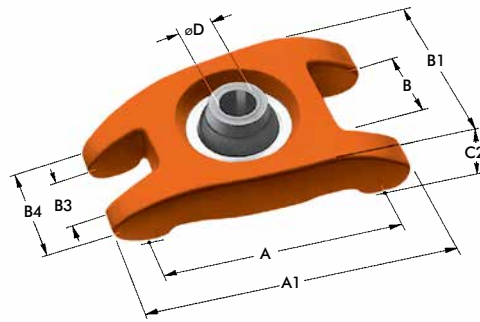
Technical Information | Holding Capacities

Holding Capacity	Working Height Range	For Screw Diameter	Model	Weight [lbs.] kg
	[0-1.75"] 0-45	[1/2"] M12	T614-0	[1.5] 0,6
	[0-2.25"] 0-57	[5/8"] M16 or [3/4"] M20	T614-1	[5.8] 2,7
	[0-3.00"] 0-75	[1"] M24	T614-2	[9.5] 4,3

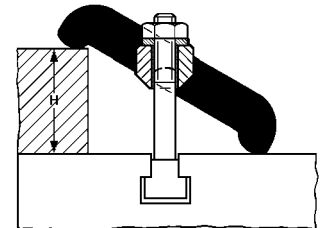
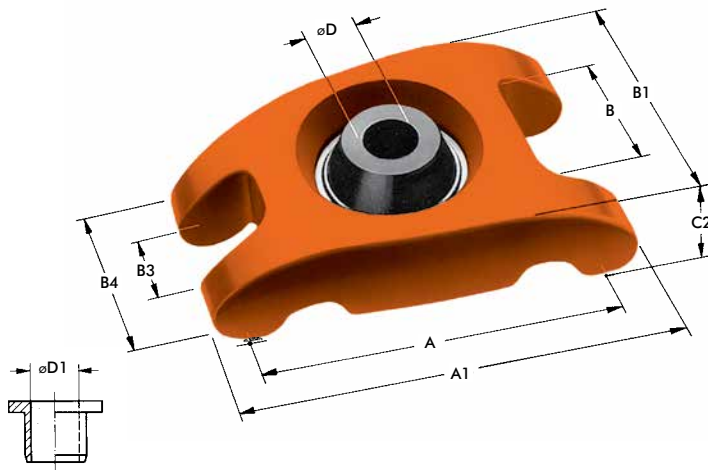
BUTTRESS-STYLE SERIES

CARVER Clamps | Dimensions

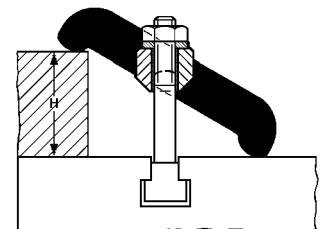
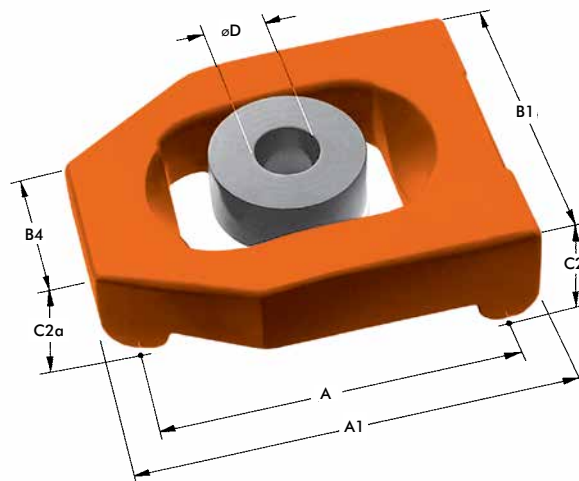
Holding capacity [2900 lbf] 13kN
 Clamping height [1.75] 45mm max.
Model T614-0



Holding capacity [14000 lbf] 62.5kN
 Clamping height [2.25] 57mm max.
Model T614-1
 Delivery includes reducing bush with
 inner diameter 17 [0.67].
 Reducer bushing is standard equipment



Holding capacity [18000 lbf] 80kN
 Clamping height 75 [3.00] max.
Model T614-2



Model	[inch] mm									
	A	A1	B	B1	B3	B4	C2	C2a	ØD	ØD1
T614-0	[3.54] 90	[4.34] 110	[1.41] 36	[2.59] 66	[0.78] 40	[1.56] 40	1.02] 26	-	[0.51] 13	-
T614-1	[5.28] 134	[6.31] 160	[2.09] 53	[3.94] 100	[1.14] 29	[2.56] 65	[1.81] 46	-	[0.83] 21	[0.67] 17
T614-2	[5.83] 148	[6.69] 170	-	[5.13] 130	-	[2.56] 65	[1.97] 50	[1.57] 40	[1.02] 26	-

T-SLOT SERIES

CARVER Clamps | Product Overview

Features:

These clamps provide rapid height adjustment and positive holding. They are designed with a single-unit clamp head and base. The DESTACO Carver T-Slot Clamp is one single assembly – there are no loose parts. When setting up, the safety lock on the back is released and the clamp lifted on the base to the desired height. When the clamp screw is turned, 100% of the force is transmitted to the work-piece. Backing off the clamp adjusting screw and releasing the safety lock and lifting the clamp head makes for rapid job changeover.


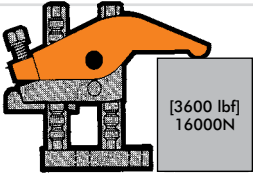
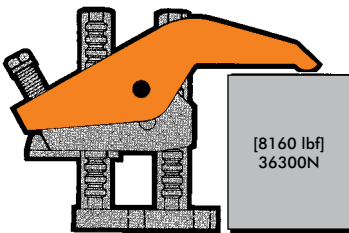
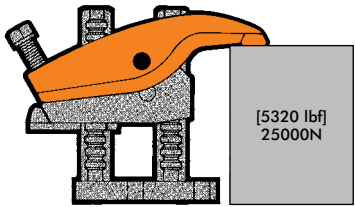


If the clamping height is more than [29.5in] 750mm the connector shown below will be delivered as standard equipment.

MODEL T813400



Technical Information | Holding Capacities

Holding Capacity	Throat Depth		Working Height C		Model	Max. Torque	Accessories Standard Equipment	Weight [lbs.] kg
	a	b	min.	max.				
 [5100 lbf] 22700N	[0.55] 14	[1.30] 33	[0.50] 12	[4.00] 100	T400-4	[36 ft. lbs.] 49Nm	(2) M12 T-nuts for 14mm T-slot T2060-05	[5.1] 2,3
			[0.50] 12	[6.00] 150	T400-6			[5.5] 2,5
			[2.00] 50	[8.00] 200	T400-8			[5.7] 2,6
 [3600 lbf] 16000N	[2.24] 57	[2.87] 73	[0.50] 12	[4.00] 100	T600-4	[30 ft. lbs.] 40Nm	(2) M12 T-nuts for 14mm T-slot T2060-05	[5.9] 2,7
			[0.50] 12	[6.00] 150	T600-6			[6.4] 2,9
			[2.00] 50	[8.00] 200	T600-8			[6.6] 3,0
 [8160 lbf] 36300N	[1.73] 44	[2.68] 68	0	[6.00] 150	T402-6	[85 ft. lbs.] 115Nm	(2) M16 T-nuts for 18mm T-slot T2060-07	[14.00] 6.4
			0	[12.00] 300	T402-12			[17.70] 8.0
			[6.00] 150	[18.00] 450	T402-18			[19.40] 8.8
			[12.00] 300	[24.00] 600	Ⓢ T402-24			[20.00] 9.0
 [5320 lbf] 25000N	[3.90] 99	[4.84] 123	0	[6.00] 150	T602-6	[70 ft. lbs.] 95Nm	(2) M16 T-nuts for 18mm T-slot T2060-07	[16.00] 7.3
			0	[12.00] 300	T602-12			[19.80] 9.0
			[6.00] 150	[18.00] 450	Ⓢ T602-18			[21.60] 9.8

Ⓢ Available upon request

T-SLOT SERIES

CARVER Clamps | Product Overview

These clamps provide rapid height adjustment and positive holding. They are designed with a single-unit clamp head and base, providing up to [8000 lbf] 35.6kn. of positive holding capacity for workpieces up to 60" high. The design applies 100% of the screw force directly onto the workpiece far more than any strap clamp arrangement. Additionally, there is no searching for the correct riser block height. The DESTACO Carver T-Slot Clamp is one single assembly – there are no loose parts.

When setting up, the safety lock on the back is released and the clamp lifted on the base to the desired height. When the clamp screw is turned, 100% of the force is transmitted to the workpiece. Backing off the clamp adjusting screw and releasing the safety lock and lifting the clamp head makes for rapid job changeover.

Safety – No loose parts. Clamp and base are one unit.

Higher clamping force holds parts more securely and safely.

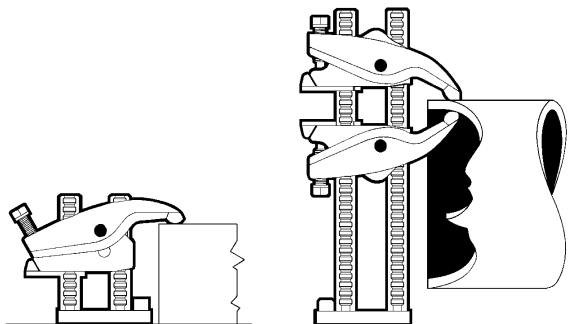
Speed – The clamp head adjusts much faster than an operator can select proper size spacers and bolts. Benefits include:

- Cuts set-up time by as much as 80%
- Reduces machine downtime
- Offers more rapid loading and unloading

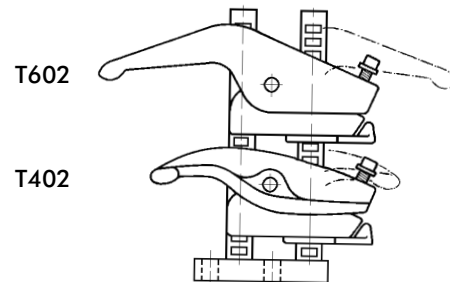
Economy – Tool tip technology and digital control have reduced machining time. Why lose these advantages on long set-up times? T-Slot clamps can reduce set-up time by as much as 80%. Benefit: Money saved.

Ease of Operation – Loosen adjusting screw and release safety catch to adjust height instantly.

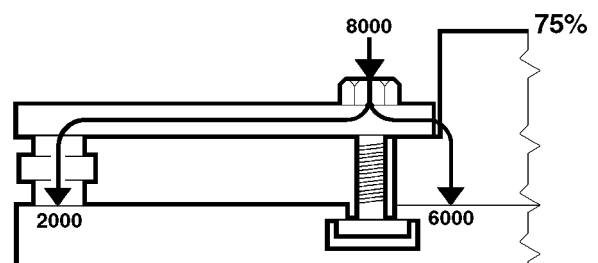
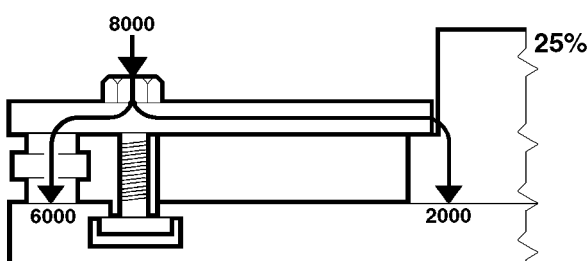
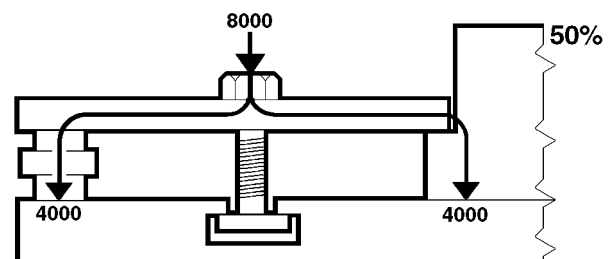
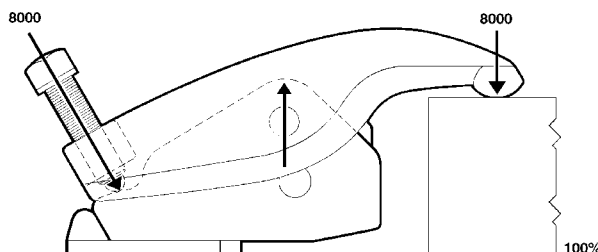
Versatility - Selection of bases gives standard clamping heights from 0 to 600mm[0 to 24in.]. Additional heights available up to 1500mm[60in.] are available upon request. Two or more heads can be used on one base to position and hold down as well as support – ideal for fine height adjustment during set-up. Also eliminates riser blocks.



Ideal for use as manual die clamps. Eliminates the need for step blocks or riser blocks.

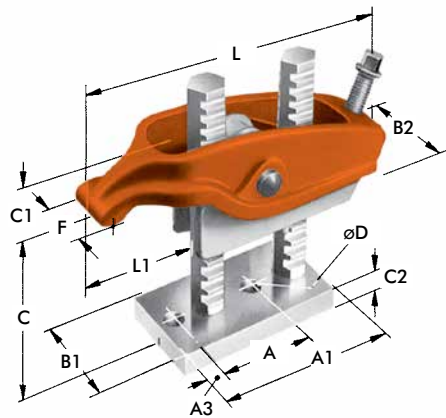


The T402 and T602 can be reversed on their bases to give added reach.

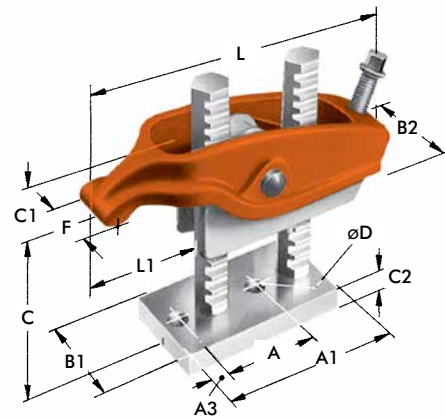


T-SLOT SERIES

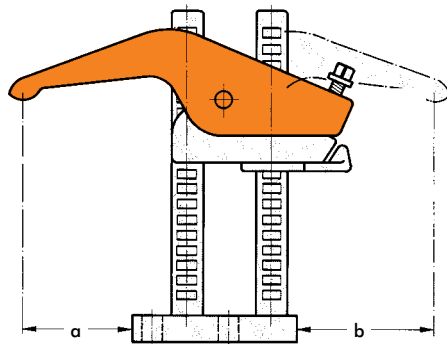
CARVER Clamps | Dimensions



Model **T400-..**



Model **T402-..**



If the T402 is reversed on its base, the measurement of the throat depth will change.

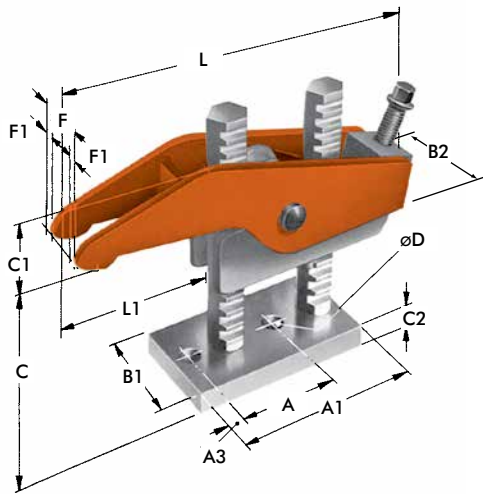
	T400-..	T402-..
a	[0.55] 14	[1.73] 44
b	[1.30] 33	[2.68] 68

Model	A	A1	A3	B1	B2	C		C1	C2	ØD	F	L	L1	Consisting of		Clamping Screw Size Ø
						min	max							1x	1x	
T400-4						[1.00] 25	[4.00] 100							400-4-1		
T400-6	[2.12] 54	[3.78] 96,2	[0.41] 10.5	[2.00] 51	[2.00] 51	[1.00] 25	[6.00] 150	[1.09] 28	[0.63] 16	[0.53] 13,5	[1.02] 26	[6.30] 160	[1.44] 36,5	400-2	400-6-1	12mm
T400-8						[2.50] 62	[8.00] 200							400-8-1		
T402-6						0	[6.00] 150							402-6-1		
T402-12	[2.81] 71	[5.51] 140	[0.59] 15	[3.00] 76	[2.68] 68	0	[1200] 300							402-12-1		
T402-18						[6.00] 150	[18.00] 450	[1.77] 45	[0.75] 19	[0.66] 16,3	[1.50] 38	[9.65] 245	[2.56] 65	402-2	402-18-1	20mm
T402-24						[12.00] 300	[24.00] 600							402-24-1		

① Available upon request

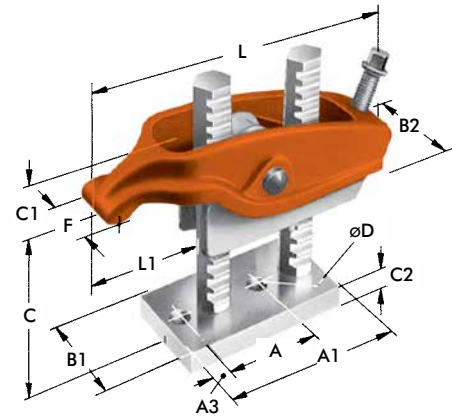
T-SLOT SERIES

CARVER Clamps | Dimensions

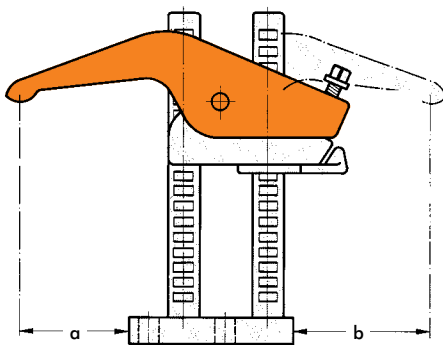


Model

T600-..



Model T602-..



If the T602 is reversed on its base, the measurement of the throat depth will change.

	T600-..	T602-..
a	[2.24] 57	[3.90] 99
b	[2.87] 73	[4.84] 123

Model	A	A1	A3	B1	B2	C		C1	C2	ØD	F	F1	L	L1	Consisting of		Clamping Screw Size Ø
						min	max								1x	1x	
T600-4						[0.47] 12	[4.00] 100								600-4-1		
T600-6	[2.12] 54	[3.78] 96,2	[0.41] 10,5	[2.00] 51	[1.97] 50	[0.47] 12	[6.00] 150	[1.50] 38	[0.63] 16	[0.53] 13,5	[1.97] 50	[0.41] 10,5	[7.88] 200	[3.35] 85	600-2	600-6-1	12mm
T600-8						[1.97] 50	[8.00] 200								600-8-1		
T602-6						0	[6.00] 150								402-6-1		
T602-12	[2.81] 71	[5.51] 140	[0.59] 15	[3.11] 79	[3.11] 79	0	[1200] 300	[3.19] 81	[0.75] 19	[0.66] 16,3	[1.50] 38	-	[12.40] 315	[5.31] 135	602-2	402-12-1	20mm
ⓘ T602-18						[6.00] 150	[18.00] 450								402-18-1		

ⓘ Available upon request

PNEUMATIC TOGGLE CLAMPS

Sizing and Application Chart

DESTACO Pneumatic Clamps use air-actuated cylinders to operate the clamping action. They are ideal for quick and repetitive production operations, and yet are portable and economical to use on short run jobs with temporary fixturing

		Max. Holding Capacity N[lbf.]							Max. Exerting Force at 5bar[72PSI] N[lbf.]						
Series	Page: MC-PTC-#	0 to 1000 [0 to 225]	1000 to 2000 [225 to 450]	2000 to 3000 [450 to 675]	3000 to 5000 [675 to 1125]	5000 to 7000 [1125 to 1575]	7000 to 10000 [1575 to 2250]	10000+ [2250+]	0 to 1000 [0 to 225]	1000 to 2000 [225 to 450]	2000 to 3000 [450 to 675]	3000 to 4000 [675 to 900]	4000 to 5000 [900 to 1125]	5000 to 6000 [1125 to 1350]	6000 to 8000 [1350 to 1800]
	812	3													
	802	5													
	807	7													
	810	9													
	846	11													
	847	15													
	8007	13													
	858	17													
	8021	19													
	8071	19													
	8101	19													
	817	21													
	827	21													
	868	23													
	803	25													
	8031	26													
	830	27													
	850	28													
	800	29													
	1200	29													

812 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Smallest of the pneumatic hold down series
- Pneumatic version of Model 201-U

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1
for spindle accessories

See page MC-PSC-40
for sensing options

High temperature version available
upon request as Model 812-**U-HT**

812-U



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Maximum Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption† dm ³ [ft ³]	Port Size	Accessories (Supplied)	
	Inner	Outer	Inner	Outer					Spindle Accessory	Flanged Washers
812-U	[100 lbf] 440 N	[55 lbf] 245 N	[136 lbf] 613 N	[92 lbf] 413 N	[0.46lb] 0,21kg	[0.75] 19,1	[0.003] 0,09	M5	305208-M	102111

†Per double stroke at 5bar [72PSI]

Max. Operating Temp: -23°C to 74°C [-10°F to 165°F]

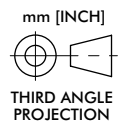
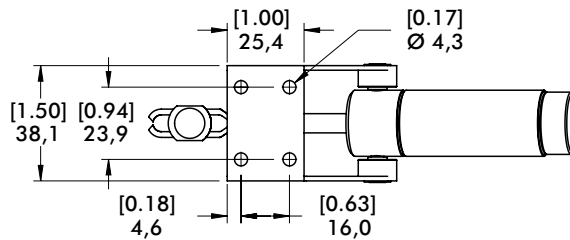
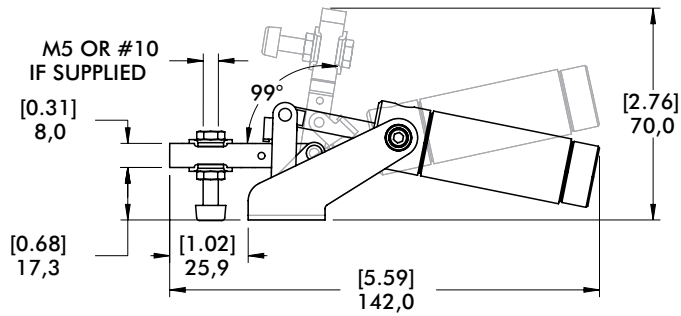
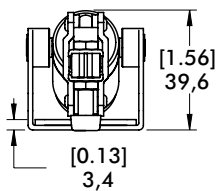
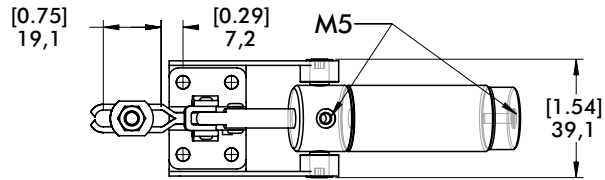
Optional Sensors: 810156, 810158

Replacement Clamp Assembly: 812-U-LC

Replacement Cylinder Assembly: 812CYL

In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

812-U



Note:

Model 812-U requires either 810156 or 810158 sensors. Two (2) sensors are required if detecting both open and closed positions. These sensors use 810156-1 (included with sensors) band clamp to mount the sensor to the cylinder wall.



802 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Pneumatic version of Model 202-U
- Sensor ready for T-slot or round sensors

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1 for spindle accessories

See page MC-PSC-40 for sensing options

High temperature version available upon request, add **-HT** to model number. Example: 802-U-**HT**

802-U
802-UE



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Max. Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption† dm ³ [ft ³]	Port Size	Accessories (Supplied)	
	Inner	Outer	Inner	Outer					Spindle Accessory	Flanged Washers
802-U	[200 lbf] 890 N	[110 lbf] 490 N	[450 lbf] 2010 N	[234 lbf] 1045 N	[1.60lb] 0,73kg	[1.26] 32	[0.012] 0,34	1/8 NPT G-1/8	202208-M	215105
802-UE										

†Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]*

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Seal Kit: 802450-32-1-00

Replacement Clamp Assembly: 802-U-LC

Replacement Cylinder Assembly: 802CYL

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix for details.

Sensor Accessories

Round Reed Switch with Quick Disconnect

T-slot Reed Switch with Quick Disconnect

Quick Disconnect 2M Extension Cable

Quick Disconnect 5M Extension Cable

Item Number

810169

8EA-109-1

CABL-010

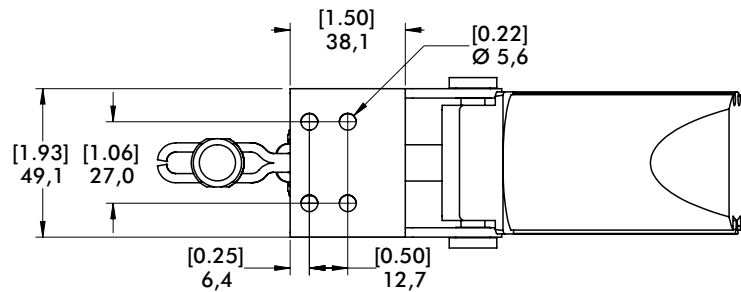
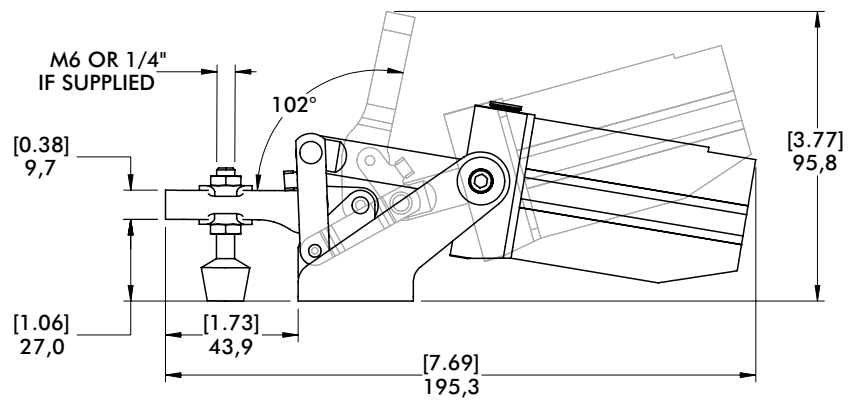
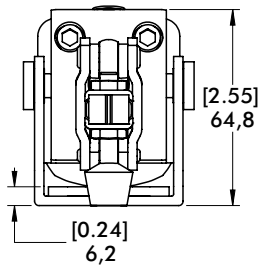
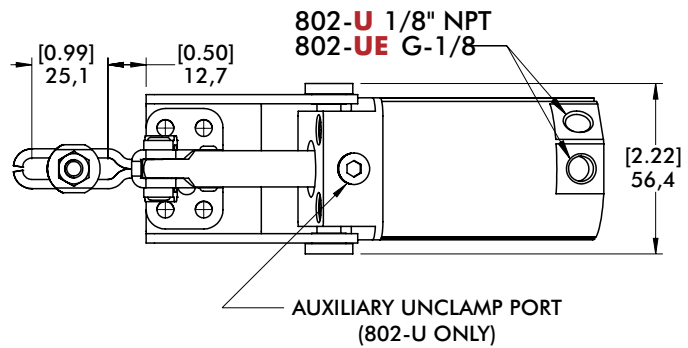
CABL-013

See Pneumatic Accessories section for more options

802 SERIES

Pneumatic Toggle Clamps | Dimensions

802-U
802-UE



mm [INCH]
THIRD ANGLE PROJECTION

807 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Pneumatic version of Series 207 manual clamps
- Sensor ready for round or T-slot sensors.
- Built-in flow restriction eliminates need for external flow controls

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1 for spindle accessories

See page MC-PSC-40 for sensing options

High temperature version available upon request, add **-HT** to model number. Example: 807-U-**HT**

807-U
807-UE



807-S
807-SE



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Maximum Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption† dm ³ [ft ³]	Port Size	Accessories (Supplied)		
	Inner	Outer	Inner	Outer					Spindle Accessory	Flanged Washers	Bolt Retainer
807-U	[375 lbf]	[275 lbf]	[576 lbf]	[297 lbf]	[1.66lb] 0,75kg	[1.26] 32	[0.015] 0,42	1/8 NPT	--	507107	--
807-UE	1670 N	1220 N	2573 N	1327 N				G-1/8	2007208-M		
807-S	[500 lbf]	[260 lbf]	[540 lbf]	[180 lbf]	[1.66lb] 0,75kg	[1.26] 32	[0.015] 0,42	1/8 NPT	--	--	207105
807-SE	2220 N	1160 N	2412 N	804 N				G-1/8	--		

†Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]*

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Seal Kit: 802450-32-1-00

Replacement Clamp Assembly: 807-U-LC, 807-S-LC

Replacement Cylinder Assembly: 807CYL

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix for details.

Sensor Accessories

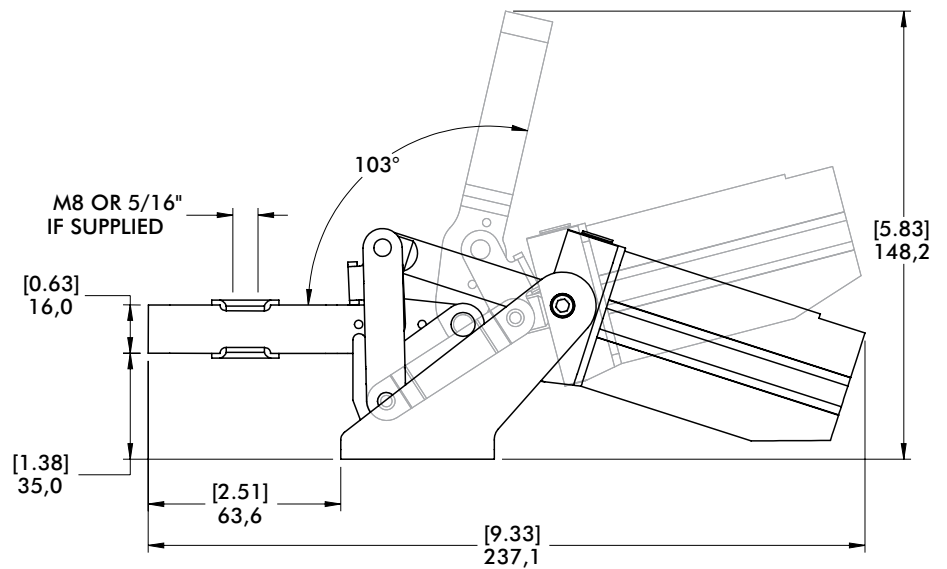
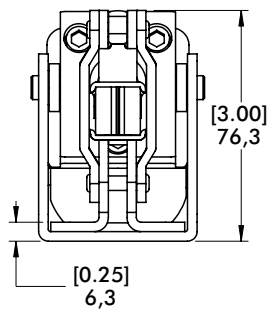
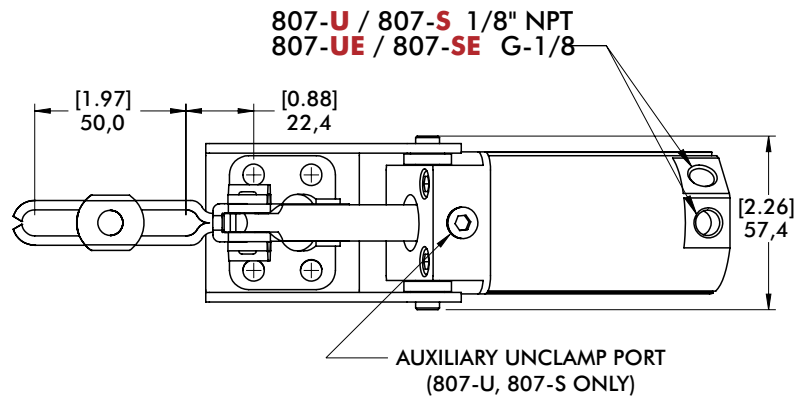
	Item Number
Round Reed Switch with Quick Disconnect	810169
T-slot Reed Switch with Quick Disconnect	8EA-109-1
Quick Disconnect 2M Extension Cable	CABL-010
Quick Disconnect 5M Extension Cable	CABL-013

See Pneumatic Accessories section for more options

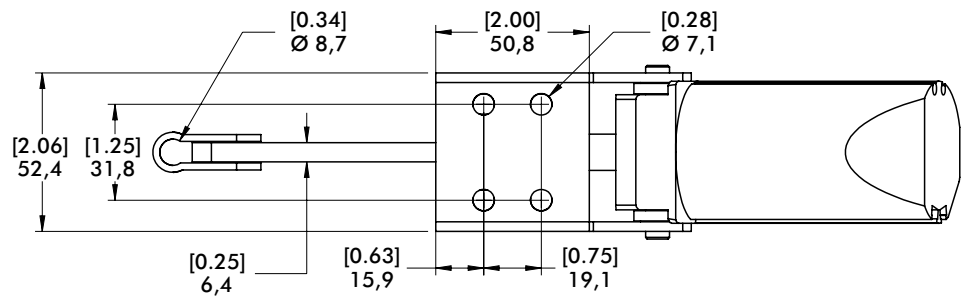
807 SERIES

Pneumatic Toggle Clamps | Dimensions

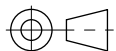
807-U
807-UE



807-S
807-SE



mm [INCH]



THIRD ANGLE PROJECTION

810 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Pneumatic version of Series 210 manual clamps
- Sensor ready for round or T-slot style sensors
- Built-in flow restriction eliminates need for external flow controls

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1 for spindle accessories
See page MC-PSC-40 for sensing options



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Maximum Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption dm ³ [ft ³]	Port Size	Accessories (Supplied)		
	Inner	Outer	Inner	Outer					Spindle Accessory	Flanged Washers	Bolt Retainer
810-U	[600 lbf]	[290 lbf]	[856 lbf]					1/8 NPT	--		
810-UE	2670 N	1290 N	3834 N	[407 lbf]	[4.07lb]	[1.57]	[0.029]	G-1/8	240208-M	235106	--
810-S	[750 lbf]	[500 lbf]	[702 lbf]					1/8 NPT	--	--	210114
810-SE	3340 N	2220 N	3143 N					G-1/8	--	--	

†Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]*

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Seal Kit: 810450-40-1-00

Replacement Clamp Assembly: 810-U-LC, 810-S-LC

Replacement Cylinder Assembly: 810CYL

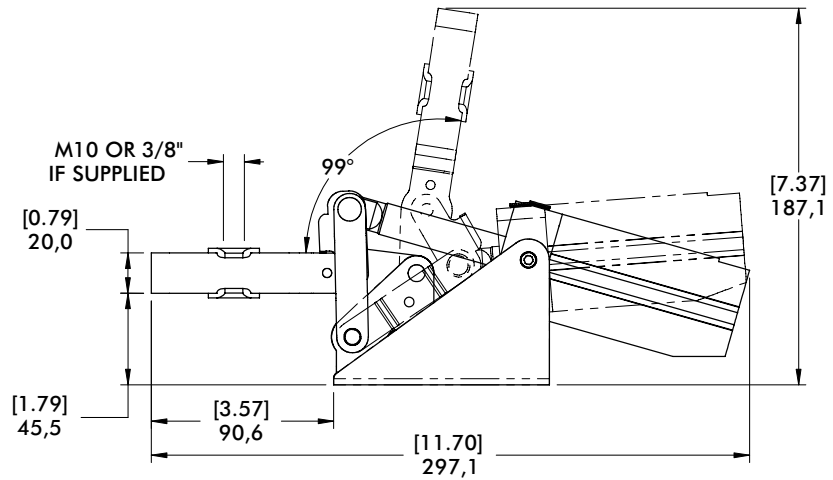
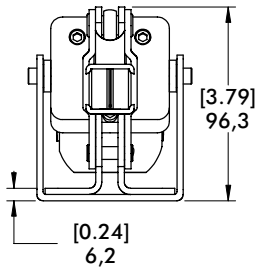
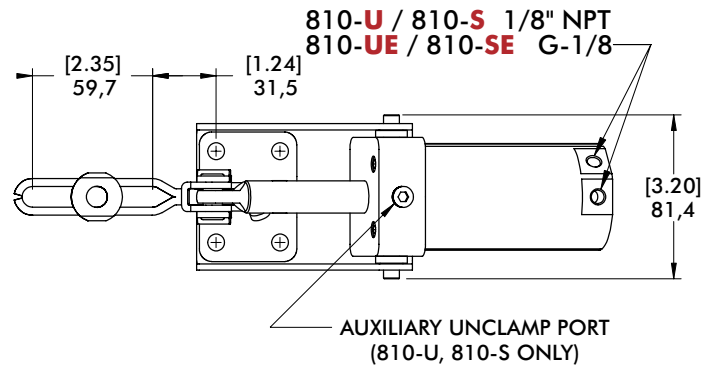
*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity.

Sensor Accessories

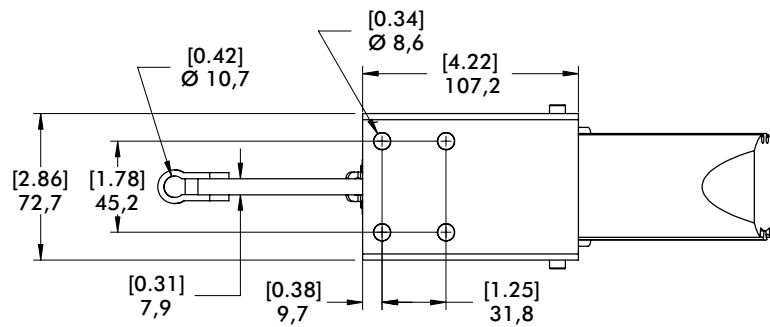
	Item Number
Round Reed Switch with Quick Disconnect	810169
T-slot Reed Switch with Quick Disconnect	8EA-109-1
Quick Disconnect 2M Extension Cable	CABL-010
Quick Disconnect 5M Extension Cable	CABL-013

See Pneumatic Accessories section for more options

810-U
810-UE



810-S
810-SE



mm [INCH]

THIRD ANGLE PROJECTION

846 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Similar in size to 807 but with higher holding capacity
- Large, solid clamping arm is easily modified to suit application requirements
- Sensor ready for round or T-slot style sensors

Applications:

- Assembly
- Welding

Also Available:

See page MC-PSC-40 for sensing options

846 ⓘ



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Max. Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption† dm ³ [ft ³]	Port Size
	Inner	Outer	Inner	Outer				
846 ⓘ	[750 lbf] 3340 N	[520 lbf] 2310 N	[786 lbf] 3520 N	[491 lbf] 2200 N	[4.18lb] 1,90kg	[1.57] 40	[0.029] 0,83	1/8 NPT

ⓘ This item is available upon request. †Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]*

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Seal Kit: 810450-40-1-00

Replacement Clamp Assembly: 846-LC

Replacement Cylinder Assembly: 846CYL

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

Sensor Accessories

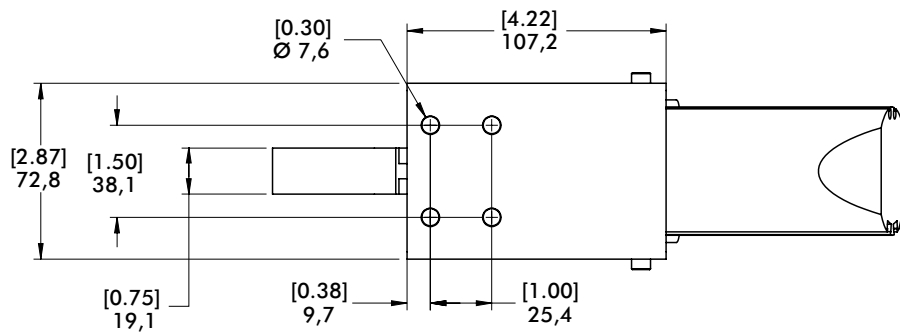
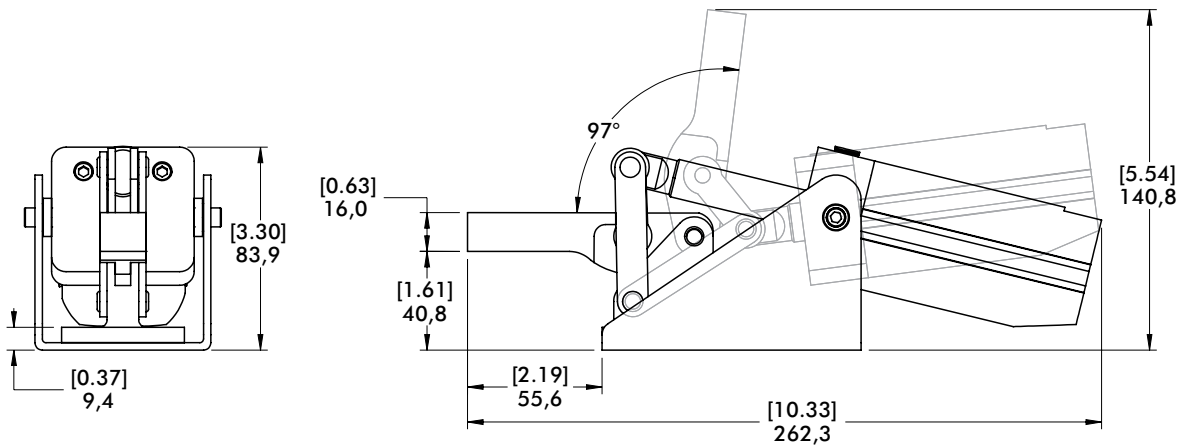
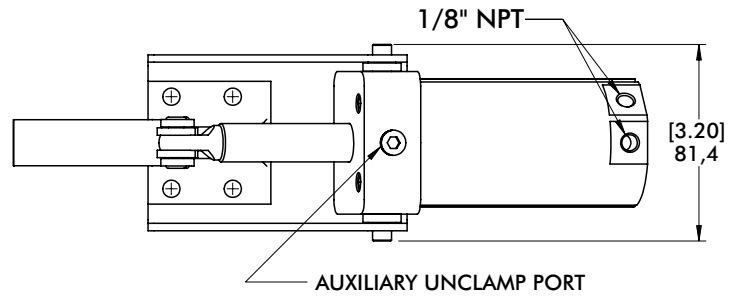
	Item Number
Round Reed Switch with Quick Disconnect	810169
T-slot Reed Switch with Quick Disconnect	8EA-109-1
Quick Disconnect 2M Extension Cable	CABL-010
Quick Disconnect 5M Extension Cable	CABL-013

See Pneumatic Accessories section for more options

846 SERIES

Pneumatic Toggle Clamps | Dimensions

846 ①



mm [INCH]
THIRD ANGLE
PROJECTION

8007 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Hardened pins and bushing at all pivot points for long life cycle
- Solid clamping bar may be modified to suit application requirements
- Sensor ready for round or T-slot style sensors

Applications:

- Assembly
- Welding

Also Available:

See page MC-PSC-40 for sensing options

8007-E



8007-EHL



8007-EHR



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Max. Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption† dm ³ [ft ³]	Port Size
	Inner	Outer	Inner	Outer				
8007-E					1,6kg [3.53lb]			
8007-EHL	[830 lbf] 3700 N	[405 lbf] 1800 N	[606 lbf] 2700 N	[225 lbf] 1000 N		[1.26] 32	[0.016] 0,44	G-1/8
8007-EHR					1,7kg [3.75lb]			

†Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]*

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Clamp Assembly: 8007-LC

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

Sensor Accessories

Round Reed Switch with Quick Disconnect

T-slot Reed Switch with Quick Disconnect

Quick Disconnect 2M Extension Cable

Quick Disconnect 5M Extension Cable

Item Number

810169

8EA-109-1

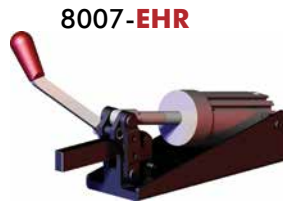
CABL-010

CABL-013

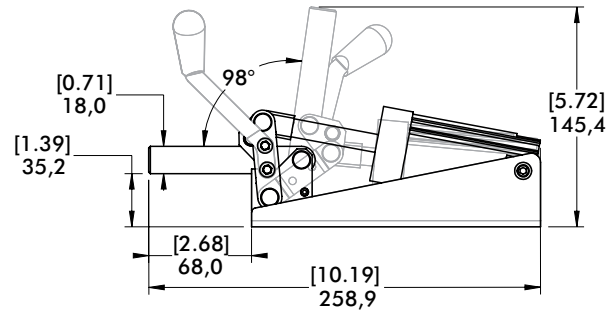
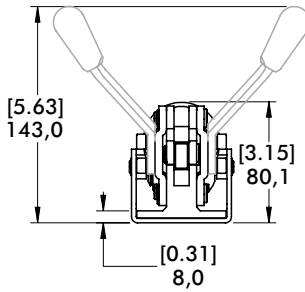
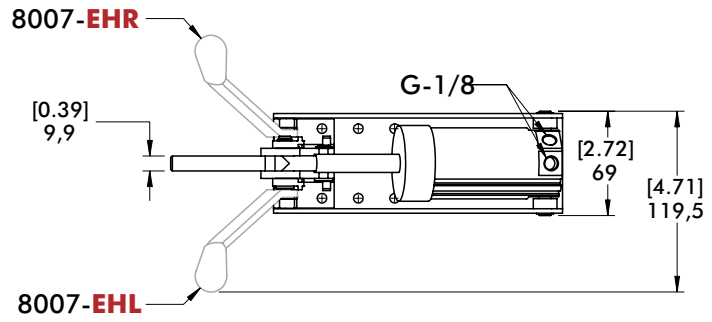
See Pneumatic Accessories section for more options

8007 SERIES

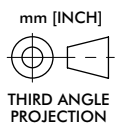
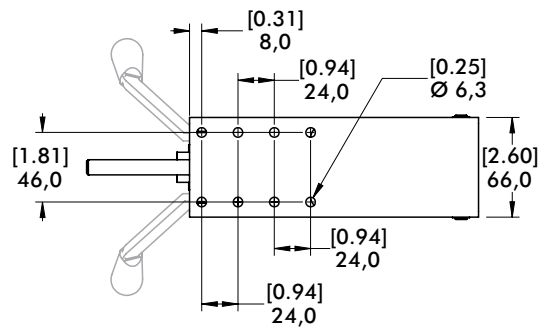
Pneumatic Toggle Clamps | Dimensions



8007-EHR



8007-E



847 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Pneumatic version of Series 247 manual clamps
- Switch ready for Ø4mm or 6,5mmX5mm sensors
- Built-in flow restriction eliminates need for external flow controls

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1 for spindle accessories
See page MC-PSC-40 for sensing options

847-U



847-S



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Max. Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption† dm³ [ft³]	Port Size	Accessories (Supplied)		
	Inner	Outer	Inner	Outer					Spindle Accessory	Flanged Washers	Bolt Retainer
847-U	[1000 lbf] 4450 N	[480 lbf] 2135 N	[948 lbf] 4248 N	[450 lbf] 2018 N	[8.93lb] 4,05kg	[1.97] 50	[0.044] 1,25	1/4 NPT	--	247109	--
847-S	[1000 lbf] 4450 N	[650 lbf] 2890 N		[426 lbf] 1912 N				1/4 NPT	--	--	247110

†Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]*

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Seal Kit: 847450-50-1-00

Replacement Clamp Assembly: 847-U-LC, 847-S-LC

Replacement Cylinder Assembly: 847CYL

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

Sensor Accessories

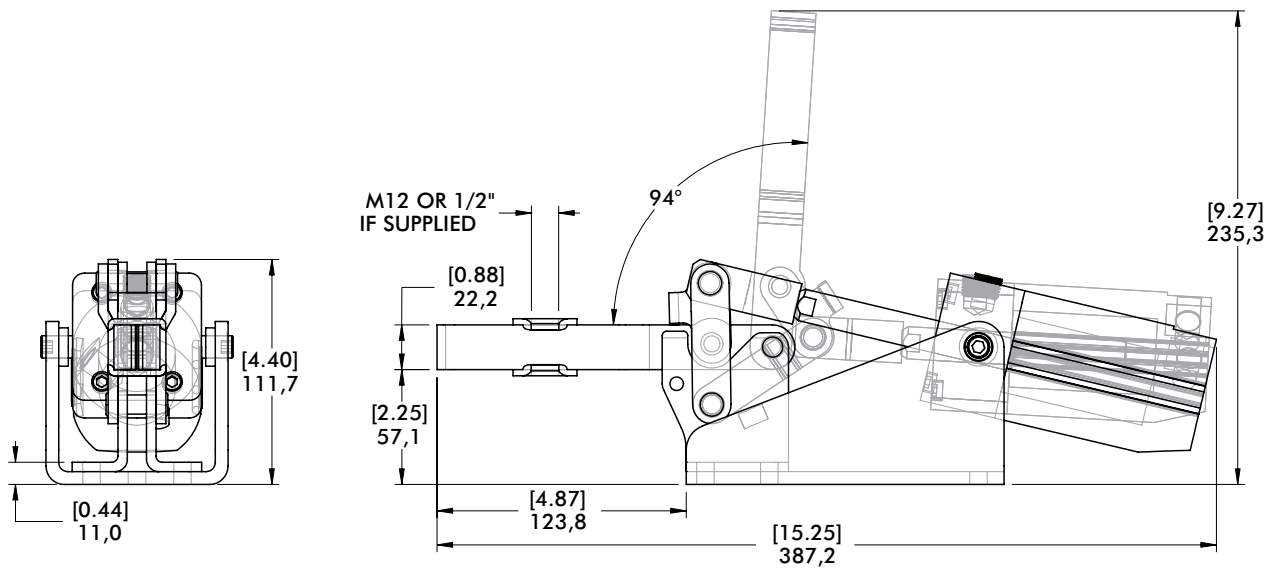
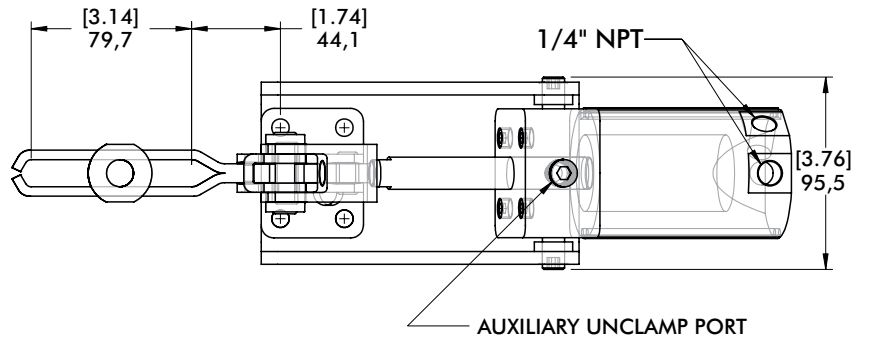
	Item Number
Round Reed Switch with Quick Disconnect	810169
T-slot Reed Switch with Quick Disconnect	8EA-109-1
Quick Disconnect 2M Extension Cable	CABL-010
Quick Disconnect 5M Extension Cable	CABL-013

See Pneumatic Accessories section for more options

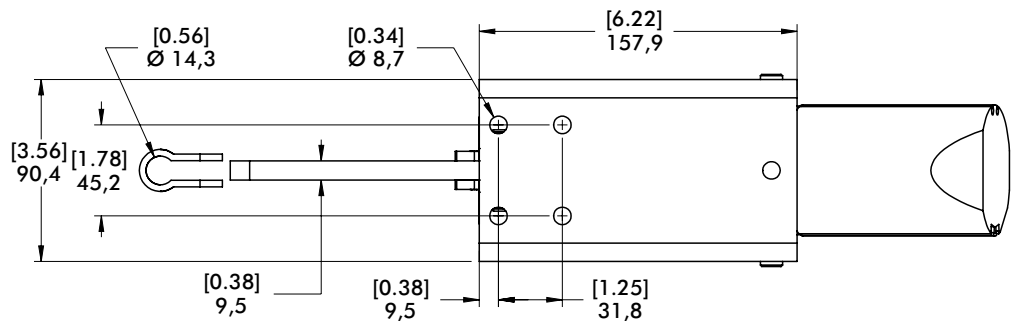
847 SERIES

Pneumatic Toggle Clamps | Dimensions

847-U



847-S



mm [INCH]
THIRD ANGLE PROJECTION

858 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Hardened pins and bushing at all pivot points for long lifecycle
- Large, solid clamping arm is easily modified to suit application requirements
- Sensor ready for round or T-slot style sensors

Applications:

- Assembly
- Welding

Also Available:

See page MC-PSC-40 for sensing options

858
858-E



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Max. Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption† dm ³ [ft ³]	Port Size
	Inner	Outer	Inner	Outer				
858	[4,000 lbf]	[2,000 lbf]	[1,530 lbf]	[800 lbf]	[16.11lb]	[2.48]	[0.109]	1/4 NPT
858-E	17800 N	8900 N	6857 N	3585 N	7.31kg	63	3,08	G-1/4

†Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]*

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Seal Kit: 850450-63-1-00

Replacement Clamp Assembly: 858-LC

Replacement Cylinder Assembly: 858CYL

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

Sensor Accessories

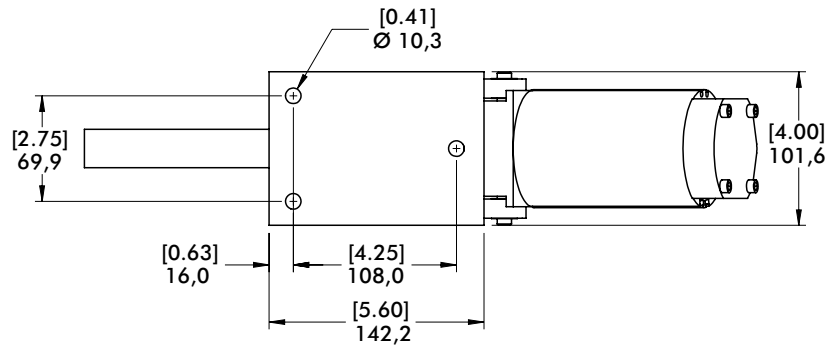
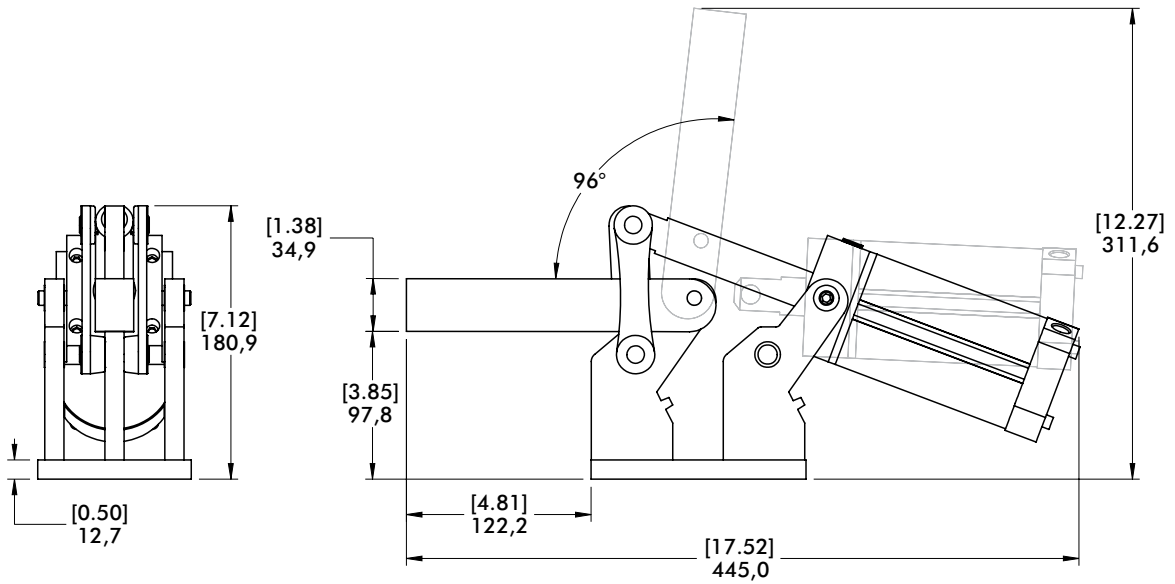
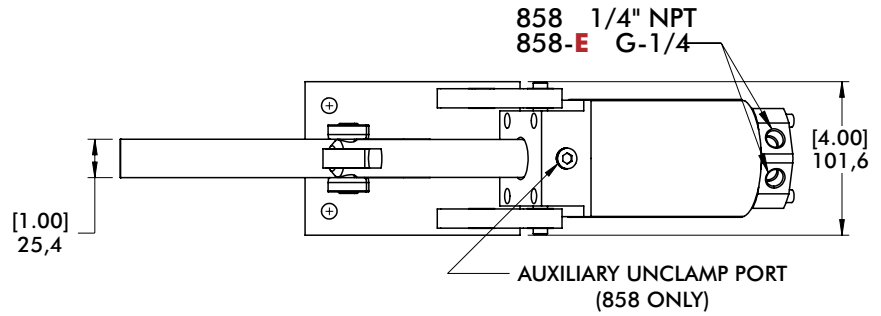
	Item Number
Round Reed Switch with Quick Disconnect	810169
T-slot Reed Switch with Quick Disconnect	8EA-109-1
Quick Disconnect 2M Extension Cable	CABL-010
Quick Disconnect 5M Extension Cable	CABL-013

See Pneumatic Accessories section for more options

858 SERIES

Pneumatic Toggle Clamps | Dimensions

858
858-E



mm [INCH]
THIRD ANGLE
PROJECTION

8021, 8071 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Enclosed clamp for dirty environments such as spot and MIG welding
- Non-pivoting cylinder can be hard-piped into fixtures
- Sensor ready for round or T-slot style sensors

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1 for spindle accessories

See page MC-PSC-40 for sensing options

8021 ⓘ
8021-UE ⓘ



8071
8071-UE



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Max. Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption† dm ³ [ft ³]	Port Size	Accessories (Supplied)	
	Inner	Outer	Inner	Outer					Spindle Accessory	Flanged Washer
8021 ⓘ 8021-UE ⓘ	[390 lbf] 1735 N	[255 lbf] 1135 N	[169 lbf] 760 N	[100 lbf] 449 N	[2.30lb] 1,04kg	[1.26] 32	[0.015] 0,42	1/8 NPT G-1/8	--	8021122
8071 8071-UE	[450 lbf] 2000 N	[310 lbf] 1380 N	[496 lbf] 2218 N	[283 lbf] 1267 N	[2.80lb] 1,27kg	[1.57] 40	[0.020] 0,58	1/8 NPT G-1/8	--	507107

ⓘ This item is available upon request. †Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]*

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Seal Kit: 8021: 802450-32-1-00
8071: 810450-40-1-00

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

Sensor Accessories

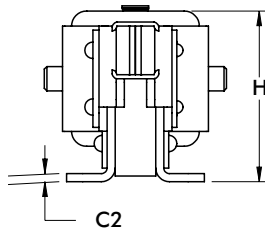
	Item Number
Round Reed Switch with Quick Disconnect	810169
T-slot Reed Switch with Quick Disconnect	8EA-109-1
Quick Disconnect 2M Extension Cable	CABL-010
Quick Disconnect 5M Extension Cable	CABL-013

See Pneumatic Accessories section for more options

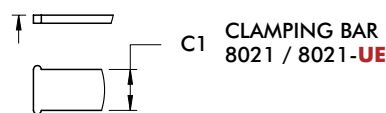
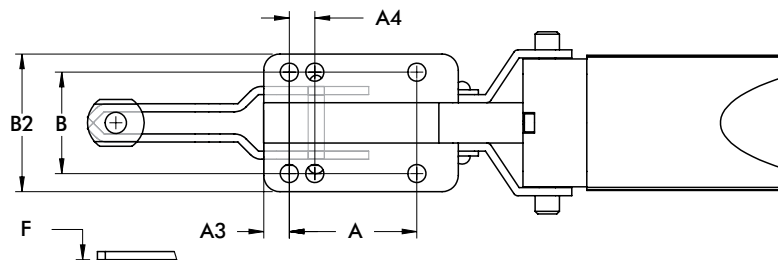
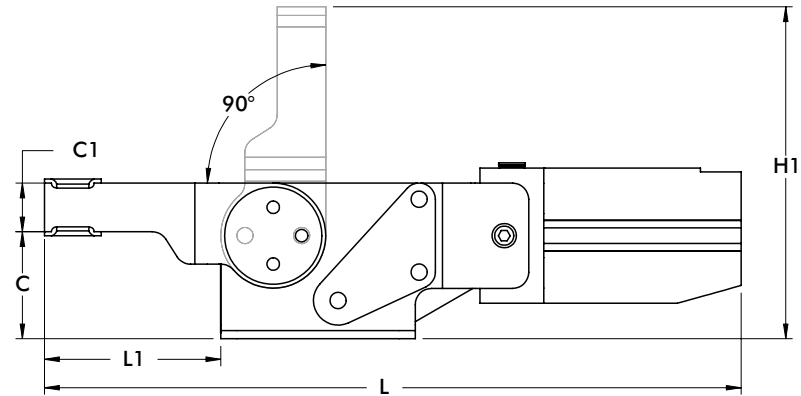
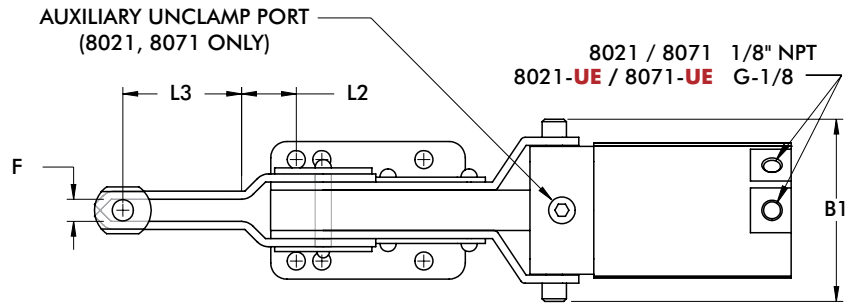
8021, 8071 SERIES

Pneumatic Toggle Clamps | Dimensions | -UE

8021
8021-UE



8071
8071-UE



mm [INCH]
THIRD ANGLE PROJECTION

Model	A	A1	A3	A4	B	B1	B2	C	C1	C2	ØD	F
8021	[0.79]	[1.97]	[0.47]	-	[1.50]	[2.26]	[1.88]	[1.56]	[0.63]	[0.13]	[0.21]	[0.34]
8021-UE	20	50	12	-	38,2	57,4	47,9	39,6	16	3,2	5,3	8,7
8071	[1.97]	[3.00]	[0.39]	[0.39]	[1.56]	[2.81]	[2.12]	[1.65]	[0.75]	[0.13]	[0.28]	[0.56]
8071-UE	50	76,2	10	10	39,7	71,4	53,9	41,9	19,1	3,2	7,1	14,3

Model	H	H1	L	L1	L2	L3	M
8021	[2.40]	[4.44]	[9.86]	[2.25]	[0.44]	[1.31]	1/4
8021-UE	60,9	112,8	250,4	57,2	11	33,2	M6
8071	[2.63]	[5.12]	[10.74]	[2.72]	[0.40]	[1.83]	5/16
8071-UE	66,9	130	272,9	69	10,1	46,5	M8

817, 827 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Dual mounting surfaces for maximum flexibility
- Sensor ready for round or T-slot style sensors
- Built-in flow restriction eliminates need for external flow controls

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1 for spindle accessories
See page MC-PSC-40 for sensing options

817-U
817-UE



817-S
817-SE



827-U
827-UE



827-S
827-SE



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Max. Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption† dm³ [ft³]	Port Size	Accessories (Supplied)		
	Inner	Outer	Inner	Outer					Spindle Accessory	Flanged Washers	Bolt Retainer
817-U	[375 lbf] 1670 N		[369 lbf] 1648 N					1/8NPT	--	507107	--
817-UE		[200 lbf] 890 N		[225 lbf] 1005 N	1,05kg [2.31lb]	[1.26] 32	[0.015] 0,42	G-1/8	225208-M		
817-S	[450 lbf] 2000 N		[360 lbf] 1608 N					1/8 NPT	--	--	207107
817-SE								G-1/8			
827-U	[600 lbf] 2670 N	[390 lbf] 1735 N		[309 lbf] 1383 N				1/8 NPT	--	235106	--
827-UE			[491 lbf] 2200 N		2,14kg [4.71lb]	[1.57] 40	[0.029] 0,83	G-1/8	240208-M		
827-S	[700 lbf] 3110 N	[330 lbf] 1470 N		[281 lbf] 1257 N				1/8 NPT	--	--	210114
827-SE								G-1/8			

†Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]*

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Seal Kit: 817: 802450-32-1-00
827: 810450-40-1-00

Replacement Clamp Assembly: 817-U-LC, 817-S-LC, 827-U-LC, 827-S-LC

Replacement Cylinder Assembly: 817: 807CYL, 827: 810CYL

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

Sensor Accessories

	Item Number
Round Reed Switch with Quick Disconnect	810169
T-slot Reed Switch with Quick Disconnect	8EA-109-1
Quick Disconnect 2M Extension Cable	CABL-010
Quick Disconnect 5M Extension Cable	CABL-013

See Pneumatic Accessories section for more options

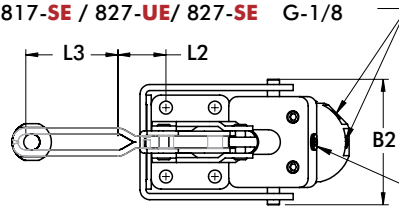
817, 827 SERIES

Pneumatic Toggle Clamps | Dimensions | -U/-UE/-S/-SE

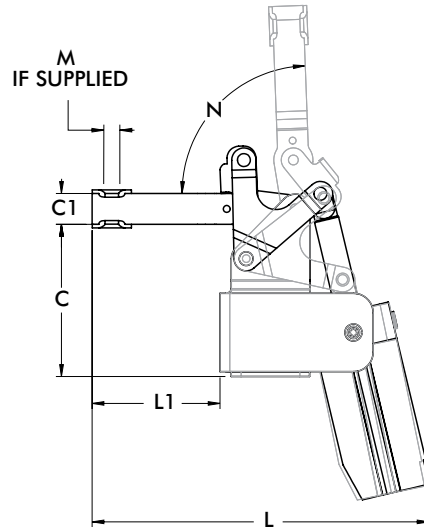
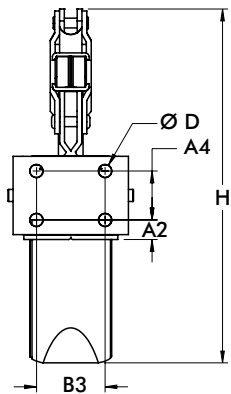
817-U
817-UE



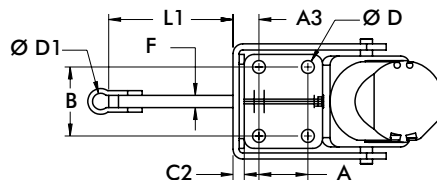
817-U / 817-S / 827-U / 827-S 1/8" NPT
817-UE / 817-SE / 827-UE / 827-SE G-1/8



AUXILIARY UNCLAMP PORT
(817-U, 817-S, 827-U, 827-S ONLY)

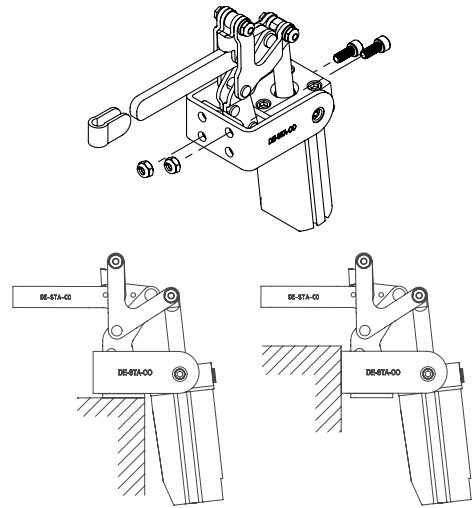


mm [INCH]
THIRD ANGLE
PROJECTION



Mounting Options:

Use two bolts in the "side" mounting holes, to secure mounting bracket, when "top" mounting.



Top Mounting

Side Mounting

Model	A	A2	A3	A4	B	B2	B3	C	C1	C2	C3	C4
817-U												
817-UE	[0.63]	[0.44]	[0.60]	[0.63]	[1.00]	[2.44]	[1.00]	[2.69]	[0.63]	[0.12]	[1.25]	[1.31]
817-S	16	11,2	15,1	16	25,4	62	25,4	68,3	16	3,1	31,8	33,3
817-SE												
827-U								[3.89]	[0.79]			[1.76]
827-UE	[1.25]	[0.51]	[0.66]	[1.25]	[1.75]	[3.08]	[1.75]	98,8	20	[0.12]	[2.00]	44,8
827-S	31,8	12,8	16,8	31,8	44,45	78,3	44,45	[3.91]	[0.75]	3,1	50,8	[1.78]
827-SE								99,2	19,1			45,3

Model	ØD	ØD1	F	H	L	L1	L2	L3	M	N
817-U					[6.24]	[2.37]	[0.19]	[1.90]		
817-UE	[0.27]	-	-	[7.51]	158,6	60,3	4,8	48,4	5/16	95°
817-S	6,7	[0.34]	[0.25]	190,7	[6.97]	[3.04]	-	-	M8	
817-SE		8,7	6,4		175,5	77,2				
827-U					[8.61]	[3.27]	[1.23]	[2.35]		
827-UE	[0.33]	-	-	[9.04]	218,7	83,1	31,2	59,7	3/8	88°
827-S	8,4	[0.42]	[0.31]	229,7	[8.49]	[3.18]	-	-	M10	
827-SE		10,7	7,9		215,6	80,7				

868 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Hardened pins and bushing at all pivot points for long lifecycle
- Large, solid clamping arm is easily modified to suit application requirements
- Sensor ready for round or T-slot style sensors

Applications:

- Assembly
- Welding

Also Available:

See page MC-PSC-40 for sensing options

868
868-E



Technical Information | Holding Capacities

Model	Maximum Holding Capacity		Max. Exerting Force @ 5bar [72PSI]		Weight	Bore Size	Air Consumption† dm ³ [ft ³]	Port Size
	Inner	Outer	Inner	Outer				
868	[4000 lbf] 17800 N	[2400 lbf] 10675 N	[1704 lbf] 7637 N	[800 lbf] 3585 N	[17.0lb] 7,71kg	[2.48] 63	[0.109] 3,08	1/4 NPT
868-E								G-1/4

†Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]*

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Seal Kit: 850450-63-1-00

Replacement Clamp Assembly: 868-LC

Replacement Cylinder Assembly: 868CYL

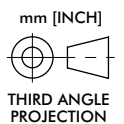
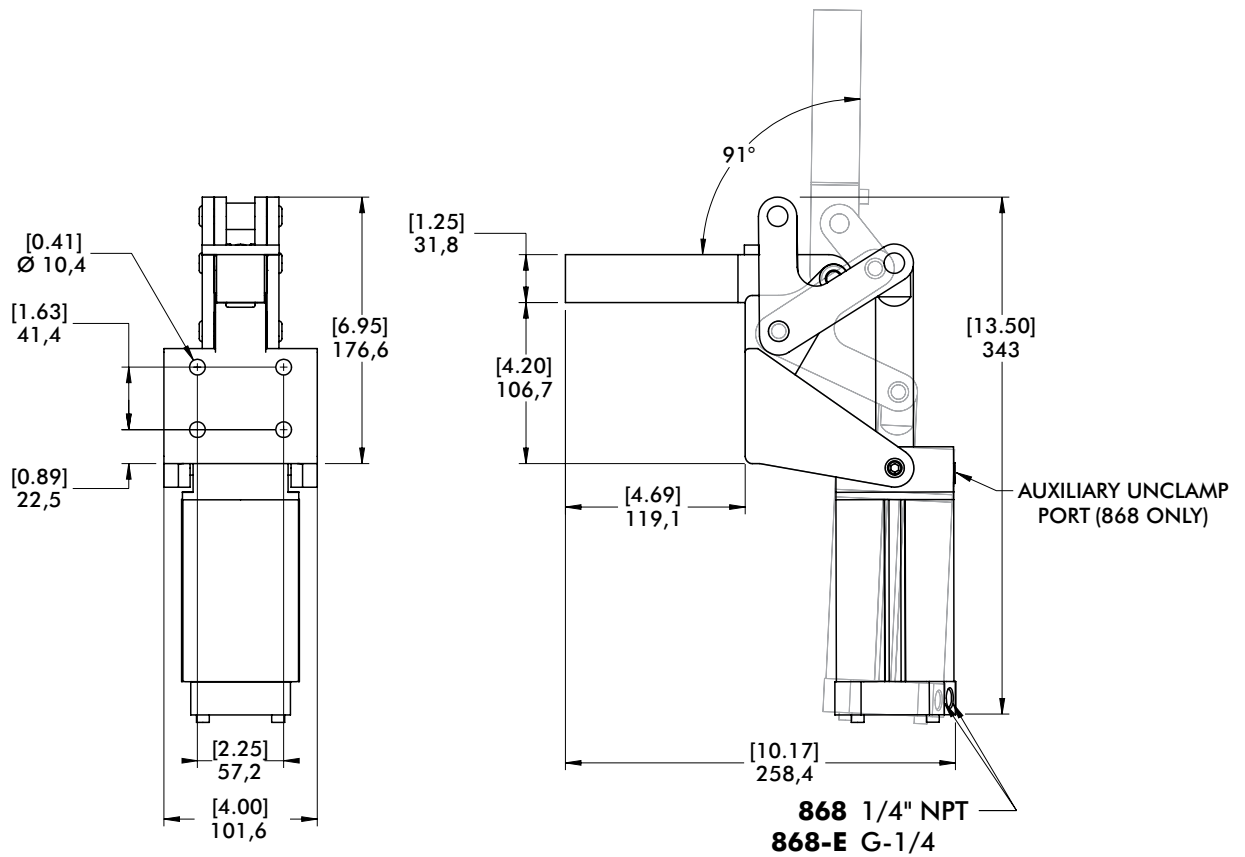
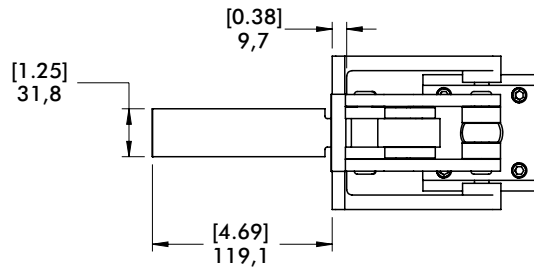
*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

Sensor Accessories

	Item Number
Round Reed Switch with Quick Disconnect	810169
T-slot Reed Switch with Quick Disconnect	8EA-109-1
Quick Disconnect 2M Extension Cable	CABL-010
Quick Disconnect 5M Extension Cable	CABL-013

See Pneumatic Accessories section for more options

868
868-E



803 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Pneumatic version of Model 603 manual straight line action clamp
- Sensor ready for round or T-slot style sensors

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1 for spindle accessories

See page MC-PSC-40 for sensing options

High temperature version available
Upon Request, add **-HT** to model number. Example: 803-U-**HT**

803
803-**ME**



Technical Information | Holding Capacities | Dimensions

Model	Maximum Holding Capacity	Maximum Exerting Force @ 5bar [72PSI]	Plunger Travel	Plunger Thread	Weight	Bore Size	Air Consumption† dm³ [ft³]	Port Size
803	[600 lbf] 2670 N	[675 lbf] 3015 N	[0.75] 19,1	5/16-18	[1.86lb] 0,84kg	[1.26] 32	[0.015] 0,42	1/8 NPT
803-ME				M8				G-1/8

†Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]

Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

Replacement Seal Kit: 802450-32-1-00

Replacement Clamp Assembly: 803-LC, 803-M-LC

Replacement Cylinder Assembly: 807CYL

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity.

See Technical Appendix Section for details.

Sensor Accessories

Round Reed Switch with Qk Disconnect

T-slot Reed Switch with Qk Disconnect

Quick Disconnect 2M Extension Cable

Quick Disconnect 5M Extension Cable

See Pneumatic Accessories section for more options

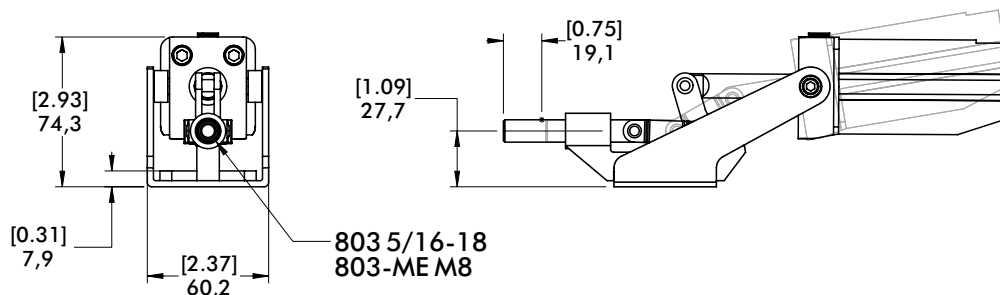
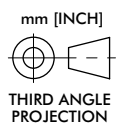
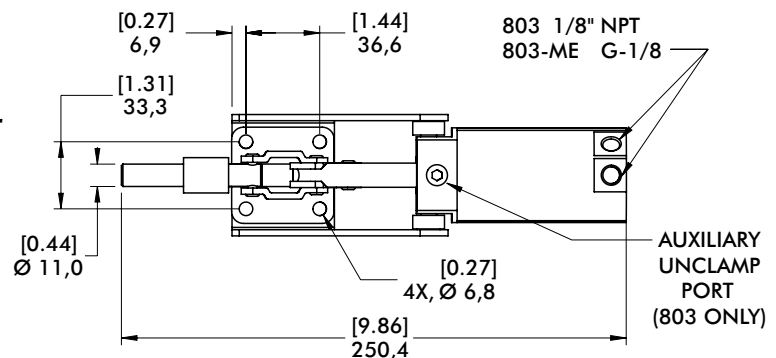
Item Number

810169

8EA-109-1

CABL-010

CABL-013



Features:

- Fully enclosed straight line action clamp for the dirtiest environments
- Compact design with high holding capacity
- Sensor ready for round style sensors

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1 for spindle accessories

See page MC-PSC-40 for sensing options

8031 ⓘ



Technical Information | Holding Capacities | Dimensions

Model	Maximum Holding Capacity	Maximum Exerting Force @ 5bar [72PSI]	Plunger Travel	Plunger Thread	Weight	Bore Size	Air Consumption† dm³ [ft³]	Port Size
8031 ⓘ	[2000 lbf] 8900 N	[731 lbf] 3285 N	[0.75] 19,1	M8	[1.17lb] 2,58kg	[1.26] 32	[0.006] 0,18	1/8 NPT

Max Cylinder Pressure: 10bar [145psig]*

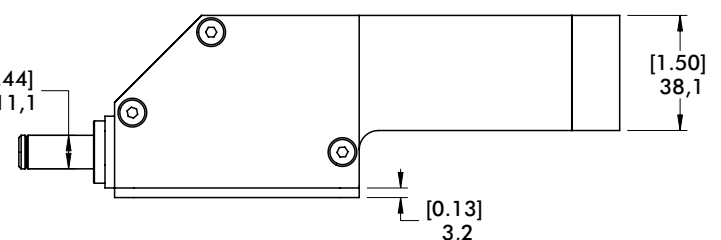
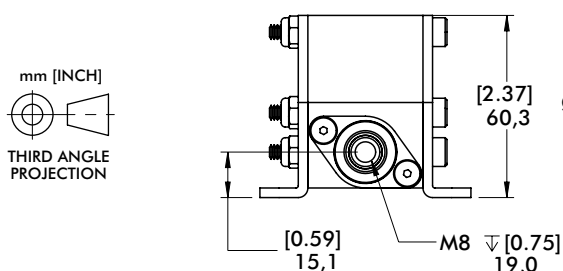
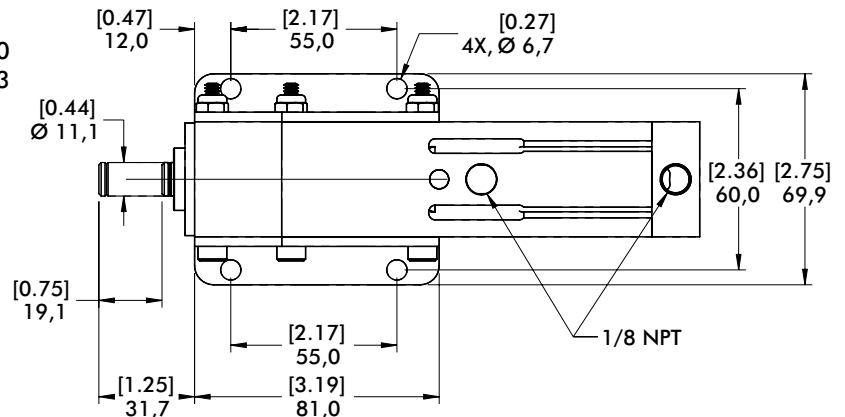
Max Operating Temp: -10°C to 90°C [-14°F to 194°F]

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

Sensor Accessories

	Item Number
Round Reed Switch with Quick Disconnect	810169
Quick Disconnect 2M Extension Cable	CABL-010
Quick Disconnect 5M Extension Cable	CABL-013

See Pneumatic Accessories section for more options



830 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Pneumatic version of Model 630 manual straight line action clamp
- Sensor ready for round or T-slot style sensors
- Built-in flow restriction eliminates need for external flow controls

Applications:

- Assembly
- Welding

Also Available:

See page MC-ACC-1 for spindle accessories
See page MC-PSC-40 for sensing options

830
830-ME



Technical Information | Holding Capacities | Dimensions

Model	Maximum Holding Capacity	Maximum Exerting Force @ 5bar [72PSI]	Plunger Travel	Plunger Thread	Weight	Bore Size	Air Consumption† dm³ [ft³]	Port Size
830	[2500 lbf] 11100 N	[800 lbf] 3582 N	[0.75] 19,1	3/8-16	2,79kg [6.14lb]	[1.57] 40	[0.029] 0,83	1/8 NPT
830-ME				M10				G-1/8

†Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]
Max Operating Temp: -10°C to 90°C [-14°F to 194°F]
Replacement Seal Kit: 810450-40-1-00
Replacement Clamp Assembly: 830-LC, 830-M-LC
Replacement Cylinder Assembly: 810CYL

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

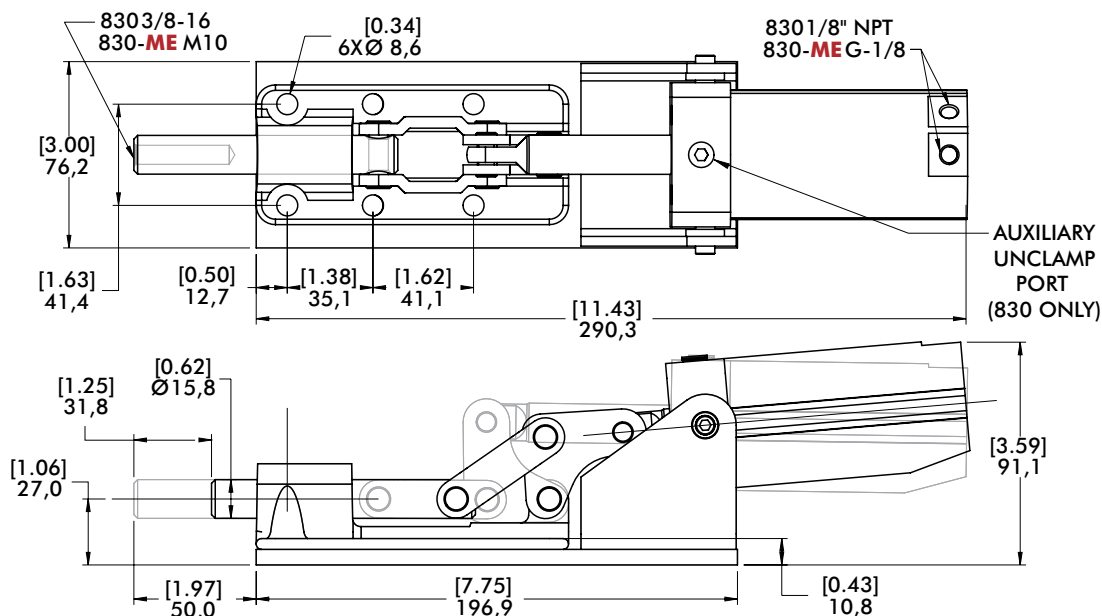
Sensor Accessories

Round Reed Switch with Quick Disconnect
T-slot Reed Switch with Quick Disconnect
Quick Disconnect 2M Extension Cable
Quick Disconnect 5M Extension Cable

Item Number

810169
8EA-109-1
CABL-010
CABL-013

See Pneumatic Accessories section for more options



Features:

- Pneumatic version of Model 650 manual straight line action clamp
- Sensor ready for round or T-slot style sensors
- Built-in flow restriction eliminates need for external flow controls

Applications:

- Assembly
- Welding
- Light press operations

Also Available:

See page MC-ACC-1 for spindle accessories
See page MC-PSC-40 for sensing options

850 ⓘ
850-ME ⓘ



Technical Information | Holding Capacities | Dimensions

Model	Maximum Holding Capacity	Maximum Exerting Force @ 5bar [72PSI]	Plunger Travel	Plunger Thread	Weight	Bore Size	Air Consumption† dm³ [ft³]	Port Size
850 ⓘ	[16,000 lbf] 71200 N	[1232 lbf] 5522 N	[2.00] 50,8	5/8-11	[16.66lb] 7,56kg	[2.48] 63	[0.109] 3,08	1/4 NPT
850-ME ⓘ				M16				G-1/4

ⓘ This item is available upon request. †Per double stroke at 5bar [72PSI]

Max Cylinder Pressure: 10bar [145psig]
Max Operating Temp: -10°C to 90°C [-14°F to 194°F]
Replacement Seal Kit: 850450-63-1-00
Replacement Clamp Assembly: 850-LC, 850-M-LC
Replacement Cylinder Assembly: 868CYL

*In no case should the inlet pressure be high enough to create an exerting force that exceeds the clamp's holding capacity. See Technical Appendix Section for details.

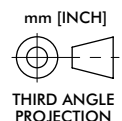
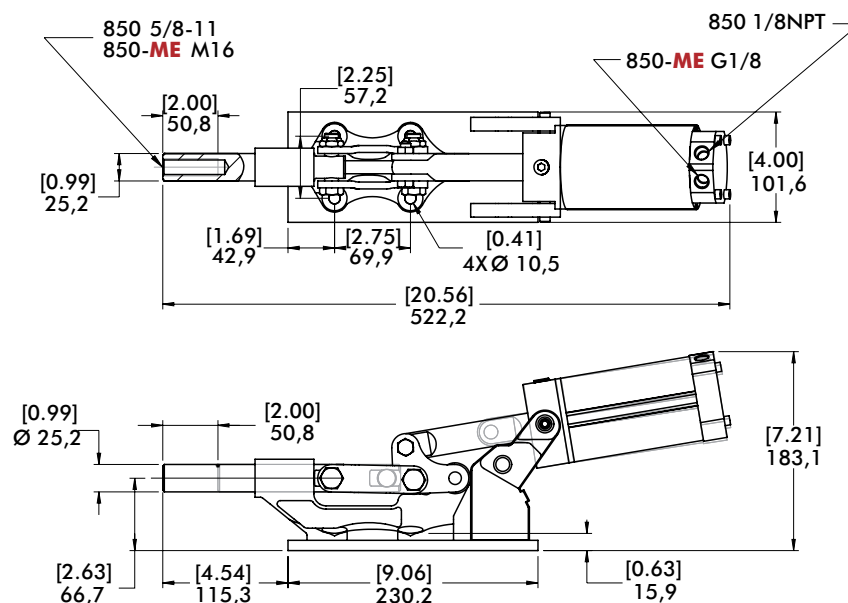
Sensor Accessories

Round Reed Switch with Quick Disconnect
T-slot Reed Switch with Quick Disconnect
Quick Disconnect 2M Extension Cable
Quick Disconnect 5M Extension Cable

Item Number

810169
8EA-109-1
CABL-010
CABL-013

See Pneumatic Accessories section for more options



800, 1200 SERIES

Pneumatic Toggle Clamps | Product Overview

Features:

- Low profile and compact for mounting in tight spaces
- Uniform clamping force throughout full stroke
- Accommodates variable workpiece thickness
- Single acting - air advance, spring return

Applications:

- Assembly
- Welding
- Light machining

How it Works:

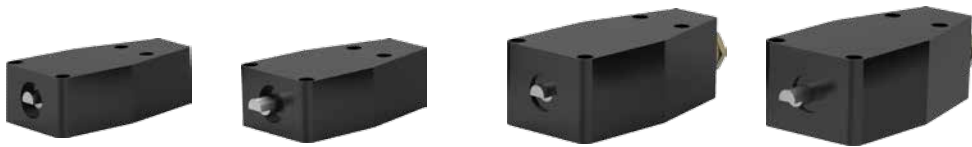
1. Clamp arm retracts fully for loading and unloading.
2. Clamp arm moves straight forward.
3. Clamp arm pivots down to hold workpiece.

800

800-E

1200 ⓘ

1200-E ⓘ



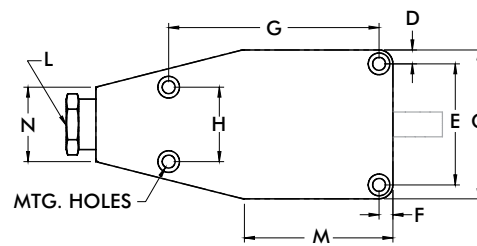
Technical Information | Holding Capacities | Dimensions

Model	Inlet Pressure bar [PSI]	Exerting Force	Max. Pressure at Max. Mechanical Advantage† bar [PSI]	Clamping Range	Weight	Port Size
800	[70~150] 4,8~10,3	[850~1500 lbf] 3780~6670N	4,8 [70]	[0.09] 2,3	[2.50lb] 1,13kg	1/4 NPT
800-E		[650~1200 lbf] 2890~5340N		[0.16] 4,0		
1200 ⓘ		[750~1600 lbf] 3340~7120N		[0.25] 6,4	[4.00lb] 1,81kg	
1200-E ⓘ		[550~1200 lbf] 2450~5340N		[0.38] 9,6		

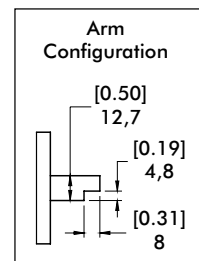
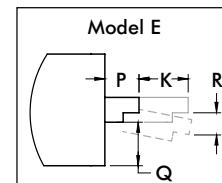
ⓘ This item is available upon request

Note: For use with pneumatic power only. This is a single acting device (air clamp, spring return), a 3-way air valve required for control.

Repair Kits: 800-00,
1200-00








Note:
K (Forward Stroke)
R (Downward Stroke)



Model	A	B	C	D	E	F	G	H	K	L	M	N	P	Q	R	MNTG HOLES	
800	[1.63] 41,4	[4.81] 122,8	[2.72] 69,1	[0.25] 6,4	[2.21] 56,1	[0.25] 6,4	[3.13] 79,5	[1.19] 30,2	[0.50] 12,7	1/4 NPT	[2.31] 58,37	[1.50] 38,1	-	[0.59] 15,0	[0.09] 2,3	[0.26] 6,6	
800-E													[0.50] 12,7		[0.16] 4,1		
1200	[2.25] 57,2	[6.00] 152,4	[3.00] 76,2	[0.28] 7,1	[2.44] 62	[0.28] 7,1	[4.25] 108	[1.50] 38,1	[1.00] 25,4			[3.00] 76,2	[1.38] 35,1	-	[0.63] 16		[0.25] 6,4
1200-E														[0.69] 17,5			[0.38] 9,7





PNEUMATIC SWING CLAMPS

Sizing and Application Chart

Series	Standard Features	Model	Bore [in]mm	Clamping Stroke [in]mm	Clamping Force [lbf.]N	Page MC- PSC-#
9500 	<ul style="list-style-type: none"> • Arm rotates at the top of stroke • Shielded rod protects against weld spatter • NEW mounting options • Sensor ready • Keyed arm connection adjustable in 90° increments • Clamp arm sold separately 	9522-2	[0.86] 22	[0.50] 13	[34] 150	3
		9530-2	[1.26] 32		[76] 340	
		9540-2	[1.57] 40	[0.79] 20	[123] 550	
		9550-2	[1.97] 50		[196] 870	
89R 	<ul style="list-style-type: none"> • Field changeable swing direction • Multiple mounting accessories • Sensor ready • Locking taper arm connection for 360° adjustability • Clamp arm sold separately 	89R20-010-2	[0.79] 20	[0.39] 10	[18] 80	8
		89R32-010-2	[1.26] 32		[55] 245	
		89R40-010-2	[1.57] 40	[0.39] 10	[85] 380	
		89R40-025-2		[0.98] 25		
		89R50-025-2	[1.97] 50	[0.98] 25	[138] 614	
89R63-025-2	[2.48] 63		[218] 970			
89B 	<ul style="list-style-type: none"> • Block style body for side mounting • Metric design with G-ports • Sensor ready • Locking taper arm connection for 360° adjustability • Clamp arm sold separately 	89B20-010-2R 89B20-010-2L	[0.79] 20		[18] 80	14
		89B32-010-2R 89B32-010-2L	[1.26] 32	[0.39] 10	[52] 231	
		89B40-010-2R 89B40-010-2L	[1.57] 40		[85] 378	
		89B50-025-2R 89B50-025-2L	[1.97] 50	[0.98] 25	[161] 716	
		89B63-008-2R 89B63-008-2L	[2.48] 63	[0.32] 8	[247] 1100	
8100/8300 	<ul style="list-style-type: none"> • Block style body for side mounting • Imperial design with NPT ports • Sensor ready • Locking taper arm connection for 360° adjustability • Clamp arm and spindle included 	8115 8116	[0.75] 19,1	[0.38] 9,7	[18] 80	19
		8315 9316	[1.50] 38,1	[0.50] 12,7	[67] 298	
89E 	<ul style="list-style-type: none"> • Threaded body style body through-hole mounting • Metric design with G-ports • Not sensing capable • Locking taper arm connection for 360° adjustability • Clamp arm sold separately 	89E20-010-2R 89E20-010-2L	[0.79] 20		[18] 80	23
		89E32-010-2R 89E32-010-2L	[1.26] 32	[0.39] 10	[52] 231	
		89E40-010-2R 89E40-010-2L	[1.57] 40		[85] 378	
		89E50-025-2R 89E50-025-2L	[1.97] 50	[0.98] 25	[161] 716	
		89E63-008-2R 89E63-008-2L	[2.48] 63	[0.32] 8	[247] 1100	

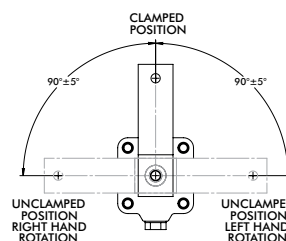
PNEUMATIC SWING CLAMPS

Sizing and Application Chart

Series	Standard Features	Model	Bore [in]/mm	Clamping Stroke [in]/mm	Clamping Force [lbf./N]	Page MC- PSC-#
8000/8200/8400 	<ul style="list-style-type: none"> Threaded body style body through-hole mounting Imperial design with NPT ports Sensor ready Locking taper arm connection for 360° adjustability Clamp arm/spindle included 	8015	[0.75]	[0.38]	[1.50]	28
		8016	19,1	9,7	38,1	
		8215 8216	[1.19] 30,2	[0.50] 12,7	[67] 300	
035-1 	<ul style="list-style-type: none"> Compact, low profile design Threaded body style body through-hole mounting Imperial design with NPT ports Not sensing capable Clamp-on style arm connections for 360° adjustability Clamp arm sold separately 	035-125-190	[0.98]	[0.53]	[20]	32
		035-125-290	25	13,5	89	
		035-132-190 035-132-290	[1.26] 32	[0.57] 14,5	[30] 133	
		035-140-190 035-140-290	[1.57] 40	[0.63] 16	[60] 267	
035-2 	<ul style="list-style-type: none"> Compact, low profile design Bottom flange mounting Imperial design with NPT ports Not sensing capable Clamp-on style arm connections for 360° adjustability Clamp arm sold separately 	035-225-190	[0.98]	[0.51]	[20]	32
		035-225-290	25	13	89	
		035-232-190 035-232-290	[1.26] 32	[0.49] 12,4	[30] 133	
		035-240-190 035-240-290	[1.57] 40	[0.52] 13,3	[60] 267	
8700 	<ul style="list-style-type: none"> Alternative solution to swing clamps when space is limited The clamping lever may be positioned left, forward, or right (relative to ports) within the same clamp body Threaded body with upper flange mount Non-toggle locking linkage Clamping arm/spindle included 	8725	[0.98]	[0.10]	[43]	37
		8732 8732G	[1.26] 32	[0.12]	[64]	
		8740 8740G	[1.57] 40	3,2	[106] 470	
		8750 8750G	[1.97] 50	[0.15] 3,8	[167] 745	

Application Note:

Swing Cylinder Rotation: The frame of reference for specifying the rotation direction (left or right) is the clamp arm viewed from above during the clamping stroke. A RIGHT HAND unit rotates CLOCKWISE and then clamps down; a LEFT HAND unit rotates COUNTER-CLOCKWISE and then clamps down.



9500 SERIES

Pneumatic Swing Clamps | Product Overview

Features:

- Ideal for tight spaces with an arm motion that rotates at the top of the stroke
- Includes a rod weld cover to protect the rod throughout the entire stroke
- Can be mounted on any face with optional side flange mounting kit
- Switch ready for Ø4mm or 6.5mm x 5mm sensors

Applications:

- Assembly
- Welding
- Light machining

Also Available:

- See page MC-PSC-6 for mounting options
- See page MC-PSC-7 for clamping arms
- See page MC-PSC-40 for sensing options

Covered under one or more U.S./International Patents

9522-2



9530-2



9540-2



9550-2



Shown with optional clamping arm.

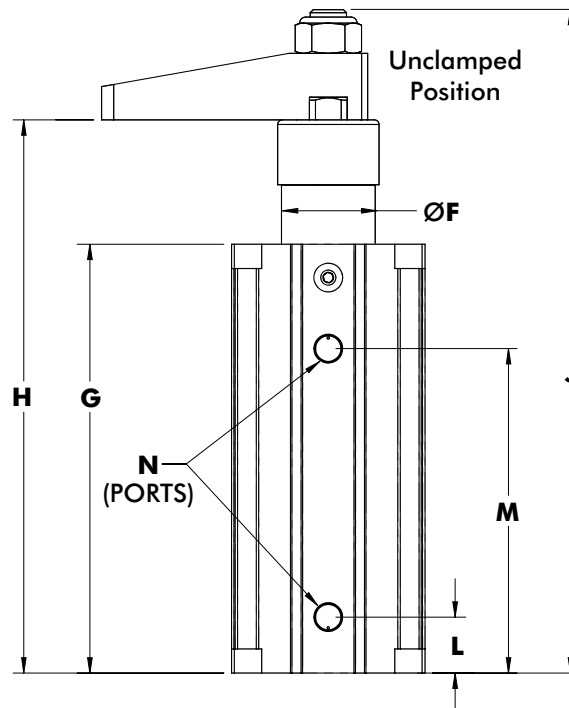
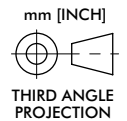
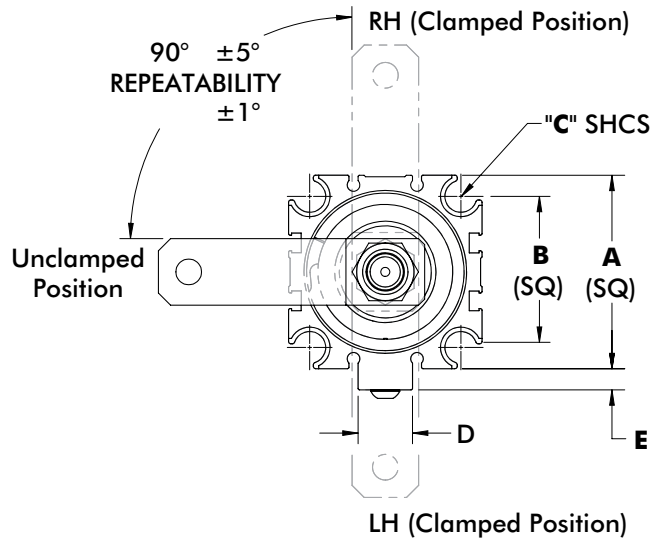
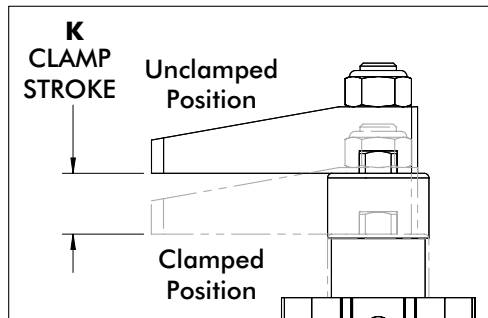
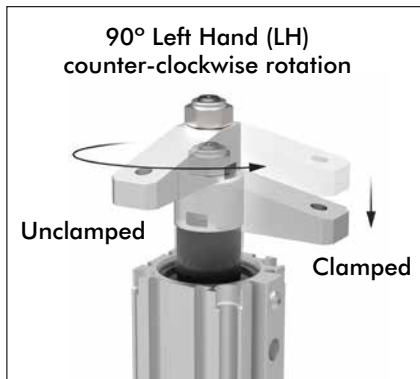
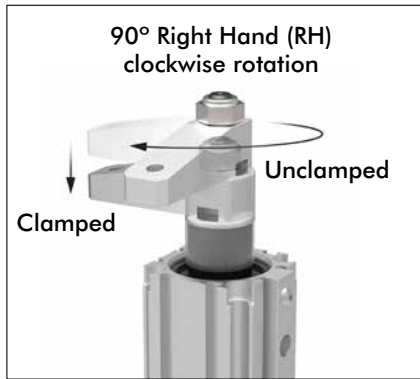
Technical Information

Model	Swing Direction	Total Stroke [in.]mm	Stroke During Rotation [in.]mm	Vertical Clamping Stroke [in.]mm	Clamping Force @ [lbf.]N†	Bore Size [in.]mm	Air Consumption‡ dm³[in³]	Weight [lb.]kg	Replacement Seal Kit	
9522-2L	LH	[0.50] 13		[0.50] 13	[34] 150	[0.86] 22	[0.004] 0,10	[0.68] 0,31	952292	
9522-2R	RH									
9530-2L	LH	[0.79] 20	--	[0.79] 20	[76] 340	[1.26] 32	[0.010] 0,29	[1.25] 0,57	953092	
9530-2GL										
9530-2R										RH
9540-2L	LH	[0.79] 20	--	[0.79] 20	[123] 550	[1.57] 40	[0.016] 0,46	[1.98] 0,90	954092	
9540-2GL										
9540-2R										RH
9550-2L	LH	[0.79] 20	--	[0.79] 20	[196] 870	[1.97] 50	[0.026] 0,74	[3.33] 1,51	955092	
9550-2GL										
9550-2R										RH
9550-2GR										

† with standard clamping arm at 5bar [72psi]. ‡ Per double stroke at 5bar [72psi]

Operating Pressure Range: 3bar [45psig] to 8bar [120psig]

Maximum Operating Temperature: 60°C [140°F]



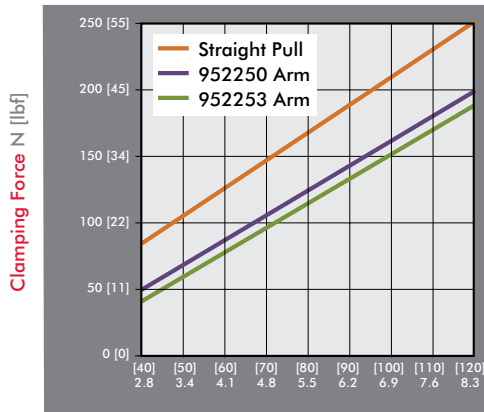
Shown with optional clamping arm.

Model	A	B	C	D	E	F	G	H	J	K	L	M	N
9522-2	[1.42] 36	[1.00] 25,4	M5 (#10)	--	--	[0.82] 21	[3.77] 95,8	[4.79] 121,8	[5.72] 145,7	[0.50] 13	[0.43] 11	[2.90] 73,8	M5
9530-2	[1.81] 46	[1.34] 34	M6 (1/4")	[0.55] 14	[0.16] 4	[0.96] 24,4	[4.48] 113,7	[6.09] 154,8	[7.33] 186	[0.79] 20	[0.61] 15,5	[3.39] 86,2	1/8NPT
9530-2G													
9540-2	[2.05] 52	[1.57] 40			[0.20] 5	[1.13] 28,7	[4.63] 117,6	[6.29] 159,7	[7.52] 190,9		[0.65] 16,5	[3.43] 87,1	1/8NPT
9540-2G													G-1/8
9550-2	[2.52] 64	[1.97] 50	M8 (5/16")	[0.71] 18	[0.28] 7	[1.32] 33,5	[5.58] 141,8	[7.20] 182,9	[8.64] 219,3		[0.73] 18,5	[4.22] 107,3	1/8NPT
9550-2G													G-1/8

9500 SERIES

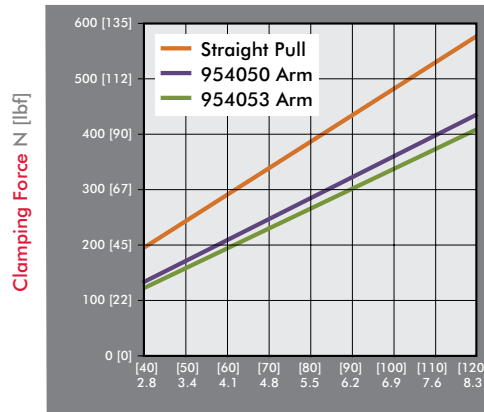
Pneumatic Swing Clamps | Clamping Forces

Series 9522-2 Clamping Force



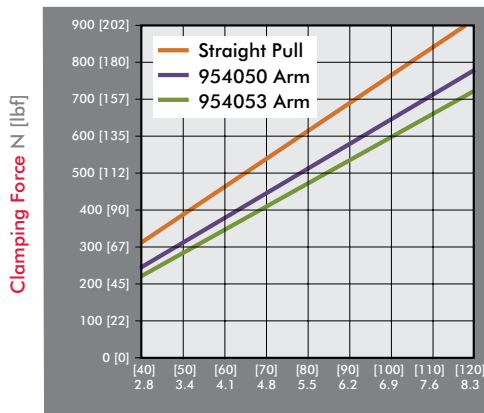
Inlet Pressure bar [PSI]

Series 9530-2 Clamping Force



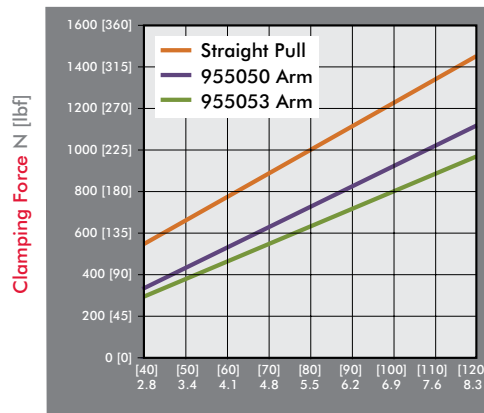
Inlet Pressure bar [PSI]

Series 9540-2 Clamping Force



Inlet Pressure bar [PSI]

Series 9550-2 Clamping Force



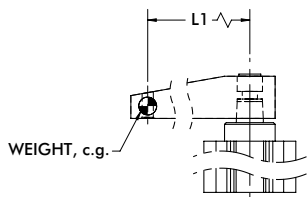
Inlet Pressure bar [PSI]

Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

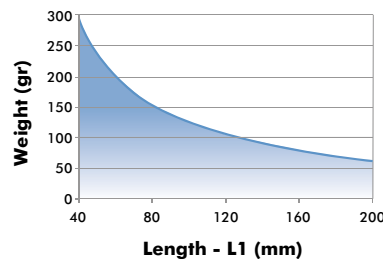
Example: 9522-2

At a weight of 80 gr, the maximum length of the arm is approximately 120mm.

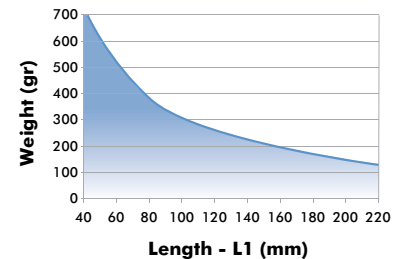


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

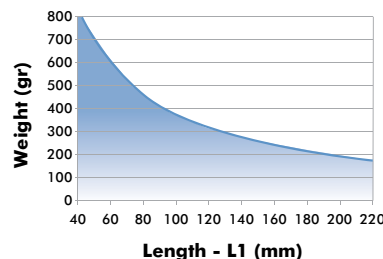
9522-2 Clamp Arm Weight



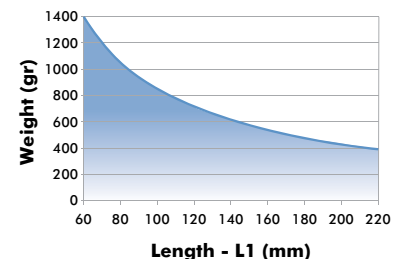
9530-2 Clamp Arm Weight

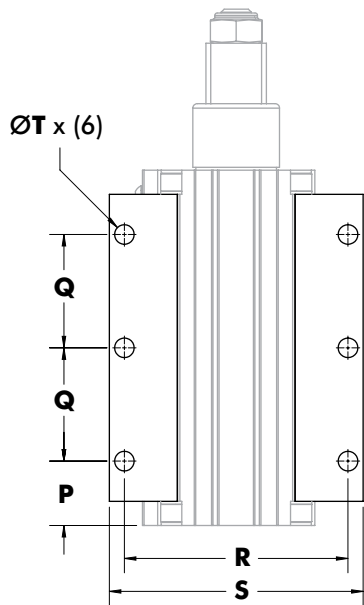
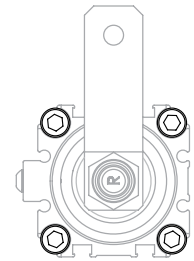
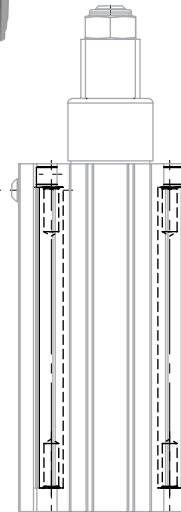
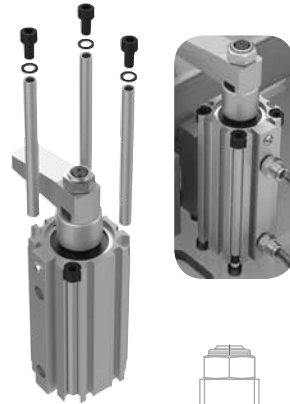
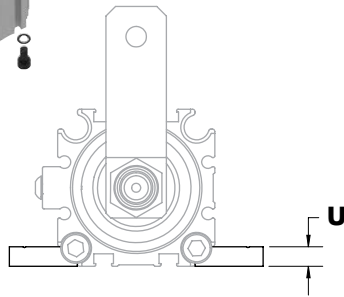
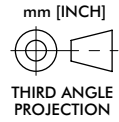


9540-2 Clamp Arm Weight

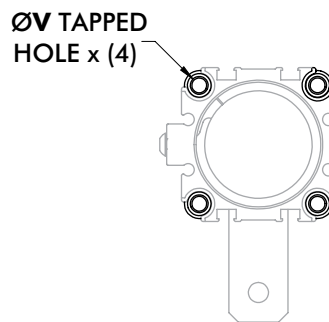


9550-2 Clamp Arm Weight

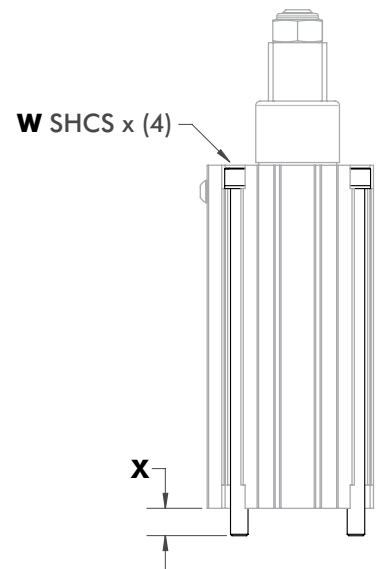




Optional Side Flange Mounting



Optional Tapped Hole Mount



Optional Standard Mount

Model	P	Q	R	S	T	U	V	W	X	Side Flange Kit	Tapped Hole Kit	Standard Mount Kit
9522-2	[0.41] 10,4		[1.91] 48,5	[2.26] 57,5	[0.22] 5,5	[0.22] 5,5	M5	M5x100	[0.36] 9.2	952260	952261	952262
9530-2	[0.76] 19,4	[1.48] 37,5	[2.68] 68	[3.07] 78	[0.26] 6,5	[0.26] 6,5	M6	M6x120	[0.52] 13.3	953060	953061	953062
9530-2G												
9540-2	[0.84] 21,3		[2.91] 74	[3.31] 84			M6	M6x120	[0.37] 9.4	954060	954061	
9540-2G												
9550-2	[0.82] 20,9	[1.97] 50	[3.66] 93	[4.17] 106	[0.33] 8,5	[0.31] 8	M8	M8x150	[0.59] 15	955060	955061	955062
9550-2G												

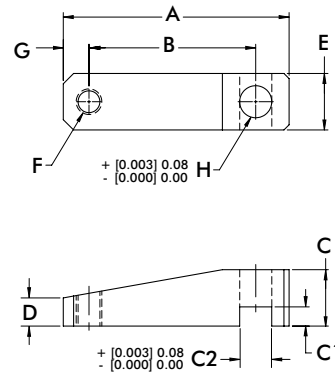
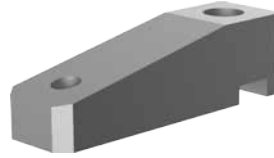
Refer to NPN-9500-2 for mounting instructions

9500 SERIES

Pneumatic Swing Clamps | Clamping Arms

Features:

- Lightweight aluminum construction
- Designed for use with 9500-2 series clamps



Part Number	Used with Model/Series	A	B	C	C1	C2	D	E	F	G	H	Weight [lbs] kg
9522150	9522-2R	[2.28] 58	[1.77] 45	[0.59]	[0.16]	[0.315]	[0.30]	[0.59]	M6	[0.20]	[0.315]	[0.06] 0,025
9522153	9522-2L	[3.07] 78	[2.56] 65	15	4	8.01	7.50	15	M6	5	8.00	[0.08] 0,034
9540150	9530-2R/9530-2L 9530-2GR/9530-2GL	[2.76] 70	[1.97] 50	[0.79]	[0.18]	[0.394]	[0.39]	[0.79]	M8		[0.394]	[0.12] 0,054
9540153	9540-2R/9540-2L 95402-GR/9540-2GL	[3.94] 100	[3.15] 80	20	4.6	10.01	10	20	M8	[0.39]	10.00	[0.17] 0,079
9550150	9550-2R/9550-2L	[3.46] 88	[2.56] 65	[0.87]	[0.30]	[0.493]	[0.43]	[0.87]	M10	10	[0.492]	[0.18] 0,081
9550153	9550-2GR/9550-2GL	[4.45] 113	[3.54] 90	22	7.5	12.51	11	22	M10		12.50	[0.23] 0,11

Features:

- Swing direction is field adjustable between left, right, or straight. (20mm not linear adjustable)
- Switch ready for Ø4mm or 6.5mm x 5mm sensors
- Lightweight and robust, designed for several million cycles
- Clamp arm sold separately

Applications:

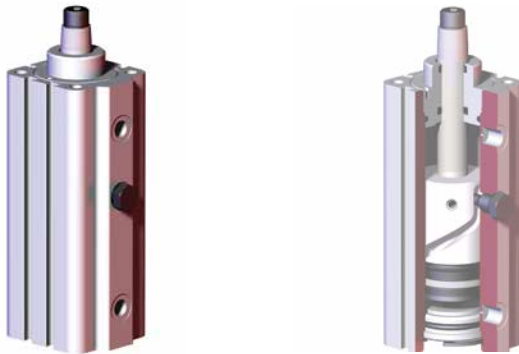
- Assembly
- Welding
- Light machining

Also Available:

See page MC-PSC-11 thru 13 for clamping arms and mounting accessories

See page MC-PSC-40 for sensing options

89R



Technical Information

Model	Swing Direction*	Total Stroke [in]mm	Stroke During Rotation [in]mm	Vertical Clamp Stroke [in]mm	Clamping Force† [lbf]N	Bore Size [in]mm	Air Consumption‡ [ft³]dm³	Weight [lb.]kg	Replacement Seal Kit
89R20-010-2	LH, RH	[0.83] 21	[0.43] 11		[18] 80	[0.79] 20	[0.002] 0,07	[0.66] 0,30	89R20-00
89R32-010-2		[1.10] 28	[0.61] 18	[0.39] 10	[55] 245	[1.26] 32	[0.009] 0,25	[1.32] 0,60	89R32-00
89R40-010-2		[1.24] 31,5	[0.85] 21,5		[85] 380	[1.57] 40	[0.015] 0,43	[2.09] 0,95	89R40-00
89R40-025-2	LH, RH, STRT	[1.83] 46,5					[0.022] 0,63	[2.43] 1,10	
89R50-025-2		[2.05] 52	[1.06] 27	[0.98] 25	[138] 614	[1.97] 50	[0.040] 1,13	[3.97] 1,80	89R50-00
89R63-025-2		[2.30] 58,5	[1.32] 33,5		[218] 970	[2.48] 63	[0.072] 2,04	[6.17] 2,80	89R63-00

*Swing direction is field adjustable. †with standard clamping arm 5bar [72psi]. ‡per double stroke at 5bar [72psi]

Operating Pressure Range: 3bar [45psig] to 8bar [120psig]

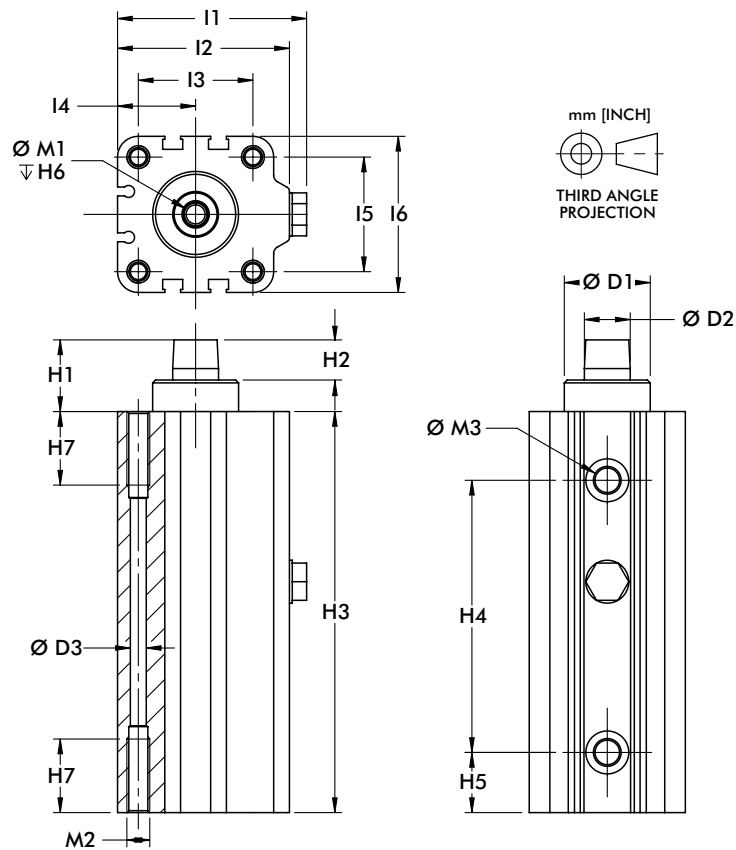
Maximum Operating Temperature: 60°C [140°F]

Note:

Switches are optional. To order with (2) 8EA-109-1 switches, add **A** to the end of the model. Ex. 89R32-010-2**A**

89R SERIES

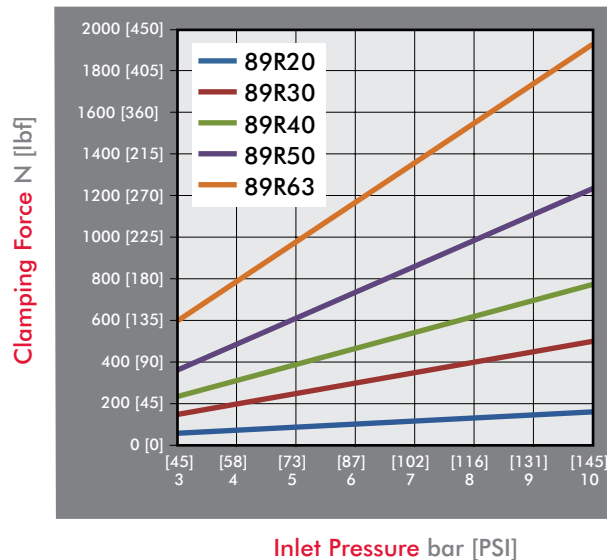
Pneumatic Swing Clamps | Dimensions



Model	ØD1 H9	ØD2 F7	ØD3	H1	H2	H3	H4	H5	H6	H7	L1	L2
89R20-010-2	[0.71] 18	[0.39] 10	[0.18] 4,6	[0.78] 19,8	[0.47] 11,9	[4.15] 105,5	[2.60] 66	[0.52] 13,2	[0.59] 15	[0.55] 14	[1.56] 39,5	[1.38] 35
89R32-010-2	[0.87] 22	[0.47] 12		[0.93] 23,7		[4.92] 125	[3.27] 83	[0.69] 17,5		[0.63] 16	[2.36] 60	[2.13] 54
89R40-010-2	[1.18] 30	[0.63] 16	[0.22] 5,5	[0.98] 25	[0.43] 11	[5.51] 140	[3.74] 95	[0.83] 21	[0.67] 17		[2.60] 66	[2.36] 60
89R40-025-2						[6.69] 170	[4.92] 125			[0.98] 25		
89R50-025-2	[1.57] 40	[0.71] 18	[0.29] 7,4	[1.24] 31,4		[7.70] 195,5	[5.39] 137	[1.05] 26,7	[0.98] 25		[3.09] 78,5	[2.85] 72,5
89R63-025-2	[1.77] 45	[0.78] 20	[0.37] 9,3	[1.30] 33	[0.59] 15	[8.33] 211,5	[6.08] 154,5	[1.04] 26,5			[3.74] 95	[3.46] 88

Model	L3	L4	L5	L6	M1	M2	M3
89R20-010-2	[0.87] 22	[0.63] 16	[0.87] 22	[1.26] 32	M5	M6	M5
89R32-010-2	[1.42] 36	[0.94] 24	[1.26] 32	[1.77] 45	M6		
89R40-010-2	[1.57] 40	[1.07] 27,3	[1.57] 40	[2.15] 54,5	M8	M8	G-1/8
89R40-025-2							
89R50-025-2	[1.97] 50	[1.28] 32,5	[1.97] 50	[2.56] 65	M10	M10	
89R63-025-2	[2.44] 62	[1.57] 40	[2.44] 62	[3.15] 80	M10	M12	G-1/4

Series 89R Clamping Force
(w/ standard clamping arm)

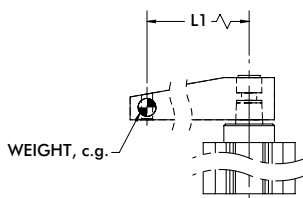


Guidelines

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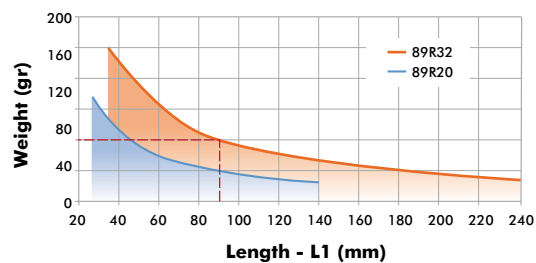
Example: 89R32

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

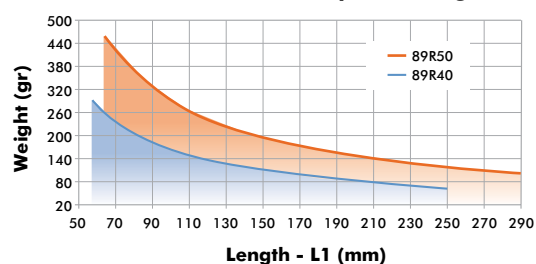


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

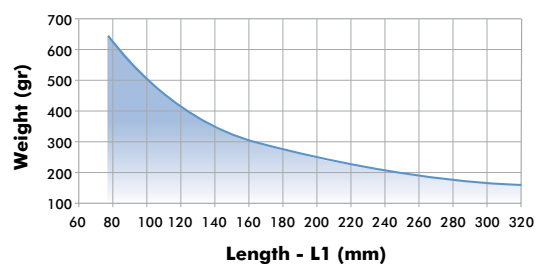
89R20 & 89R32 Clamp Arm Weight



89R40 & 89R50 Clamp Arm Weight



89R63 Clamp Arm Weight

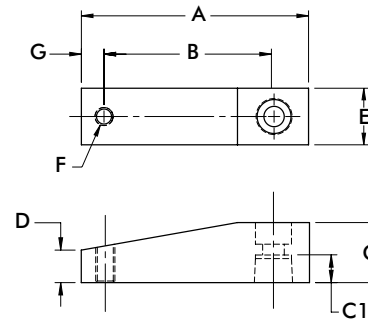


89R SERIES

Pneumatic Swing Clamps | Clamping Arms

Features:

- Lightweight aluminum construction
- Locking tapered connection for 360 deg. arm positioning

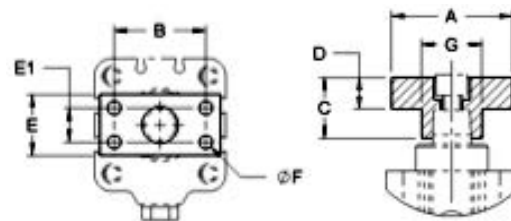
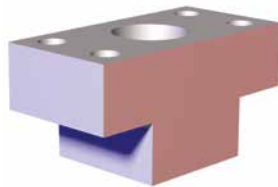


Part Number	Used with Model/series	A	B	C	C1	D	E	F	G	Weight [lbs] kg
8JG-215-1	89R20-010-2	[2.64] 67	[2.05] 52	[0.59] 15	[0.33] 8.5	[0.33] 8.5	[0.59] 15	M6	[0.28] 7	[0.08] 0.04
8JG-217-1	89R32-010-2	[3.15] 80	[2.36] 60	[0.79] 20	[0.37] 9.5	[0.33] 8.5	[0.79] 20	M8	[0.39] 10	[0.14] 0.06
8JG-218-1	89R40-010-2 89R40-025-2	[3.74] 95	[2.76] 70	[0.98] 25	[0.45] 11.5	[0.55] 14	[0.98] 25	M8	[0.39] 10	[0.28] 0.13
8JG-219-1	89R50-025-2	[4.17] 106	[3.15] 80	[1.18] 30	[0.59] 15	[0.57] 14,5	[1.18] 30	M8	[0.39] 10	[0.42] 0.19
8JG-220-1	89R63-025-2	[4.72] 120	[3.54] 90	[1.38] 35	[0.67] 17	[0.67] 17	[1.38] 35	M10	[0.47] 12	[0.66] 0.30

Clamping Arm Adapters

Features:

- For attaching custom made clamp arms
- 360° rotatable arm
- Aluminum construction

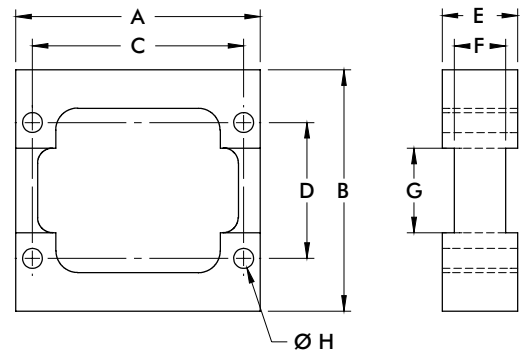


Part Number	Used with Model/series	A	B	C	D	E	E1	F	Weight [lbs] kg
8MA-084-1	89R20-010-2	[1.57] 40	[1.10] 28	[0.59] 15	[0.32] 8	[0.59] 15	--	[0.22]	[0.03] 0,014
8MA-086-1	89R32-010-2	[1.97] 50	[1.38] 35	[0.79] 20	[0.43] 11	[0.79] 20	--	5,5 (2x)	[0.08] 0,035
8MA-087-1	89R40-010-2 89R40-025-2	[1.97] 50	[1.50] 38	[0.98] 25	[0.51] 13	[0.98] 25	[0.55] 14	[0.22] 5,5 (4x)	[0.11] 0,050
8MA-088-1	89R50-025-2	[2.36] 60	[1.77] 45	[1.18] 30	[0.59] 15	[1.18] 30	[0.59] 15	[0.28] 7 (4x)	[0.19] 0,085
8MA-089-1	89R63-025-2	[2.56] 65	[1.89] 48	[1.38] 35	[0.67] 17	[1.38] 35	[0.71] 18	[0.35] 9 (4x)	[0.28] 0,125

Pneumatic Swing Clamps | Body Mount Flanges

Features:

- For recessed mounting
- Variable height adjustment
- Can be used with switches
- For use with the **89R** Series Pneumatic Swing Clamps

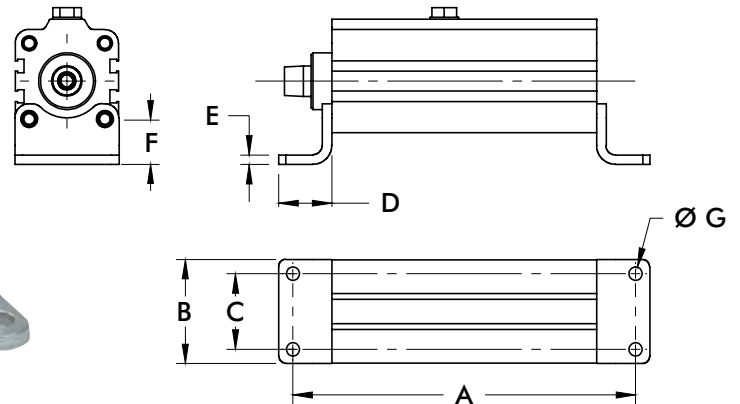


Part Number	Used with Model/series	A	B	C	D	E	F	G	H	Weight [lbs] kg
8MA-092-1	89R20-010-2	[2.24] 57	[2.17] 55	[1.85] 47	[0.94] 24	[0.59] 15	--	--	[0.28] 5,5	[0.22] 0,10
8MA-094-1	89R32-010-2		[2.95] 75		[1.57] 40	[0.79] 20	[0.47] 12	[0.98] 25		[0.44] 0,20
8MA-095-1	89R40-010-2	[3.19] 81	[3.15] 80	[2.55] 70	[1.77] 45	[0.98] 25	[0.67] 17	[1.10] 28	[0.26] 6,6	[0.55] 0,25
	89R40-025-2							[1.46] 37	[0.35] 9	[0.88] 0,40
8MA-096-1	89R50-025-2	[4.00] 101,5	[3.94] 100	[3.37] 85,5	[1.97] 50					

Mounting Feet

Features:

- Can be mounted on bottom side or front side
- Can be mounted on 4 sides of the cylinder
- For use with **89R** Series Pneumatic Swing Clamps



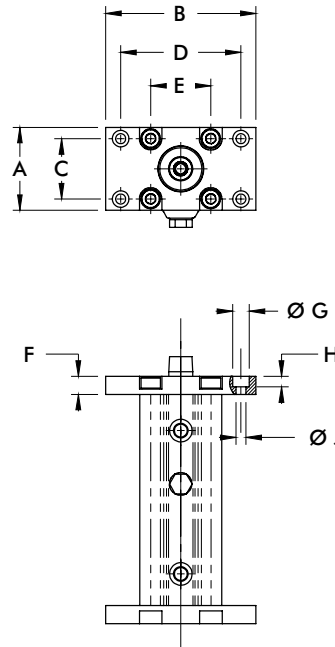
Part Number	Used with Model/series	A	B	C	D	E	F	G	Weight [lbs] kg
8MW-018-1	89R20-010-2	[5.41] 137,5	[1.38] 35	[0.87] 22	[0.87] 22	[0.16] 4	[0.63] 16		[0.08] 0,04
8MW-020-1	89R32-010-2	[6.54] 166	[1.97] 50	[1.38] 35			[0.71] 18	[0.28] 7	[0.15] 0,07
8MW-021-1	89R40-010-2	[7.13] 181	[2.17] 55	[1.57] 40	[1.10] 28	[0.20] 5	[0.94] 24		[0.22] 0,10
	89R40-025-2	[8.31] 211							
8MW-022-1	89R50-025-2	[9.39] 238,5	[2.64] 67	[1.97] 50	[1.26] 32	[0.24] 6		[0.35] 9	[0.33] 0,15
8MW-023-1	89R63-025-2	[10.37] 263,5	[3.35] 85	[2.44] 62	[1.57] 40		[1.06] 27	[0.43] 11	[0.52] 0,24

89R SERIES

Pneumatic Swing Clamps | End Mount Flanges

Features:

- Can be mounted on bottom side or top side
- For use with **89R** Pneumatic Swing Clamps



Part Number	Used with Model/series	A	B	C [±0.008] ±0,2	D [±0.008] ±0,2	E	F	G	H	J	Weight [lbs]kg
8MA-061-1	89R20-010-2	[1.26] 32	[2.56] 65	[0.71] 18	[1.97] 50	[0.87] 22	[0.39] 10				[0.07] 0,03
8MA-063-1	89R32-010-2	[1.97] 50	[3.15] 80	[1.26] 32	[2.52] 64	[1.26] 32	[0.47] 12	[0.43] 11	[0.28] 7	[0.26] 6,6	[0.20] 0,09
8MA-064-1	89R40-010-2	[2.17] 55	[3.94] 100	[1.57] 40	[3.15] 80	[1.57] 40					[0.29] 0,13
	89R40-025-2										
8MA-065-1	89R50-025-2	[2.56] 65	[4.72] 120	[1.77] 45	[3.94] 100	[1.97] 50	[0.59] 15	[0.59] 15	[0.35] 9	[0.33] 8,5	[0.46] 0,21
8MA-066-1	89R63-025-2	[3.15] 80	[5.12] 130	[2.36] 60	[4.33] 110	[2.44] 62				[0.35] 8,8	[0.66] 0,30

Features:

- Lightweight and robust, designed for several millions cycles
- Can be mounted from the side or the top
- Sensor ready for T-slot style sensors
- Metric design
- Clamp arm sold separately

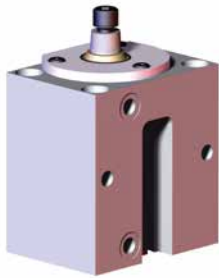
Applications:

- Assembly
- Welding
- Light machining

Also Available:

See page MC-PSC-17 for clamping arms
See page MC-PSC-40 for sensing options

Series 89B



Technical Information

Model	Swing Direction	Total Stroke [in]mm S	Stroke During Rotation [in]mm S1	Vertical Clamp Stroke [in]mm S2	Clamping Force [lbf.] N†	Bore Size mm[in]	Air Consumption‡ [ft³]dm³	Weight [lb.]kg	Replacement Seal Kit
89B20-010-2R	RH	[0.79]	[0.39]		[29]	[0.79]	[0.003]	[1.46]	89B/E20-2-00
89B20-010-2L	LH	20	10		130	20	0,08	0,66	
89B32-010-2R	RH	[0.83]	[0.43]	[0.39]	[79]	[1.25]	[0.008]	[2.25]	89B/E32-2-00
89B32-010-2L	LH	21	11	10	350	32	0,22	1,02	
89B40-010-2R	RH	[0.94]	[0.55]		[130]	[1.57]	[0.014]	[3.17]	89B/E40-2-00
89B40-010-2L	LH	24	14		580	40	0,39	1,44	
89B50-025-2R	RH	[1.57]	[0.59]	[0.98]	[225]	[1.97]	[0.036]	[5.95]	89B/E50-2-00
89B50-025-2L	LH	40	15	25	1000	50	1,03	2,70	
89B63-008-2R	RH	[1.02]	[0.71]	[0.32]	[321]	[2.48]	[0.038]	[6.39]	89B/E63-2-00
89B63-008-2L	LH	26	18	8	1430	63	1,08	2,90	

† with standard clamping arm at 6bar [87psi]. ‡ per double stroke at 6bar [87psi]

Operating Pressure Range: 3bar [45psig] to 6bar [87psig]

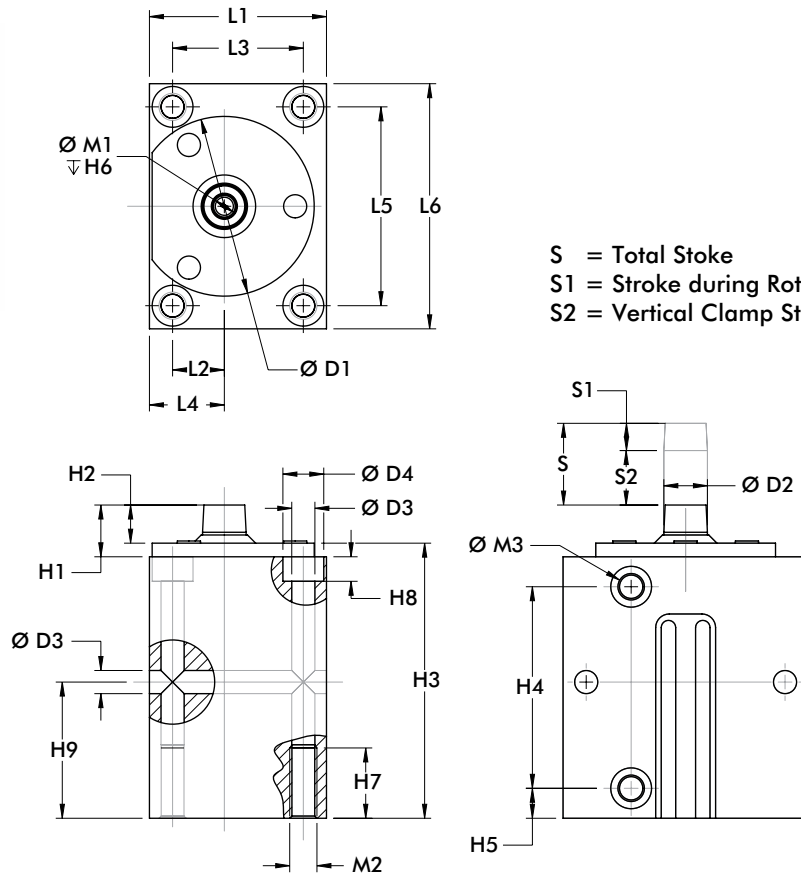
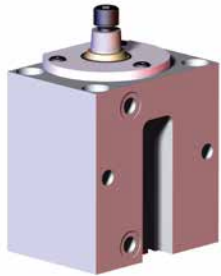
Maximum Operating Temperature: 80°C [176°F]

Note:

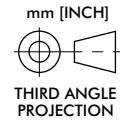
Switches are optional. To order clamp with (2) 8EA-109-1 switches, add **A** to the end of the model. EX. 89B30-010-2**RA**. See page MC-PSC-40 for additional switch options.

89B SERIES

Pneumatic Swing Clamps | Dimensions



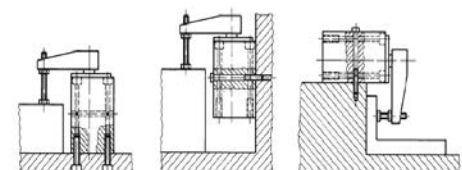
S = Total Stroke
 S1 = Stroke during Rotation
 S2 = Vertical Clamp Stroke



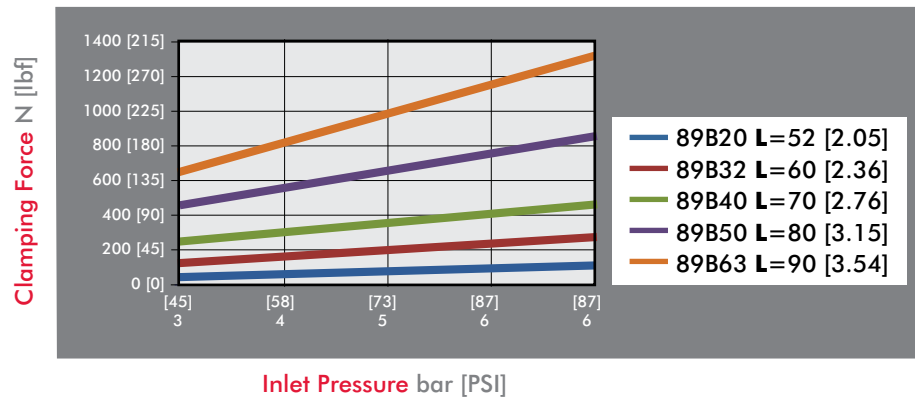
Model	ØD1	ØD2	ØD3	D4	H1	H2	H3	H4	H5	H6	H7	H8	H9	L1
89B20	[1.89] 48	[0.39] 10	[0.26] 6,6	[0.43] 11	[0.69] 17,5	[0.35] 9	[3.48] 88.5	[2.28] 58	[0.35] 9	[0.59] 15	[0.79] 20	[0.28] 7	[1.57] 40	[1.77] 45
89B32	[2.20] 56	[0.47] 12	[0.33]	[0.59]	[0.63] 16	[0.43] 11	[3.70] 94	[2.72] 69	[0.39] 10	[0.67] 17	[0.98] 25	[0.35] 9	[1.77] 45	[2.17] 55
89B40	[2.60] 66	[0.63] 16	8,5	15	[0.75] 19	[0.55] 14	[3.98] 101	[2.91] 74					[1.97] 50	[2.56] 65
89B50	[3.07] 78	[0.71] 18	[0.41]	[0.71]	[0.98] 25	[0.67] 17	[5.51] 140	[4.29] 109	[0.43] 11	[0.98] 25	[1.18] 30	[0.43] 11	[2.76] 70	[2.95] 75
89B63	[3.70] 94	[0.79] 20	10,5	18	[1.06] 27	[0.75] 19	[4.53] 115	[3.35] 85					[2.16] 55	[3.54] 90

Model	L2	L3	L4	L5	L6	M1	M2	M3
89B20	[0.45] 11,5	[1.18] 30	[0.75] 19	[2.36] 60	[2.95] 75	M5	M8	M5
89B32	[0.55] 14	[1.50] 38	[0.89] 22,5	[2.68] 68	[3.35] 85	M6	M10	
89B40	[0.75] 19	[1.89] 48	[1.08] 27,5	[2.87] 73	[3.54] 90	M8		G-1/8
89B50	[0.94] 24	[2.17] 55	[1.34] 34	[3.54] 90	[4.33] 110		M12	
89B63	[1.18] 30	[2.76] 70	[1.57] 40	[3.94] 100	[4.72] 120	M10		G-1/4

Mounting Options



Series 89B Clamping Force (w/ standard clamping arm)

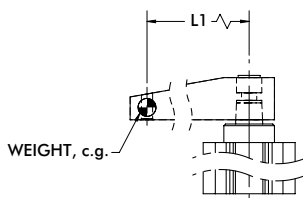


Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

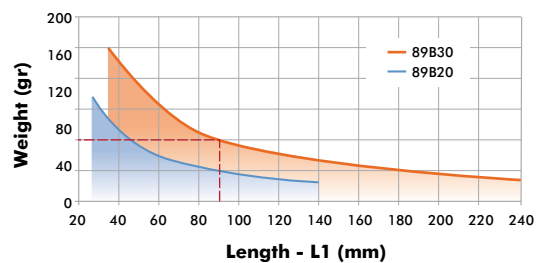
Example: 89B32

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

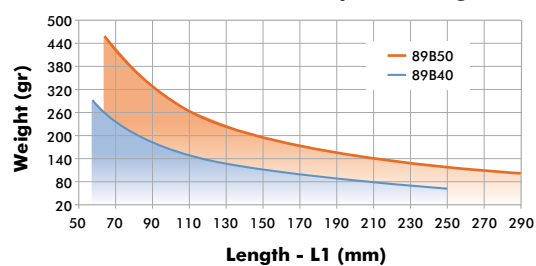


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

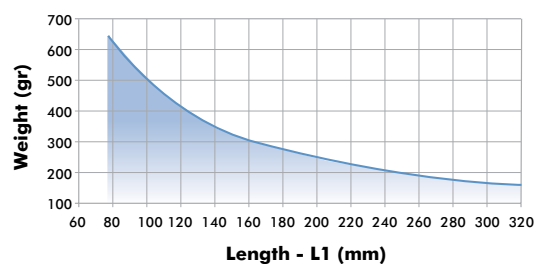
89B20 & 89B32 Clamp Arm Weight



89B40 & 89B50 Clamp Arm Weight



89B63 Clamp Arm Weight

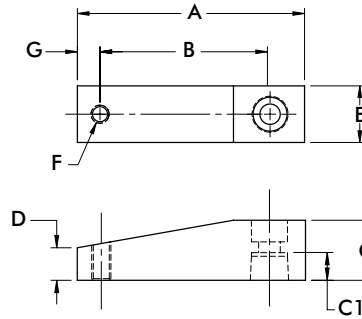


89B SERIES

Pneumatic Swing Clamps | Clamping Arm

Features:

- Lightweight aluminum construction
- Locking tapered connection for 360 deg. arm positioning

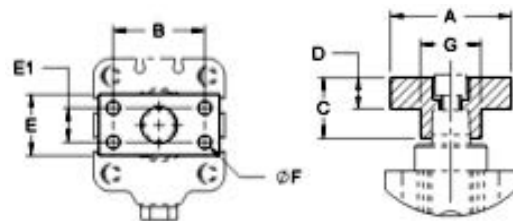
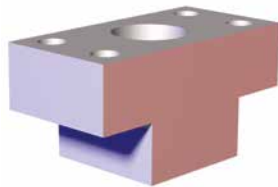


Part Number	Used with Model/series	A	B	C	C1	D	E	F	G	Weight [lbs] kg
8JG-215-1	89B20-010-2	[2.64] 67	[2.05] 52	[0.59] 15	[0.33] 8.5	[0.33] 8.5	[0.59] 15	M6	[0.28] 7	[0.08] 0.04
8JG-217-1	89B32-010-2	[3.15] 80	[2.36] 60	[0.79] 20	[0.37] 9.5	[0.33] 8.5	[0.79] 20	M8	[0.39] 10	[0.14] 0.06
8JG-218-1	89B40-010-2	[3.74] 95	[2.76] 70	[0.98] 25	[0.45] 11.5	[0.55] 14	[0.98] 25	M8	[0.39] 10	[0.28] 0.13
8JG-219-1	89B50-025-2	[4.17] 106	[3.15] 80	[1.18] 30	[0.59] 15	[0.57] 14,5	[1.18] 30	M8	[0.39] 10	[0.42] 0.19
8JG-220-1	89B63-008-2	[4.72] 120	[3.54] 90	[1.38] 35	[0.67] 17	[0.67] 17	[1.38] 35	M10	[0.47] 12	[0.66] 0.30

Clamping Arm Adapters

Features:

- For attaching custom made clamp arms
- 360° rotatable arm
- Aluminum construction



Part Number	Used with Model/series	A	B	C	D	E	E1	F	Weight [lbs] kg
8MA-084-1	89B20-010-2	[1.57] 40	[1.10] 28	[0.59] 15	[0.32] 8	[0.59] 15	--	[0.22]	[0.03] 0,014
8MA-086-1	89B32-010-2	[1.97] 50	[1.38] 35	[0.79] 20	[0.43] 11	[0.79] 20	--	5,5 (2x)	[0.08] 0,035
8MA-087-1	89B40-010-2	[1.97] 50	[1.50] 38	[0.98] 25	[0.51] 13	[0.98] 25	[0.55] 14	[0.22] 5,5 (4x)	[0.11] 0,050
8MA-088-1	89B50-025-2	[2.36] 60	[1.77] 45	[1.18] 30	[0.59] 15	[1.18] 30	[0.59] 15	[0.28] 7 (4x)	[0.19] 0,085
8MA-089-1	89B63-008-2	[2.56] 65	[1.89] 48	[1.38] 35	[0.67] 17	[1.38] 35	[0.71] 18	[0.35] 9 (4x)	[0.28] 0,125

8100, 8300 SERIES

Pneumatic Swing Clamps | Product Overview

Features:

- Lightweight and robust, designed for several millions cycles
- Block style body may be mounted from the side or the top.
- Sensor ready for use with round style sensors
- Clamp arm and spindle included

Applications:

- Assembly
- Welding
- Light machining

Also Available:

See page MC-PSC-22 for clamping arms

See page MC-PSC-40 for sensing options

Series 8100, 8300



Sensor ready.

Supplied with clamping arm and spindle.

To order without clamping arm add **-LA** to the end of the model. Ex. 8115-**LA**

Technical Information

Model	Swing Direction	Total Stroke [in]mm	Stroke During Rotation [in]mm	Vertical Clamp Stroke [in]mm	Clamping Force [lbf.] N†	Bore Size mm[in]	Air Consumption‡ [ft³]dm³	Weight [lb.]kg	Replacement Seal Kit
8115	RH	[0.85]	[0.47]	[0.38]	[25]	[18]	[0.002]	[0.68]	801560
8116	LH	21,5	11,8	9,7	110	80	0,06	0,31	
8315	RH	[1.25]	[0.75]	[0.50]	[89]	[67]	[0.014]	[2.00]	821560
8316	LH	31,8	19,1	12,7	400	298	0,40	0,91	

† with standard clamping arm at 5bar [72psi]. ‡ per double stroke at 5bar [72psi]

Operating Pressure Range: 3bar [45psig] to 9bar [130psig]

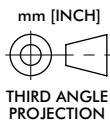
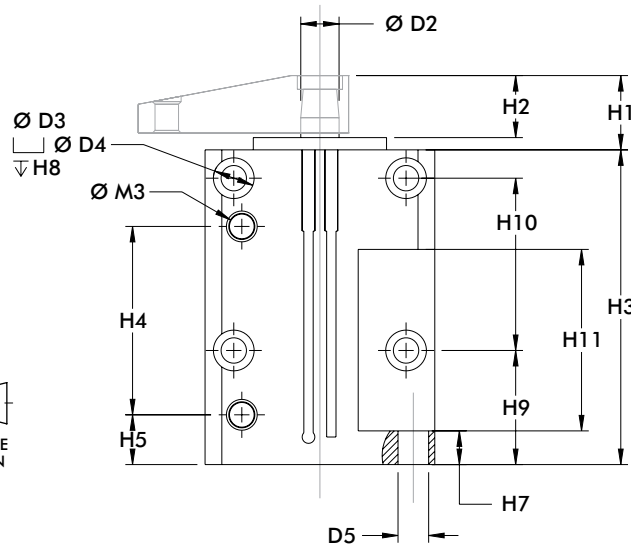
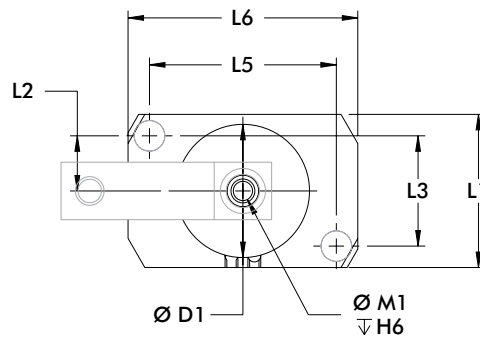
Maximum Operating Temperature: -18°C to 60°C [0°F to 140°F]

Note:

To order with out clamping arm, add **-LA** to the end of the model number. EX. 8115-**LA**.

8100, 8300 SERIES

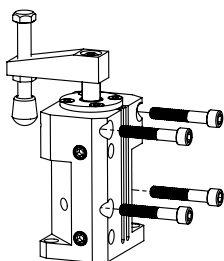
Pneumatic Swing Clamps | Dimensions



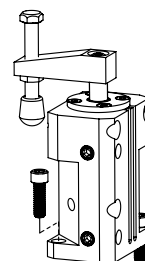
Model	ØD1	ØD2	ØD3	ØD4	ØD5	H1	H2	H3	H4	H5	H6	H7
8115	[1.23]	[0.44]	[0.20]	--	--	[0.53]	[0.41]	[3.37]	[1.45]	[0.35]	[0.75]	[0.25]
8116	31,2	11,2	5,1	--	--	13,5	10,4	85,6	36,8	8,9	19,1	6,4
8315	[1.74]	[0.50]	[0.33]	[0.53]	[0.40]	[0.97]	[0.81]	[4.11]	[2.46]	[0.65]	[0.67]	[0.44]
8316	44,2	12,7	8,4	13,5	10,2	24,6	20,6	104,4	62,5	16,5	17	11,2

Model	H8	H9	H10	H11	L1	L2	L3	L5	L6	M1	M3
8115	--	[1.37]	[1.00]	[1.00]	[1.25]	[0.47]	[0.94]	[0.94]	[1.25]	¼-20	#10-32
8116	--	34,8	25,4	25,4	31,8	11,9	23,9	23,9	31,8		
8315	[1.00]	[1.49]	[2.25]	[2.37]	[2.00]	[0.72]	[1.44]	[2.44]	[3.00]	5/16/18	1/8 NPT
8316	25,4	37,9	57,2	60,2	50,8	18,3	36,6	62	76,2		

Mounting Options



Can be mounted to the side or front of the fixture, or mounted back to back for multiple clamping operations.

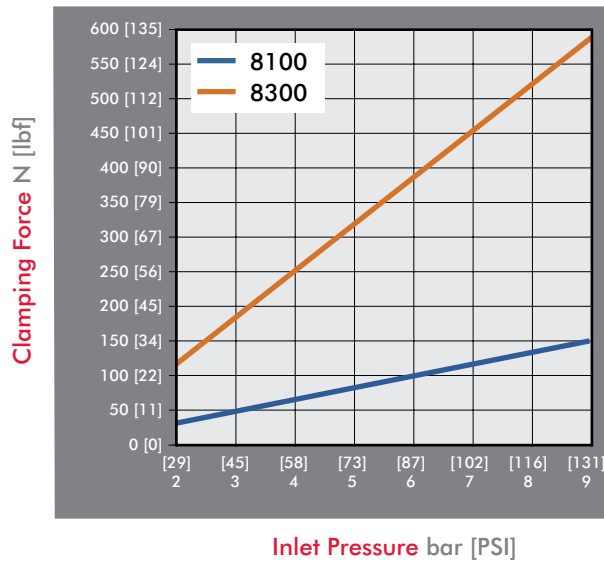


Mounted to the top of the work surface through the two mounting holes in the bottom of unit.

8100, 8300 SERIES

Pneumatic Swing Clamps | Clamping Forces

Series 8100, 8300 Clamping Force
(w/ standard clamping arm)

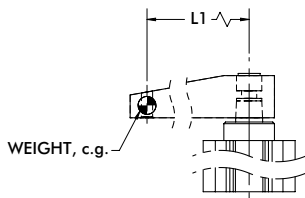


Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

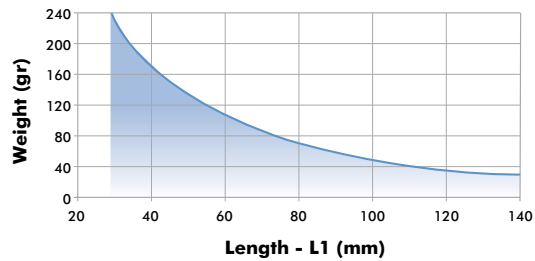
Example: 8315

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

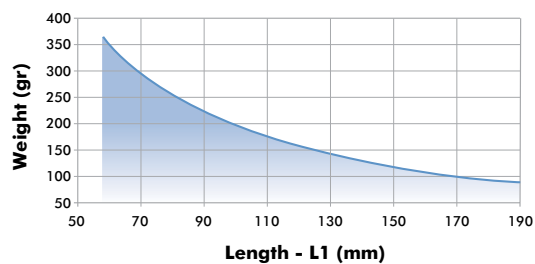


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

8115/8116 Clamp Arm Weight



8315/8316 Clamp Arm Weight

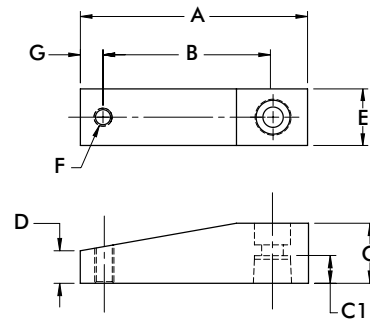


8100, 8300 SERIES

Pneumatic Swing Clamps | Clamping Arms

Features:

- Lightweight aluminum construction
- Locking tapered connection for 360 deg. arm positioning

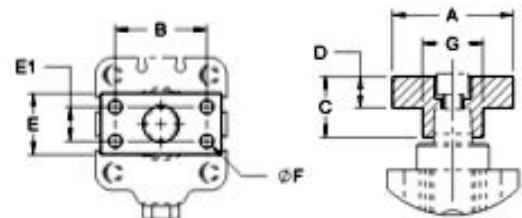


Part Number	Used with Model/series	A	B	C	C1	D	E	F	G	Weight [lbs] kg
801528	8115/8116	[1.74] 44.2	[1.11] 28.2	[0.37] 9.4	[0.33] 8.3	[0.25] 6.4	[0.62] 15.7	#10-32	[0.32] 8.1	[0.03] 0.01
801529	8115/8116	[2.87] 72.9	[2.24] 56.9	[0.37] 9.4	[0.33] 8.3	[0.25] 6.4	[0.62] 15.7	#10-32	[0.32] 8.1	[0.05] 0.02
821512	8315/8316	[2.75] 69.9	[2.00] 50.8	[0.75] 19.1	[0.57] 14.5	[0.38] 9.5	[0.75] 19.1	3/8-16	[0.38] 9.5	[0.04] 0.02
821513	8315/8316	[3.75] 95.3	[3.00] 76.2	[0.75] 19.1	[0.57] 14.5	[0.38] 9.5	[0.75] 19.1	3/8-16	[0.38] 9.5	[0.05] 0.02

Clamping Arm Adapters

Features:

- For attaching custom made clamp arms
- 360° rotatable arm
- Aluminum construction



Part Number	Used with Model/series	A	B	C	D	E	E1	F	Weight [lbs] kg
801532	8115/8116	[1.37] 34,8	[1.00] 25,4	[0.39]	[0.25]	[0.62]	--	#10-32 (2x)	[0.03] 0,014
821556	8315/8316	[1.50] 38,1	[1.06] 26,9	[0.75]	[0.37]	[0.75]	--	1/4-20 (2x)	[0.05] 0,020

89E SERIES

Pneumatic Swing Clamps | Product Overview

Features:

- Lightweight and robust, designed for several millions cycles
- Threaded body may be mounted in a tapped hole or a clearance hole with optional mounting flange
- Metric design
- Clamp arm sold separately

Applications:

- Assembly
- Welding
- Light machining

Also Available:

See page MC-PSC-26 for clamping arms

See page MC-PSC-27 for mounting flanges

Series 89E



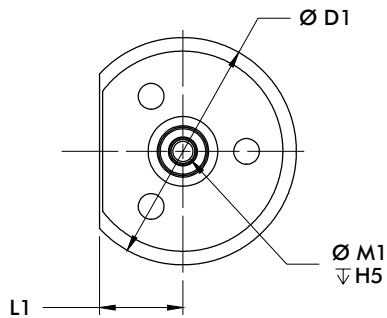
Technical Information

Model	Swing Direction	Total Stroke [in]mm S	Stroke During Rotation [in]mm S1	Vertical Clamp Stroke [in]mm S2	Clamping Force [lbf.] N†	Bore Size mm[in]	Air Consumption‡ [ft³]dm³	Weight [lb.]kg	Replacement Seal Kit
89E20-010-2R	RH	[0.79]	[0.39]		[29]	[0.79]	[0.003]	[0.64]	89B/E20-2-00
89E20-010-2L	LH	20	10		130	20	0,08	0,29	
89E32-010-2R	RH	[0.83]	[0.43]	[0.39]	[79]	[1.25]	[0.008]	[0.93]	89B/E32-2-00
89E32-010-2L	LH	21	11	10	350	32	0,22	0,42	
89E40-010-2R	RH	[0.94]	[0.55]		[130]	[1.57]	[0.014]	[1.76]	89B/E40-2-00
89E40-010-2L	LH	24	14		580	40	0,39	0,80	
89E50-025-2R	RH	[1.57]	[0.59]	[0.98]	[225]	[1.97]	[0.036]	[3.22]	89B/E50-2-00
89E50-025-2L	LH	40	15	25	1000	50	1,03	1,46	
89E63-008-2R	RH	[1.02]	[0.71]	[0.32]	[321]	[2.48]	[0.038]	[3.68]	89B/E63-2-00
89E63-008-2L	LH	26	18	8	1430	63	1,08	1,67	

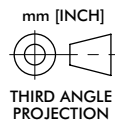
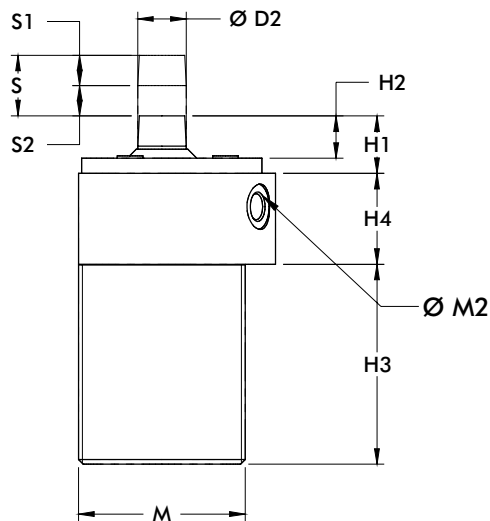
† with standard clamping arm at 6bar [87psi]. ‡ per double stroke at 6bar [87psi]

Operating Pressure Range: 3bar [45psig] to 10bar [145psig] (89E20 8bar [116psig] max.)

Maximum Operating Temperature: 80°C [176°F]

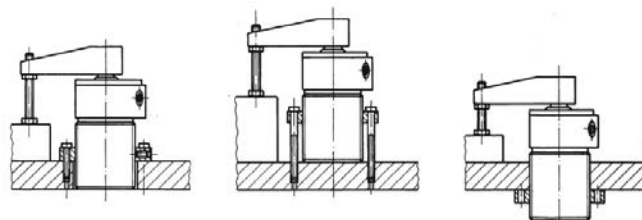


S = Total Stroke
 S1 = Stroke during Rotation
 S2 = Vertical Clamp Stroke



Model	ØD1	ØD2	H1	H2	H3	H4	H5	L1	M	M1	M2
89E20	[1.89] 48	[0.39] 10	[0.69] 17,5	[0.35] 9	[2.36] 60	[0.79] 20	[0.59] 15	[0.75] 19	M36X1,5	M5	M5
89E32	[2.52] 64	[0.47] 12	[0.63] 16	[0.43] 11	[2.72] 69		[0.67] 17	[0.89] 22,5	M42X1,5	M6	
89E40	[2.95] 75	[0.63] 16	[0.75] 19	[0.55] 14	[2.60] 66	[1.18] 30	[0.98] 25	[1.08] 27,5	M55X2	M8	G-1/8
89E50	[3.54] 90	[0.71] 18	[0.98] 25	[0.67] 17	[4.09] 104		[1.36] 34,5	M68X2	M10		
89E63	[4.13] 105	[0.79] 20	[1.06] 27	[0.75] 19	[3.03] 77		[1.57] 40	M80X2	M10	G-1/4	

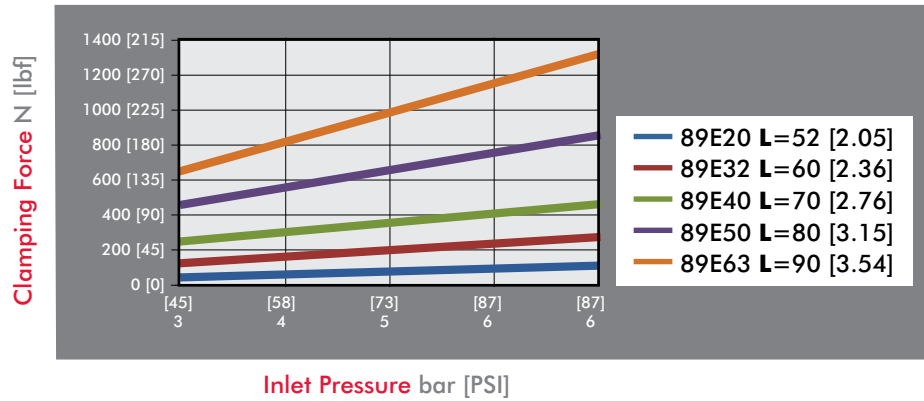
Mounting Options



89E SERIES

Pneumatic Swing Clamps | Clamping Forces

Series 89E Clamping Force
(w/ standard clamping arm)

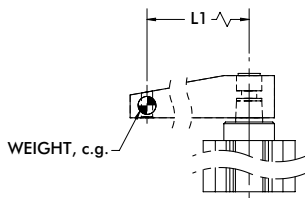


Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

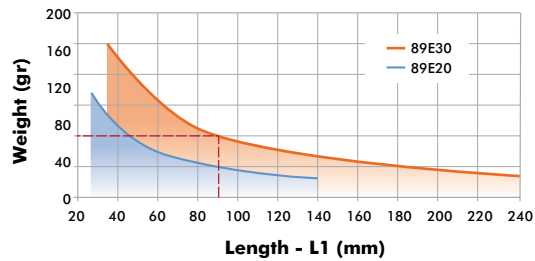
Example: 89E32

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

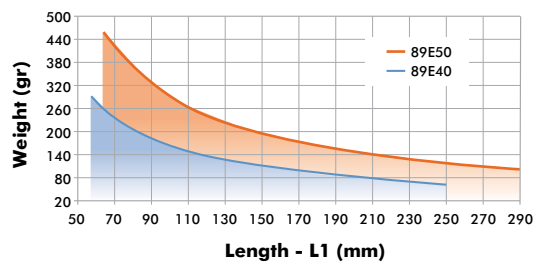


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

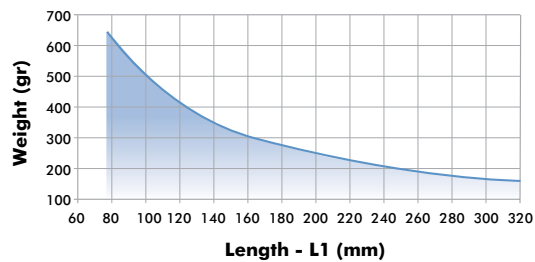
89E20 & 89E32 Clamp Arm Weight



89E40 & 89E50 Clamp Arm Weight



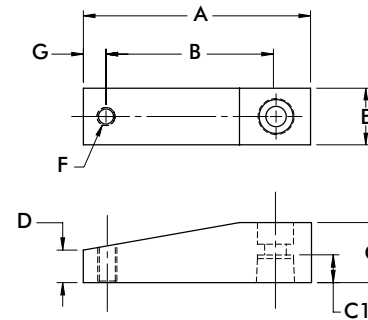
89E63 Clamp Arm Weight



Pneumatic Swing Clamps | Clamping Arms

Features:

- Lightweight aluminum construction
- Locking tapered connection for 360 deg. arm positioning

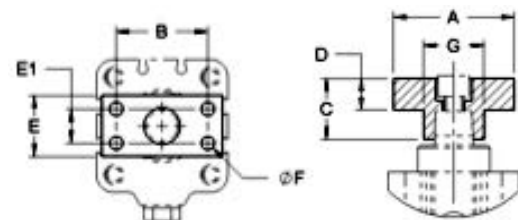
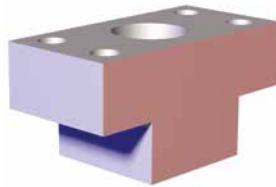


Part Number	Used with Model/series	A	B	C	C1	D	E	F	G	Weight [lbs] kg
8JG-215-1	89E20-010-2	[2.64] 67	[2.05] 52	[0.59] 15	[0.33] 8.5	[0.33] 8.5	[0.59] 15	M6	[0.28] 7	[0.08] 0.04
8JG-217-1	89E32-010-2	[3.15] 80	[2.36] 60	[0.79] 20	[0.37] 9.5	[0.33] 8.5	[0.79] 20	M8	[0.39] 10	[0.14] 0.06
8JG-218-1	89E40-010-2	[3.74] 95	[2.76] 70	[0.98] 25	[0.45] 11.5	[0.55] 14	[0.98] 25	M8	[0.39] 10	[0.28] 0.13
8JG-219-1	89E50-025-2	[4.17] 106	[3.15] 80	[1.18] 30	[0.59] 15	[0.57] 14,5	[1.18] 30	M8	[0.39] 10	[0.42] 0.19
8JG-220-1	89E63-008-2	[4.72] 120	[3.54] 90	[1.38] 35	[0.67] 17	[0.67] 17	[1.38] 35	M10	[0.47] 12	[0.66] 0.30

Clamping Arm Adapters

Features:

- For attaching custom made clamp arms
- 360° rotatable arm
- Aluminum construction



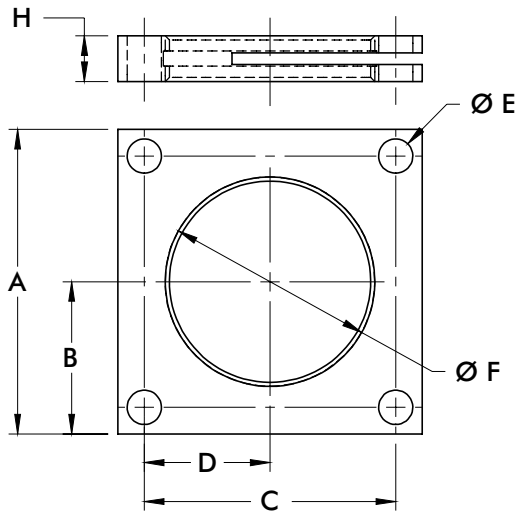
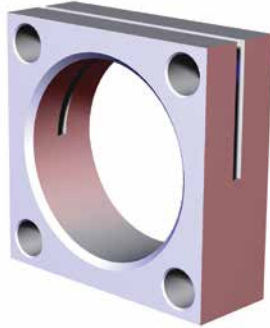
Part Number	Used with Model/series	A	B	C	D	E	E1	F	Weight [lbs] kg
8MA-084-1	89BE0-010-2	[1.57] 40	[1.10] 28	[0.59] 15	[0.32] 8	[0.59] 15	--	[0.22]	[0.03] 0,014
8MA-086-1	89E32-010-2	[1.97] 50	[1.38] 35	[0.79] 20	[0.43] 11	[0.79] 20	--	5,5 (2x)	[0.08] 0,035
8MA-087-1	89E40-010-2	[1.97] 50	[1.50] 38	[0.98] 25	[0.51] 13	[0.98] 25	[0.55] 14	[0.22] 5,5 (4x)	[0.11] 0,050
8MA-088-1	89E50-025-2	[2.36] 60	[1.77] 45	[1.18] 30	[0.59] 15	[1.18] 30	[0.59] 15	[0.28] 7 (4x)	[0.19] 0,085
8MA-089-1	89E63-008-2	[2.56] 65	[1.89] 48	[1.38] 35	[0.67] 17	[1.38] 35	[0.71] 18	[0.35] 9 (4x)	[0.28] 0,125

89E SERIES

Pneumatic Swing Clamps | Mounting Flanges

Features:

- For use with Threaded Body Pneumatic Swing Clamps
- Variable height adjustment
- For recessed mounting



Part Number	Used with Model/series	A	B	C	D	E	F	H
8MA-219-1	89E20-010-2	[2.17] 55	[4.33] 27,5	[1.65] 42	[0.83] 21	[0.26] 6,6	M36X1,5	[0.31] 8
8MA-220-1	89E32-010-2	[2.76] 70	[1.38] 35	[2.13] 54	[1.06] 27	[0.35] 9	M42X1,5	[0.39] 10
8MA-221-1	89E40-010-2	[3.15] 80	[1.57] 40	[2.60] 66	[1.30] 33		M55X2	[0.47] 12
8MA-222-1	89E50-025-2	[3.54] 90	[1.77] 45	[2.99] 76	[1.50] 38	[0.43] 11	M68X2	[0.59] 15
8MA-223-1	89E63-008-2	[4.33] 110	[2.17] 55	[3.54] 90	[1.77] 45		M80X2	

8000, 8200, 8400 SERIES

Pneumatic Swing Clamps | Product Overview

Features:

- Threaded body may be mounted in a tapped hole or a clearance hole with optional mounting flange. 8215/8216 may be mounted with the upper flange.
- Sensor ready for use with round style sensors
- Clamp arm and spindle included

Applications:

- Assembly
- Welding
- Light machining

Also Available:

- See page MC-PSC-31 for clamping arms
- See page MC-PSC-31 for mounting flanges
- See page MC-PSC-40 for sensing options

Series 8000, 8200, 8400



Technical Information

Model	Swing Direction	Total Stroke [in]mm	Stroke During Rotation [in]mm	Vertical Clamp Stroke [in]mm	Clamping Force [lbf.] N†	Bore Size [in]mm	Air Consumption‡ [ft³]dm³	Weight [lb.]kg	Replacement Seal Kit
8015	RH	[0.85]	[0.47]	[0.38]	[18]	[0.75]	[0.002]	[1.0]	801560
8016	LH	21,5	11,8	9,7	80	19,1	0,06	0,45	
8215	RH	[1.25]	[0.75]	[0.50]	[67]	[1.50]	[0.015]	[2.2]	821560
8216	LH				300	38,1	0,41	1,0	
8415	RH	31,8	19,1	12,7	[55]	[1.19]	[0.009]	[1.5]	841560
8416	LH				245	30,2	0,25	0,68	

† with standard clamping arm at 5bar [72psi]. ‡ per double stroke at 5bar [72psi]

Operating Pressure Range: 3bar [45psig] to 9bar [130psig]

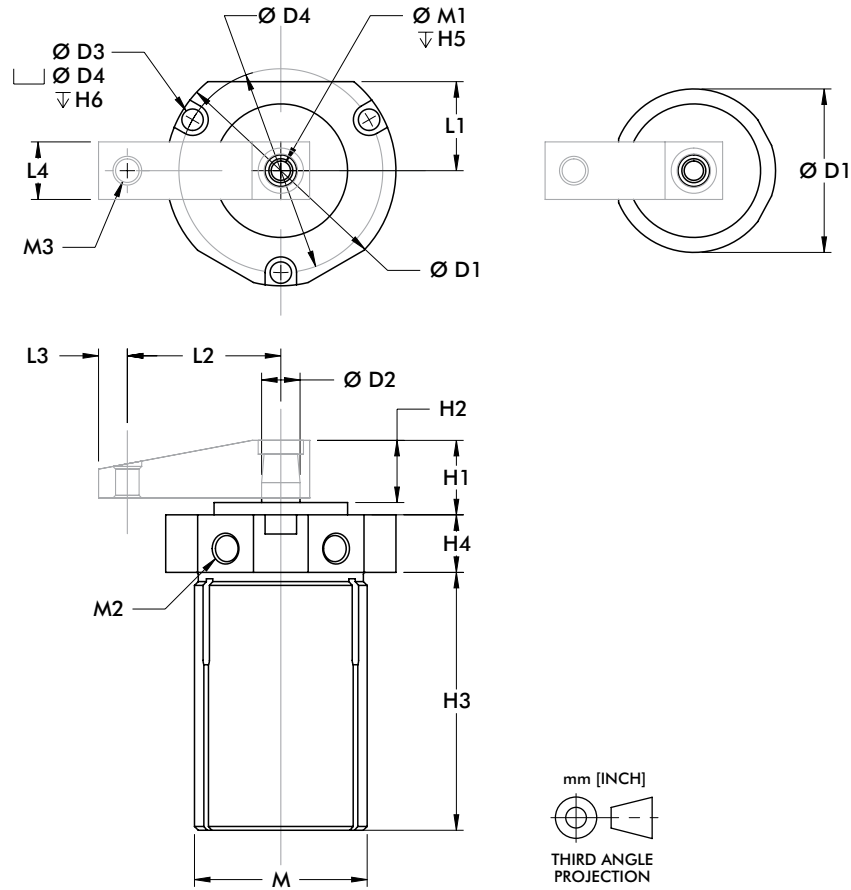
Maximum Operating Temperature: 60°C [140°F]

Note:

To order with out clamping arm, add **-LA** to the end of the model number. EX. 8115-**LA**.

8000, 8200, 8400 SERIES

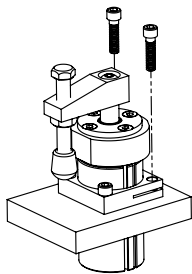
Pneumatic Swing Clamps | Dimensions



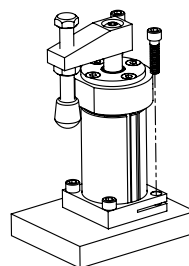
Model	$\varnothing D1$	$\varnothing D2$	$\varnothing D3$	$\varnothing D4$	H1	H2	H3	H4	H5	H6	L1	L2
8015	[1.25]	[0.44]	--	--	[0.53]	[0.41]	[2.87]	[0.50]	[0.75]	--	--	[1.12]
8016	31,8	11,1	--	--	13,5	10,4	72,9	12,7	19,1	--	--	28,4
8215	[3.00]	--	[0.28]	[2.66]	[0.97]	[0.81]	[3.36]	--	--	[0.25]	[1.16]	[2.00]
8216	76,2	[0.50]	7,1	67,6	24,6	20,6	85,3	[0.75]	[0.67]	6,4	29,5	50,8
8415	[2.13]	12,7	--	--	[0.94]	[0.78]	[3.17]	19,1	17	--	--	[1.56]
8416	54,1	--	--	--	23,9	19,8	80,5	--	--	--	--	39,6

Model	L3	L4	M	M1	M2	M3
8015	[0.31]	[0.62]	1-1/8-16	1/4-20	#10-32	#10-32
8016	7,9	15,7				
8215			2-1/4-12			
8216	[0.38]	[0.75]		5/16-18	1/8 NPT	3/8-16
8415	9,6	19,1				
8416			1-3/4-12			

Mounting Options



8000, 8200, 8400
Mounted into a tapped hole or a through hole with the optional mounting flange. Jam nuts are available for 8000.

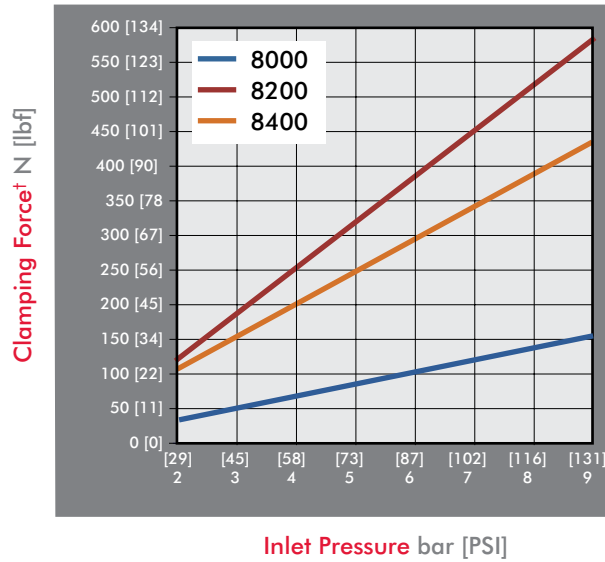


8200 only
Mounted through a clearance hole using mounting screws in the top flange.

8000, 8200, 8400 SERIES

Pneumatic Swing Clamps | Clamping Forces

Series 8000, 8200, 8400 Clamping Force (w/ standard clamping arm)

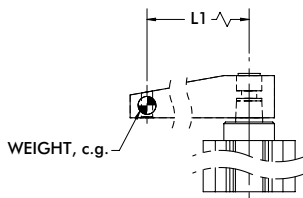


Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

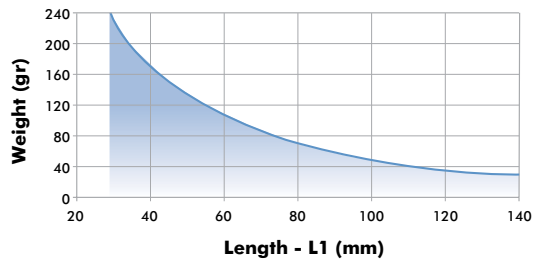
Example: 8215

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

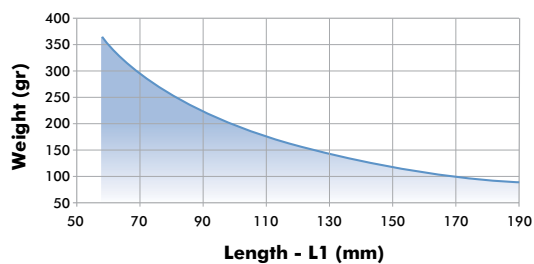


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

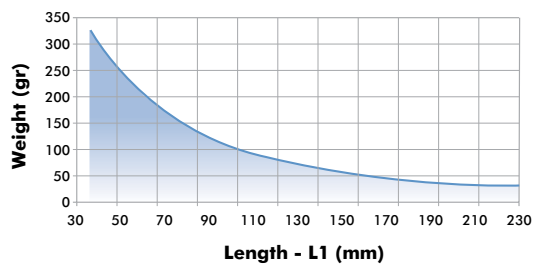
8015/8016 Clamp Arm Weight



8215/8216 Clamp Arm Weight



8415/8416 Clamp Arm Weight

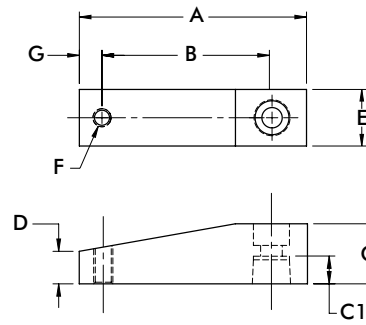


8000, 8200, 8400 SERIES

Pneumatic Swing Clamps | Clamping Arms

Features:

- Lightweight aluminum construction
- Locking tapered connection for 360 deg. arm positioning

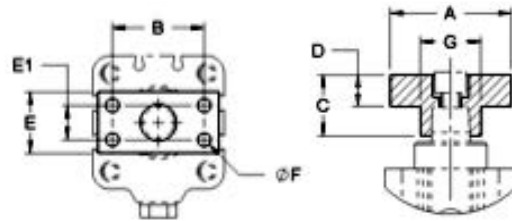


Part Number	Used with Model/series	A	B	C	C1	D	E	F	G	Weight [lbs] kg
801528	8015/8016	[1.74] 44.2	[1.11] 28.2	[0.37] 9.4	[0.33] 8.3	[0.25] 6.4	[0.62] 15.7	#10-32	[0.32] 8.1	[0.03] 0.01
801529	8015/8016	[2.87] 72.9	[2.24] 56.9	[0.37] 9.4	[0.33] 8.3	[0.25] 6.4	[0.62] 15.7	#10-32	[0.32] 8.1	[0.05] 0.02
821512	8215/8216 8415/8416	[2.75] 69.9	[2.00] 50.8	[0.75] 19.1	[0.57] 14.5	[0.38] 9.5	[0.75] 19.1	3/8-16	[0.38] 9.5	[0.04] 0.02
821513	8215/8216	[3.75] 95.3	[3.00] 76.2	[0.75] 19.1	[0.57] 14.5	[0.38] 9.5	[0.75] 19.1	3/8-16	[0.38] 9.5	[0.05] 0.02

Clamping Arm Adapters

Features:

- For attaching custom made clamp arms
- 360° rotatable arm
- Aluminum construction

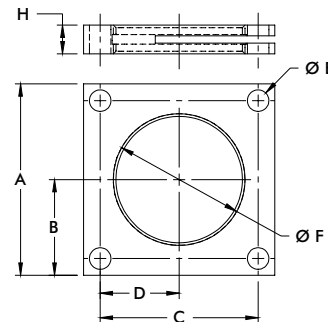


Part Number	Used with Model/series	A	B	C	D	E	E1	F	Weight [lbs] kg
801532	8015/8016	[1.37] 34,8	[1.00] 25,4	[0.39]	[0.25]	[0.62]	--	#10-32 (2x)	[0.03] 0,014
821556	8215/8216	[1.50] 38,1	[1.06] 26,9	[0.75]	[0.37]	[0.75]	--	1/4-20 (2x)	[0.05] 0,020

Mounting Flanges

Features:

- For use with Threaded Body Pneumatic Swing Clamps
- Variable height adjustment
- For recessed mounting



Part Number	Used with Model/series	A	B	C	D	E	F	H
801553	8015/8016	[1.38] 35	[0.69] 17,5	[1.08] 27,4	[0.54] 13,7	[0.20] 5,1	1 1/8-16	[0.50] 12.7
821553	8215/8216	[2.50] 63,5	[1.25] 31,8	[2.12] 53,8	[1.06] 26,9	[0.28] 7,1	2 1/4-12	
841550	8415/8416	[2.00] 50,8	[1.00] 25,4	[1.60] 40,6	[0.80] 20,3		1 3/4-12	

Features:

- Available with threaded body, or lower flange mounting
- Low profile for confined spaces
- Double locked arm attachment is bolted to piston rod and clamped around shaft diameter

Applications:

- Assembly
- Welding
- Light machining

Also Available:

See page MC-PSC-35 for clamping arms
See page MC-PSC-36 for jam nuts

Series 035-1



Threaded body design for mounting through fixture plates.

Series 035-2



Flanged body design for quick and easy mounting

Technical Information

Model	Swing Direction	Total Stroke [in]mm S	Stroke During Rotation [in]mm S1	Vertical Clamp Stroke [in]mm S2	Clamping Force [lbf.] N†	Bore Size [in]mm	Air Consumption‡ [ft³]dm³	Weight [lb.]kg	Replacement Seal Kit
035-125-190	RH	[1.04]	[0.51]	[0.53]	[20]	[0.98]	[0.005]	[0.56]	905516
035-125-290	LH	26,3	12,8	13,5	89	25	0,13	0,25	
035-132-190	RH	[1.13]	[0.56]	[0.57]	[30]	[1.26]	[0.008]	[0.94]	905517
035-132-290	LH	28,8	14,3	14,5	133	32	0,24	0,43	
035-140-190	RH	[1.20]	[0.57]	[0.63]	[60]	[1.57]	[0.015]	[1.31]	905518
035-140-290	LH	30,4	14,4	16	267	40	0,41	0,59	
035-150-190	RH	[1.18]	[0.63]	[0.55]	[69]	[1.97]	[0.023]	[1.81]	905519
035-150-290	LH	30	16	14	307	50	0,64	0,82	
035-225-190	RH	[1.05]	[0.54]	[0.51]	[20]	[0.98]	[0.005]	[0.56]	905516
035-225-290	LH	26,7	13,7	13	89	25	0,13	0,25	
035-232-190	RH	[1.06]	[0.57]	[0.49]	[30]	[1.26]	[0.008]	[1.13]	905517
035-232-290	LH	26,8	14,4	12,4	133	32	0,24	0,51	
035-240-190	RH	[1.09]	[0.57]	[0.52]	[60]	[1.57]	[0.015]	[1.40]	905518
035-240-290	LH	27,7	14,4	13,3	267	40	0,41	0,64	
035-250-190	RH	[1.13]	[0.63]	[0.51]	[69]	[1.97]	[0.023]	[1.90]	905519
035-250-290	LH	28,8	16	12,8	307	50	0,64	0,86	

† with standard clamping arm at 5bar [72psi]. ‡ per double stroke at 5bar [72psi]

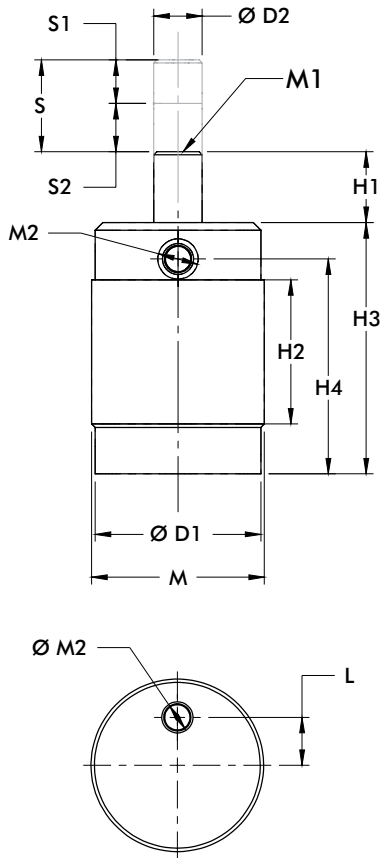
Operating Pressure Range: 3bar [45psig] to 7bar [100psig]
Maximum Operating Temperature: 80°C [176°F]

035 SERIES

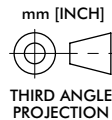
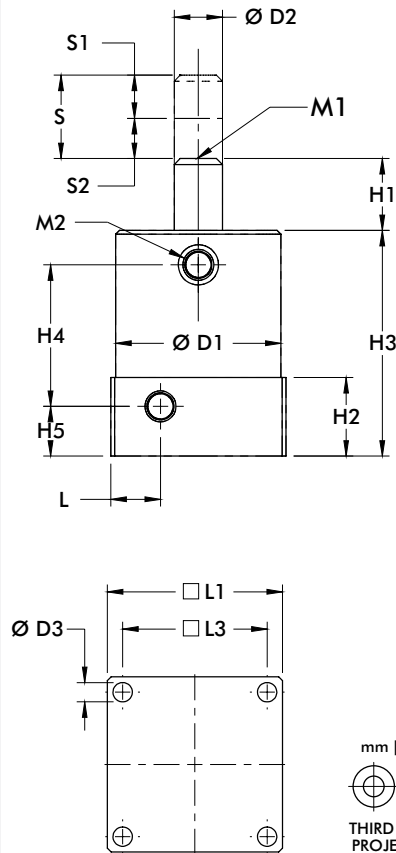
Pneumatic Swing Clamps | Dimensions



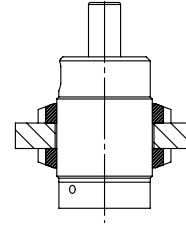
Series 035-1



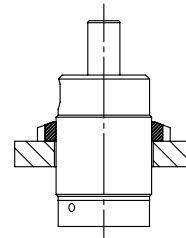
Series 035-2



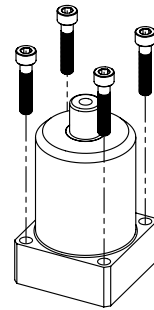
Mounting Options



035-1
Threaded body mounts through a clearance hole and locked in place using two optional jam nuts



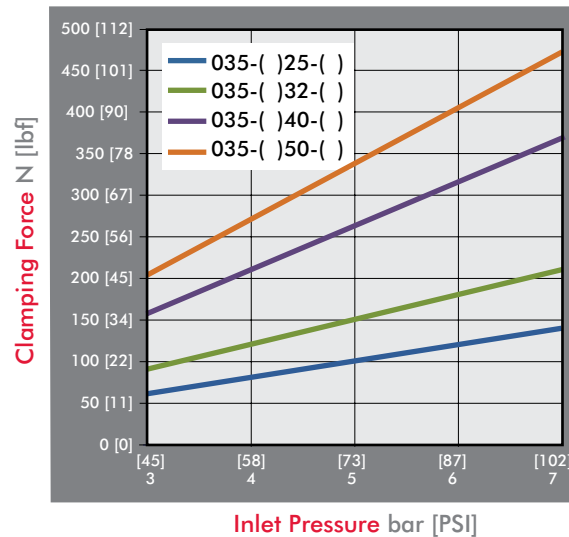
035-1
Threaded body mounts into a threaded hole and is locked in place using one optional jam nuts



035-2
Mount using four mounting holes in the base flange

Model	ØD1	ØD2	D3	H1	H2	H3	H4	H5	L	L1	L3	M	M1	M2
035-125-()	[1.42] 36	[.55] 14	--	[0.57] 14,4	[1.50] 38,1	[2.76] 70	[2.25] 57,2	--	[0.35] 9	--	--	1-½ -16	1/4-20	#10-32
035-132-()	[1.79] 45,4	[0.63] 16	--	[0.75] 19,1	[1.72] 43,7	[3.87] 98,2	[2.63] 66,7	--	[0.45] 11,4	--	--	1-7/8-16	5/16-18	1/8 NPT
035-140-()	[2.16] 54,8	[0.63] 16	--	[0.76] 19,4	[1.88] 47,7	[3.28] 83,2	[2.80] 71	--	[0.70] 17,8	--	--	2-1/4-16		
035-150-()	[2.36] 60	[0.79] 20	--	[0.70] 17,8	[2.00] 50,8	[3.48] 88,3	[2.95] 75	--	[0.50] 12,7	--	--	2-1/2-16	3/8-16	
035-225-()	[1.38] 35	[.55] 14	[.18] 4,5	[0.60] 15,2	[.91] 23	[2.62] 66,5	[1.60] 40,6	[0.50] 12,7	[0.57] 14,5	[1.57] 40	[1.22] 31	--	1/4-20	#10-32
035-232-()	[1.97] 50	[0.63] 16	[.26] 6,5	[0.85] 21,6	[.91] 23	[2.79] 71	[1.76] 44,6	[0.57] 14,5	[0.65] 16,5	[2.13] 54	[1.73] 44	--	5/16-18	1/8 NPT
035-240-()	[2.16] 54,8	[0.63] 16	[.26] 6,5	[0.94] 23,9	[1.03] 26,1	[2.95] 75	[1.85] 47	[0.65] 16,5	[0.65] 16,5	[2.29] 58,2	[1.89] 48	--		
035-250-()	[2.36] 60	[0.79] 20	[.33] 8,5	[0.78] 19,7	[1.03] 26	[3.15] 80	[2.05] 52	[0.65] 16,5	[0.65] 16,5	[2.68] 68	[2.17] 55	--	3/8-16	

Series 035 Clamping Force (w/ standard clamping arm)

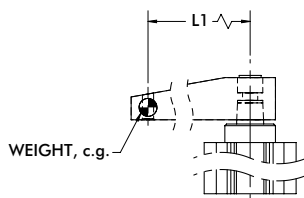


Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

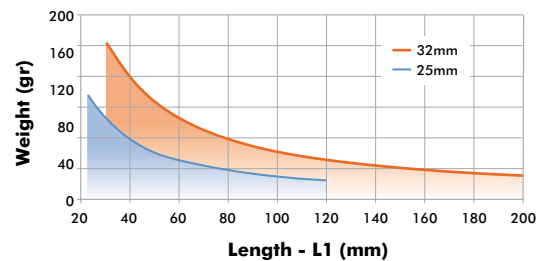
Example: 035-132-190

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

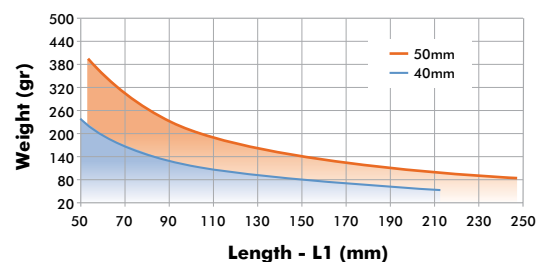


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

25mm, 32mm Clamp Arm Weight



40mm, 50mm Clamp Arm Weight

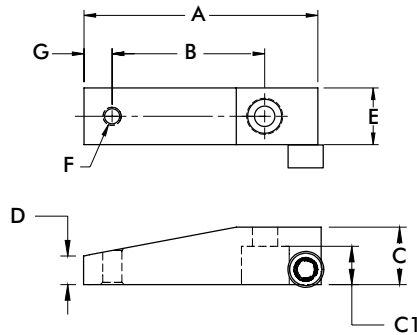


035 SERIES

Pneumatic Swing Clamps | Clamping Arms

Features:

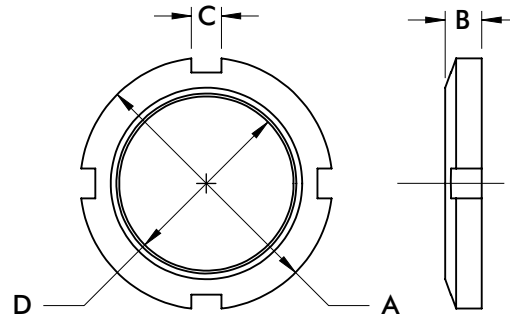
- For standard use
- Aluminum construction
- Clamp on style connection for 360 deg. arm positioning



Part Number	Used with Model/series	A	B	C	C1	D	E	F	G	Weight [lbs] kg
036-551-01	035-12.... 035-22....	[2.38] 60.5	[1.36] 34.5	[0.63] 15.9	[0.40] 10.2	[0.31] 8.0	[0.75] 19.1	1/4-20	[0.32] 8.0	[0.10] 0.05
036-551-02	035-12.... 035-22....	[3.38] 85.9	[2.36] 60.0	[0.63] 15.9	[0.40] 10.2	[0.31] 8.0	[0.75] 19.1	1/4-20	[0.32] 8.0	[0.13] 0.06
036-630-01	035-13.... 035-23.... 035-14.... 035-24....	[3.10] 78.7	[2.00] 50.8	[0.75] 19.1	[0.50] 12.7	[0.38] 9.5	[0.75] 19.1	5/16-18	[0.38] 9.5	[0.15] 0.07
036-630-02	035-13.... 035-23.... 035-14.... 035-24....	[4.73] 120.0	[3.63] 92.1	[0.75] 19.1	[0.50] 12.7	[0.38] 9.5	[0.75] 19.1	5/16-18	[0.38] 9.5	[0.21] 0.10
036-787-01	035-15.... 035-25....	[4.00] 101.6	[2.75] 69.9	[1.00] 25.4	[0.70] 17.8	[0.50] 12.7	[1.00] 25.4	3/8-16	[0.38] 9.5	[0.33] 0.15
036-787-02	035-15.... 035-25....	[6.36] 161.5	[5.00] 127.0	[1.00] 25.4	[0.70] 17.8	[0.50] 12.7	[1.00] 25.4	3/8-16	[0.38] 9.5	[0.49] 0.22

Features:

- For use with Threaded Body Pneumatic Swing Clamps
- Variable height adjustment
- For recessed mounting
- Steel construction



Part Number	Used with Model/series	A	B	C	D	Weight [lbs] kg
051-150-160	035-125-190 035-125-290	[2.00] 50.8	[0.38] 9.7	[0.275] 7.0	1 1/2-16 UN	[0.13] 0.06
051-187-160	035-132-190 035-132-290	[2.63] 66.7	[0.38] 9.7	[0.312] 7.9	1 7/8-16 UN	[0.25] 0.11
051-225-160	035-140-190 035-140-290	[3.00] 76.2	[0.50] 12.7	[0.312] 7.9	2 1/4-16 UN	[0.40] 0.18
051-250-160	035-150-190 035-150-290	[3.25] 82.6	[0.50] 12.7	[0.312] 7.9	2 1/2-16 UN	[0.44] 0.20

8700 SERIES

Pneumatic Swing Clamps | Product Overview

Features:

- Alternative solution to swing clamps when space is limited
- The clamping lever may be positioned left, forward, or right (relative to ports) within the same clamp body
- Threaded body with upper flange mount
- Non-toggle locking linkage
- Clamping arm and spindle included

Applications:

- Assembly & welding fixtures
- Light machining

Also Available:

See page MC-PSC-39 for jam nuts

8725



8732
8732G



8740
8740G



8750
8750G



Technical Information

Model	Vertical Clamping Stroke* [in.]mm	Clamping Force† [lb.]N	Bore Size [in.]mm	Air Consumption‡ [in. ³]cm ³	Weight [lb.]kg	Seal Kit
8725	[0.10] 2,5	[43] 195	[0.98] 25	[0.004] 0,11	[1.3] 0,6	872500
8732	[0.12] 3,2	[64] 285	[1.26] 32	[0.008] 0,23	[2.2] 1,0	873200
8732G		[106] 470	[1.57] 40	[0.014] 0,41	[2.6] 1,2	874000
8740		[167] 745	[1.97] 50	[0.023] 0,64	[4,4] 2,0	875000
8740G	[0.15] 3,8	[167] 745	[1.97] 50	[0.023] 0,64	[4,4] 2,0	875000
8750	[0.15] 3,8	[167] 745	[1.97] 50	[0.023] 0,64	[4,4] 2,0	875000
8750G	[0.15] 3,8	[167] 745	[1.97] 50	[0.023] 0,64	[4,4] 2,0	875000

* Equal to approx. 6° above horizontal with standard clamping arm. † at 5bar [72psi].

‡ per double stroke at 5bar [72psi].

Operating Pressure Range:

3bar [45psig] to 7bar [100psig]

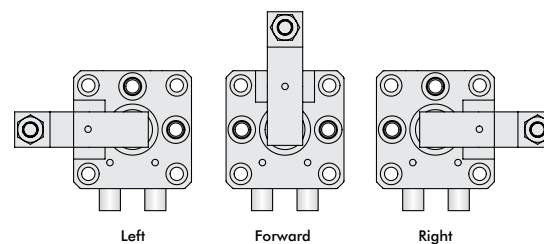
Max. Operating Temperature:

-10°C to 80°C [14°F to 175°F]

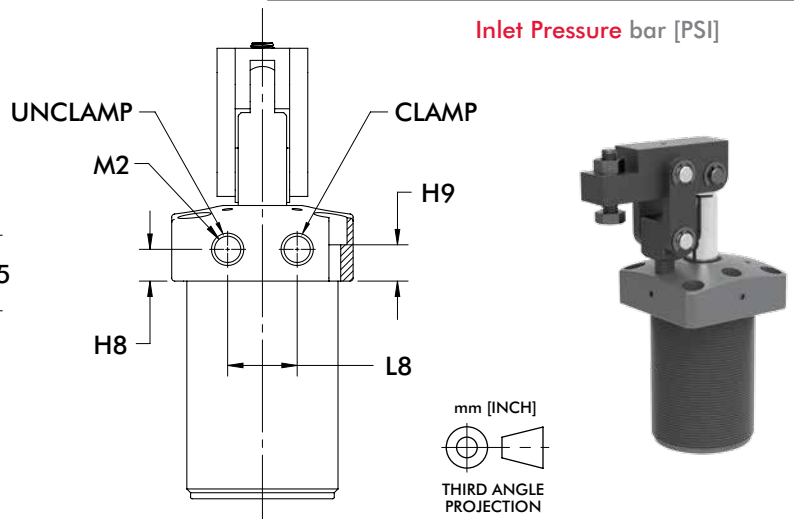
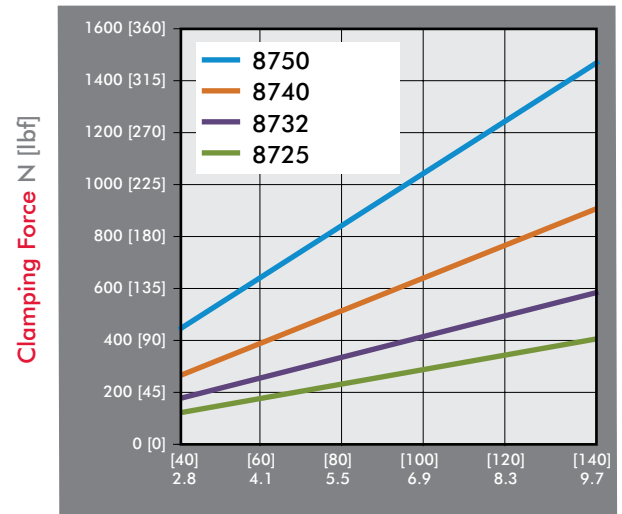
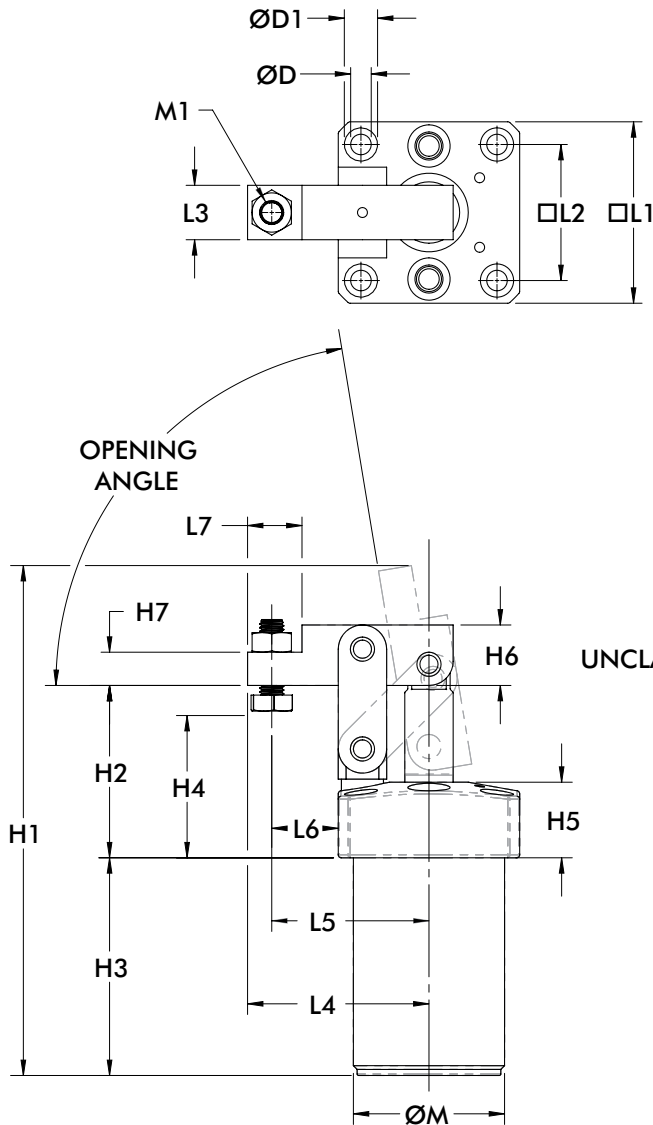
Application Note:

If using clamping arms other than standard, the length must not exceed 1.5X the overall length of the standard arm.

The inlet air flow rate should be adjusted to position the arm in no less than 1/2 second for standard arms and no less than 1 second in the case of an extended arm.



Levers can be positioned in one of three positions in relation to the air ports.



Model	Opening Angle	ØD	ØD1	H1	H2	H3	H4 (min/max)	H5	H6	H7	H8	H9
8725	80°	[0.22] 5,5	[0.35] 9	[5.67] 144	[1.97] 50	[2.42] 61,5	[0.59-0.98] 15-25	[0.98] 25	[0.67] 17	[0.39] 10	[0.47] 12	[0.59] 15
8732/ 8732G	81°	[0.27] 6,8	[0.43] 11	[6.65] 169	[2.25] 57	[2.83] 72	[0.63-1.18] 16-30		[0.79] 20	[0.43] 11	[0.41] 10,5	[0.51] 13
8740/ 8740G	82°	[0.27] 6,8	[0.43] 11	[6.93] 176	[2.40] 61	[2.85] 72,5	[0.75-1.14] 19-29		[0.98] 25	[0.55] 14		[0.41] 10,5
8750/ 8750G	75°	[0.33] 8,5	[0.55] 14	[7.87] 200	[2.60] 66	[3.11] 79	[0.86-1.30] 22-33		[1.18] 30	[0.59] 15	[0.41] 10,5	[0.43] 11

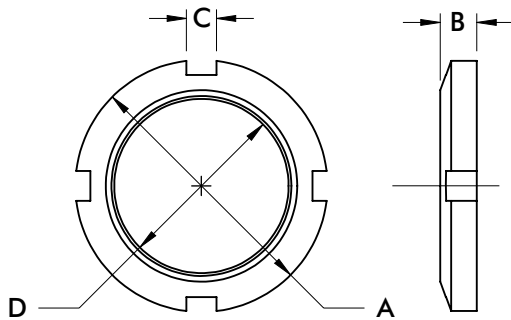
Model	L1	L2	L3	L4	L5	L6	L7	L8	ØM	M1	M2
8725	[1.97] 50	[1.46] 37	[0.63] 16	[1.89] 48	[1.61] 41	[0.63] 16	[0.55] 14	[0.91] 23	M40 x 1.50	M6 x 1.0	M5 x 0.8
8732 8732G	[2.36] 60	[1.77] 45	[0.71] 18	[2.36] 60	[2.05] 52	[0.87] 22	[0.71] 18	[0.91] 23	M50 x 1.50	M8 x 1.25	[1/8NPT] G-1/8
8740 8740G	[2.65] 65	[1.97] 50	[0.79] 20	[2.60] 66	[2.20] 56	[0.93] 23,5	[0.79] 20	[1.02] 26	M55 x 1.50		[1/8NPT] G-1/8
8750 8750G	[2.95] 75	[2.28] 57	[0.87] 22	[3.05] 77,5	[2.50] 63,5	[1.02] 26	[1.10] 28	[1.26] 32	M65 x 1.50	M12 x 1.75	[1/8NPT] G-1/8

8700 SERIES

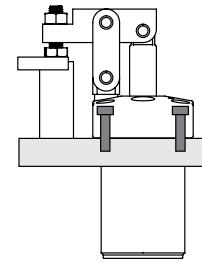
Pneumatic Swing Clamps | Jam Nuts

Features:

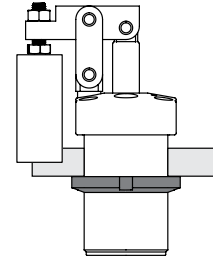
- For use with 8700 Series Pneumatic Lever Clamps
- Variable height adjustment
- For recessed mounting



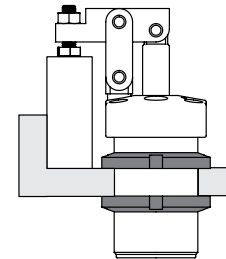
Mounting from above using 4 socket cap screws through the flange.



Mounting by screwing body into a tapped hole and locking with one jam nut.



Mounting by inserting body into a plain hole and locking with two jam nuts.



Part Number	Used with Model/series	A	B	C	D	Weight [lbs] kg
872550	8725	[2.09] 53	[0.35] 9	[0.28] 7	M40 x 1.50	[0.13] 0.06
873250	8732/ 8732G	[2.76] 70	[0.43] 11	[0.24] 6	M50 x 1.50	[0.35] 0.16
874050	8740/ 8740G	[2.95] 75		[0.31] 8	M55 x 1.50	[0.37] 0.17
875050	8750/ 8750G	[3.25] 82,5	[0.39] 10	[0.39] 10	M65 x 1.50	[0.33] 0.15

PNEUMATIC SWING CLAMPS ACCESSORIES

Pneumatic Swing Clamps | Sensors

Features:

- Sensors are activated by a magnetic ring installed on the cylinder piston
- All sensors feature an LED for easy set-up
- IP67 rated
- Temperature Range: -10°C to 60°C [14°F to 140°F]

810169,
810173,
810174



8EA-109-1,
8EA-120-1,
810170,
810171



810151,
810153,
810155,
810157



Tie rod clip 810151-1 included.

810156,
810158



810153



Technical Information

Item Number	Mount Style	Connector	Length	Function	Voltage	Max. Switching Current	Voltage Drop
810169	Round	M8 male quick connect	165mm [6.5in.]	Reed	5-120V AC/DC	50mA	3.0V
810173				PNP	4.5-28V DC	100mA	0.5V
810174				NPN	4.5-28V DC	100mA	0.5V
8EA-109-1	T-slot	M8 male quick connect	300mm [11.8in.]	Reed	10-30V DC	100mA	3.0V
8EA-120-1		M12 male quick connect	300mm [11.8in.]	Reed	15-30 V AC/DC	500mA	1.5V
810170		M8 male quick connect	165mm [6.5in.]	PNP	10-30V DC	100mA	2.0V
810171	NPN			10-30V DC	100mA	2.0V	
810151	Tie Rod	No connector cord	2.7m [9ft.]	Reed	5-120V AC/DC	500mA	3.5V
810153				Reed	24-240V AC	4A	1.0V
810155				PNP	6-24V DC	500mA	1.0V
810157				NPN	6-24V DC	500mA	1.0V
810156	Band Clamp			Reed	5-120V AC/DC	500mA	3.5V
810158				PNP	6-24V DC	500mA	1.0V

PNEUMATIC SWING CLAMPS ACCESSORIES

Pneumatic Swing Clamps | Extension Cordsets

Features:

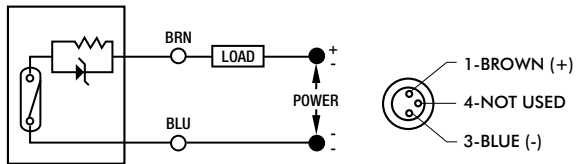
- For use with M8 quick connect sensors
- Threaded coupling nuts provide IP67 protection
- Robotic grade, oil and abrasion resistant polyurethane (PUR) cable



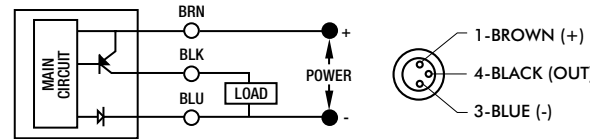
Item Number	Length	Rating	Temperature Rating
CABL-010	2 Meter [78in.]	120V AC/DC, 3A max.	-20°C to 80°C [-40°F to 176°F]
CABL-013	5 Meter [16.4ft.]		

Wiring Schematics

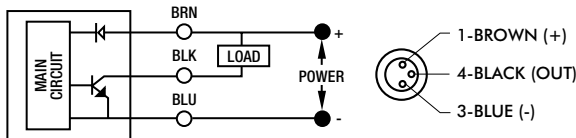
810169



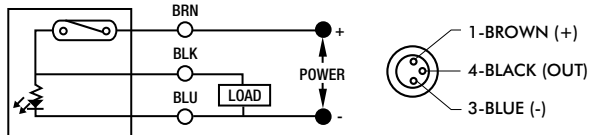
810170, 810173



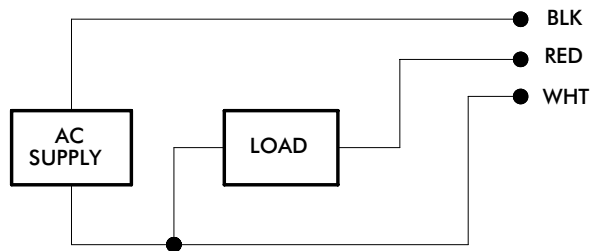
810171, 810174



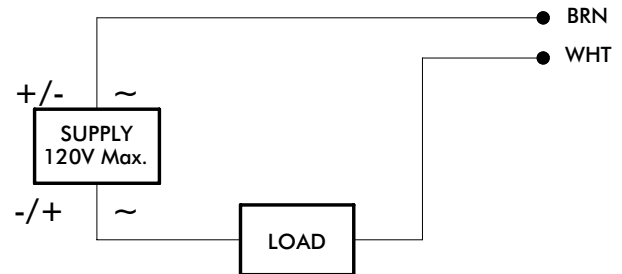
8EA-109-1, 8EA-120-1



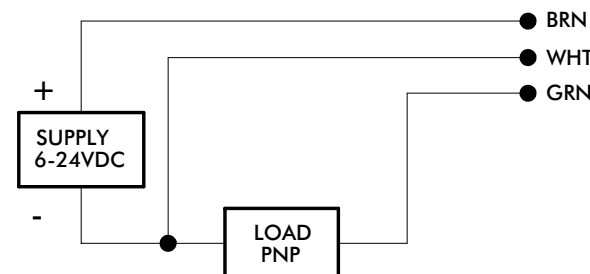
810153



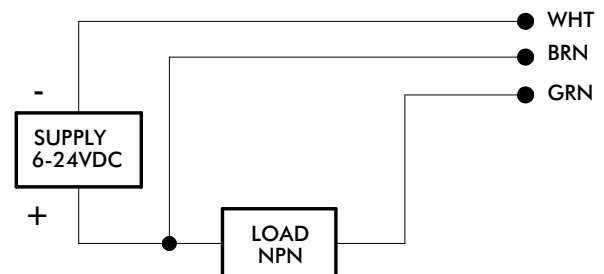
810151, 810156



810155, 810158



810157, 810158



PNEUMATIC POWER CYLINDERS

Features

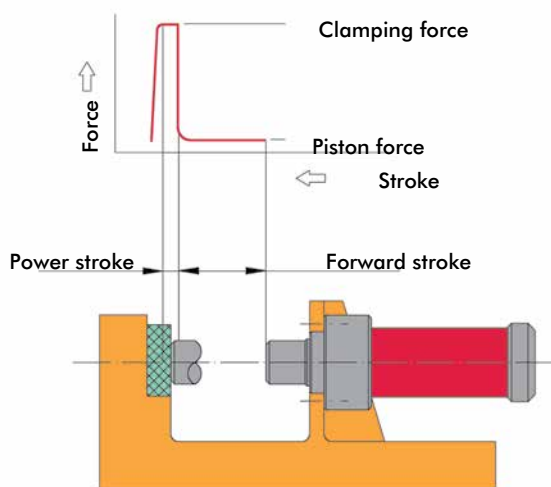
Your requirements

Power element of machines, tools and devices for the following applications:

- Clamping
- Coining
- Punching
- Riveting
- Stamping
- Pressing
- Notching
- Clinching

The solution

DESTACO's double acting power cylinder, which is based on the wedge lever principle.



Product features

- Mechanical advantage: 10:1
- Characteristic are the two steps of stroke: the forward stroke to move a certain distance and the power stroke with an amplified force on a short distance
- Exact positioning of cylinder by flange mount on cylinder's head
- Cylinder works in any position
- High durability because of solid and maintenance free wedge lever mechanics.
- End position control by magnetic field sensing

Technical Data

Power forces at 6 bar	4 – 60 kN
Forward strokes	15 – 200 mm
Power strokes	6 and 7 mm*
Air pressure	max. 6 bar, min 3 bar
Mechanical advantage	max. 10:1
Cylinders require clean, water- and oil free air	

*power strokes up to max. 12 mm upon request

Round design: Type K and WK

- Piston rod with male thread (Type K) or ISO fit (Type WK)



Rectangular design: Type WR

- Two piston rods prevent twisting

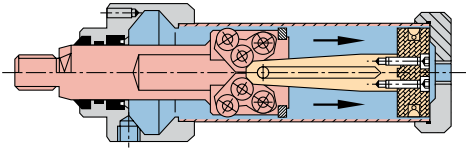


Application Recommendations

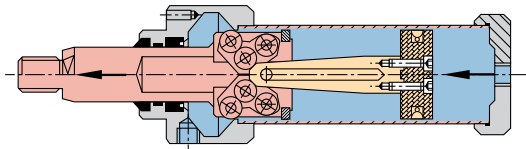
- Compressed air should be treated by filter, water separator and pressure regulator. Oiler is not allowed!
- For an adequate piston speed air hoses with 6mm I.D. should be used.
- Do not increase the max. air pressure of 6 bar, because this would reduce the cylinder's life cycle considerably.
- The piston rods of type K and WK are not secured against twisting, an external device should be provided.
- Piston rod should not be subjected to transversal forces. Force should always be exerted by coaxial force through the piston rod to the work piece.
- For Type WR, force must be transmitted via the centre of the pressure plate.
- Connection between rod and tool should be performed as frictional connection (coupling), not as form fitting connection.
- For punching operations we recommend a force reserve of approx. 30 %.
- If the cylinder is used for positioning in the extended rod position you should consider that a possible counter-force will cause an axial deflection of approx. 1 mm. This feature is due to the cylinder's design because after the nominal power stroke the clamping force drops down to the level of the piston force (see force-stroke diagram left side).
- Valves are not usable to avoid piston movement. If the piston should be positioned within the range of the forward stroke, both chambers of the cylinder have to be vented. If the cylinder should stay at a retracted position the piston rod chamber should be under pressure and the piston chamber should be vented.
- For further facts and additional applications features see operating instruction MAPnkz-2.

PNEUMATIC POWER CYLINDERS

Functions

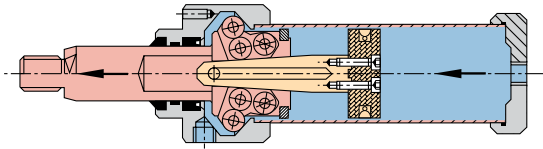


Basic position



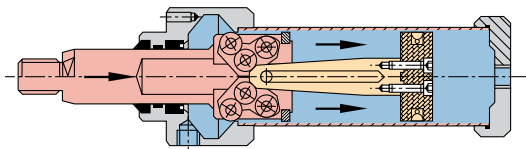
Forward stroke

Piston force is identical to the force of a common pneumatic cylinder with adequate piston diameter



Power stroke

Beginning of mechanical force amplification. Mechanical advantage max. 10:1

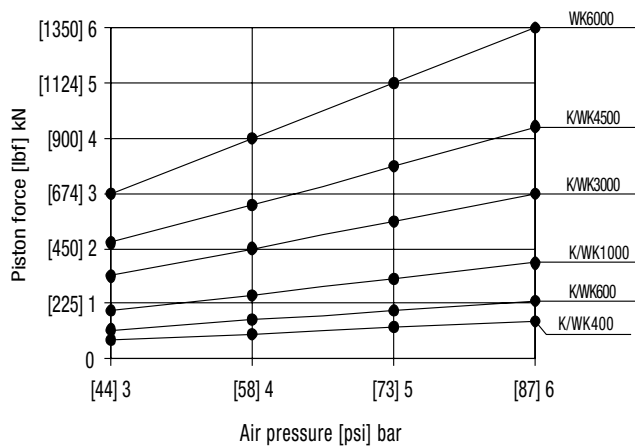


Return stroke

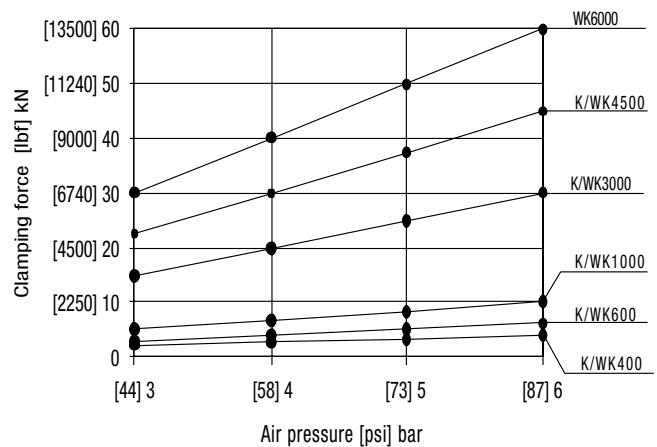
The return stroke can be initiated in any position of piston. The force during return stroke is approx. half of piston force.

Forces

Force within forward stroke



Clamping force within power stroke



Return stroke force: half of piston force

TYPE K SERIES

Pneumatic Power Cylinders | Product Overview | Technical Information



- Piston rod with male thread

Note:

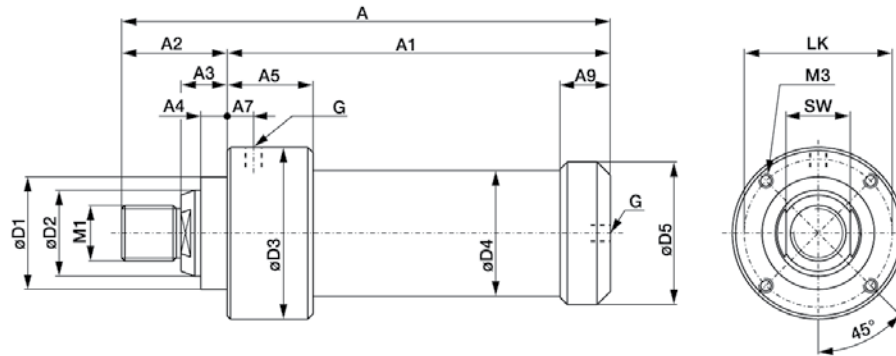
Operating pressure max. 6 bar [87psi], min 3 bar [44psi]. Use only clean, water- and oilfree compressed air. Piston rod is not secured against twisting and should not be loaded transversal.

See page MC-PPC-2 for more information.

Model	Piston force within forward stroke at 6 bar kN [lbf]	Forward stroke mm [in]	Clamping force within power stroke at 6 bar kN [lbf]	Power stroke mm [in]	Piston dia. mm [in]	Air consumption per double stroke at 6 bar dm ³ [ft ³]	Stroke frequency depending on total stroke [min ⁻¹]	Temperature range °C [°F]	Weight Kg [lbs]
K400-15-6-1	0,68 [153]	15 [0.59]	4 [900lbf]	6 [0.24]	40 [1.75]	0,71 [0.025]	5 to 30	- 5 to +75 [23 to 167]	1,20 [2.6]
K400-30-6-1		30 [1.18]				0,89 [0.031]			1,25 [2.8]
K400-50-6-1		50 [1.97]				1,14 [0.040]			1,30 [2.9]
K400-70-6-1		70 [2.76]				1,38 [0.049]			1,35 [3.0]
K400-120-6-1		120 [4.72]				1,98 [0.070]			1,50 [3.3]
K400-200-6-1		200 [7.87]				2,94 [0.104]			1,70 [3.7]
K600-15-6-1	1,06 [238]	15 [0.59]	6 [1350lbf]	6 [0.24]	50 [1.97]	1,34 [0.047]	5 to 30	- 5 to +75 [23 to 167]	2,05 [4.5]
K600-30-6-1		30 [1.18]				1,65 [0.058]			2,15 [4.7]
K600-50-6-1		50 [1.97]				2,06 [0.073]			2,30 [5.1]
K600-70-6-1		70 [2.76]				2,47 [0.087]			2,40 [5.3]
K600-120-6-1		120 [4.72]				3,50 [0.124]			2,70 [6.0]
K600-200-6-1		200 [7.87]				5,15 [0.182]			3,20 [7.1]
K1000-15-7-1	1,75 [393]	15 [0.59]	10 [2250lbf]	7* [0.27]	63 [2.48]	2,20 [0.078]	5 to 30	- 5 to +75 [23 to 167]	3,60 [7.9]
K1000-30-7-1		30 [1.18]				2,66 [0.094]			3,80 [8.4]
K1000-50-7-1		50 [1.97]				3,26 [0.115]			4,10 [9.0]
K1000-70-7-1		70 [2.76]				3,85 [0.136]			4,40 [9.7]
K1000-120-7-1		120 [4.72]				5,35 [0.189]			5,20 [11.5]
K1000-200-7-1		200 [7.87]				7,74 [0.273]			6,40 [14.1]
K3000-15-6-1	3 [674]	15 [0.59]	30 [4500lbf]	6* [0.24]	85 [3.35]	4,48 [0.158]	5 to 25	- 5 to +75 [23 to 167]	11,80 [26.0]
K3000-30-6-1		30 [1.18]				5,20 [0.184]			12,50 [27.6]
K3000-50-6-1		50 [1.97]				6,17 [0.218]			13,40 [29.5]
K3000-70-6-1		70 [2.76]				7,13 [0.252]			14,30 [31.5]
K3000-120-6-1		120 [4.72]				9,54 [0.337]			16,60 [36.6]
K3000-200-6-1		200 [7.87]				13,40 [0.473]			20,20 [44.5]
K4500-15-6-1	4,2 [944]	15 [0.59]	45 [10120lbf]	6* [0.24]	100 [3.94]	6,18 [0.218]	5 to 25	- 5 to +75 [23 to 167]	13,30 [29.3]
K4500-30-6-1		30 [1.18]				7,17 [0.253]			14,00 [30.9]
K4500-50-6-1		50 [1.97]				8,50 [0.300]			15,00 [33.1]
K4500-70-6-1		70 [2.76]				9,83 [0.347]			15,80 [34.8]
K4500-120-6-1		120 [4.72]				13,20 [0.466]			18,10 [39.9]
K4500-200-6-1		200 [7.87]				18,50 [0.653]			21,70 [47.8]

* Power strokes up to 12 mm and other forward strokes upon request

Type K in standard version

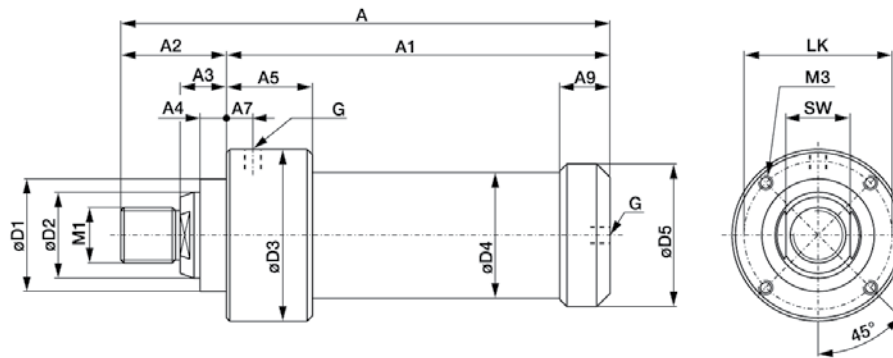


Model	Dimensions for standard version of type K Differences of dimensions for cylinder with magnet piston rings see chart on page MC-PPC-10																	
	A	A ₁	A ₂	A ₃	A ₄	A ₅	A ₇	A ₉	Ø D ₁	Ø D ₂	Ø D ₃	Ø D ₄	Ø D ₅	M ₁	M ₃	LK	SW	G
K400-15-6-1	186 [7.32]	145 [5.71]																
K400-30-6-1	201 [7.91]	160 [6.30]																
K400-50-6-1	221 [8.70]	180 [7.09]	41 [1.6]	21 [0.8]	12 [0.5]	39 [1.5]	10 [0.4]	23,5 [0.9]	40 _{h8} [1.6]	25 _{h7} [1.0]	63 [2.5]	44 [1.7]	49 [1.9]	M16 x 1,5 [0.06]	M5, 10mm deep [0.1]	54 [2.1]	21 [0.8]	G1/8
K400-70-6-1	241 [9.49]	200 [7.87]																
K400-120-6-1	291 [11.46]	250 [9.84]																
K400-200-6-1	371 [14.61]	330 [12.99]																
K600-15-6-1	201 [7.91]	160 [6.30]																
K600-30-6-1	216 [8.50]	175 [6.89]																
K600-50-6-1	236 [9.29]	195 [7.68]	41 [1.6]	21 [0.8]	12 [0.5]	39 [1.5]	10 [0.4]	23,5 [0.9]	40 _{h8} [1.6]	25 _{h7} [1.0]	73 [2.9]	54 [2.1]	59 [2.3]	M16 x 1,5 [0.06]	M6, 10mm deep [0.1]	64 [2.5]	21 [0.1]	G1/8
K600-70-6-1	256 [10.08]	215 [8.46]																
K600-120-6-1	306 [12.05]	265 [10.43]																
K600-200-6-1	386 [15.20]	345 [13.58]																
K1000-15-7-1	243 [9.57]	187 [7.36]																
K1000-30-7-1	258 [10.16]	202 [7.95]																
K1000-50-7-1	278 [10.94]	222 [8.74]	56 [2.2]	25 [1.0]	15 [0.6]	52 [2.0]	10 [0.4]	29 [1.1]	63 _{h8} [2.5]	40 _{h7} [1.6]	100 [3.9]	68 [2.7]	74,5 [2.9]	M24 x 3,0 [0.98]	M8, 12mm deep [1]	85 [3.3]	32 [1.3]	G1/8
K1000-70-7-1	298 [11.73]	242 [9.53]																
K1000-120-7-1	348 [13.70]	292 [11.50]																
K1000-200-7-1	428 [16.85]	372 [14.65]																

TYPE K SERIES

Pneumatic Power Cylinders | Technical Information

Type K in standard version



Model	Dimensions for standard version of type K Differences of dimensions for cylinder with magnet piston rings see chart on page MC-PPC-10																		
	A	A ₁	A ₂	A ₃	A ₄	A ₅	A ₇	A ₉	Ø D ₁	Ø D ₂	Ø D ₃	Ø D ₄	Ø D ₅	M ₁	M ₃	LK	SW	G	
K3000-15-6-1	315 [12.40]	235 [9.25]																	
K3000-30-6-1	330 [12.99]	250 [9.84]																	
K3000-50-6-1	350 [13.78]	270 [10.63]	50 [2.0]	35 [1.4]	20 [0.8]	70 [2.8]	20 [0.8]	45 [1.8]	85 _{h8} [3.3]	65 _{h7} [2.6]	130 [5.1]	95 [3.7]	108 [4.3]	M42 x 2,5 [1.65]	M10, 16mm deep [1.7]	112 [4.4]	55 [2.2]	G1/4	
K3000-70-6-1	370 [14.57]	290 [11.42]																	
K3000-120-6-1	420 [16.54]	340 [13.39]																	
K3000-200-6-1	500 [19.69]	420 [16.54]																	
K4500-15-6-1	315 [12.40]	235 [9.25]																	
K4500-30-6-1	330 [12.99]	250 [9.84]																	
K4500-50-6-1	350 [13.78]	270 [10.63]	80 [3.1]	35 [1.4]	20 [0.8]	70 [2.8]	20 [0.8]	45 [1.8]	85 _{h8} [3.3]	65 _{h7} [2.6]	145 [5.7]	110 [4.3]	123 [4.8]	M42 x 2,5 [1.65]	[1.7] M10, 16mm deep	127 [5.0]	55 [2.2]	G1/4	
K4500-70-6-1	370 [14.57]	290 [11.42]																	
K4500-120-6-1	420 [16.54]	340 [13.39]																	
K4500-200-6-1	500 [19.69]	420 [16.54]																	

TYPE WK SERIES

Pneumatic Power Cylinders | Product Overview | Technical Information



- Piston rod with ISO fit

Note:

Operating pressure max. [87psi]6 bar, min [44psi] 3 bar. Use only clean, water- and oilfree compressed air. Piston rod is not secured against twisting and should not be loaded transversal.

See page MC-PPC-2 for more information.

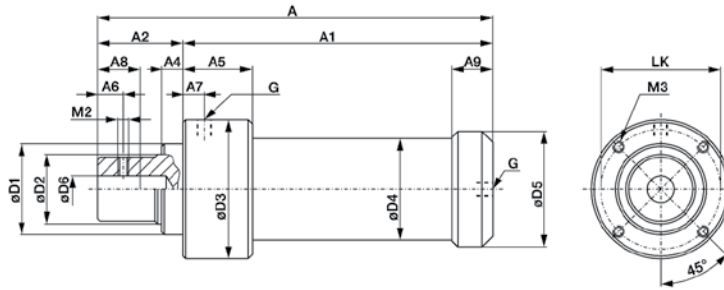
Model	Piston force within forward stroke at 6 bar kN [lbf]	Forward stroke mm [in]	Clamping force within power stroke at 6 bar kN [lbf]	Power stroke mm [in]	Piston dia. mm [in]	Air consumption per double stroke at 6 bar dm ³ [ft ³]	Stroke frequency depending on total stroke [min ⁻¹]	Temperature range °C [°F]	Weight [lbs] kg
WK400-15-6-1	0,68 [153]	15 [0.59]	4 [900lbf]	6 [0.24]	40 [1.75]	0,71 [0.025]	5 to 30	- 5 to +75 [23 to 167]	1,20 [2.6]
WK400-30-6-1		30 [1.18]				0,89 [0.031]			1,25 [2.8]
WK400-50-6-1		50 [1.97]				1,14 [0.040]			1,30 [2.9]
WK400-70-6-1		70 [2.76]				1,38 [0.049]			1,35 [3.0]
WK400-120-6-1		120 [4.72]				1,98 [0.070]			1,50 [3.3]
WK400-200-6-1	200 [7.87]	2,94 [0.104]	1,70 [3.7]						
WK600-15-6-1	1,06 [238]	15 [0.59]	6 [1350lbf]	6 [0.24]	50 [1.97]	1,34 [0.047]	5 to 30	- 5 to +75 [23 to 167]	2,05 [4.5]
WK600-30-6-1		30 [1.18]				1,65 [0.058]			2,15 [4.7]
WK600-50-6-1		50 [1.97]				2,06 [0.073]			2,30 [5.1]
WK600-70-6-1		70 [2.76]				2,47 [0.087]			2,40 [5.3]
WK600-120-6-1		120 [4.72]				3,50 [0.124]			2,70 [6.0]
WK600-200-6-1	200 [7.87]	5,15 [0.182]	3,20 [7.1]						
WK1000-15-7-1	1,75 [393]	15 [0.59]	10 [2250lbf]	7* [0.27]	63 [2.48]	2,20 [0.078]	5 to 30	- 5 to +75 [23 to 167]	3,60 [7.9]
WK1000-30-7-1		30 [1.18]				2,66 [0.094]			3,80 [8.4]
WK1000-50-7-1		50 [1.97]				3,26 [0.115]			4,10 [9.0]
WK1000-70-7-1		70 [2.76]				3,85 [0.136]			4,40 [9.7]
WK1000-120-7-1		120 [4.72]				5,35 [0.189]			5,20 [11.5]
WK1000-200-7-1	200 [7.87]	7,74 [0.273]	6,40 [14.1]						
WK3000-15-6-1	3 [674]	15 [0.59]	30 [4500lbf]	6* [0.24]	85 [3.35]	4,48 [0.158]	5 to 25	- 5 to +75 [23 to 167]	11,80 [26.0]
WK3000-30-6-1		30 [1.18]				5,20 [0.184]			12,50 [27.6]
WK3000-50-6-1		50 [1.97]				6,17 [0.218]			13,40 [29.5]
WK3000-70-6-1		70 [2.76]				7,13 [0.252]			14,30 [31.5]
WK3000-120-6-1		120 [4.72]				9,54 [0.337]			16,60 [36.6]
WK3000-200-6-1	200 [7.87]	13,40 [0.473]	20,20 [44.5]						
WK4500-15-6-1	4,2 [944]	15 [0.59]	45 [10120lbf]	6* [0.24]	100 [3.94]	6,18 [0.218]	5 to 25	- 5 to +75 [23 to 167]	13,30 [29.3]
WK4500-30-6-1		30 [1.18]				7,17 [0.253]			14,00 [30.9]
WK4500-50-6-1		50 [1.97]				8,50 [0.300]			15,00 [33.1]
WK4500-70-6-1		70 [2.76]				9,83 [0.347]			15,80 [34.8]
WK4500-120-6-1		120 [4.72]				13,20 [0.466]			18,10 [39.9]
WK4500-200-6-1	200 [7.87]	18,50 [0.653]	21,70 [47.8]						
WK6000-30-6	6,0 [1350]	[1.18] 30	60,0 [13490lbf]	6* [0.24]	125,0 [4.92]	[0.367] 10,40	5 to 25	- 5 to +75 [23 to 167]	24,00 [52.9]
WK6000-50-6		[1.97] 50				[0.454] 12,85			24,50 [54.0]
WK6000-70-6		[2.76] 70				[0.536] 15,17			25,00 [55.1]
WK6000-120-6		[4.72] 120				[0.747] 21,15			26,50 [58.4]

* Power strokes up to 12 mm and other forward strokes upon request

TYPE WK SERIES

Pneumatic Power Cylinders | Technical Information

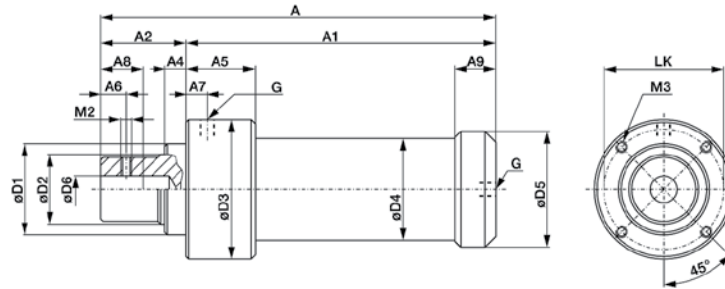
Type WK in standard version



Model	Dimensions for standard version of type WK																		
	Differences of dimensions for cylinder with magnet piston rings see chart on page MC-PPC-10																		
	A	A ₁	A ₂	A ₃	A ₄	A ₅	A ₇	A ₈ **	A ₉	Ø D ₁	Ø D ₂	Ø D ₃	Ø D ₄	Ø D ₅	Ø D ₆	M ₂	M ₃	LK	G
WK400-15-6-1	186 [7.32]	145 [5.71]																	
WK400-30-6-1	201 [7.91]	160 [6.30]																	
WK400-50-6-1	221 [8.70]	180 [7.09]	41 [1.61]	21 [0.83]	12 [0.47]	39 [1.54]	10 [0.39]	25 [0.98]	23,5 [0.93]	40 _{h7} [1.57]	25 _{h7} [0.98]	63 [2.48]	44 [1.73]	49 [1.93]	10 ^{H7}	M6	M5, 10mm deep [0.06]	54 [2.13]	G1/8
WK400-70-6-1	241 [9.49]	200 [7.87]																	
WK400-120-6-1	291 [11.46]	250 [9.84]																	
WK400-200-6-1	371 [14.61]	330 [12.99]																	
WK600-15-6-1	201 [7.91]	160 [6.30]																	
WK600-30-6-1	216 [8.50]	175 [6.89]																	
WK600-50-6-1	236 [9.29]	195 [7.68]	41 [1.61]	21 [0.83]	12 [0.47]	39 [1.54]	10 [0.39]	25 [0.98]	23,5 [0.93]	40 _{h7} [1.57]	25 _{h7} [0.98]	73 [2.87]	54 [2.13]	[2.32] 59	10 ^{H7}	M6	M6, 10mm deep [0.06]	64 [2.52]	G1/8
WK600-70-6-1	256 [10.08]	215 [8.46]																	
WK600-120-6-1	306 [12.05]	265 [10.43]																	
WK600-200-6-1	386 [15.20]	345 [13.58]																	
WK1000-15-7-1	243 [9.57]	187 [7.36]																	
WK1000-30-7-1	258 [10.16]	202 [7.95]																	
WK1000-50-7-1	278 [10.94]	222 [8.74]	56 [2.20]	25 [0.98]	15 [0.59]	52 [2.05]	10 [0.39]	40 [1.57]	29 [1.14]	63 _{h8} [2.48]	40 _{h7} [1.57]	99,5 [3.92]	68 [2.68]	74,5 [2.93]	20 ^{H7}	M8	M8, 12mm deep [0.98]	85 [3.35]	G1/8
WK1000-70-7-1	298 [11.73]	242 [9.53]																	
WK1000-120-7-1	348 [13.70]	292 [11.50]																	
WK1000-200-7-1	428 [16.85]	372 [14.65]																	

Continued on next page

Type WK in standard version

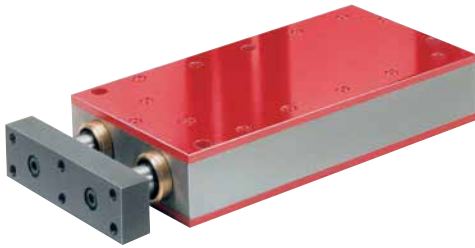


Model	Dimensions for standard version of type WK Differences of dimensions for cylinder with magnet piston rings see chart on page MC-PPC-10																		
	A	A ₁	A ₂	A ₃	A ₄	A ₅	A ₇	A ₈ **	A ₉	Ø D ₁	Ø D ₂	Ø D ₃	Ø D ₄	Ø D ₅	Ø D ₆	M ₂	M ₃	LK	G
WK3000-15-6-1	315 [12.40]	235 [9.25]																	
WK3000-30-6-1	330 [12.99]	250 [9.84]																	
WK3000-50-6-1	350 [13.78]	270 [10.63]	80 [3.15]	35 [1.38]	20 [0.79]	70 [2.76]	20 [0.79]	40 [1.57]	45 [1.77]	85 _{h8} [3.35]	65 _{h7} [2.56]	130 [5.12]	95 [3.74]	108 [4.25]	25 ^{H7}	M10	M10, 16mm deep [16]	112 [4.41]	G1/4
WK3000-70-6-1	370 [14.57]	290 [11.42]																	
WK3000-120-6-1	420 [16.54]	340 [13.39]																	
WK3000-200-6-1	500 [19.69]	420 [16.54]																	
WK4500-15-6-1	315 [12.40]	235 [9.25]																	
WK4500-30-6-1	330 [12.99]	250 [9.84]																	
WK4500-50-6-1	350 [13.78]	270 [10.63]	80 [3.15]	35 [1.38]	20 [0.79]	70 [2.76]	20 [0.79]	40 [1.57]	45 [1.77]	85 _{h8} [3.35]	65 _{h7} [2.56]	145 [5.71]	110 [4.33]	123 [4.84]	25 ^{H7}	M10	M10, 16mm deep [1.65]	127 [5.00]	G1/4
WK4500-70-6-1	370 [14.57]	290 [11.42]																	
WK4500-120-6-1	420 [16.54]	340 [13.39]																	
WK4500-200-6-1	500 [19.69]	420 [16.54]																	
WK6000-30-6	365 [14.37]	285 [11.22]																	
WK6000-50-6	[15.16] 385	305 [12.01]	80 [3.15]	20 [0.79]	48 [1.89]	24 [0.94]	22 [0.87]	40 [1.57]	53 [2.09]	85 _{h8} [3.35]	65 _{h7} [2.56]	178 [7.01]	135 [5.31]	148 [5.83]	25 ^{H7}	M10	M10, 16mm deep [1.65]	150 [5.91]	G1/2
WK6000-70-6	405 [15.94]	325 [12.80]																	
WK6000-120-6	455 [17.91]	375 [14.76]																	

** Usable depth of bore with ISO fit D6

TYPE WR SERIES

Pneumatic Power Cylinders | Product Overview

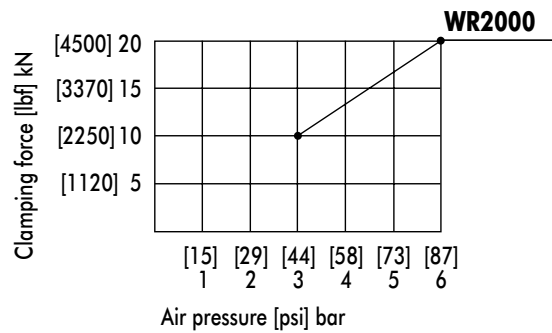
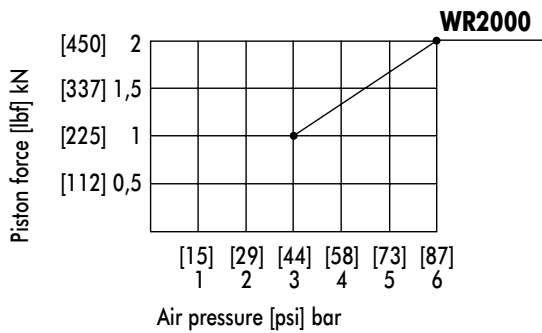
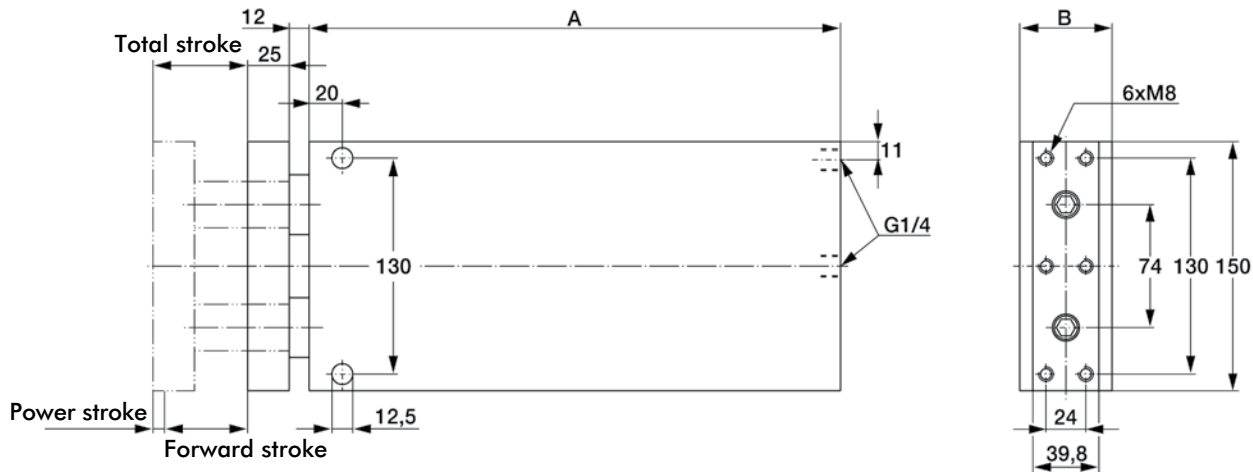


- Piston rods prevent twisting

Note:

Use only clean, water- and oilfree compressed air. Force must be transmitted via the centre of the pressure plate. One-sided loading of the pressure plate should be avoided. For punching applications contact our technical support! See page MC-PPC-2 for more information.

Type WR



Return stroke force: half of piston force

Air pressure: max. [87psi] 6 bar; min. [44psi] 3 bar

Model	Piston force within forward stroke at 6 bar kN [lbf]	Forward stroke mm [in]	Clamping force within power stroke at 6 bar [lbf] kN	Power stroke mm [in]	Piston dia. mm [in]	Air consumption per double stroke at 6 bar dm ³ [ft ³]	Stroke frequency depending on total stroke [min ⁻¹]	Temperature range °C [°F]	Weight kg [lbs]	A	B
WR 2000-15-7		15 [0.59]				2,44 [0.086]			12,5 [27.6]	285	51,6
WR 2000-30-7		30 [1.18]				2,95 [0.104]			14,0 [30.9]	300	51,6
WR 2000-50-7	2 [450]	50 [1.97]	20 [4500]	7 [0.27]	70 [2.76]	3,62 [0.128]	5 - 25	-5 up to +75 [23 to up167]	15,5 [34.1]	320	55,6
WR 2000-70-7		70 [2.76]				4,27 [0.151]			17,2 [37.9]	340	55,6
WR 2000-120-7		120 [4.72]				5,94 [0.210]			21,0 [46.3]	390	59,6

Pneumatic Power Cylinders Type K and WK with end position control by magnetic field sensors.

- For the sizes

K and WK 400.... , K and WK 600... ,
K and WK 1000.... K and WK 3000... ,
K and WK 4500...

- Change of Model

Indicate „-A“ at the end of Model instead of „-1“ for standard version!

Example:

K400 – 15 – 6 – 1 change to K400 – 15 – 6 – A

WK 3000 – 50 – 6 – 1 change to WK 3000 – 50 – 6 – A

- Change in construction

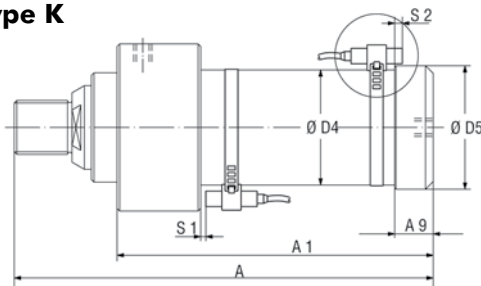
Only the dimensions Ø D4, Ø D5, A/A 1 and A9 are different to the standard version.



- Standard equipment (as shown above)

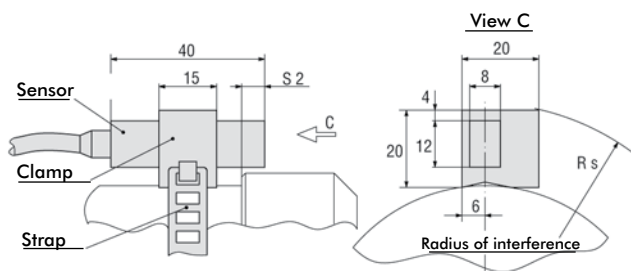
Pneumatic Power Cylinders with „-A“ at the end of Model are completely furnished with a magnetic piston ring and with two mounted sensor sets (Model SMB-102157, consisting of magnetic field sensor with 3m cable, clamp and strap)

Type K

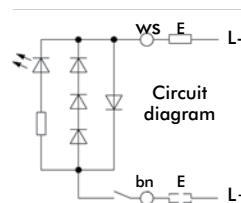


For sizes	Switching points of sensors		**Differences of dimensions compared with standard version				
	S1*	S2*	Ø D4	Ø D5	A/A 1	A9	Rs
K 400-...-A	5	12	-	-	+15	-	44
K 1000-...-A	10	18	-	-	+15	-	56
K 3000-...-A	5	14	90	97	-	30	67
K 45000-...-A	5	12	106	113	-	28,5	75

* Approx. data, because of magnet field variations. S1 refers to the max. power stroke and enlarges up to 60 mm, when smaller power strokes are used.

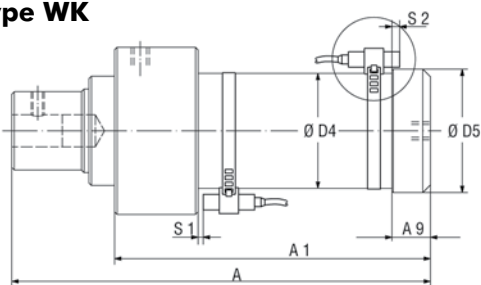


Circuit diagram and technical data of sensor set Model **SMB-102157**, consisting of magnetic field sensor with 3 m cable, clamp and strap (2 sets per cylinder are standard equipment).



Switching voltage	10...250 VAC/DC
Switching current	0,5 A
Switching power	20 W/30 VA
Function	normally open contact
Protection class	IP 67 (DIN 40050)
Indicator	LED

Type WK



For sizes	Switching points of sensors		**Differences of dimensions compared with standard version				
	S1*	S2*	Ø D4	Ø D5	A/A 1	A9	Rs
WK 400-...-A	5	12	-	-	+15	-	44
WK 1000-...-A	10	18	-	-	+15	-	56
WK 3000-...-A	5	14	90	97	-	30	67
WK 45000-...-A	5	12	106	113	-	28,5	75

* Approx. data, because of magnet field variations. S1 refers to the max. power stroke and enlarges up to 60 mm, when smaller power strokes are used.

-K OPTION

Magnetic Field Sensing | Technical Specifications



Sensor cage for T-slot proximity sensor

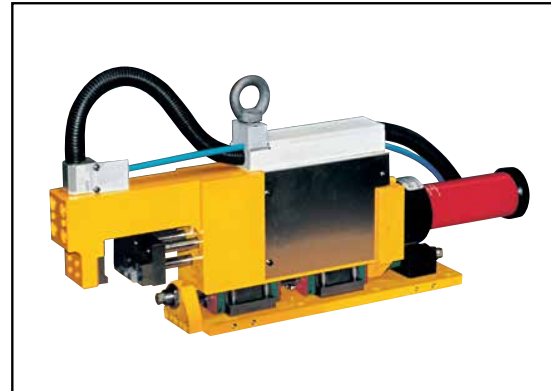
- **For the sizes**
K and WK 400.... , K and WK 600... , K and WK 1000.... ,
K and WK 3000..., K and WK 4500...
- **Change of Model**
Indicate "-K" at the end of Model instead of "-A" for
standard version.
Example:
K400 – 15 – 6 – A change to K400 – 15 – 6 – K
WK 3000 – 50 – 6 – A change to WK 3000 - 50 – 6 – K
- **Benefits:**
Small radii of interference.
Customer specific T-slot sensors are usable.
- **Standard equipment:**
Pneumatic power cylinder with "-K" at the end of Model
number are supplied with mounted sensor cages but
without T-slot sensors.

PNEUMATIC POWER CYLINDERS

Application Examples



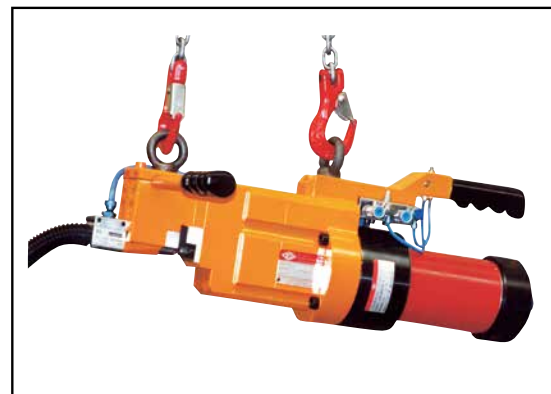
Radius clinching unit for profiled aluminium



Special punching unit for 2 holes Ø 3,4 in steel 0,9 mm



Special device for 2 holes Ø 12 in steel 1,2 mm



Mobile punching unit for holes Ø 6,2 in crossbeams



Device for holes Ø 8 in sheet metal



Stamping units placed in line



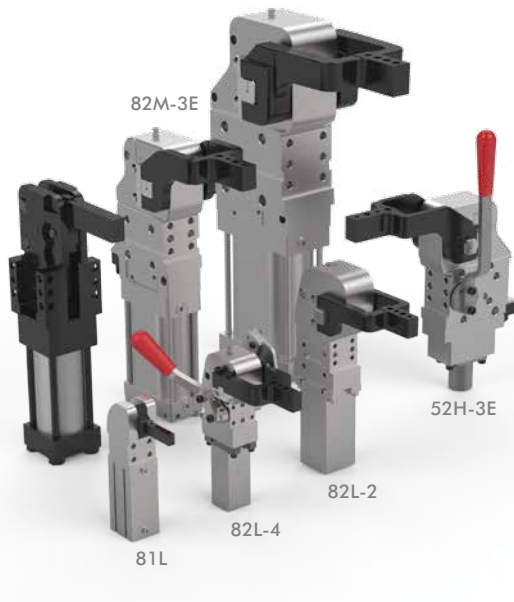
Stamping units placed in line



Welding fixture for exhaust components

PNEUMATIC POWER CLAMPS

Sizing and Application Chart



Series	Page MC-PPC-#	Holding Torque at 5 bar Nm					Clamping Torque at 5 bar Nm					Piston Diameter mm						
		0 to 100	100 to 500	500 to 1000	1000 to 2000	2000 to 4000	0 to 100	100 to 500	500 to 1000	1000 to 2000	2000 to 4000	Less than 25	25	32	40	50	63	80
81L	3	●					●					●						
82L-4	7	●					●					●	●					
82L-2	15	●	●				●	●				●	●	●				
82M-3E	25		●		●	●		●	●						●	●	●	●
52H-3E	47				●													
870/871	57		●				●								●			
860/861	59			●				●								●		
890/891	59				●			●										●
1000/1001	59				●				●									●
82D	61	●					●	●						●			●	

81L SERIES

Pneumatic Power Clamps | Ordering Information

81L **12-1** **01** **00**

Base Model

Size

Description

12-1	12mm Cylinder Bore Size
16-1	16mm Cylinder Bore Size
20-1	20mm Cylinder Bore Size
25-1	25mm Cylinder Bore Size

Arm Style

Description

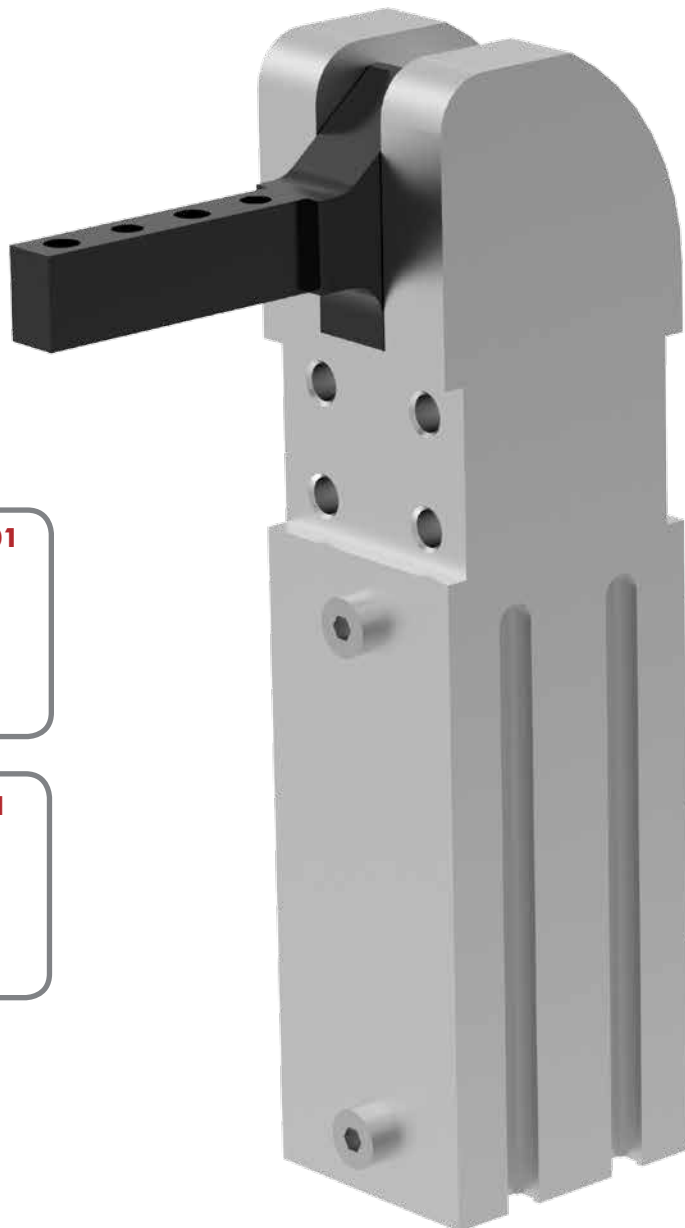
01	Clamping arm, horizontal
41	Clamping arm, vertical

See below for further details

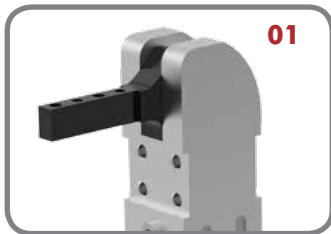
Design

Description

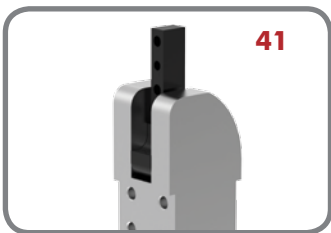
00	Standard design
-----------	-----------------



Arm Style



01



41

Accessories

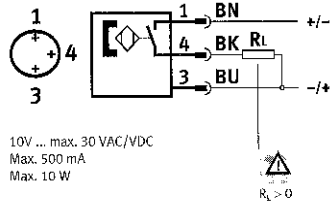
8EA-109-1

Description (order separately)

Sensor, 3-wire cable, M8x1 connector, 3-pin

82ZB-004-1

Adapter for mounting 81L20-1, 81L25-1 to 25mm dia. bar



12

Max Holding Torque
25 Nm
Max Clamping Torque
4,5 Nm at 5bar

16

Max Holding Torque
60 Nm
Max Clamping Torque
7,0 Nm at 5bar

20

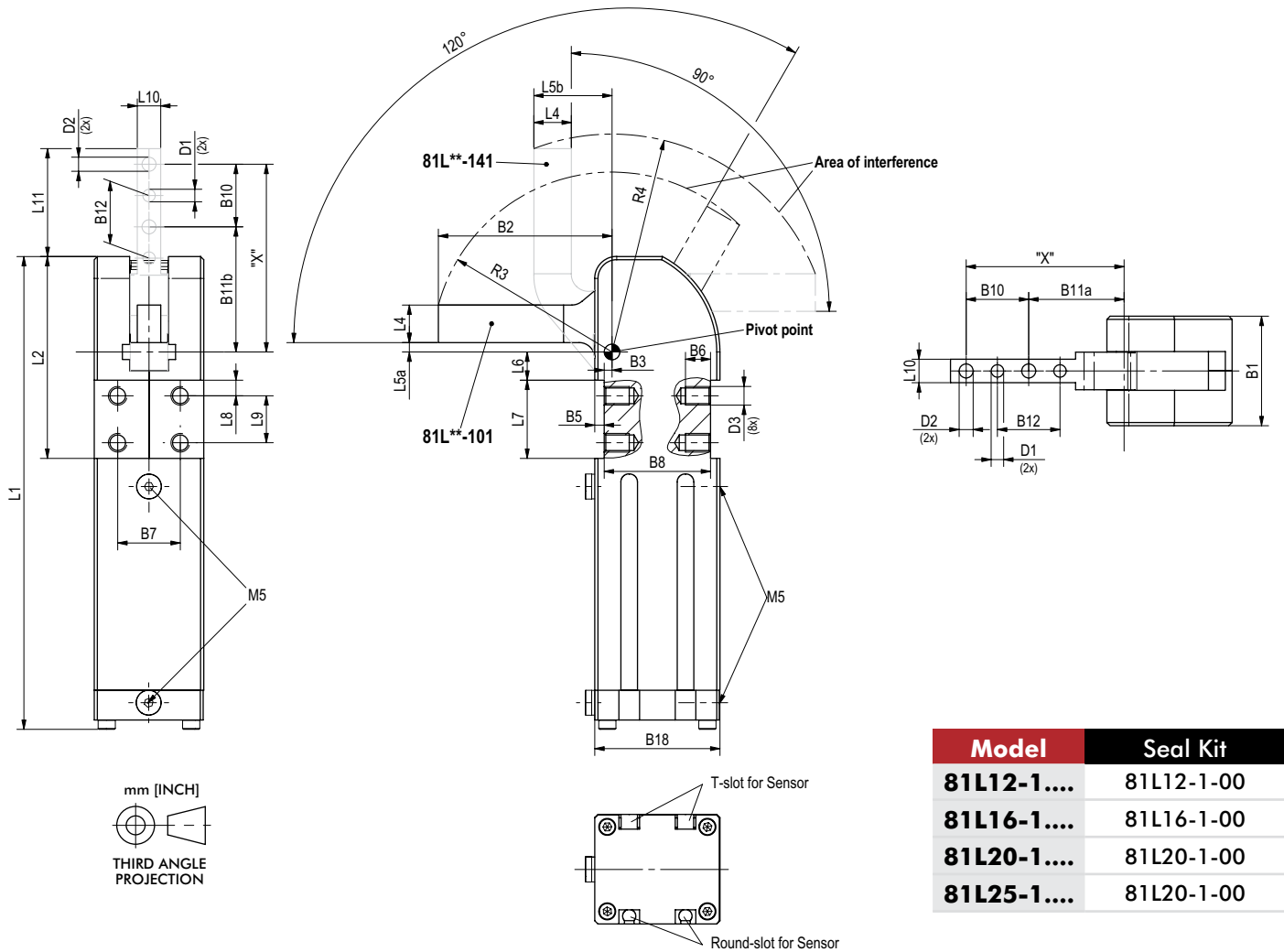
Max Holding Torque
100 Nm
Max Clamping Torque
18 Nm at 5bar

25

Max Holding Torque
100 Nm
Max Clamping Torque
18 Nm at 5bar

81L SERIES

Pneumatic Power Clamps | Dimensions and Seal Kits



mm [INCH]
THIRD ANGLE PROJECTION

Power by compressed air, max. 6 bar Operation with oil-free air is permissible.

Model	D1 Ø [H7]	D2 Ø	D3 Ø	B1	B2	B3 ±0,1	B5 ±0,2	B6	B7 ±0,1	B8 ±0,1	B10 ±0,2	B11a	B11b	B12
81L12-1....	[0.12] 3	[0.13] 3,3	M4	[0.94] 24	[1.57] 40	[0.10] 2,5	[0.06] 1,5	[0.24] 6	[0.59] 15	[0.98] 25	[0.35] 9	[1.06] 27	[1.24] 31,5	[0.35] 9
81L16-1....	[0.12] 3	[0.17] 4,3	M5	[1.12] 30	[1.97] 50	[0.08] 2	[0.08] 2	[0.19] 5	[0.79] 20	[1.02] 26	[0.59] 15	[1.18] 30	[1.56] 39,5	[0.59] 15
81L20-1....	[0.16] 4	[0.18] 4,5	M6	[1.38] 35	[2.12] 55,5	[0.10] 2,5	[0.12] 3	[0.28] 7	[0.79] 20	[1.34] 34	[0.79] 20	[1.20] 30,5	[1.57] 40	[0.79] 20
81L25-1....	[0.16] 4	[0.26] 6,5	M6	[1.38] 35	[2.58] 65,5	[0.10] 2,5	[0.12] 3	[0.28] 7	[0.79] 20	[1.34] 34	[0.79] 20	[1.59] 40,5	[1.97] 50	[0.79] 20

Model	B18	L1 ~	L2	L4	L5a	L5b	L6	L7 ±0,1	L8	L9	L10	L11	R3 ~	R4 ~
81L12-1....	[1.10] 28	[4.09] 104	[1.59] 40,5	[0.28] 7	[0.10] 2,5	[0.7] 17,5	[0.18] 4,5	[0.59] 15	[0.12] 3	[0.35] 9	[0.24] 6	[0.93] 23,5	[1.61] 41	[1.89] 48
81L16-1....	[1.18] 30	[4.69] 119	[1.95] 49,5	[0.35] 9	0.09 2,25	[0.8] 20,5	[0.23] 5,75	[0.79] 20	[0.16] 4	[0.47] 12	[0.31] 8	[1.41] 35,75	[2.00] 51	[2.48] 63
81L20-1....	[1.57] 40	[5.94] 151	[2.54] 64,5	[0.47] 12	[0.12] 3	[0.98] 25	[0.35] 9	[0.98] 25	[0.19] 5	[0.59] 15	[0.29] 7,5	[1.36] 34,5	[2.26] 57,5	[2.75] 70
81L25-1....	[1.57] 40	[5.94] 151	[2.54] 64,5	[0.47] 12	[0.12] 3	[0.98] 25	[0.35] 9	[0.98] 25	[0.19] 5	[0.59] 15	[0.47] 12	[1.75] 44,5	[2.64] 67	[3.11] 79

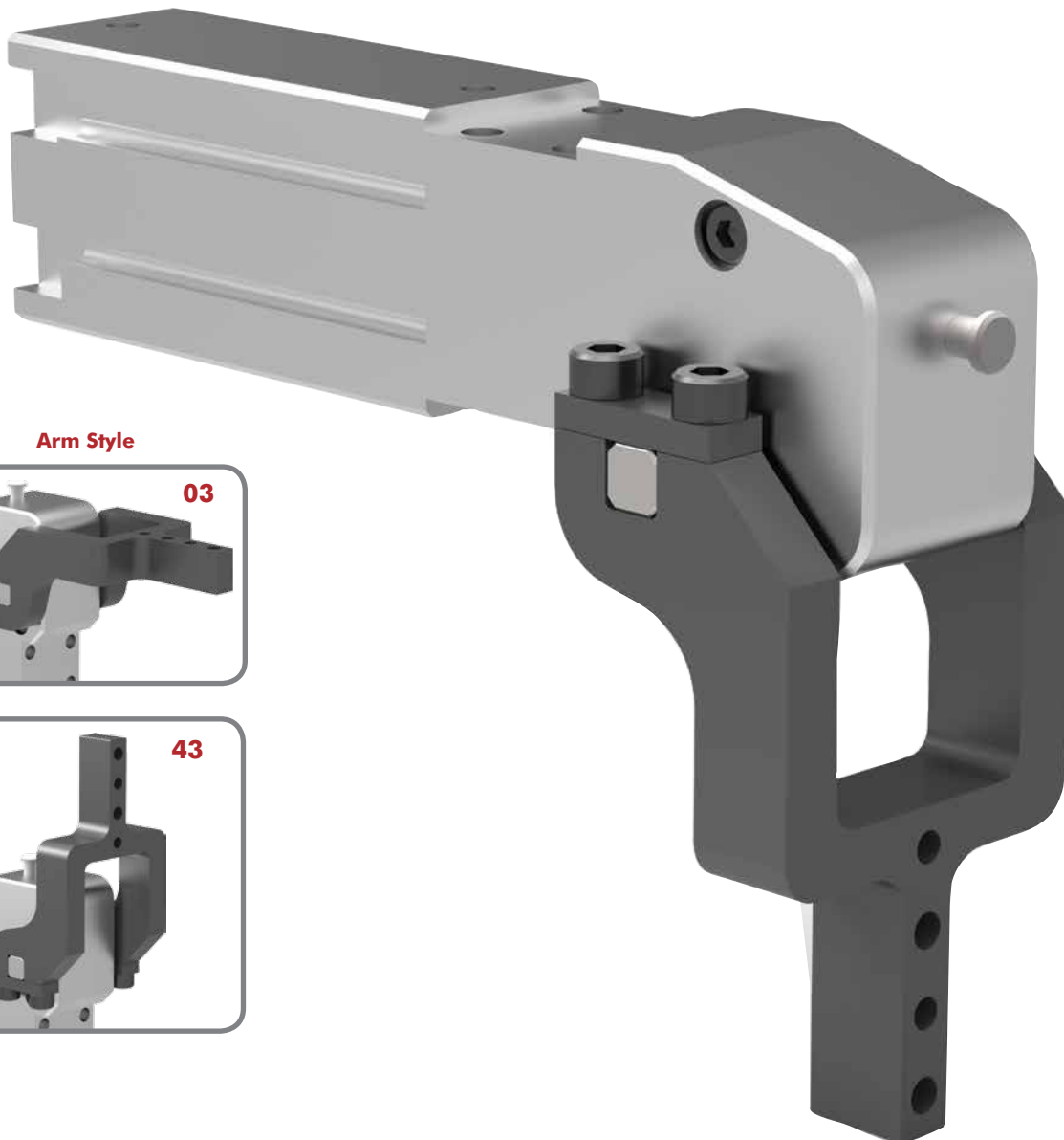
Model	Max. Holding Torque Nm [lb ft]	Max. Clamping Torque at 5 bar [72 psi] Nm [lb ft]	Weight kg [lb]	Air Consumption per double stroke at 5 bar [72 psi] dm ³ [ft ³]	Max. Added Load (at Position, "X") g [oz]
81L12-101..	25 [18.4]	4,5 [3.3]	0,16 [0.4]	0,25 [0.01]	50 [1.8]
81L12-141..	20 [14.8]	4,5 [3.3]	0,17 [0.4]	0,25 [0.01]	50 [1.8]
81L16-101..	60 [44]	6,5 [4.8]	0,25 [0.6]	0,27 [0.01]	80 [2.8]
81L16-141..	40 [29.5]	7,0 [5.23]	0,27 [0.6]	0,26 [0.01]	80 [2.8]
81L20-101..	100 [73.8]	18 [13.3]	0,50 [1.1]	0,40 [0.02]	90 [3.2]
81L20-141..	80 [59]	17 [12.5]	0,52 [1.2]	0,35 [0.01]	90 [3.2]
81L25-101..	100 [73.8]	18 [13.3]	0,52 [1.2]	0,40 [0.02]	100 [3.5]
81L25-141..	80 [59]	17 [12.5]	0,54 [1.25]	0,35 [0.01]	100 [3.5]

82L...-4... SERIES

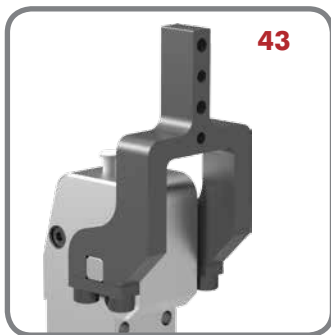
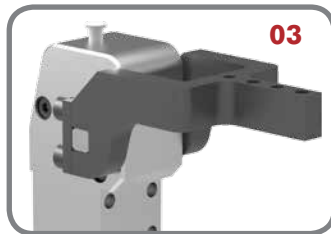
Pneumatic Power Clamps | Ordering Information

82L **16-4** **03** **0**

Base Model	Size	Description	Arm Style	Description	Opening Angle	Description
	12-4	12mm Cylinder Bore Size	00	No clamping arm	0	105° (Standard)
	16-4	16mm Cylinder Bore Size	03	U-bar, central 90°	3	90°
	20-4	20mm Cylinder Bore Size	43	U-bar, central 180°	4	75°
	25-4	25mm Cylinder Bore Size		See below for further details	5	60°
					6	45°
					7	30°
					8	15°



Arm Style



82L..-4... SERIES

Pneumatic Power Clamps | Ordering Information

Accessories

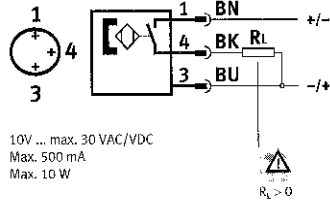
8EA-109-1

82ZB-004-1

Description (order separately)

Sensor, 3-wire cable, M8x1 connector, 3-pin

Adapter for mounting 82L20-4, 82L25-4 to 25mm dia. bar



12

Max Holding Torque
35 Nm

Max Clamping Torque

90° version: 10,4 Nm at 5bar

180° version: 8,7 Nm at 5bar

16

Max Holding Torque
40 Nm

Max Clamping Torque

12,4 Nm at 5bar

11,0 Nm at 5bar

20

Max Holding Torque
50 Nm

Max Clamping Torque

21,0 Nm at 5bar

19,3 Nm at 5bar

25

Max Holding Torque
80 Nm

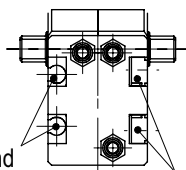
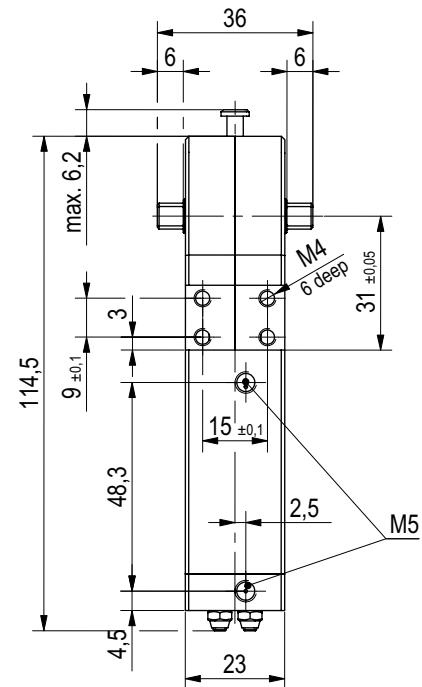
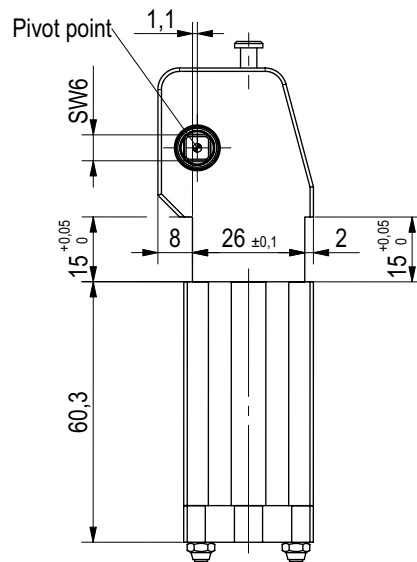
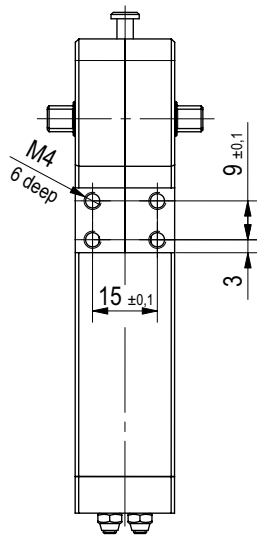
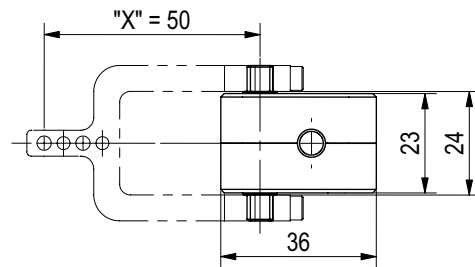
Max Clamping Torque

31,8 Nm at 5bar

28,5 Nm at 5bar

82L12-4 SERIES

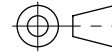
Pneumatic Power Clamps | Dimensions | Technical Specifications



Slot for round sensor

T-slot for sensor

mm [INCH]



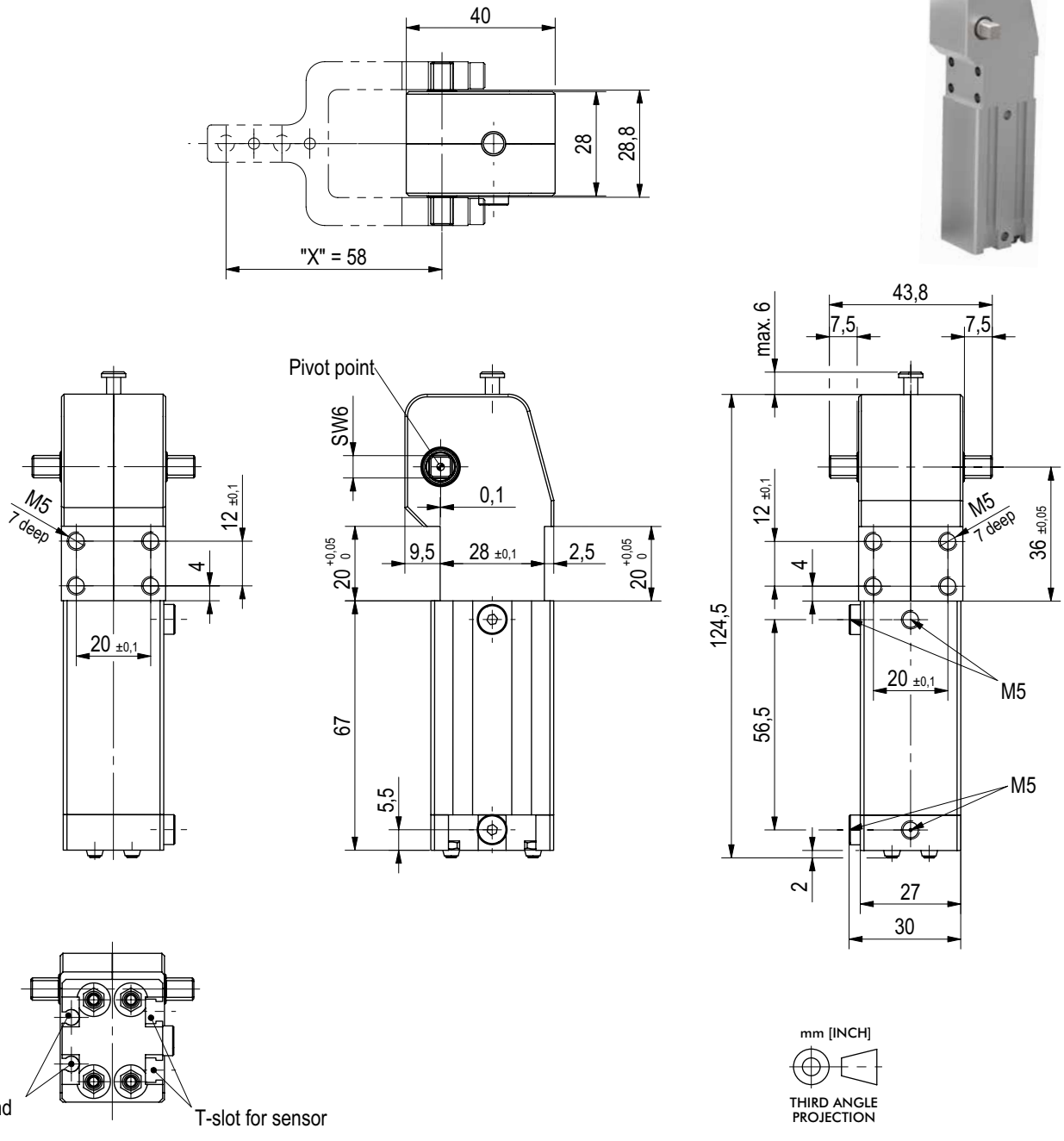
THIRD ANGLE PROJECTION

Power by compressed air, max. 6 bar Operation with oil-free air is permissible.

Model	Max. Holding Torque Nm [lb ft]	Max. Clamping Torque at 5 bar [72 psi] Nm [lb ft]	Weight [with arm] kg [lb]	Air Consumption per double stroke at 5 bar [72 psi] dm ³ [ft ³]	Max. Added Load (at Position "X") g [oz]
82L12-4030	35 [25.8]	10,4 [7.8]	0,23 [0.5]	0,25 [0.01]	50 [1.8]
82L12-4430	35 [25.8]	8,7 [6.4]	0,23 [0.5]	0,25 [0.01]	50 [1.8]

82L16-4 SERIES

Pneumatic Power Clamps | Dimensions | Technical Specifications

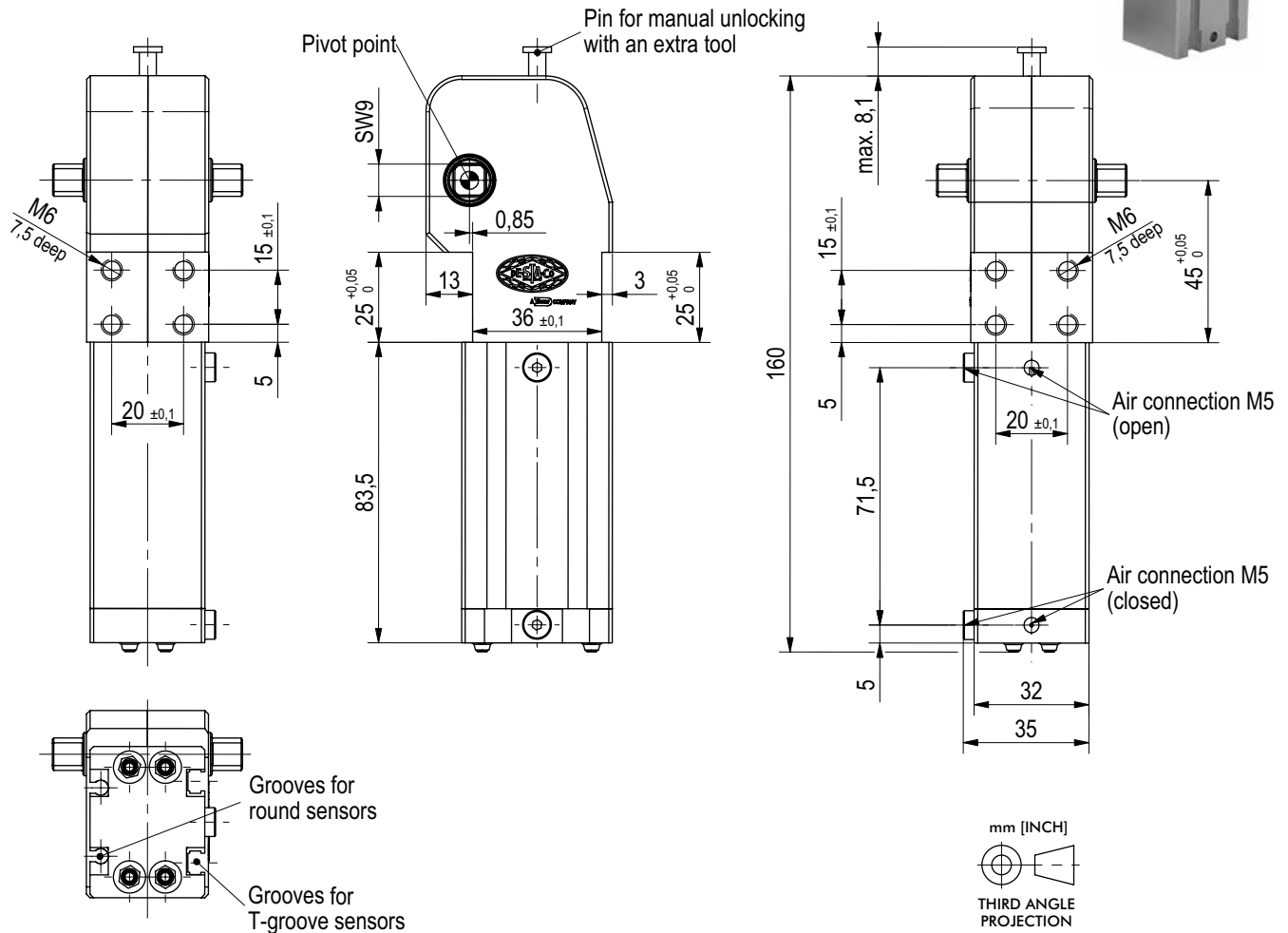
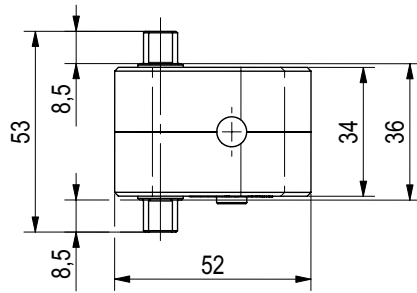


Power by compressed air, max. 6 bar Operation with oil-free air is permissible.

Model	Max. Holding Torque Nm [lb ft]	Max. Clamping Torque at 5 bar [72 psi] Nm [lb ft]	Weight [with arm] kg [lb]	Air Consumption per double stroke at 5 bar [72 psi] dm ³ [ft ³]	Max. Added Load (at Position "X") g [oz]
82L16-4030	40 [29.5]	12,4 [9.4]	0,33 [0.7]	0,27 [0.01]	80 [2.8]
82L16-4430	40 [29.5]	11,0 [8.1]	0,33 [0.7]	0,27 [0.01]	80 [2.8]

82L25-4 SERIES

Pneumatic Power Clamps | Dimensions | Technical Specifications

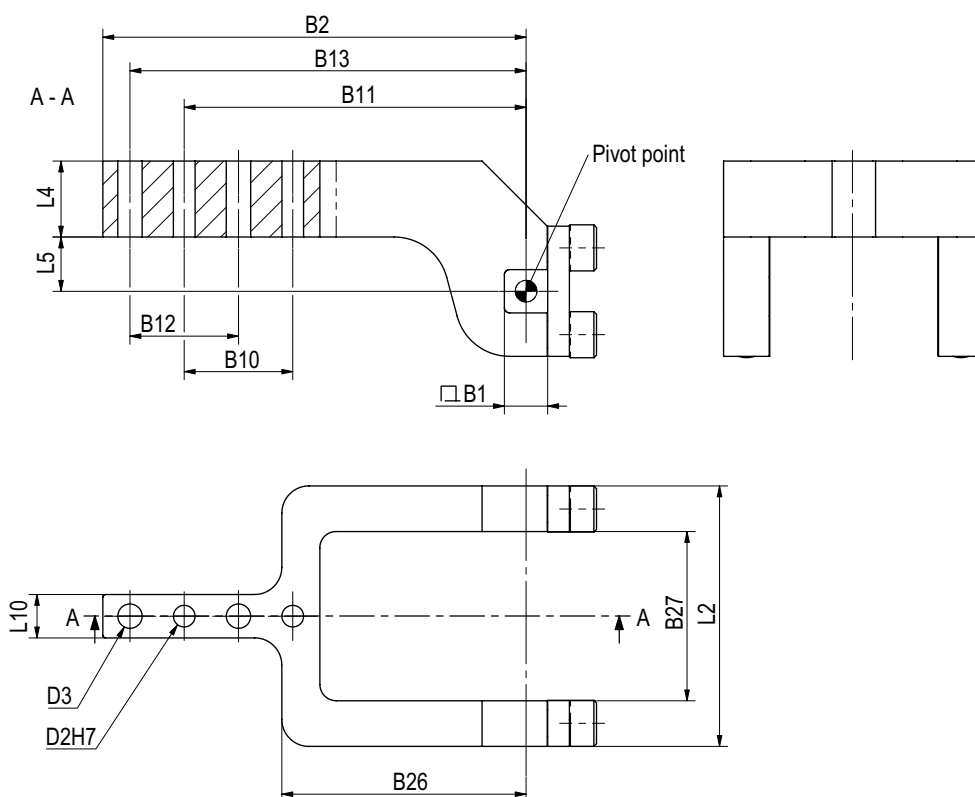


Power by compressed air, max. 6 bar Operation with oil-free air is permissible.

Model	Max. Holding Torque Nm [lb ft]	Max. Clamping Torque at 5 bar [72 psi] Nm [lb ft]	Weight [with arm] kg [lb]	Air Consumption per double stroke at 5 bar [72 psi] dm ³ [ft ³]	Max. Added Load (at Position "X") g [oz]
82L25-4030	80 [59]	31,8 [23.5]	0,66 [1.5]	0,40 [0.01]	100 [3.5]
82L25-4430	80 [59]	28,5 [12.5]	0,66 [1.5]	0,40 [0.01]	100 [3.5]

82L...-4... SERIES

Pneumatic Power Clamps | Clamp Arm Dimensions



Model	Order no. for Arm	Max. Opening angle	B1	B2	B10 ±0,02	B11 ±0,02	B12 ±0,1	B13 ±0,1	B26	B27	D2 H7	D3	L2	L4	L5	L10
82L12-4...	8JG-401-1-01	105°	6	54	9	45.5	9	50	38,5	24	3	3.3	36	7	10	6
82L16-4...	8JG-402-1-01	105°	6	63	15	50.5	15	58	36,5	29	3	4.5	44	9.5	10	10
82L20-4...	8JG-403-1-01	105°	8	78	20	63	20	73	45	31,2	4	4.5	48	14	10	8
82L25-4...	8JG-404-1-01	105°	9	81	20	66	20	76	48	36	4	6.4	53	16	10	12

82L...-2... SERIES

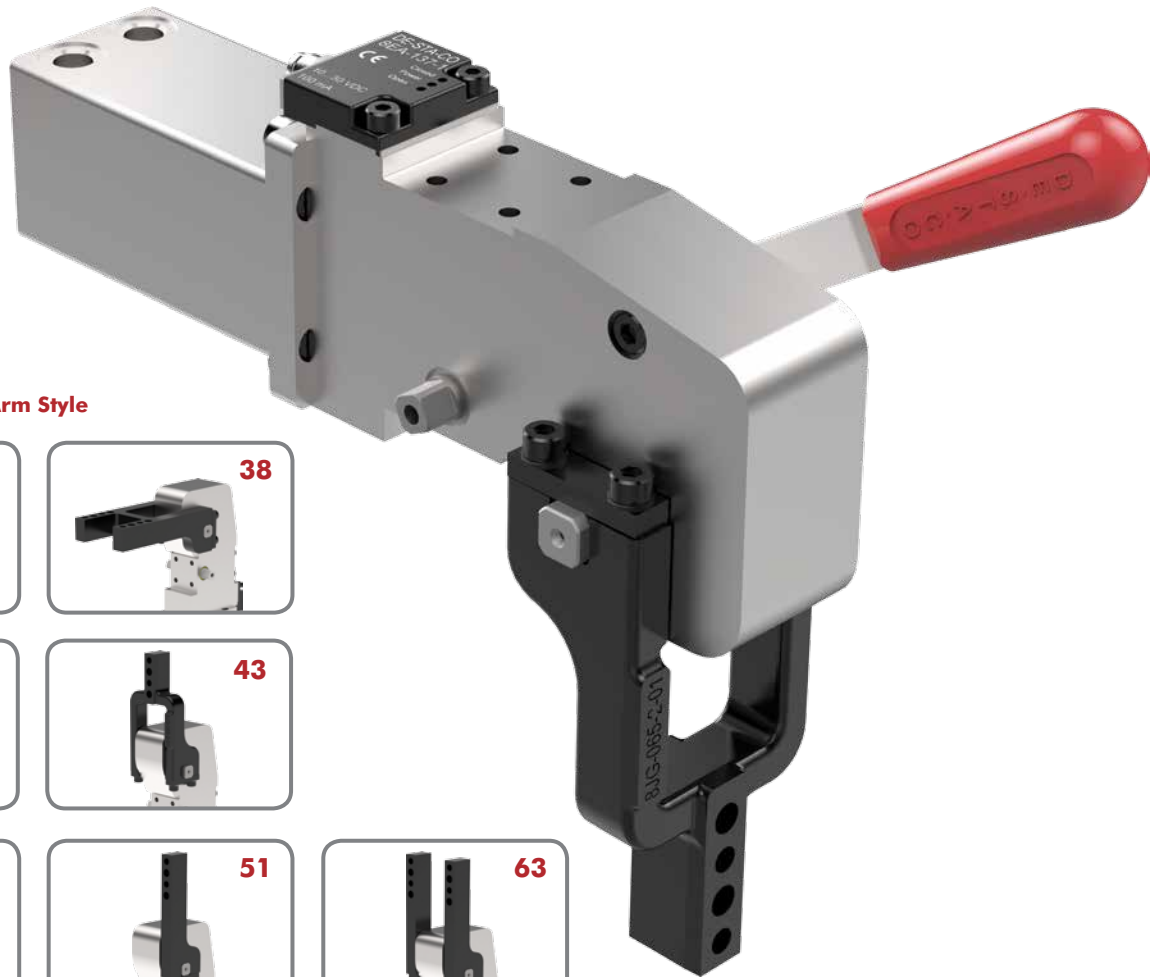
Pneumatic Power Clamps | Ordering Information

82L **2G** **-2** **03** **B8** **H** **0** **B**

Base Model	Size	Description
	2G	Ø25 (G1/8) Cylinder Bore Size
	3G	Ø32 (G1/8) Cylinder Bore Size
	3N	Ø32 (1/8-18 NPT) Cylinder Bore Size
	4G	Ø40 (G1/4) Cylinder Bore Size
	4N	Ø40 (1/4-18 NPT) Cylinder Bore Size

Arm Style	Description
03	U-clamp arm, central 90°
11	Lateral clamp arm, left 90°
12	Lateral clamp arm, right 90°
23	2x lateral clamp arm 90°
38	H-clamp arm 90°
43	U-clamp arm, central 180°
51	Lateral clamp arm, left 180°
52	Lateral clamp arm, right 180°
63	2x lateral clamp arm 180°
78	H-clamp arm 180°

See below for further details



Arm Style



82L..-2... SERIES

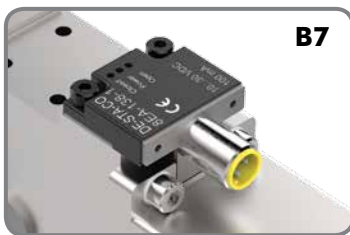
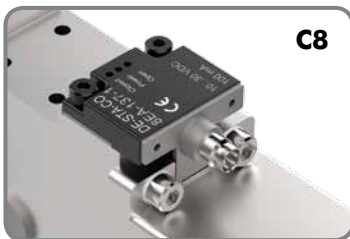
Pneumatic Power Clamps | Ordering Information

Hand Lever	Description
0	No Hand Lever
H	With Hand Lever

Base Model	Description
B	Power clamp without clamping arm. To be marked with an additional "B". Only with clamping arm "03"

Opening Angle	Description
0	105° (Standard)
3	90°
4	75°
5	60°
6	45°
7	30°
8	15°

Sensing	Description
00	No Sensing
C8	8EA-137-1 (M8x1)
B7	8EA-138-1 (M12x1)
B8	8EA-139-1 (M12x1)



2G

Max Holding Torque
75 Nm
Max Clamping Torque
25 Nm at 5bar

3G/N

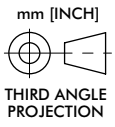
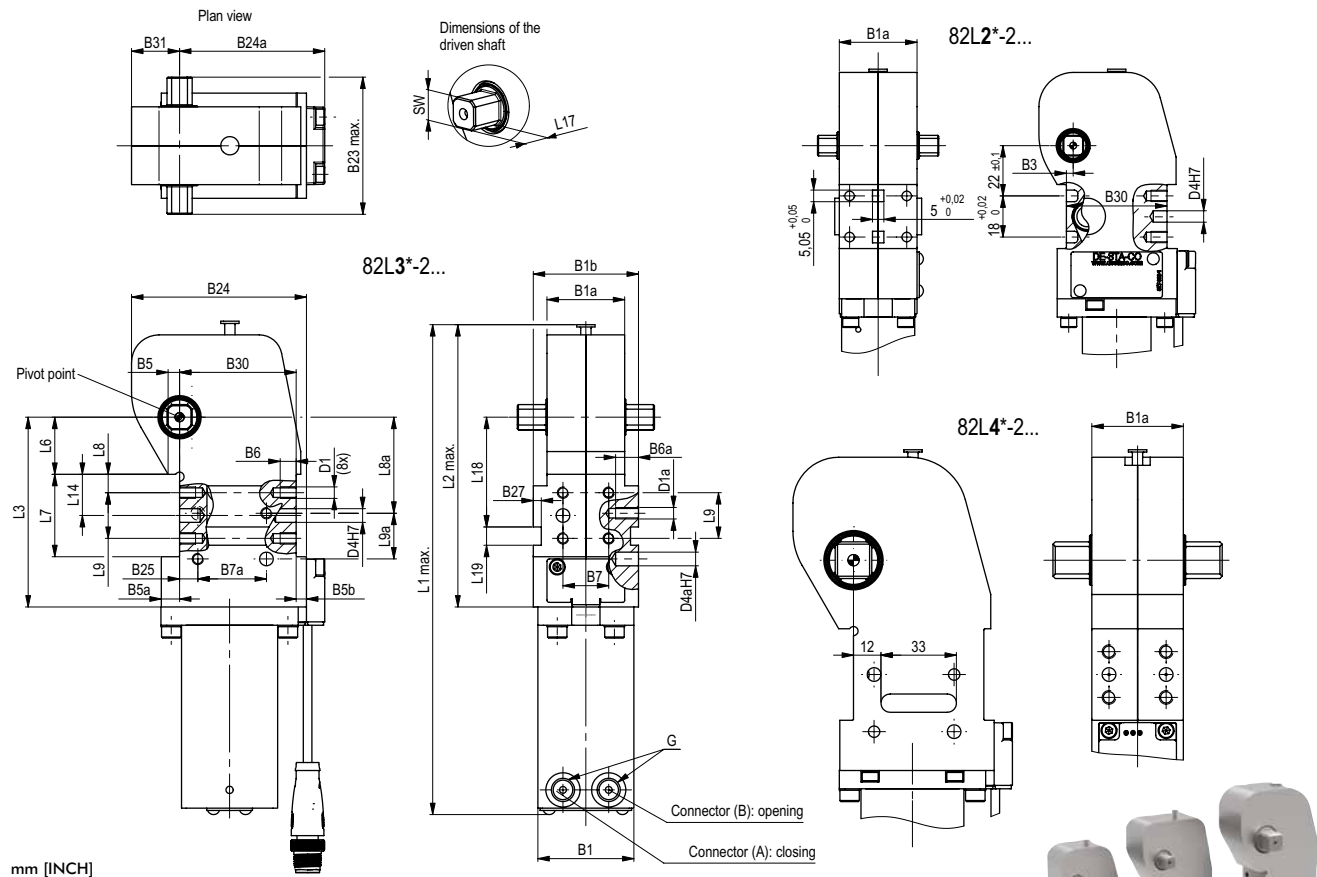
Max Holding Torque
180 Nm
Max Clamping Torque
55 Nm at 5bar

4G/N

Max Holding Torque
380 Nm
Max Clamping Torque
120 Nm at 5bar

82L...-2... SERIES

Pneumatic Power Clamps | Dimensions | Technical Specifications



Power by compressed air, max. 6 bar
Operation with oil-free air is permissible.

Technical Information | Model without Hand Lever

Model	Max. holding torque Nm [lb ft]	Clamping torque at 5 bar [72 psi] Nm [lb ft]	Piston Ø mm	Weight kg [lbs]	Air consumption per double stroke at 5 bar [72 psi] dm ³ [ft ³]	Connection G
82L2G-2...	75 [55]	25 [18]	25	1,0 [2.20]	0,4 [0.01]	G1/8
82L3G-2... 82L3N-2...	180 [133]	55 [41]	32	1,3 [2.86]	0,8 [0.03]	G1/8 1/8-18 NPT
82L4G-2... 82L4N-2...	380 [280]	120 [89]	40	1,9 [4.18]	1,2 [0.04]	G1/4 1/4-18 NPT

Model	B1	B1a	B1b	B3	B5	B5a	B5b	B6	B6a	B7	B7a**	B23	B24	B24a	B25	B27	B30	B31
										± 0,1	± 0,1	max.			+0,1		± 0,1	
82L2G-2...	32	34	-	3	4	4	4,5	7	-	25	-	53	60,5	53,5	-	-	44	15
82L3.-2...	42	34	46	-	5	8	4,5	7	10	20	30	60	76,5	63,5	8	3,5	51	21
82L4.-2...	45	40	-	-	6,5	6	4,5	10	10	25	35	74	88	69,5	9	3,5	57	26,5

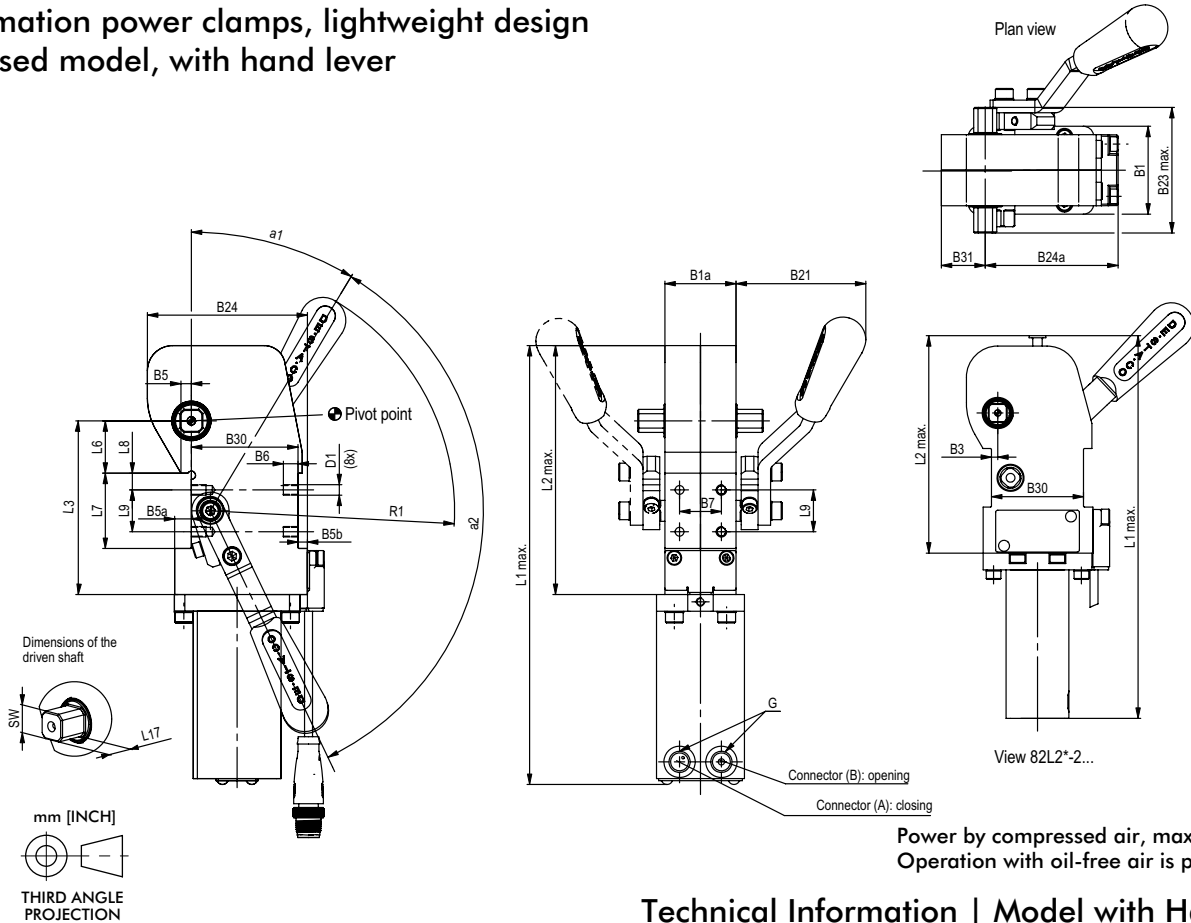
Model	D1	D1a	D4	D4a	L1	L2	L3	L6	L7	L8	L8a	L9	L9a**	L14	L17	L18	L19	SW
			H7	H7	max.	max.		± 0,05	+ 0,1	± 0,1	± 0,1	± 0,1	± 0,1	± 0,1	± 0,1		N9	h9
82L2G-2...	M5	M5	5	-	183,5	104,5	67	17	28	5	-	18	-	14	8,5	-	-	9
82L3.-2...	M5	M5	6	6	215	124	83	25	36	8	42	20	20	18	12,5	48	8	11
82L4.-2...	M6	M6	6	6	245	141	92	30	40	10	50	20	25	20	16	58,5	8	16

**Tolerance for distance to dowel hole ±0,02

82L..-2... SERIES

Pneumatic Power Clamps | Dimensions | Technical Specifications

Automation power clamps, lightweight design
enclosed model, with hand lever



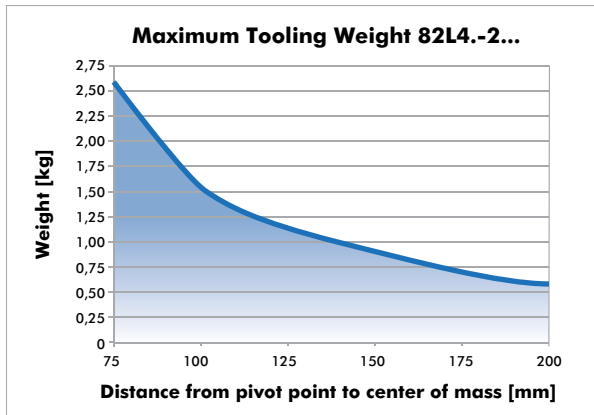
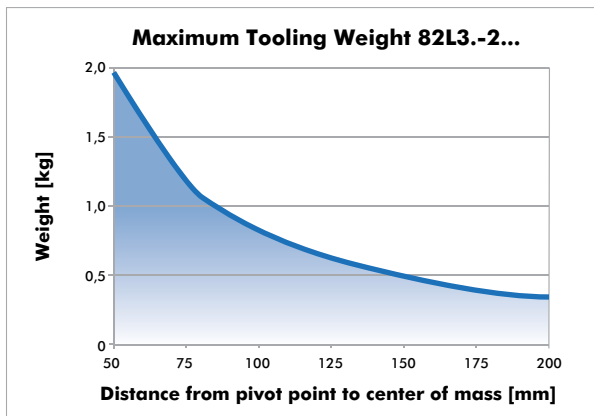
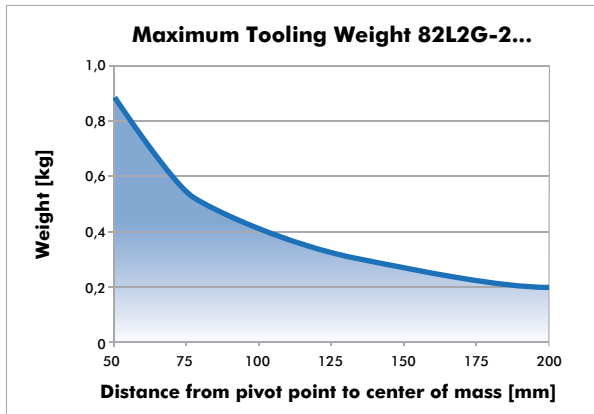
Technical Information | Model with Hand Lever

Model	Max. holding torque Nm [lb ft]	Clamping torque at 5 bar [72 psi] Nm [lb ft]	Piston Ø mm	Weight kg [lbs]	Opening angle	Air consumption per double stroke at 5 bar [72 psi] dm ³ [ft ³]	Connection G	B1	B1a	B3	B5	B5a
82L2G-2...	75 [55]	25 [18]	25	1,1 [2.42]	105°	0,4 [0.01]	G1/8	32	34	3	4	4
82L3G-2... 82L3N-2...	180 [133]	55 [41]	32	1,5 [3.30]		0,8 [0.03]	G1/8 1/8-18NPT	42	34	-	5	8
82L4G-2... 82L4N-2...	380 [280]	120 [89]	40	2,1 [4.62]		1,2 [0.04]	G1/4 1/4-18NPT	45	40	-	6,5	6

Model	B5b	B6	B7	B21	B23	B24	B24a	B30	B31	D1	L1	L2	L3	L6	L7	L8	L9	L17	SW	α1	α2	R1
			±0,1	~	max			±0,1			max.	max.		±0,05	+0,1	±0,1	±0,1	h9		~	~	~
82L2G-2...	4,5	7	25	62	53	60,5	53,5	44	15	M5	183,5	104,5	67	17	28	5	18	8,5	9	36°	131°	117
82L3G-2... 82L3N-2...	4,5	7	20	62	60	76,5	63,5	51	21	M5	210	119	83	25	36	8	20	12,5	11	31°	124°	117
82L4G-2... 82L4N-2...	4,5	10	25	62	74	88	69,5	57	26,5	M6	241	137	92	30	40	10	20	16	16	31°	131°	117

82L2G-2, 82L3.-2, 82L4.-2 SERIES

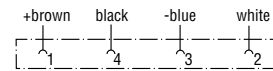
Pneumatic Power Clamps | Technical Specifications



Wiring diagram of electrical sensing system
Sensing system immune to interference from d.c. arc welding and a.c. arc welding

Inductive version: B8, B7, C8

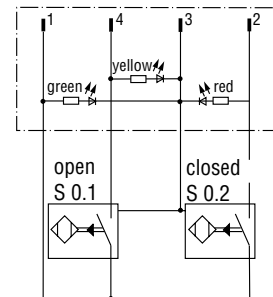
Pin Assignment



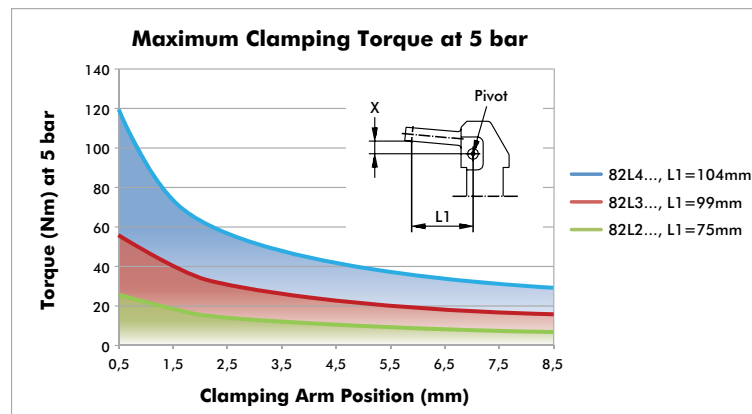
Plug M8x1



Plug M12x1



ATTENTION:
Calculation tool available. Please consult factory.



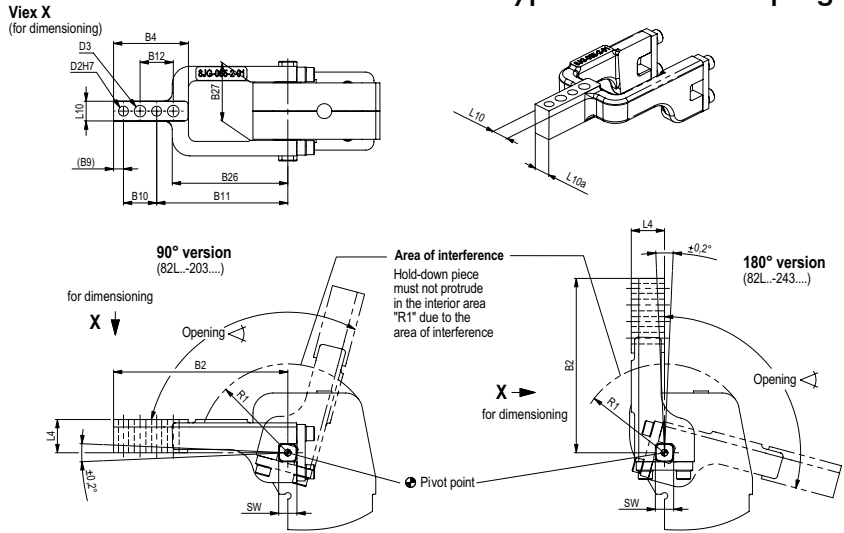
All data refers to a pneumatic pressure of 6 bar and to a opening and closing time of 1 second, as well as to the center of gravity of the complete construction directly attached to the clamp arm related to the fixed fulcrum.

82L2G-2, 82L3.-2, 82L4.-2 SERIES

Pneumatic Power Clamps | Dimensions | Technical Specifications

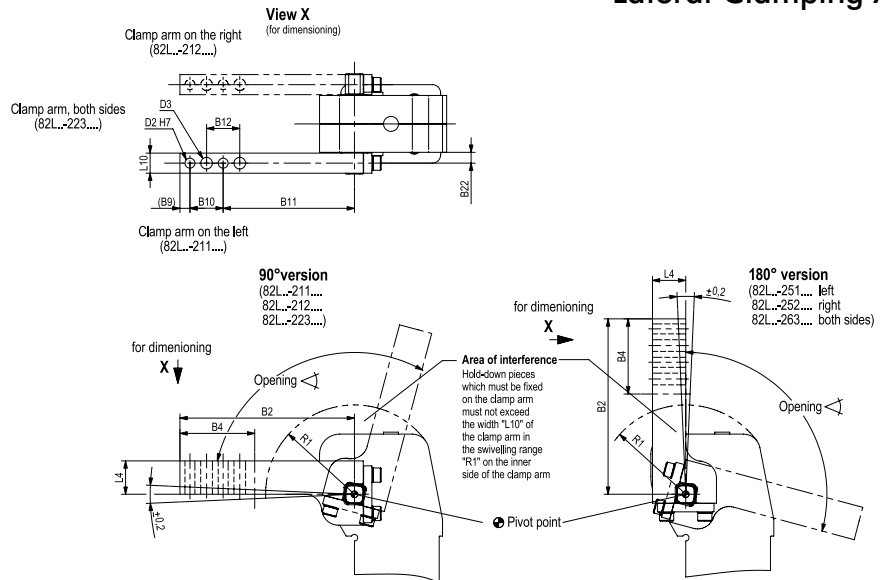
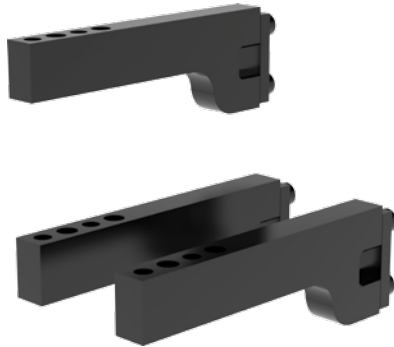


U-Type Central Clamping Arms



Model	Order no. for set of U-type central clamping arms	Opening angle for 90° Version	Opening angle for 180° Version	Weight [kg]	B2	B4	B9	B10	B11	B12	B26	B27	D2	D3	L4	L10	L10α	R1	SW J7
		max.	max.												H7		±0,1	*±1,1	~
82L2G-2...	8JG-075-3-01	105°	105°	0,3	93	45	8	20	65	20	58	36	4	6,5	20	12	-	45	9
82L3.-2...	8JG-065-2-01	105°	105°	0,37	105	45	6	20	79	20	69	35,1	6	7	20	12*	11,4	55	11
82L4.-2...	8JG-067-2-01	105°	105°	0,5	110	45	6	20	84	20	78	42,1	6	7	22	15*	14,3	58	16

Lateral Clamping Arms

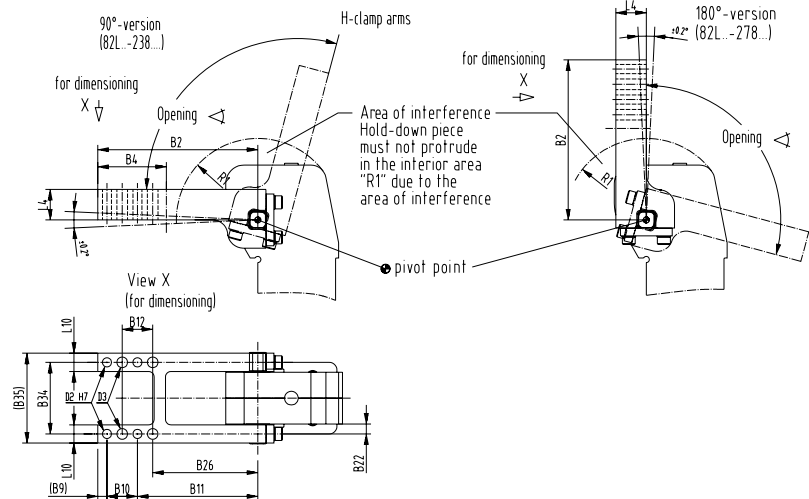
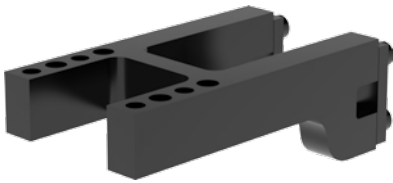


Model	Order no. for set of Lateral clamping arms	Opening angle for 90° - Version	Opening angle for 180° - Version	Weight [kg]	B2	B4	B9	B10	B11	B12	B22	D2	D3	L4	L10	R1
		max.	max.										H7		±0,1	~
82L3.-2...	8JG-066-1-01	105°	105°	0,25	105	45	6	20	79	20	6,5	6	7	20	12	55
82L4.-2...	8JG-068-1-01	105°	105°	0,3	92	45	6	20	66	20	8,5	6	7	22	15	58

82L2G-2, 82L3.-2, 82L4.-2 SERIES

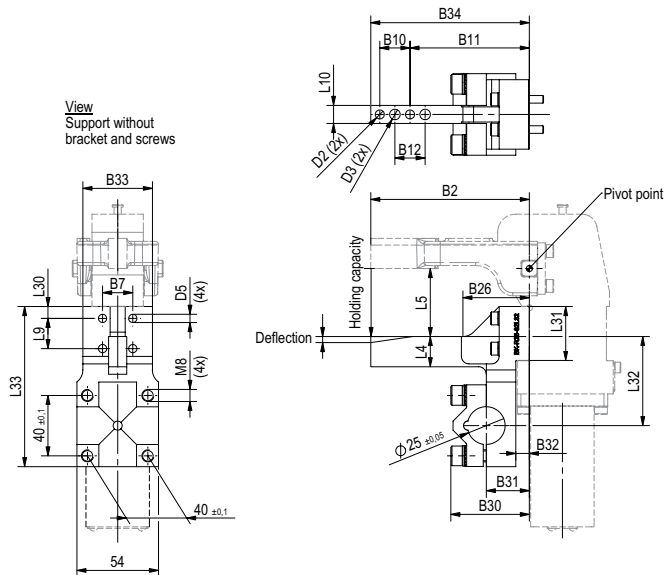
Pneumatic Power Clamps | Dimensions | Technical Specifications

H- Clamping Arms



Model	Order no. for set of H-clamping arms	Opening angle for 90° - Version	Opening angle for 180° - Version	Weight [kg]	B2	B4	B9	B10	B11	B12	B26	B34	B35	D2	D3	L4	L10	R1
		max.	max.												H7			
82L3.-2.8...	8JG-363-1-01	105°	105°	0,52	105	45	6	20	79	20	69	47,1	59,1	6	7	20	12	55
82L4.-2.8...	8JG-364-1-01	105°	105°	0,77	110	45	6	20	84	20	78	57,1	72,1	6	7	22	15	58

Counter-Support



* = Tolerance for distance to dowel holes $\pm 0,02$
 ** = distance from pivot point

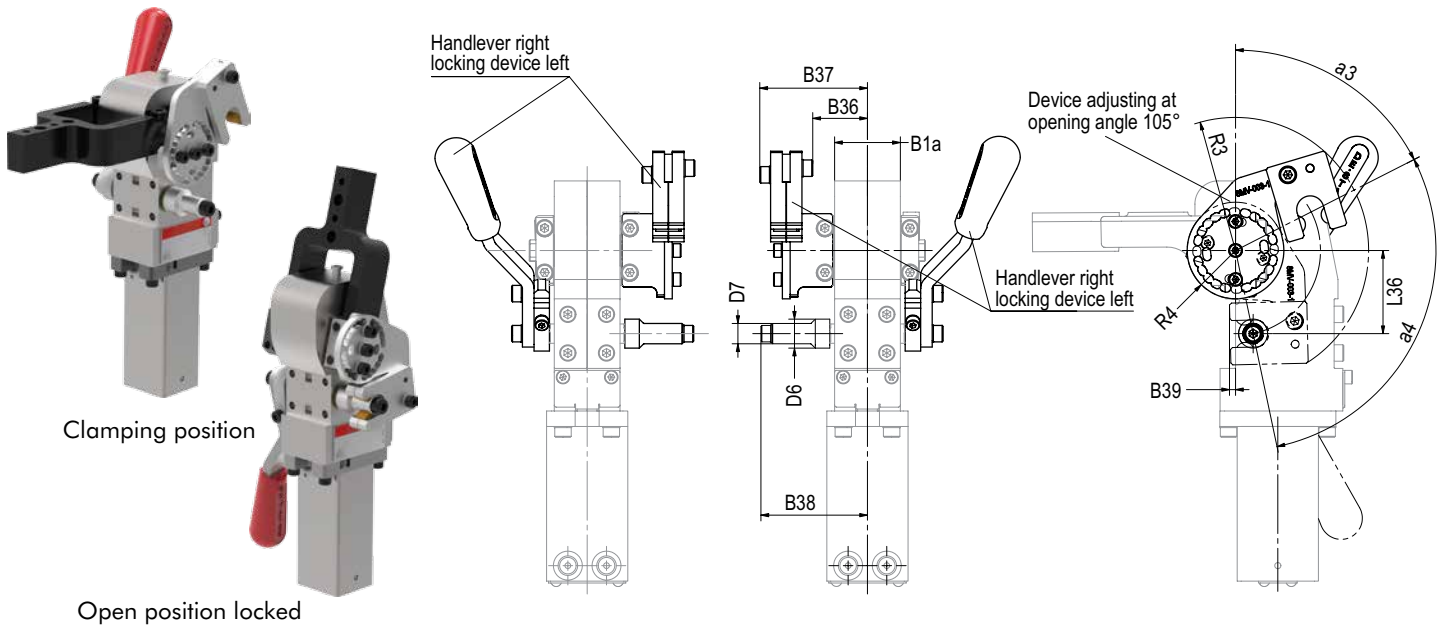
Model	Fit for Model	Holding Capacity max.	Deflection [mm]	Weight [kg]	B2	B7*	B10	B11	B12	B26**	B30**	B31**	B32**
		[N]											
BK-R25-82L25-1	82L2_	914	0,2	0,4	93	25	20	62	20	42	55	31,5	11
BK-R25-82L32-1	82L3_	660	0,16	0,5	105	20	20	79	20	44	52	28,5	9
BK-R25-82L40-1	82L4_	2000	0,37	0,56	110	25	20	84	20	41	52	28,5	7,5

Model	B33	B34	D2	D3	D5	L4	L5	L9	L10	L30	L31	L32	L33
			\varnothing H7	\varnothing	\varnothing	$\pm 0,1$		$\pm 0,1$			-0,1		
BK-R25-82L25-1	35	90	4	6,5	5,5	20	45	18	12	4,95	27,9	50,9	106
BK-R25-82L32-1	46	105	6	7	5,5	20	45	20	12	7,85	35,7	59	106
BK-R25-82L40-1	40	110	6	7	6,6	22	45	20	15	9,85	39,7	66	108

82L2G-2, 82L3.-2, 82L4.-2 SERIES

Pneumatic Power Clamps | Dimensions | Technical Specifications

Hold Open Device


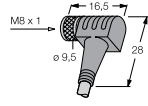

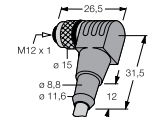



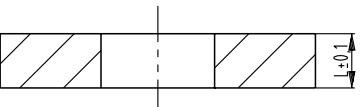
Model	Fit for Model	B1 α	B36	B37	B38	B39	D6	D7	L36	R3	R4	α 3	α 4
82ZB-036-1	82L2.-2....H..	34	25	47	47	3	15	10	31	53	18,5	63°	105°
82ZB-037-1	82L3.-2....H..	34	28	56	56	4	15	10,5	43	69	25	63°	105°
82ZB-038-1	82L4.-2....H..	40	30	58	58	3	15	10,5	50	76	27	63°	105°

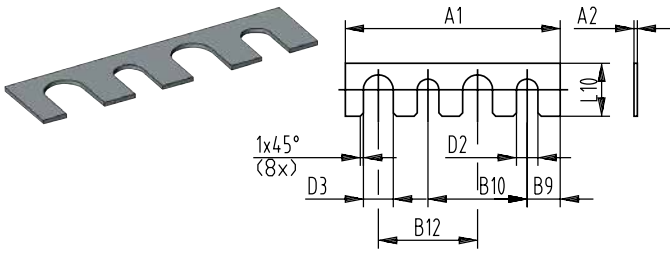
82L2G-2, 82L3.-2, 82L4.-2 ACCESSORIES

Pneumatic Power Clamps | For Use With or Without Hand Lever

Clamping Arms	Order No. for set 82L2G-2....0../ 82L2G-2....H..	Order No. for set 82L3.-2....0../ 82L3.-2....H..	Order No. for set 82L4.-2....0../ 82L4.-2....H..
U-central	8JG-075-3-01	8JG-065-2-01	8JG-067-2-01
Lateral	--	8JG-066-1-01	8JG-068-1-01
H-Shape	--	8JG-363-1-01	8JG-364-1-01

Connector cable (1 connector socket & 5 m cable)				
Connector socket M8x1 straight 4-pin		8EL-009-1	8EL-009-1	8EL-009-1
Connector socket M8x1 angular 4-pin		8EL-007-1	8EL-007-1	8EL-007-1
Connector socket M12x1 straight 5-pin		8EL-002-1	8EL-002-1	8EL-002-1
Connector socket M12x1 angular 4-pin		8EL-003-1	8EL-003-1	8EL-003-1

Opening angle limitation	Opening Angle	82L2G-2		82L3.-2		82L4.-2	
		Order No.	L ± 0,1	Order No.	L ± 0,1	Order No.	L ± 0,1
 	15°	8CE-282-1	28,6	8CE-296-1	33,3	8CE-310-1	38,4
	30°	8CE-284-1	22	8CE-298-1	26,9	8CE-312-1	31
	45°	8CE-286-1	18,5	8CE-300-1	21,5	8CE-314-1	24,7
	60°	8CE-288-1	14	8CE-302-1	16,3	8CE-316-1	18,6
	75°	8CE-290-1	7,9	8CE-304-1	11	8CE-318-1	11
	90°	8CE-292-1	4,7	8CE-306-1	5,5	8CE-320-1	6,2

Shim for clamping arm	Order No.	A1	A2	D2	D3	B9	B10	B12	L10
	82ZB-SH4001		0,1						
	82ZB-SH4002		0,2						
	82ZB-SH4005	42	0,5	6,5	7	6	20	20	11,8
	82ZB-SH4010		1,0						
	82ZB-SH4020		2,0						
	82ZB-SH4050		5,0						

Spare Parts	Order No. for set		Order No. for set		Order No. for set	
	82L2G-2....0..	82L2G-2....H..	82L3.-2....0..	82L3.-2....H..	82L4.-2....0..	82L4.-2....H..
Cylinder	8PW-095-2		82L3G-2 (G port): 8PW-096-2 82L3N-2 (NPT port): 8PW-102-2		82L4G-2 (G port): 8PW-097-2 82L4N-2 (NPT port): 8PW-103-2	

Sensor Kit						
B8 Connector plug, M12x1, cable			8EA-139-1			
B7 Connector plug, M12x1, parallel with cylinder			8EA-138-1			
C8 Connector plug, M8x1, parallel with cylinder			8EA-137-1			
Hand Lever	--	8KB-031-1	--	8KB-031-1	--	8KB-032-1

82M-3E SERIES

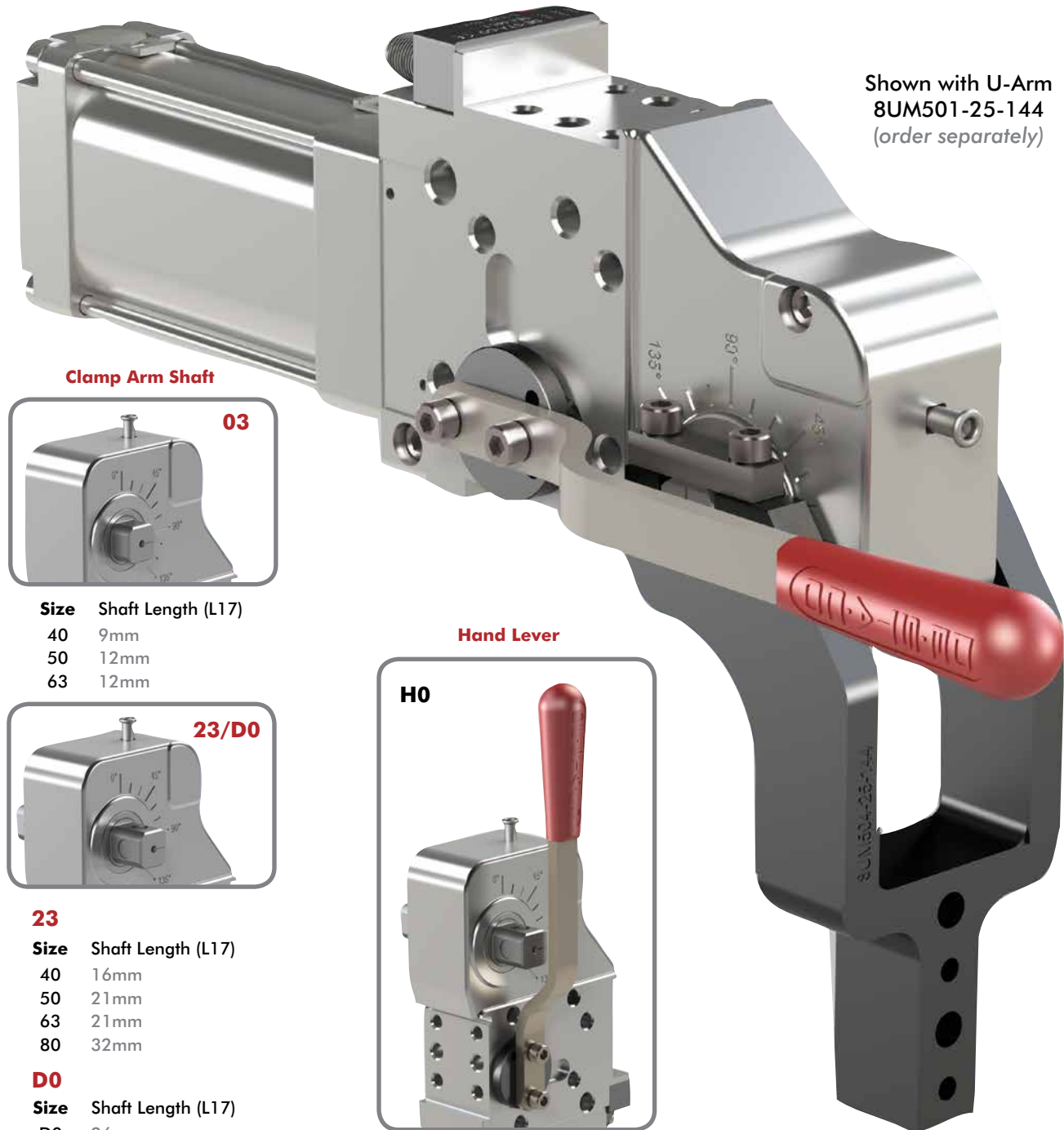
Pneumatic Power Clamps | Ordering Information

82M-3 **E** **23** **H0** **50** **L8**

Base Model	Mounting	Description	Clamp Arm Shaft	Description	Handle	Description
	E	Standard	03	for U-Arms	00	No Hand lever
	N	NAAMS (Size 63 only)	23	for Lateral Arms	H0	Hand Lever
			D0	for Lateral Arms (size 63 only)		

See below for further details

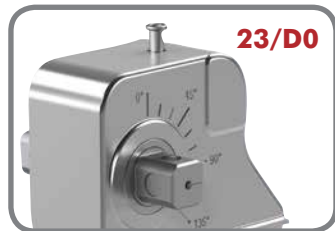
Shown with U-Arm
8UM501-25-144
(order separately)



Clamp Arm Shaft



Size	Shaft Length (L17)
40	9mm
50	12mm
63	12mm



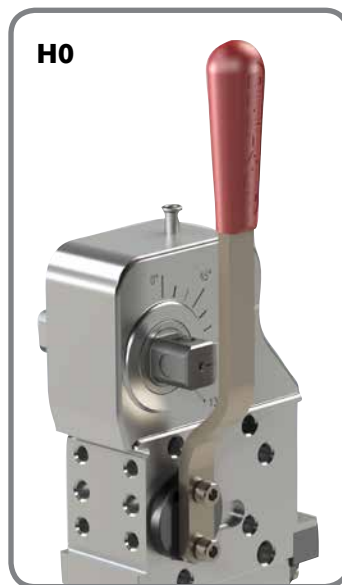
23

Size	Shaft Length (L17)
40	16mm
50	21mm
63	21mm
80	32mm

D0

Size	Shaft Length (L17)
D0	26mm

Hand Lever



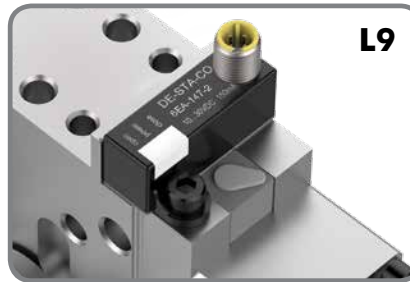
82M-3E SERIES

Pneumatic Power Clamps | Ordering Information

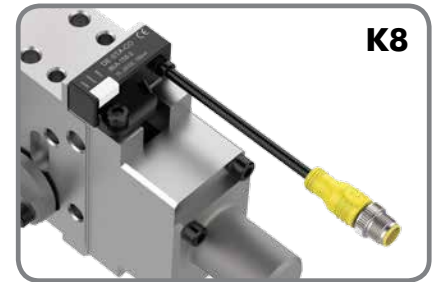
Sensor	Description
00	No sensor
L8	Sensor with In-line Connector (Replacement Order No.: 8EA-146-4)
L9	Sensor with 90 deg Connection (Replacement Order No.: 8EA-147-4)
K8	Sensor with Cable Connection (Replacement Order No.: 8EA-158-4)



L8



L9



K8

Size	Description
40	40mm Cylinder Bore Size with G Port
50	50mm Cylinder Bore Size with G Port
5N	50mm Cylinder Bore Size with NPT
63	63mm Cylinder Bore Size with G Port
6N	63mm Cylinder Bore Size with NPT
80	80mm Cylinder Bore Size with G Port
8N	80mm Cylinder Bore Size with NPT



40

Max Holding Torque
380 Nm
Max Clamping Torque
120 Nm at 5bar



50

Max Holding Torque
1300 Nm
Max Clamping Torque
270 Nm at 5bar



63

Max Holding Torque
1800 Nm
Max Clamping Torque
420 Nm at 5bar



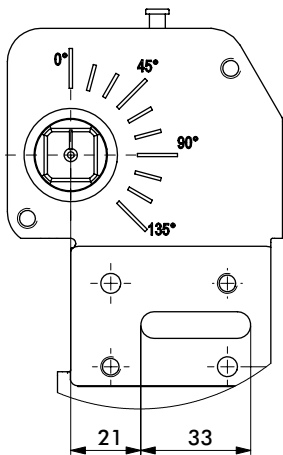
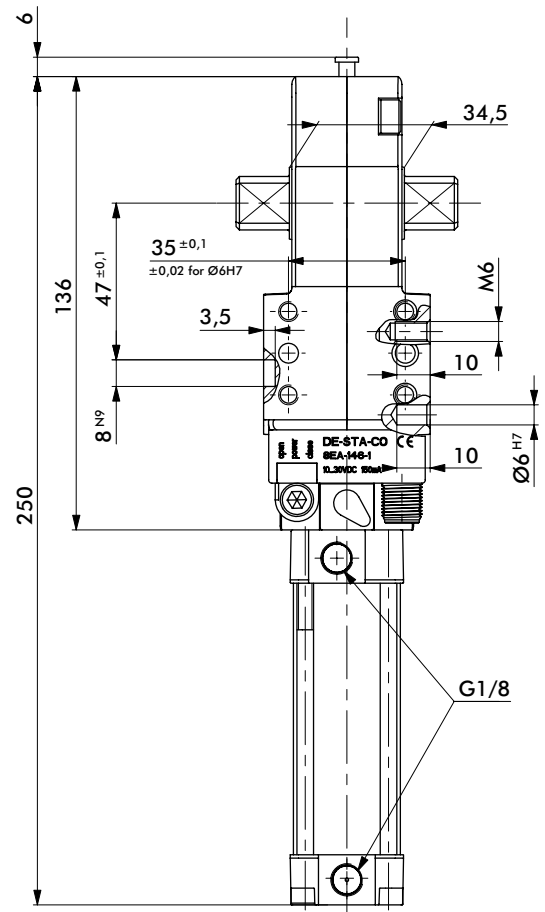
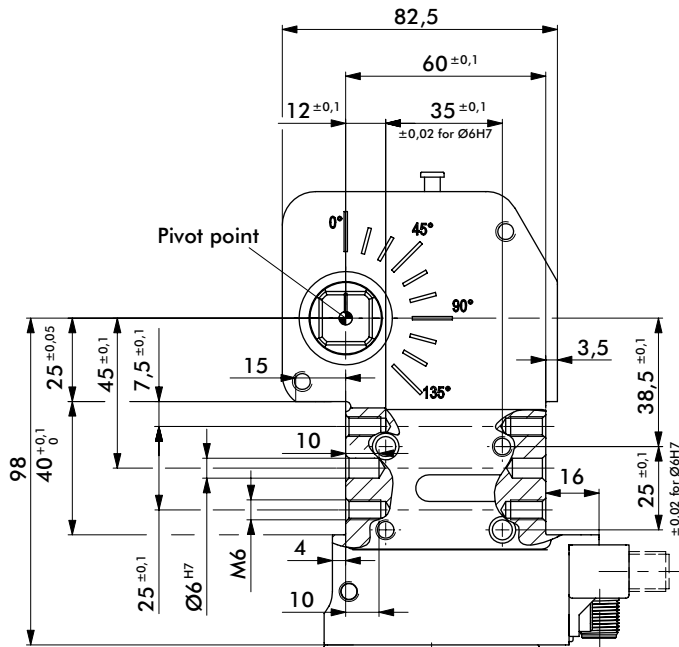
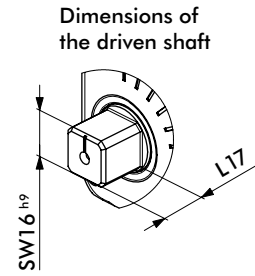
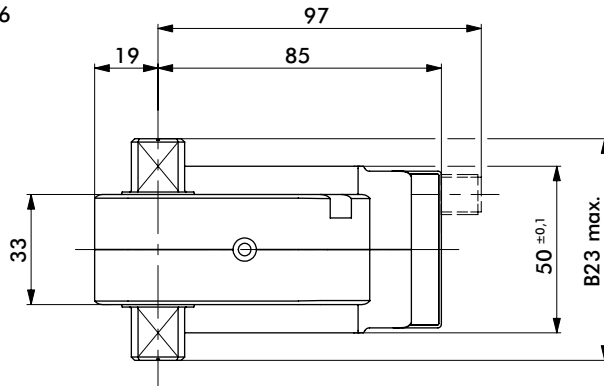
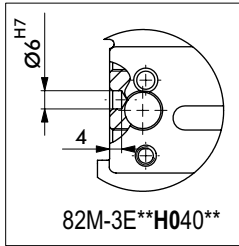
80

Max Holding Torque
3000 Nm
Max Clamping Torque
850 Nm at 5bar

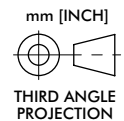
82M-3E...40 SERIES

Pneumatic Power Clamps | Dimensions

Model	B23 Max.	L17
82M-3E03..40..	54,5	9
82M-3E23..40..	66,5	16



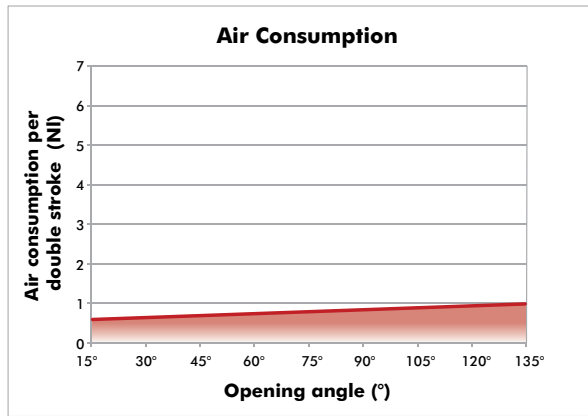
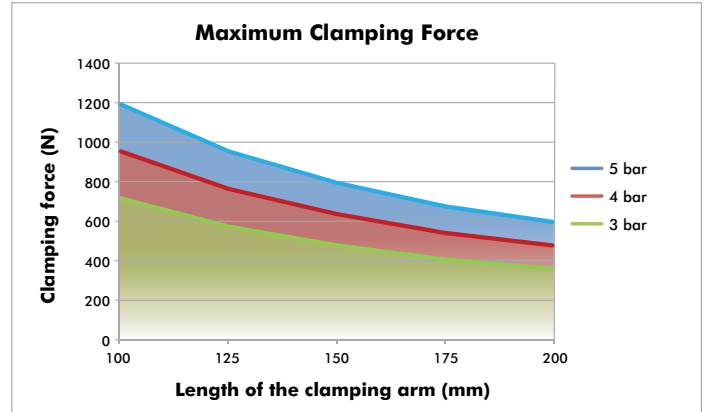
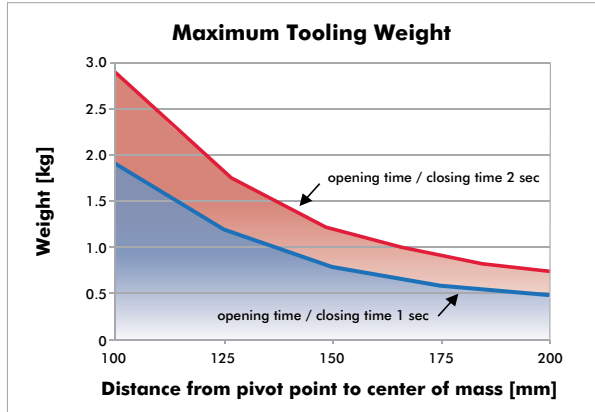
Power by compressed air, max. 6 bar operation with oil-free air is permissible.
The connector socket and the cable are not supplied with the unit.



82M-3E....40 SERIES

Pneumatic Power Clamps | Technical Specifications

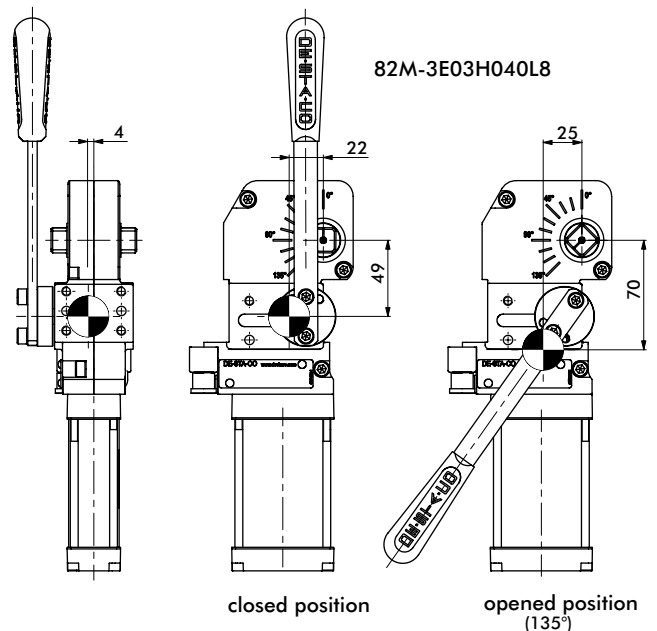
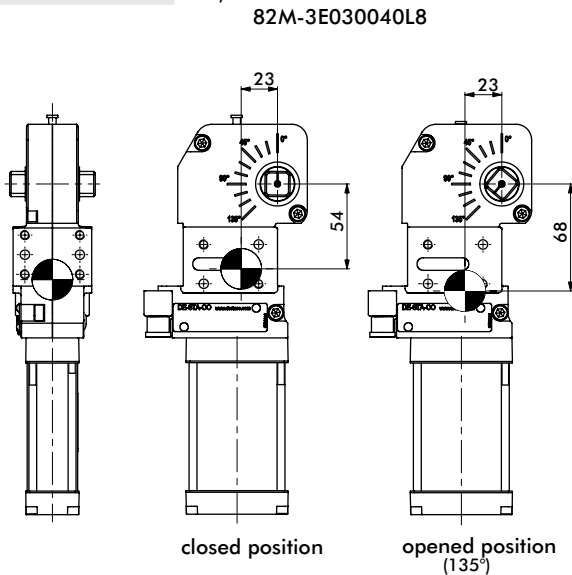
Model	Max. Holding Torque (Nm)	Clamping Torque at 5 bar (Nm)	Cylinder Ø (mm)	Weight (kg)	Air Consumption per double stroke at 5 bar (liter)
82M-3E....40..	380	120	40	1,5	0,9



ATTENTION:
Calculation tool available. Please consult factory.

Center of Mass

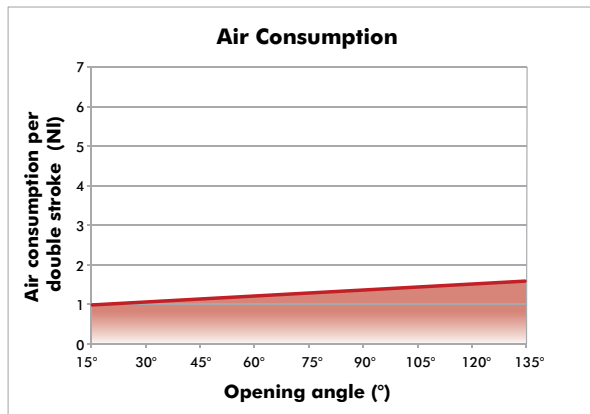
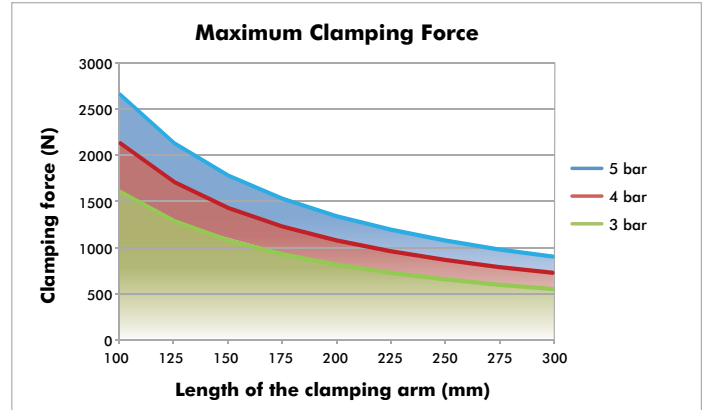
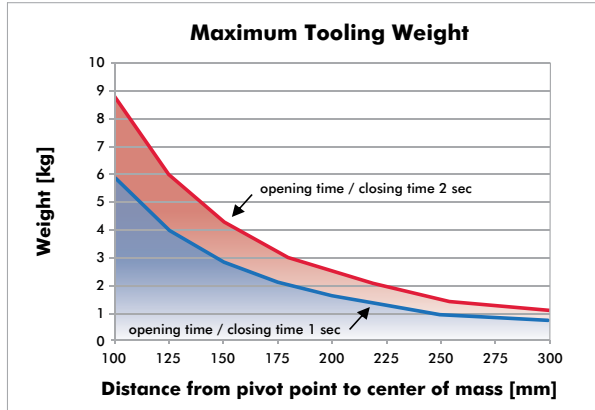
Model	Weight (kg)
82M-3E030040L.	1,5
82M-3E03H040L.	1,6



82M-3E....5. SERIES

Pneumatic Power Clamps | Technical Specifications

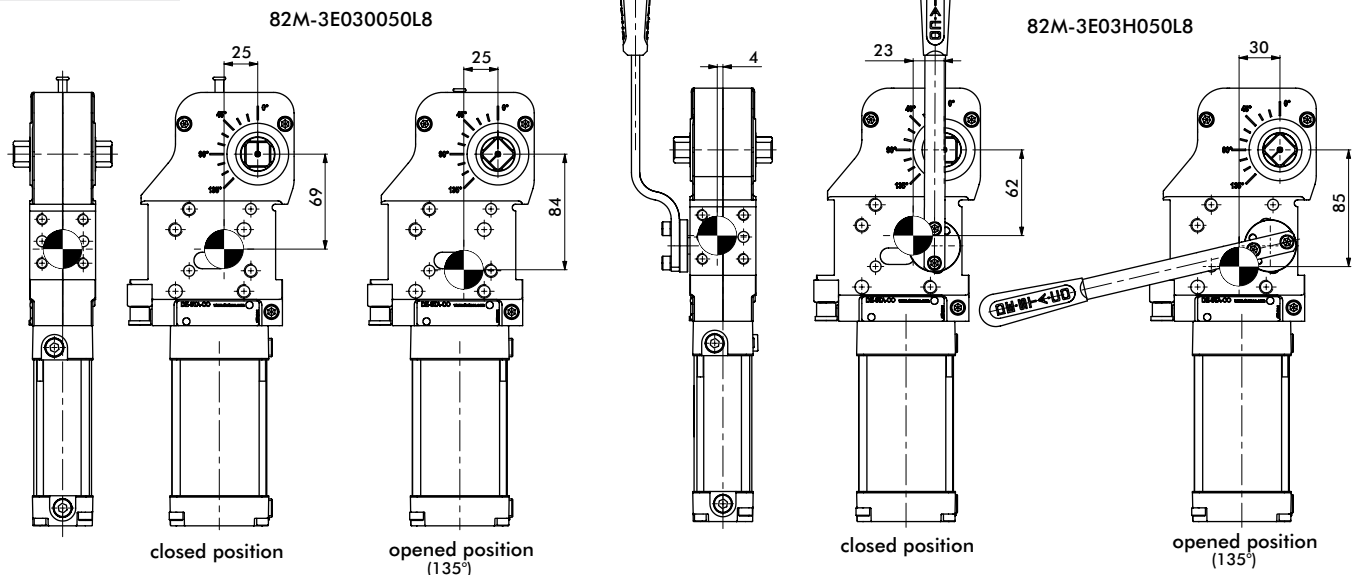
Model	Connection (C)	Max. Holding Torque (Nm)	Clamping Torque at 5 bar (Nm)	Cylinder Ø (mm)	Weight (kg)	Air Consumption per double stroke at 5 bar (liter)
82M-3E....50..	G 1/4	1300	270	50	2,8	1,6
82M-3E....5N..	1/4-18 NPT					



ATTENTION:
Calculation tool available. Please consult factory.

Center of Mass

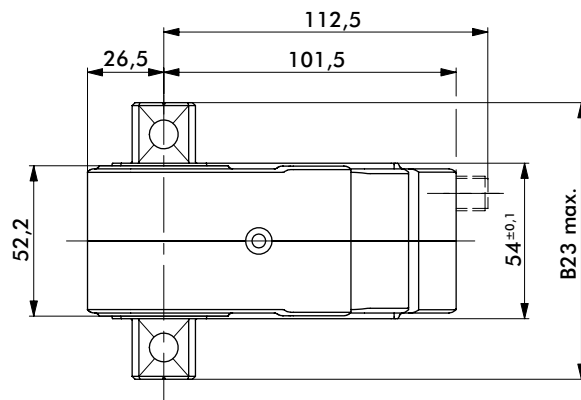
Model	Weight (kg)
82M-3E030050L.	2,8
82M-3E03H050L.	3,1



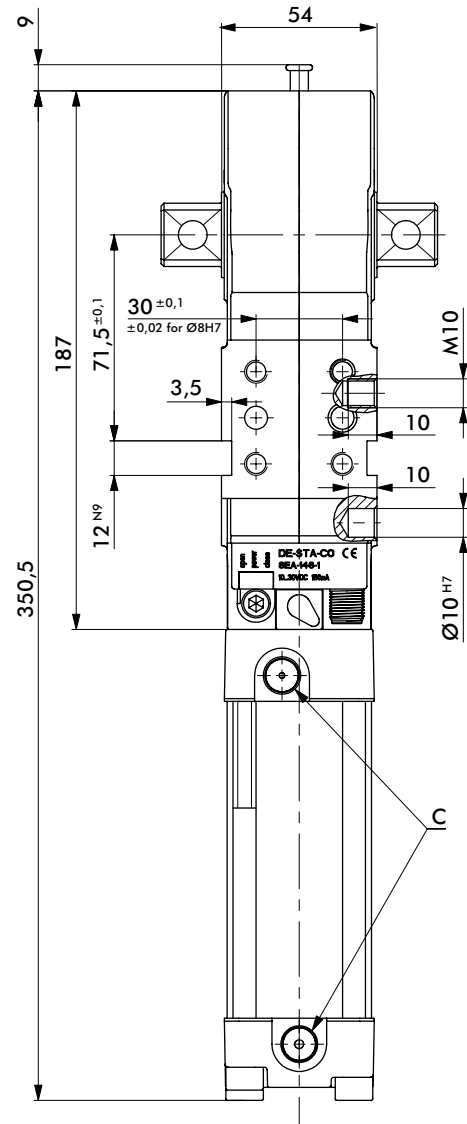
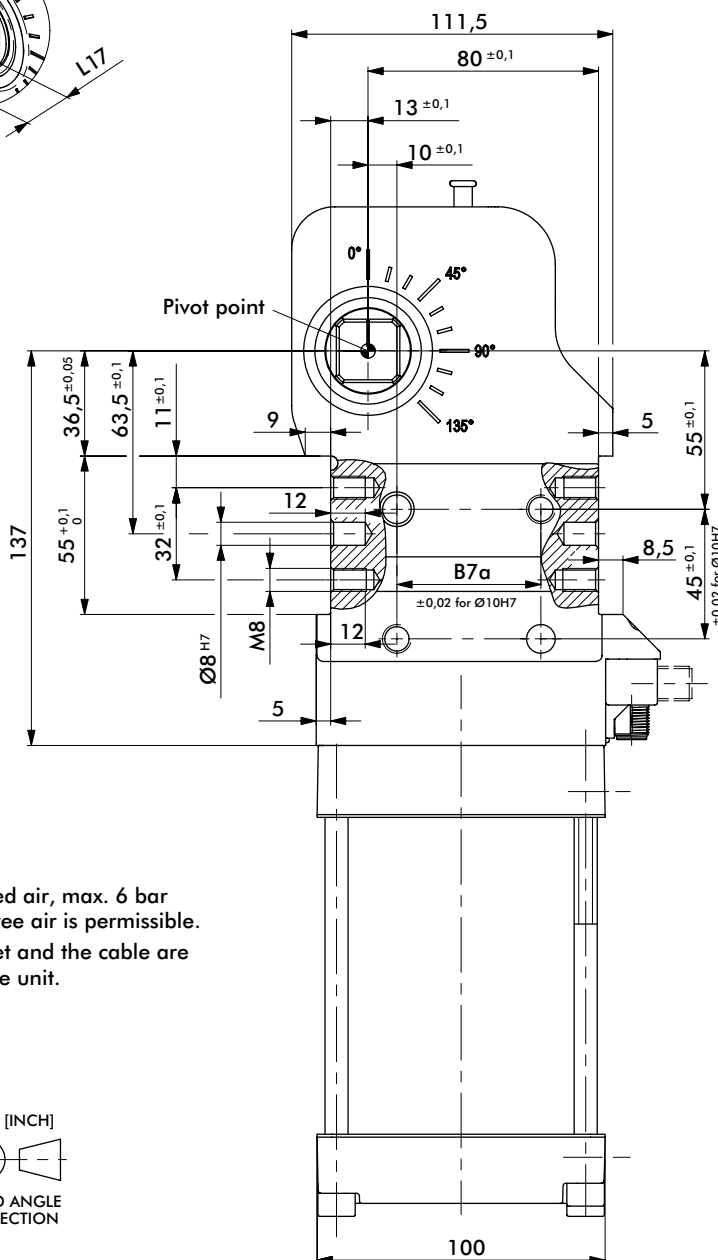
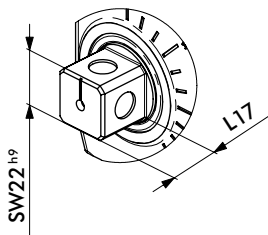
82M-3.....6. SERIES

Pneumatic Power Clamps | Dimensions

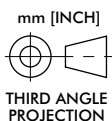
Model	B7a ±0,1	B23 Max.	L17
82M-3E03..6...	50	78	12
82M-3N03..6...	55	96	21
82M-3E23..6...	50	106	26
82M-3N23..6...	55		



Dimensions of the driven shaft



Power by compressed air, max. 6 bar operation with oil-free air is permissible. The connector socket and the cable are not supplied with the unit.

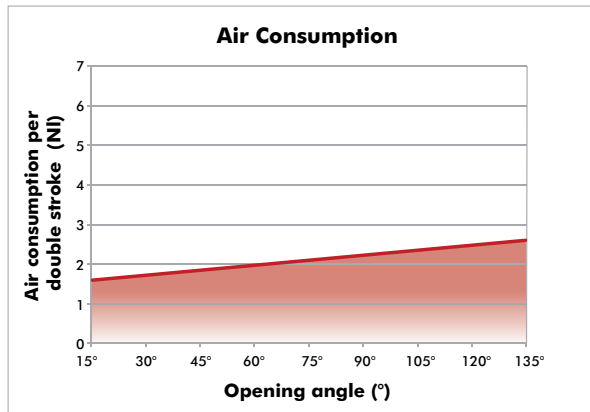
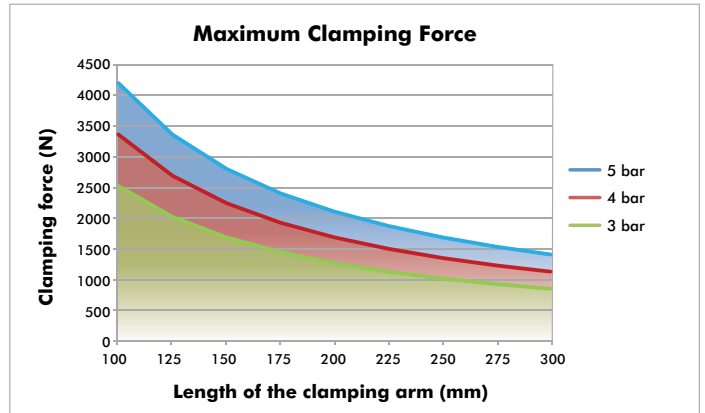
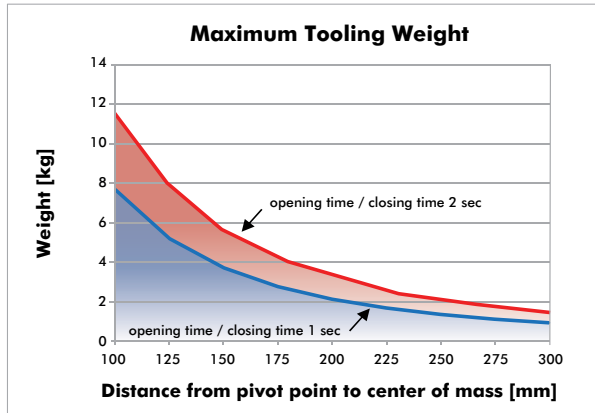


Important !
For optimal cushioning external pneumatic one-way, flow control valves should be used.

82M-3.....6. SERIES

Pneumatic Power Clamps | Technical Specifications

Model	Connection (C)	Max. Holding Torque (Nm)	Clamping Torque at 5 bar (Nm)	Cylinder Ø (mm)	Weight (kg)	Air Consumption per double stroke at 5 bar (liter)
82M-3E....63..	G 1/4	1800	420	63	3,8	2,6
82M-3N....63..						
82M-3E....6N..	1/4-18 NPT	1800	420	63	3,8	2,6
82M-3N....6N..						

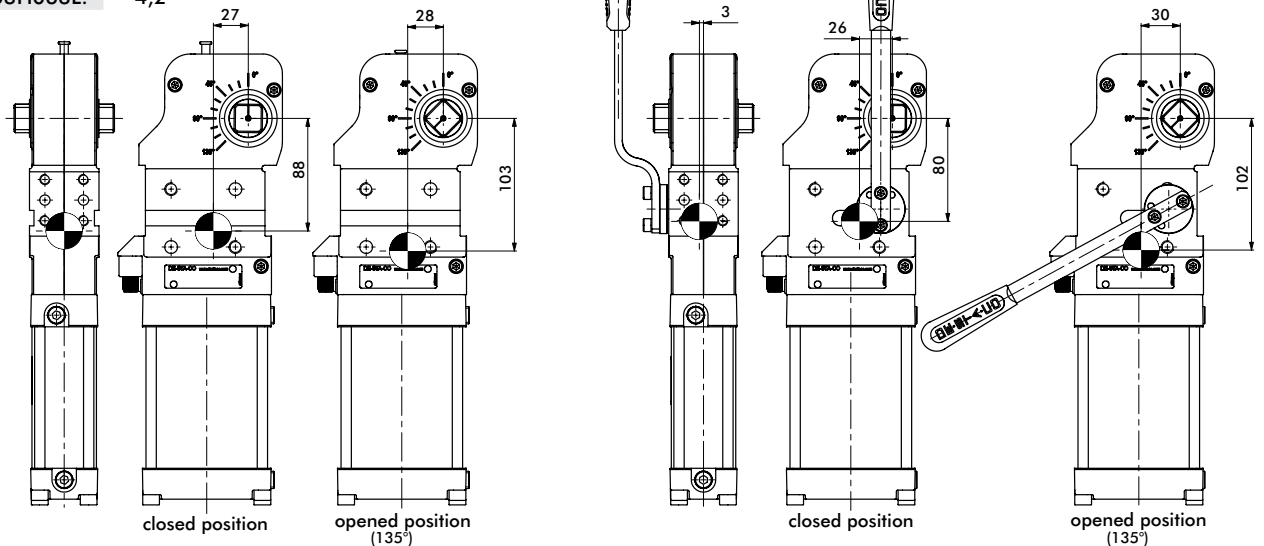


ATTENTION:
Calculation tool available. Please consult factory.

Model	Weight (kg)
82M-3E030063L.	3,8
82M-3E03H063L.	4,2

82M-3E030063L8

82M-3E03H063L8

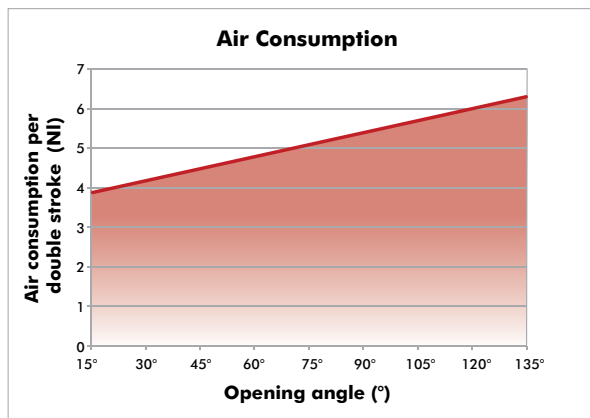
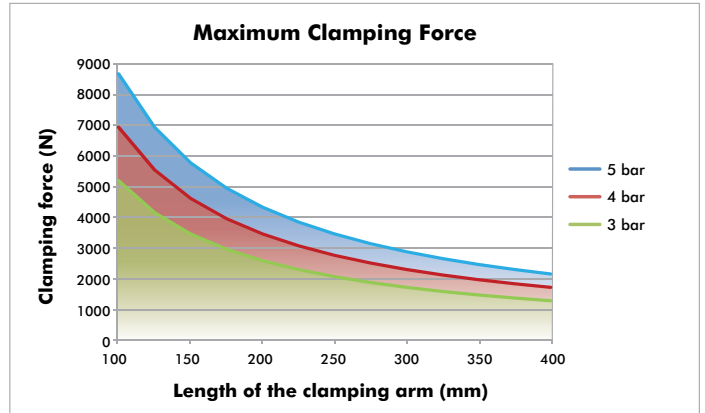
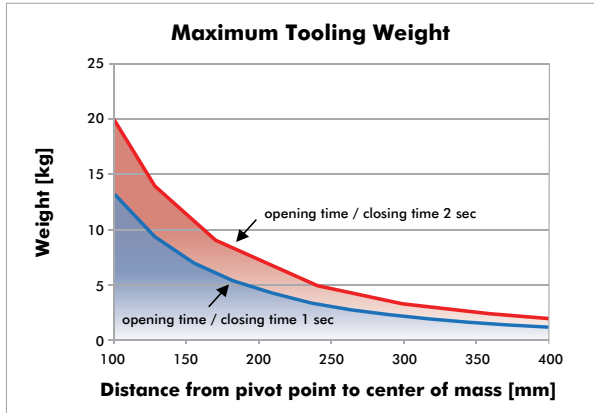


Center of Mass

82M-3E....8. SERIES

Pneumatic Power Clamps | Technical Specifications

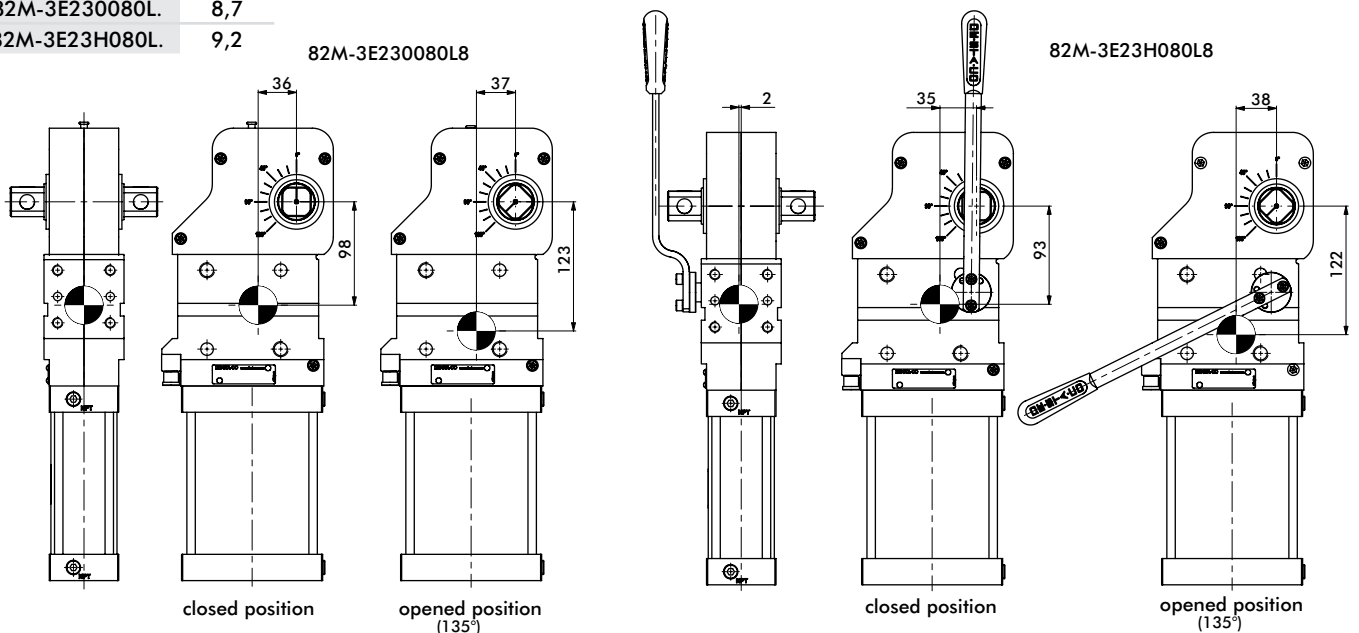
Model	Connection (C)	Max. Holding Torque (Nm)	Clamping Torque at 5 bar (Nm)	Cylinder Ø (mm)	Weight (kg)	Air Consumption per double stroke at 5 bar (liter)
82M-3E....80..	G 1/4	3000	850	80	8,7	6,3
82M-3E....8N..	1/4-18 NPT					



ATTENTION:
Calculation tool available. Please consult factory.

Center of Mass

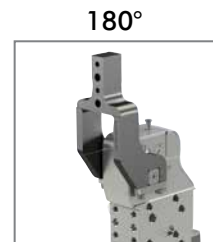
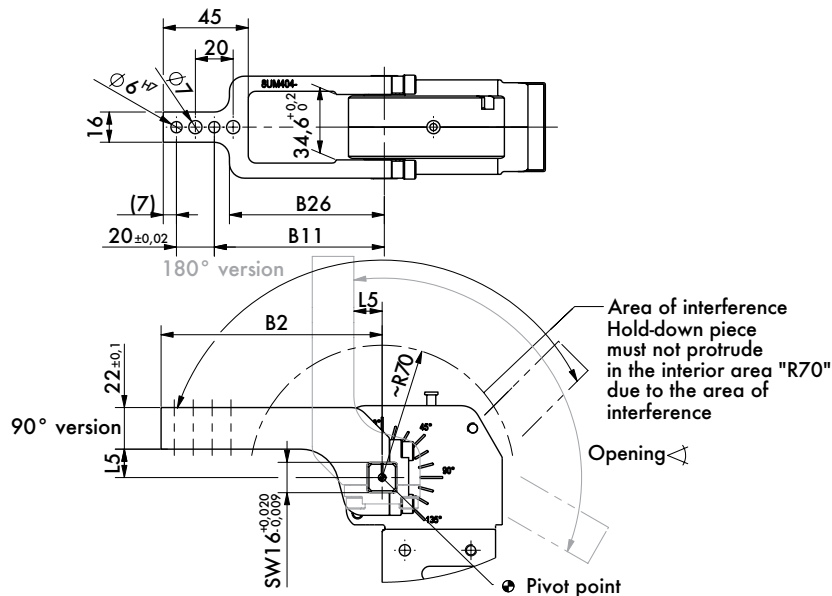
Model	Weight (kg)
82M-3E230080L.	8,7
82M-3E23H080L.	9,2



U-ARMS CENTER (ALUMINUM)

Pneumatic Power Clamps | Dimensions | Technical Specifications

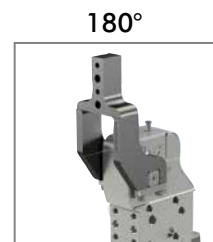
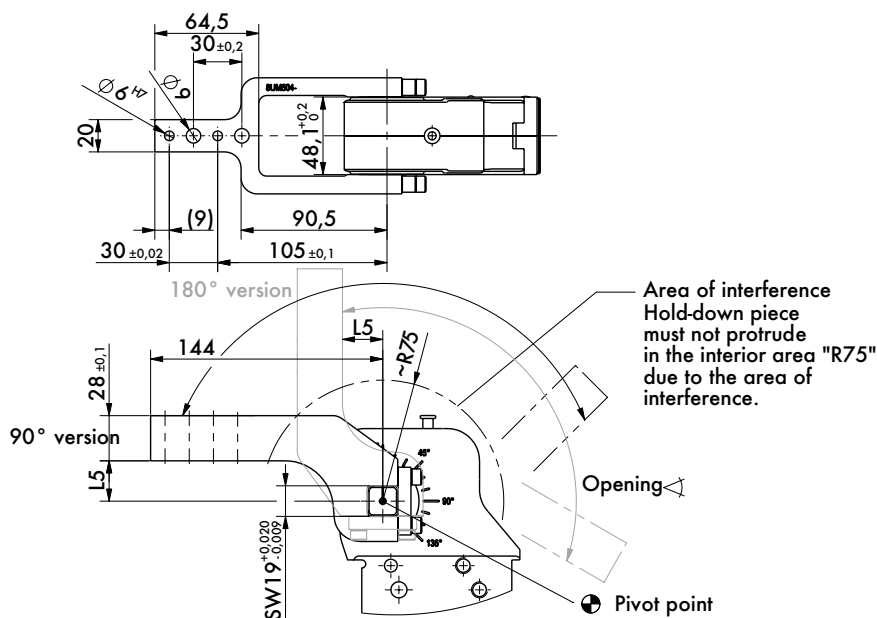
82M-3E....40..



8UM404-00-117
8UM404-15-117
8UM404-25-117
8UM404-45-107

Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	B2	B11 ±0,1	B26	L5
8UM404-00-117		105°	0,23				0
8UM404-15-117	135°	120°	0,24	117	90	82	15
8UM404-25-117			0,25				25
8UM404-45-107	130°	135°	0,24	107	80	72	45

82M-3E....5...



8UM504-15-144
8UM504-25-144
8UM504-45-144

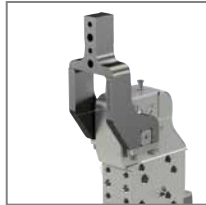
Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	L5
8UM504-15-144		105°	0,44	15
8UM504-25-144	135°	120°	0,45	25
8UM504-45-144		135°	0,48	45

U-ARMS CENTER (ALUMINUM)

Pneumatic Power Clamps | Dimensions | Technical Specifications

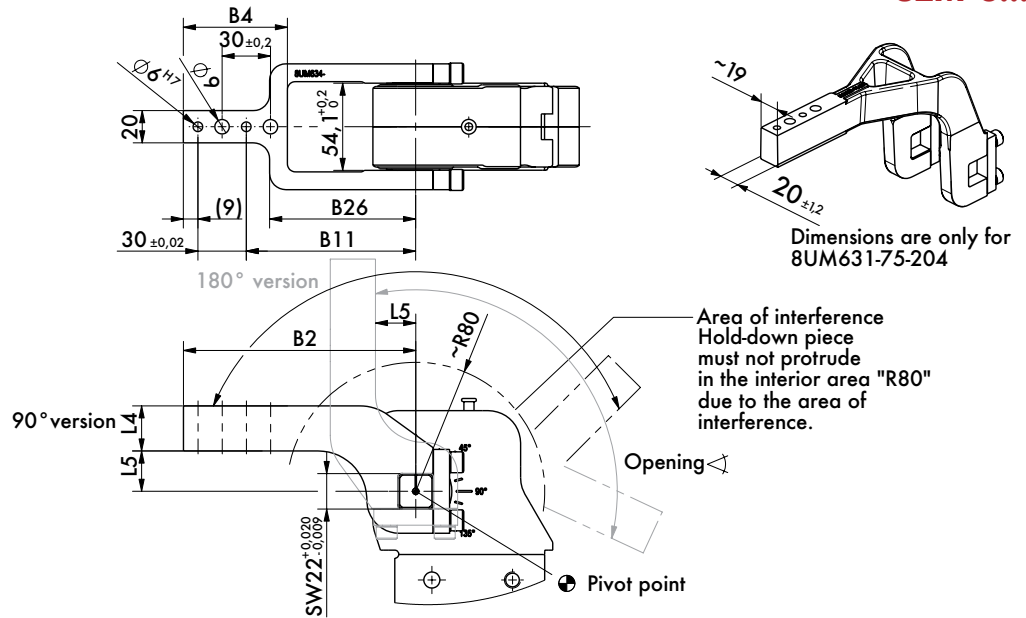


180°



8UM634-15-144
8UM634-25-144
8UM634-45-144
8UM631-75-204

82M-3...6...



Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	B2	B4	B11 ±0,1	B26	L4 ±0,1	L5
8UM634-15-144	135°	105°	0,50						15
8UM634-25-144		120°	0,53	144	64,5	105	90,5	28	25
8UM634-45-144		135°	0,56						45
8UM631-75-204*		135°	1,7	204	82	165	107	30	75

* only steel version available.

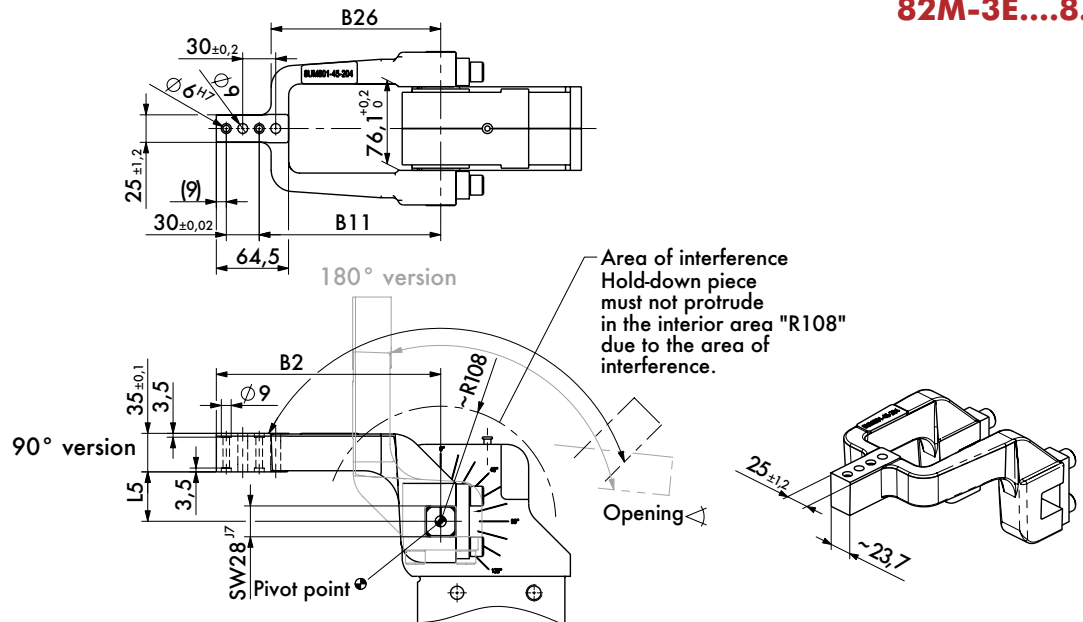


180°



8JG-169-2-01
8UM801-45-204

82M-3E...8...



Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	B2	B11 ±0,1	B26	L5** ±0,2
8JG-169-2-01	135°	105°	3,5	179	140	129	20
8UM801-45-204*		135°	4,1	204	165	154	45

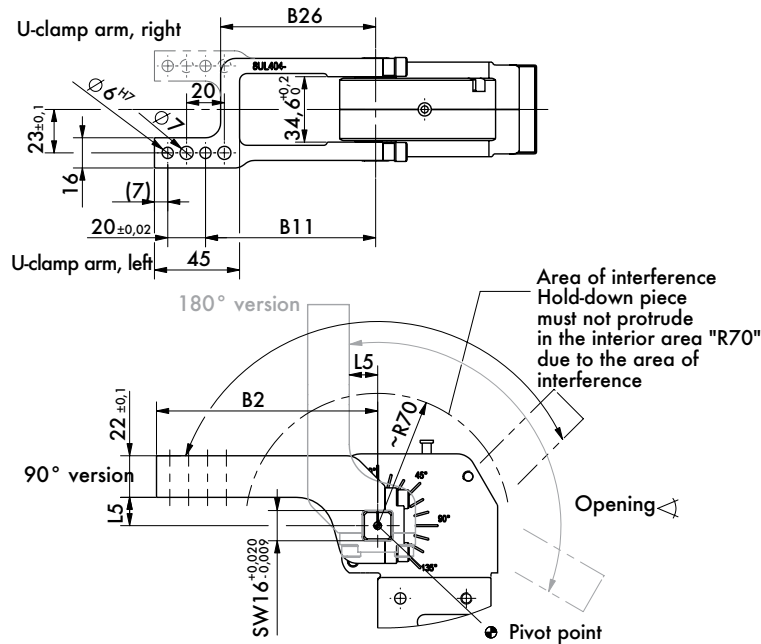
*only steel version available.

** Tolerance measured 80mm from pivot point.

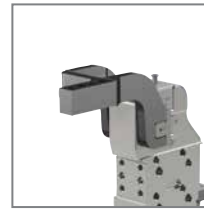
U-ARMS OFFSET (ALUMINUM)

Pneumatic Power Clamps | Dimensions | Technical Specifications

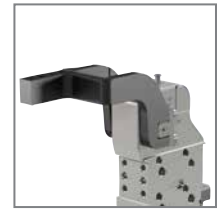
82M-3E...40..



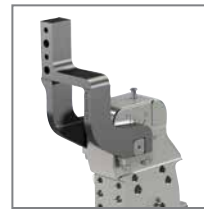
90° Left



90° Right



180° Right*



180° Left*



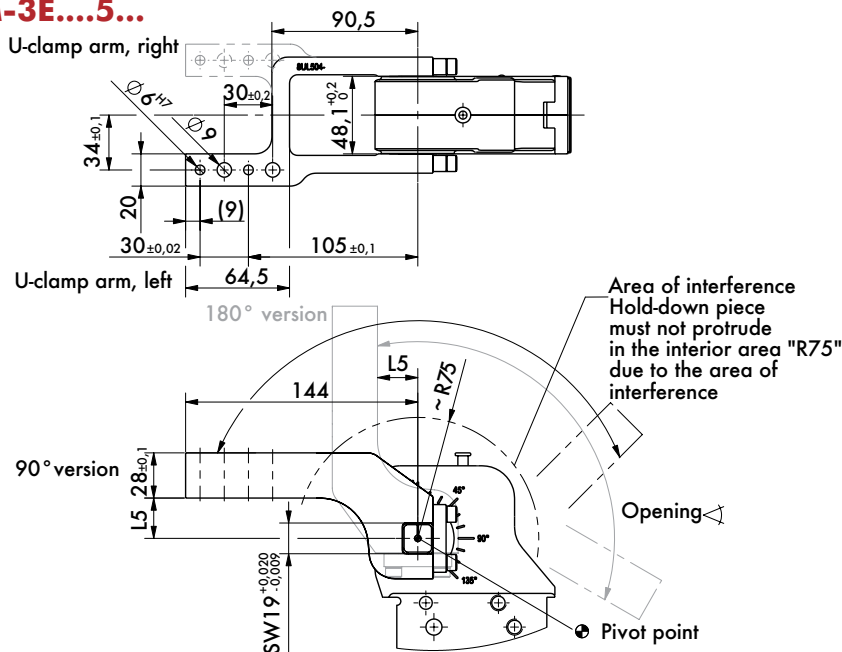
8UL404-00-117
8UL404-15-117
8UL404-25-117
8UL404-45-107

8UR404-00-117
8UR404-15-117
8UR404-25-117
8UR404-45-107

*90° left/180° right uses same clamp arm.
90° right/180° left uses same clamp arm.

Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	B2	B11 ±0,1	B26	L5
8U(•)404-00-117		105°	0,23				0
8U(•)404-15-117	135°	120°	0,24	117	90	82	15
8U(•)404-25-117		135°	0,25				25
8U(•)404-45-107	130°		0,25	107	80	72	45

82M-3E...5...



90° Left



90° Right



180° Right*



180° Left*



8UL504-15-144
8UL504-25-144
8UL504-45-144

8UR504-15-144
8UR504-25-144
8UR504-45-144

*90° left/180° right uses same clamp arm.
90° right/180° left uses same clamp arm.

Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	L5
8U(•)504-15-144		105°	0,45	15
8U(•)504-25-144	135°	120°	0,46	25
8U(•)504-45-144		135°	0,49	45

U-ARMS OFFSET (ALUMINUM)

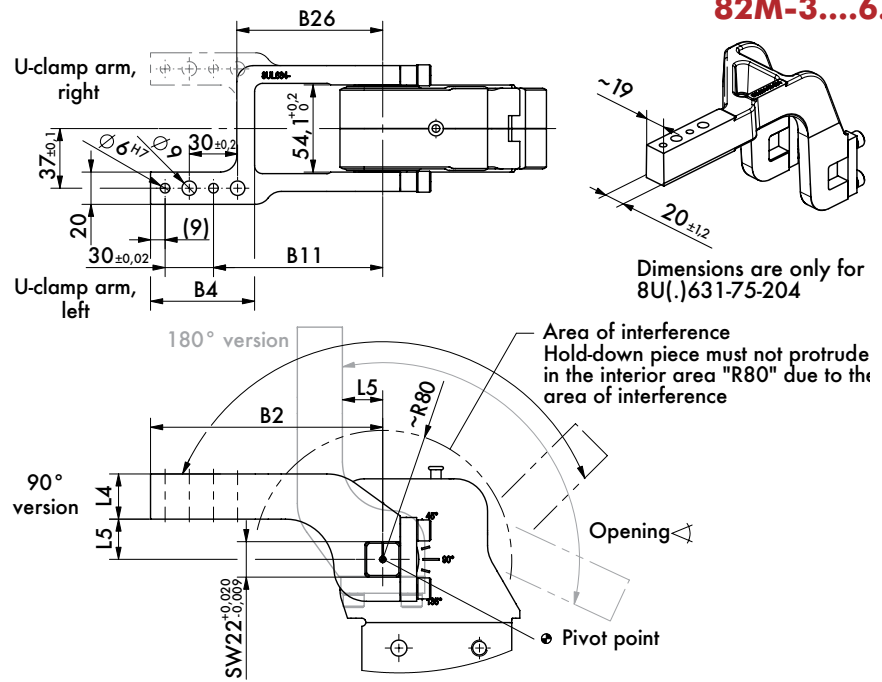
Pneumatic Power Clamps | Dimensions | Technical Specifications



8UL634-15-144
8UL634-25-144
8UL634-45-144
8UL631-75-204**

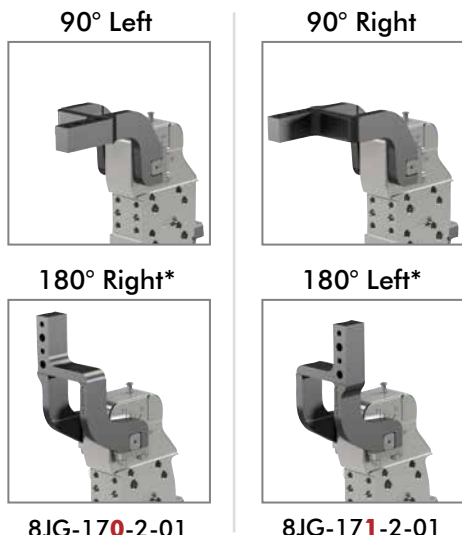
8UR634-15-144
8UR634-25-144
8UR634-45-144
****8UR631-75-204**

*90° left/180° right uses same clamp arm.
 90° right/180° left uses same clamp arm.



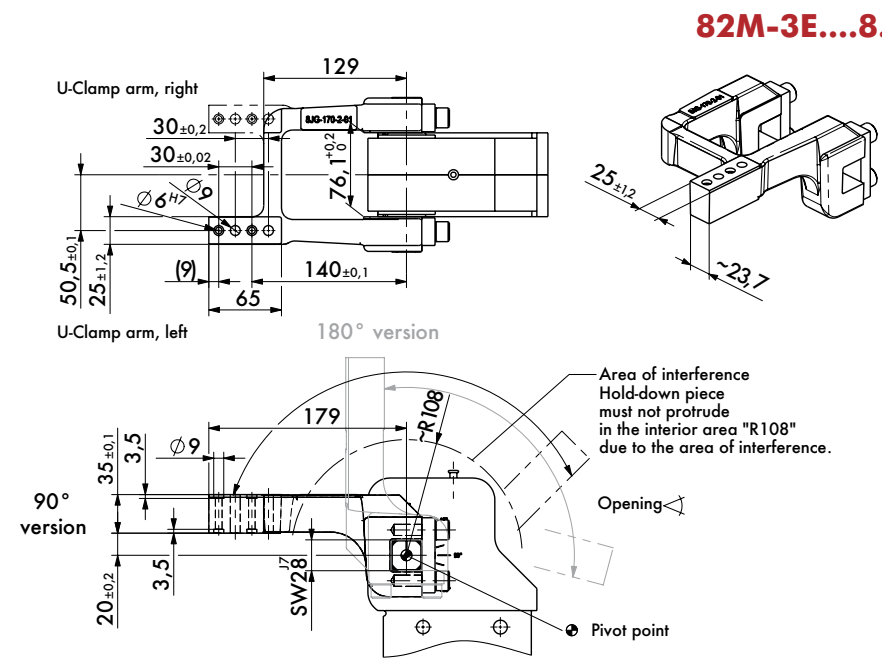
Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	B2	B4	B11 ±0,1	B26	L4 ±0,1	L5
8U(.)634-15-144	135°	105°	0,52	144	64,5	105	90,5	28	15
8U(.)634-25-144		120°	0,54						25
8U(.)634-45-144		135°	0,58						45
8U(.)631-75-204**			1,9						204

** only steel version available.



8JG-170-2-01
8JG-171-2-01

*90° left/180° right uses same clamp arm.
 90° right/180° left uses same clamp arm.



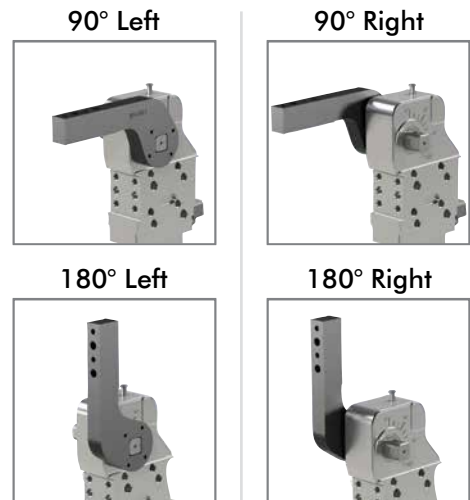
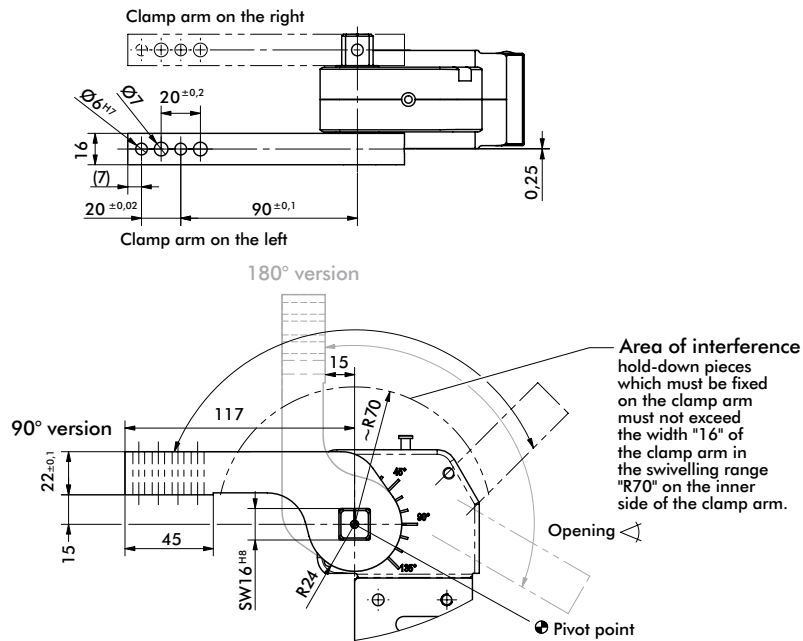
Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)
8JG-17(.)2-01**	135°	105°	3,5

**only steel version available.

LATERAL (SIDE) ARMS

Pneumatic Power Clamps | Dimensions | Technical Specifications

82M-3E....40..

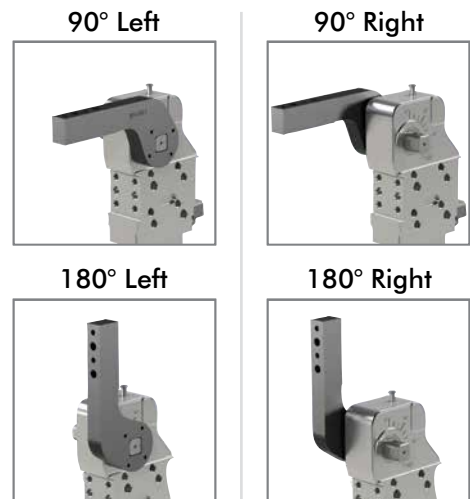
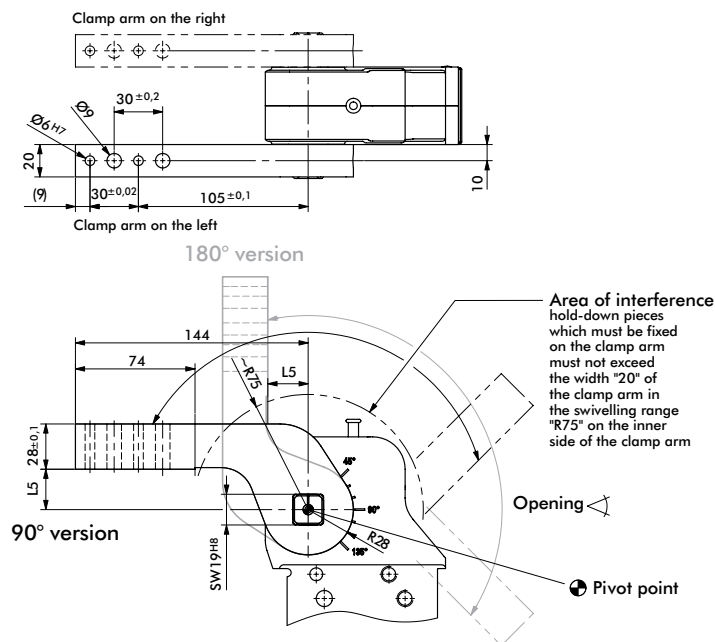


8S401-15-117

Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)
8S401-15-117	135°	120°	0,5

Models with 2 lateral clamp arms requires 2 clamp arm sets.

82M-3E....5...



8JG-070-1-01
8S501-25-144

Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	L5
8JG-070-1-01	135°	135°	0,9	15
8S501-25-144			1,0	25

Models with 2 lateral clamp arms requires 2 clamp arm sets.

LATERAL (SIDE) ARMS

Pneumatic Power Clamps | Dimensions | Technical Specifications

82M-3...6...

90° Left



90° Right



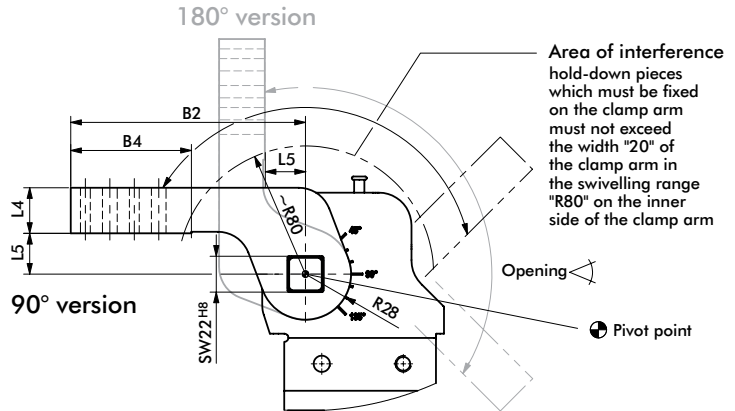
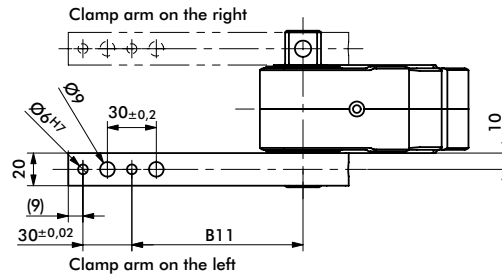
180° Left



180° Right



8JG-080-1-01
8S631-25-144
8S631-45-144
8S631-75-204



Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	B2	B4	B11 ±0,1	L4 ±0,1	L5
8JG-080-1-01	135°	135°	0,9	144	74	105	28	15
8S631-25-144			1,0					25
8S631-45-144			1,1					45
8S631-75-204			1,5					75

Models with 2 lateral clamp arms requires 2 clamp arm sets.

82M-3E...8...

90° Left



90° Right



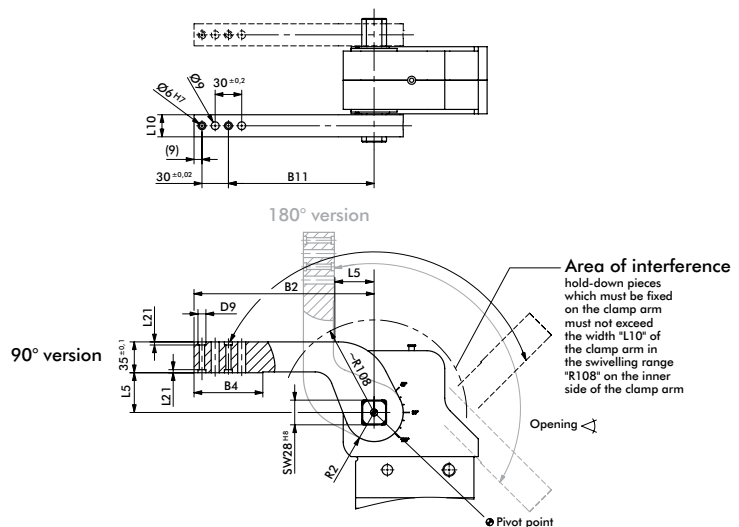
180° Left



180° Right



8JG-1179-1-01
8S801-45-204



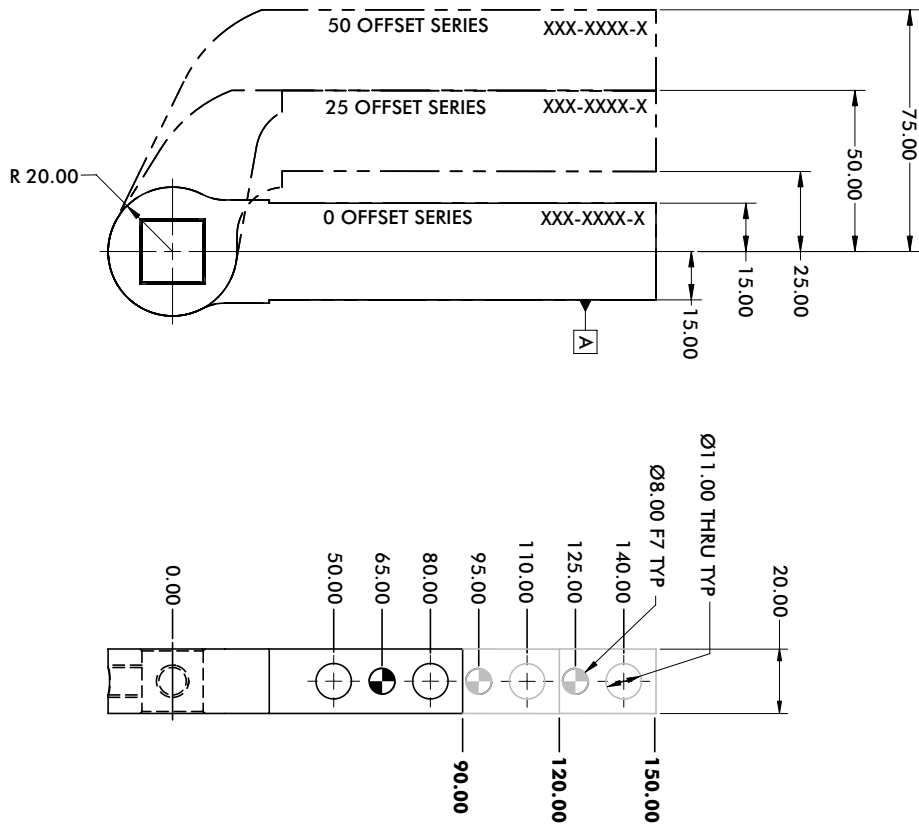
Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	B2	B4	D9	B11 ±0,1	L5	L10	L21	R2
8JG-1179-1-01	135°	135°	2,1	179	74	-	140	20	30	-	35
8S801-45-204				204	78	9	165	45	25	3,5	33

Models with 2 lateral clamp arms requires 2 clamp arm sets.

LATERAL (SIDE) ARMS, NAAMS-STYLE

Pneumatic Power Clamps | Dimensions | Technical Specifications

82M-3E 50mm



9mm Thru Hole (6.00 H7 Dowel)

90mm [3.54"] Arm Length			120mm [4.72"] Arm Length			150mm [5.90"] Arm Length		
Series	Arm Style	Model	Series	Arm Style	Model	Series	Arm Style	Model
50 Offset	▲ • 3256	B8JG-3256-1	50 Offset	▲ • 3257	B8JG-3257-1	50 Offset	▲ • 3258	B8JG-3258-1
25 Offset	▲ • 3246	B8JG-3246-1	25 Offset	▲ • 3247	B8JG-3247-1	25 Offset	▲ • 3248	B8JG-3248-1
0 Offset	▲ • 3236	B8JG-3236-1	0 Offset	▲ • 3237	B8JG-3237-1	0 Offset	▲ • 3238	B8JG-3238-1

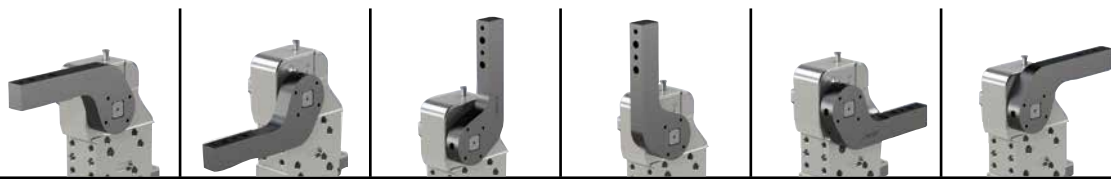
11mm Thru Hole (8.00 F7 Dowel)

90mm [3.54"] Arm Length			120mm [4.72"] Arm Length			150mm [5.90"] Arm Length		
Series	Arm Style	Model	Series	Arm Style	Model	Series	Arm Style	Model
50 Offset	▲ • 1226	B8JG-1226-1	50 Offset	▲ • 1227	B8JG-1227-1	50 Offset	▲ • 1228	B8JG-1228-1
25 Offset	▲ • 1216	B8JG-1216-1	25 Offset	▲ • 1217	B8JG-1217-1	25 Offset	▲ • 1218	B8JG-1218-1
0 Offset	▲ • 1206	B8JG-1206-1	0 Offset	▲ • 1207	B8JG-1207-1	0 Offset	▲ • 1208	B8JG-1208-1

▲ Common in North America

(•) STANDARD ARM OFFERING

Maximum Opening Angle (shown in locked position)

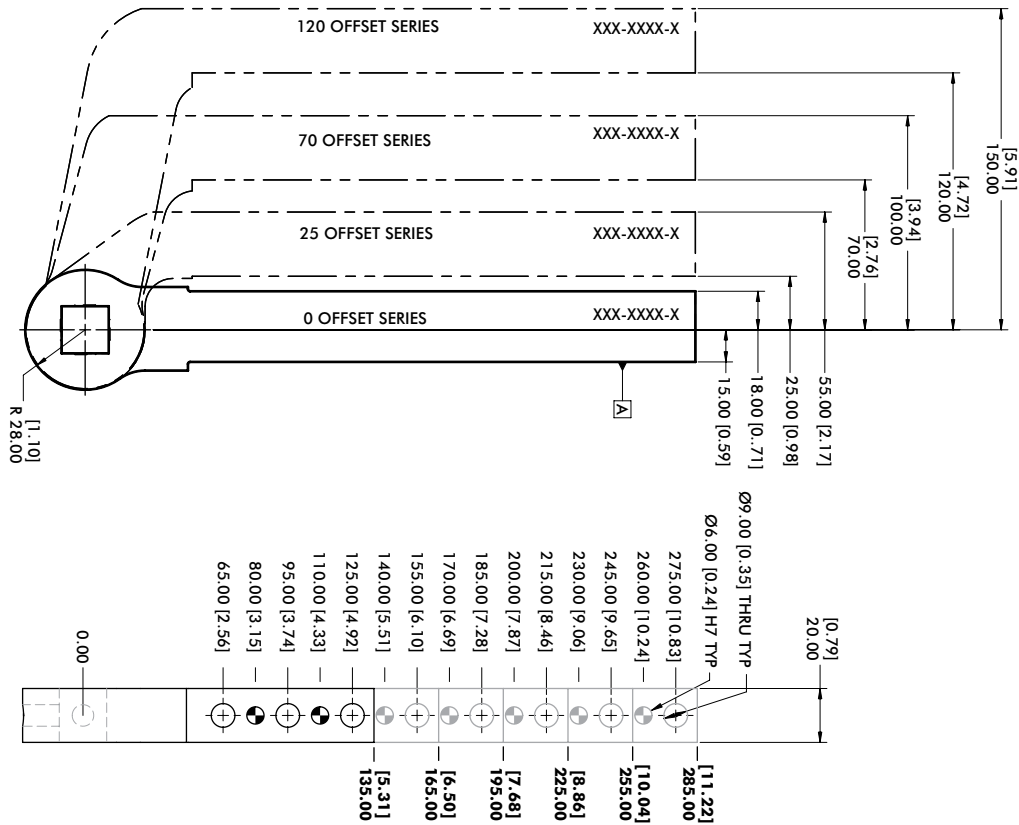


Arm Styles	1206-1208/3236-3238	1216-1218/3246-3248	1226-1228/3256-3258	1206-1207	1216-1217	1226-1227	1206-1208	1216-1218	1226-1228
1206-1208/3236-3238	135°	135°	100°	100°	N/A	N/A	N/A	N/A	N/A
1216-1218/3246-3248	135°	N/A	50°	125°	N/A	30°	N/A	N/A	30°
1226-1228/3256-3258	125°	N/A	35°	135°	N/A	50°	N/A	N/A	50°

LATERAL (SIDE) ARMS, NAAMS-STYLE

Pneumatic Power Clamps | Dimensions | Technical Specifications

82M-3. 63mm for 23 Clamp Arm Shaft Option



135mm [5.31"] Arm Length

Series	Arm Style	Model
120 Offset	▲ 1543	B8JG-1543-1
70 Offset	▲ 1531	B8JG-1531-1
25 Offset	▲ 1519	B8JG-1519-1
0 Offset	▲ 1507	B8JG-1507-1

165mm [6.50"] Arm Length

Series	Arm Style	Model
120 Offset	▲ 1544	B8JG-1544-1
70 Offset	▲ 1532	B8JG-1532-1
25 Offset	▲ 1520	B8JG-1520-1
0 Offset	▲ 1508	B8JG-1508-1

195mm [7.68"] Arm Length

Series	Arm Style	Model
120 Offset	▲ 1545	B8JG-1545-1
70 Offset	▲ 1533	B8JG-1533-1
25 Offset	▲ 1521	B8JG-1521-1
0 Offset	▲ 1509	B8JG-1509-1

225mm [8.86"] Arm Length

Series	Arm Style	Model
120 Offset	▲ 1546	B8JG-1546-1
70 Offset	▲ 1534	B8JG-1534-1
25 Offset	▲ 1522	B8JG-1522-1
0 Offset	▲ 1510	B8JG-1510-1

255mm [10.04"] Arm Length

Series	Arm Style	Model
120 Offset	▲ 1547	B8JG-1547-1
70 Offset	▲ 1535	B8JG-1535-1
25 Offset	▲ 1523	B8JG-1523-1
0 Offset	▲ 1511	B8JG-1511-1

285mm [11.22"] Arm Length

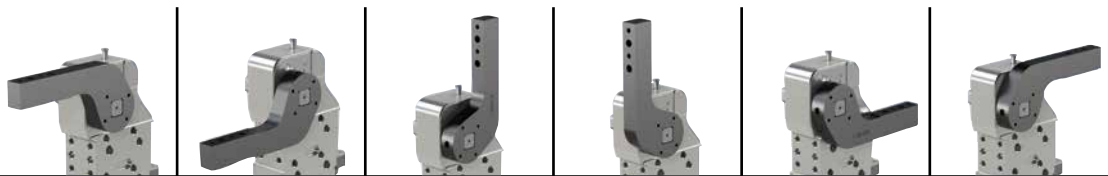
Series	Arm Style	Model
120 Offset	▲ 1548	B8JG-1548-1
70 Offset	▲ 1536	B8JG-1536-1
25 Offset	▲ 1524	B8JG-1524-1
0 Offset	▲ 1512	B8JG-1512-1

▲ Common in North America

(•) STANDARD ARM OFFERING

(i) NON-STANDARD ARM OFFERING (extended leadtimes apply)

Maximum Opening Angle (shown in locked position)

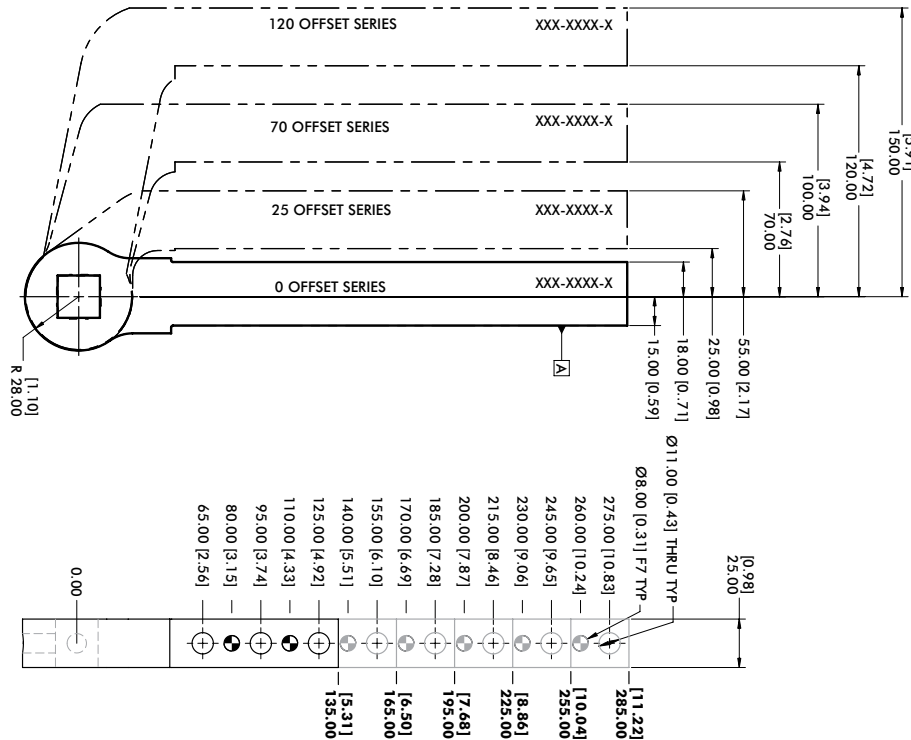


Arm Styles	135°	135°	100°	100°	N/A	N/A
1510-1512/1507-1509	135°	135°	100°	100°	N/A	N/A
1522-1524/1519-1521	135°	N/A	50°	130°	N/A	40°
1534-1536/1531-1533	115°	N/A	25°	135°	N/A	75°
1546-1548/1543-1545	110°	N/A	20°	135°	N/A	85°

LATERAL (SIDE) ARMS, NAAMS-STYLE

Pneumatic Power Clamps | Dimensions | Technical Specifications

82M-3. 63mm for D0 Clamp Arm Shaft Option



135mm [5.31"] Arm Length

Series	Arm Style	Model
120 Offset	▲ • 1043	B8JG-1043-1
70 Offset	▲ • 1031	B8JG-1031-1
25 Offset	▲ • 1019	B8JG-1019-1
0 Offset	▲ • 1007	B8JG-1007-1

165mm [6.50"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1044	B8JG-1044-1
70 Offset	▲ • 1032	B8JG-1032-1
25 Offset	▲ • 1020	B8JG-1020-1
0 Offset	▲ • 1008	B8JG-1008-1

195mm [7.68"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1045	B8JG-1045-1
70 Offset	▲ • 1033	B8JG-1033-1
25 Offset	▲ ⓘ 1021	B8JG-1021-1
0 Offset	▲ • 1009	B8JG-1009-1

225mm [8.86"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1046	B8JG-1046-1
70 Offset	▲ • 1034	B8JG-1034-1
25 Offset	▲ ⓘ 1022	B8JG-1022-1
0 Offset	▲ ⓘ 1010	B8JG-1010-1

255mm [10.04"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1047	B8JG-1047-1
70 Offset	▲ • 1035	B8JG-1035-1
25 Offset	▲ ⓘ 1023	B8JG-1023-1
0 Offset	▲ ⓘ 1011	B8JG-1011-1

285mm [11.22"] Arm Length

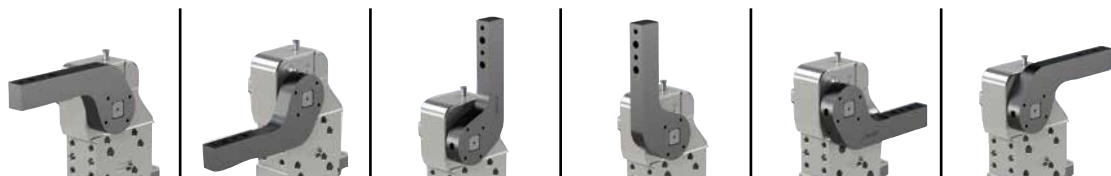
Series	Arm Style	Model
120 Offset	▲ ⓘ 1048	B8JG-1048-1
70 Offset	▲ ⓘ 1036	B8JG-1036-1
25 Offset	▲ ⓘ 1024	B8JG-1024-1
0 Offset	▲ ⓘ 1012	B8JG-1012-1

▲ Common in North America

(•) STANDARD ARM OFFERING

(ⓘ) NON-STANDARD ARM OFFERING (extended leadtimes apply)

Maximum Opening Angle (shown in locked position)

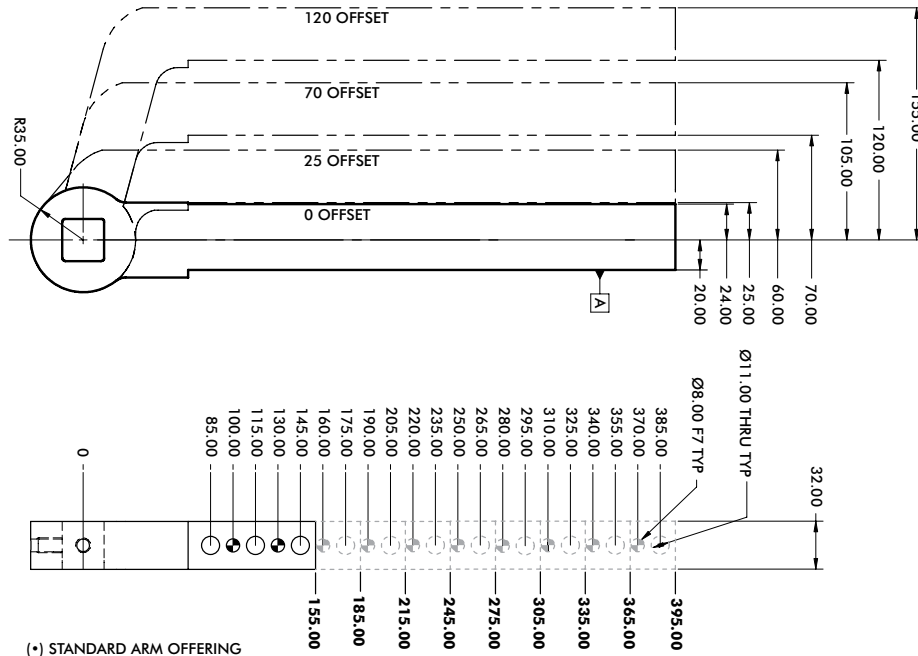


Arm Styles	Model 1	Model 2	Model 3	Model 4	Model 5	Model 6
1010-1012/1007-1009	135°	135°	100°	100°	N/A	N/A
1022-1024/1019-1021	135°	N/A	50°	130°	N/A	40°
1034-1036/1031-1033	115°	N/A	25°	135°	N/A	75°
1046-1048/1043-1045	110°	N/A	20°	135°	N/A	85°

LATERAL (SIDE) ARMS, NAAMS-STYLE

Pneumatic Power Clamps | Dimensions | Technical Specifications

82M-3E 80mm



155mm [4.53"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1170	B8JG-1170-1
70 Offset	▲ • 1150	B8JG-1150-1
25 Offset	▲ ⓘ 1130	B8JG-1130-1
0 Offset	▲ ⓘ 1110	B8JG-1110-1

185mm [7.28"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1171	B8JG-1171-1
70 Offset	▲ ⓘ 1151	B8JG-1151-1
25 Offset	▲ ⓘ 1131	B8JG-1131-1
0 Offset	▲ ⓘ 1111	B8JG-1111-1

215mm [8.46"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1172	B8JG-1172-1
70 Offset	▲ ⓘ 1152	B8JG-1152-1
25 Offset	▲ ⓘ 1132	B8JG-1132-1
0 Offset	▲ • 1112	B8JG-1112-1

245mm [9.65"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1173	B8JG-1173-1
70 Offset	▲ ⓘ 1153	B8JG-1153-1
25 Offset	▲ ⓘ 1133	B8JG-1133-1
0 Offset	▲ ⓘ 1113	B8JG-1113-1

275mm [10.83"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1174	B8JG-1174-1
70 Offset	▲ ⓘ 1154	B8JG-1154-1
25 Offset	▲ • 1134	B8JG-1134-1
0 Offset	▲ ⓘ 1114	B8JG-1114-1

305mm [12.00"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1175	B8JG-1175-1
70 Offset	▲ • 1155	B8JG-1155-1
25 Offset	▲ ⓘ 1135	B8JG-1135-1
0 Offset	▲ ⓘ 1115	B8JG-1115-1

335mm [13.19"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1176	B8JG-1176-1
70 Offset	▲ ⓘ 1156	B8JG-1156-1
25 Offset	▲ ⓘ 1136	B8JG-1136-1
0 Offset	▲ ⓘ 1116	B8JG-1116-1

365mm [14.37"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ⓘ 1177	B8JG-1177-1
70 Offset	▲ ⓘ 1157	B8JG-1157-1
25 Offset	▲ ⓘ 1137	B8JG-1137-1
0 Offset	▲ ⓘ 1117	B8JG-1117-1

395mm [15.55"] Arm Length

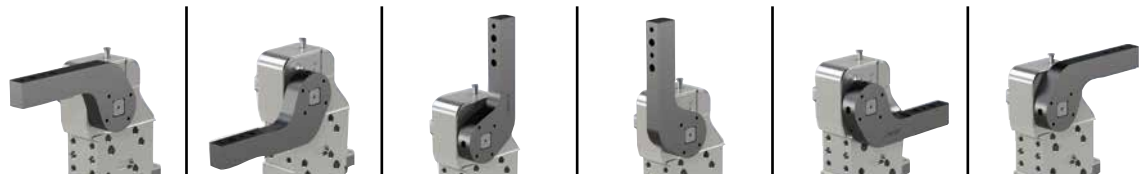
Series	Arm Style	Model
120 Offset	▲ ⓘ 1178	B8JG-1178-1
70 Offset	▲ • 1158	B8JG-1158-1
25 Offset	▲ ⓘ 1138	B8JG-1138-1
0 Offset	▲ • 1118	B8JG-1118-1

▲ Common in North America

(*) STANDARD ARM OFFERING

ⓘ NON-STANDARD ARM OFFERING (extended leadtimes apply)

Maximum Opening Angle (shown in locked position)

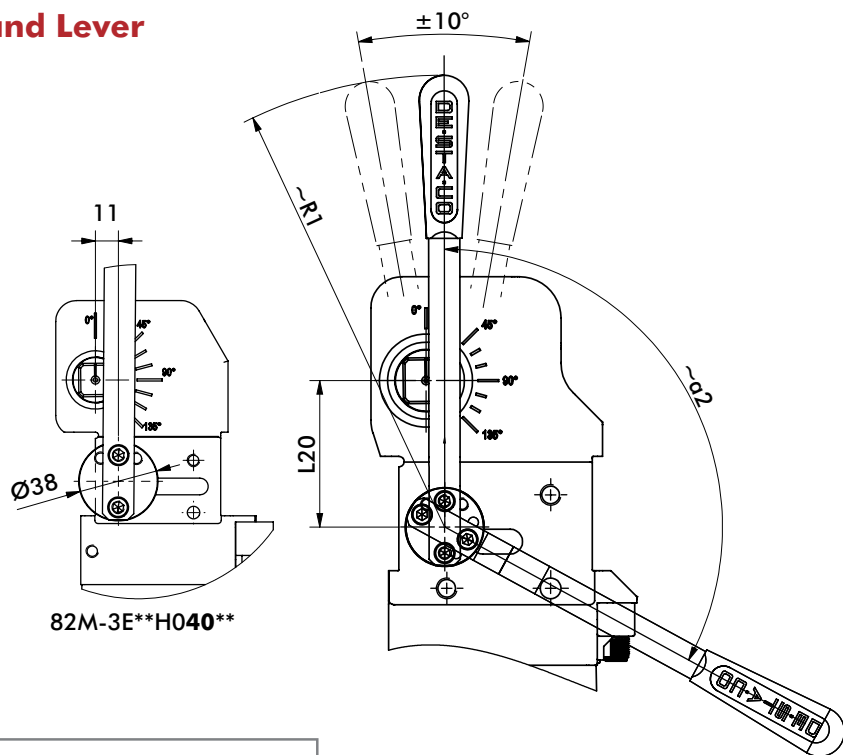


Arm Styles	1110 - 1118	1130 - 1138	1150 - 1158	1170 - 1178	1190 - 1198	1210 - 1218
1110 - 1118	135°	135°	100°	100°	N/A	N/A
1130 - 1138	135°	N/A	60°	120°	N/A	30°
1150 - 1158	125°	N/A	35°	135°	N/A	55°
1170 - 1178	115°	N/A	25°	135°	N/A	80°

82M-3E ACCESSORIES

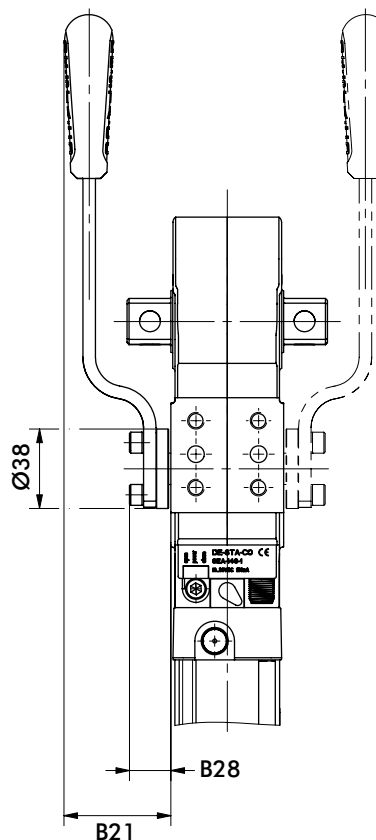
Pneumatic Power Clamps | Dimensions | Technical Specifications

Hand Lever

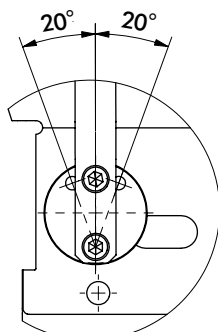
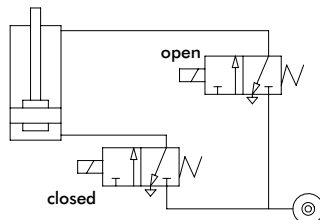


82M-3E**H040**

Hand lever left Hand lever right



Pneumatic circuit required for manual and pneumatic actuation.



Hand lever can be mounted in 3 positions



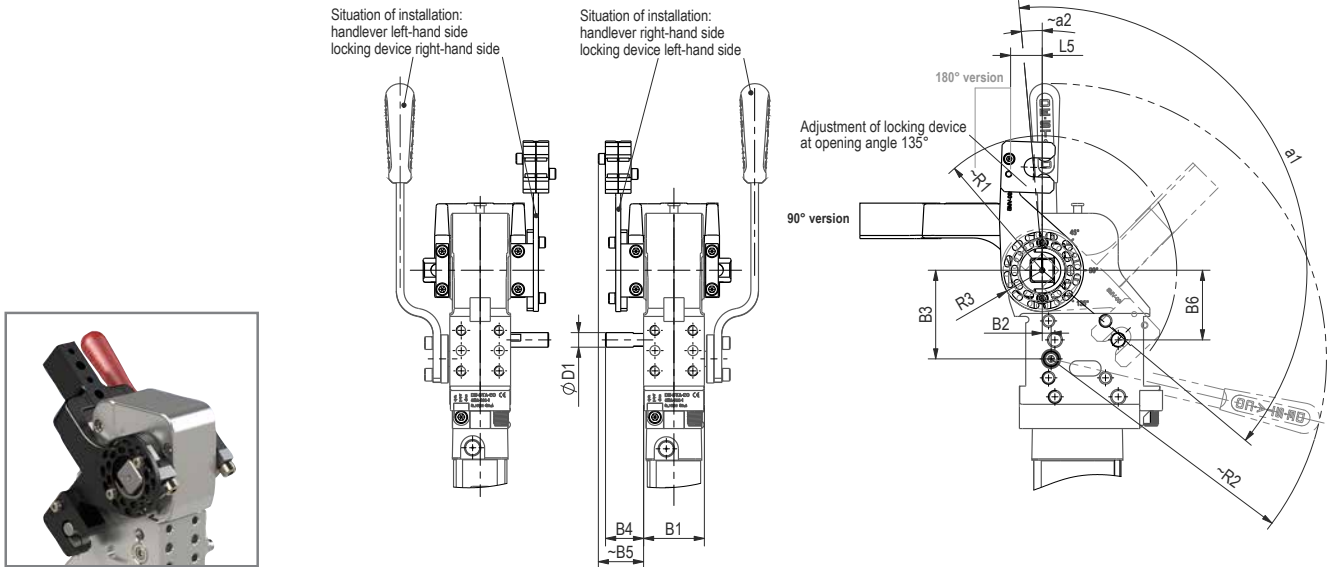
Hand lever position is adjustable to ± 20 degrees for improved ergonomics.

Model No.	B21	B28	L20	~R1	Swivel Angle $\alpha 2$ (with reference to opening angle of clamp arm)									
					0°	15°	30°	45°	60°	75°	90°	105°	120°	135°
82M-3E..H040..	27	24	48,5	190	0°	31°	41°	49°	58°	69°	88°	113°	134°	144°
82M-3E..H05...	52	20	70	218	1°	32°	40°	48°	55°	63°	72°	83°	95°	105°
82M-3E..H06..	52	20	70,5	218	0°	30°	39°	47°	56°	66°	79°	94°	108°	119°
82M-3E..H08..	56	24	82	268	-1°	28°	37°	45°	53°	63°	75°	92°	107°	117°

82M-3E ACCESSORIES

Pneumatic Power Clamps | Dimensions | Technical Specifications

Locking Device for Hand Lever

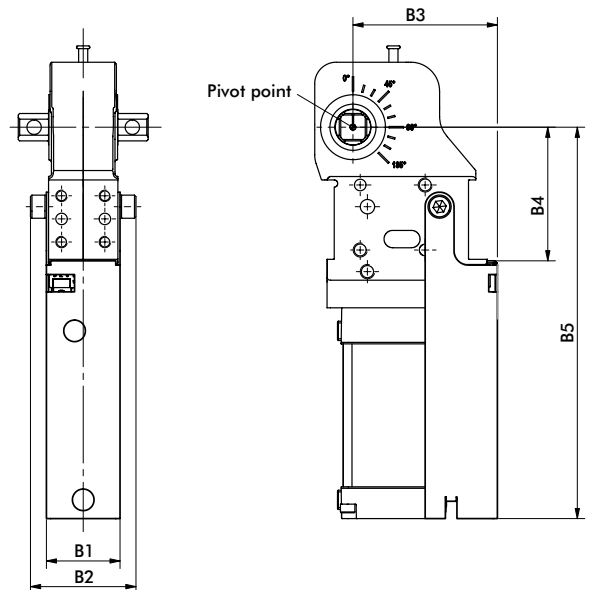


Order No.	For Model	B1	B2	B3	B4	B5	B6	ØD1	R1	R2	R3	a1 max.	a2	Limited setting options at 180° version! Height of the clamping arm: L5		
														00	15	25
82ZB-162-1	82M-3E..H040..	50	11	48,5	25	31	38,5	10,5	81	160	27		6	max.105°	max.120°	max.120°
82ZB-084-1	82M-3E..H05...	48	7	70	30	36	55	11,5	107	218	32,5	135°	6	-	max.105°	max.120°
82ZB-039-1	82M-3E..H06...	54	9	70,5	30	36	55	11,5	107	210	32,5		6	-	max.105°	max.120°



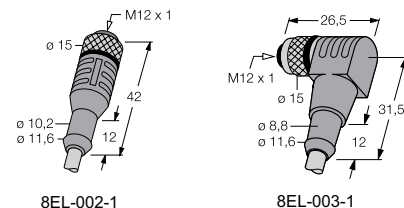
Using of the anti-ramming device is only possible with 82M-3E.....00 and 82M-3E.....L8

Anti-Ramming Device



Order No.	For Model	B1	B2	B3	B4	B5
8AB-151-1	82M-3E....40..	53	66,5	89,5	65,5	210,5
8AB-152-1	82M-3E....5...	51	73	100	92,5	271
8AB-153-1	82M-3E....6...	57	79	120	104,5	296
8AB-154-1	82M-3E....8...	79	105,5	148	142,5	360

Cable and Connector



Order No.	Description
8EL-002-1	M12x1, Straight, 5-pin Connector with 5m Cable
8EL-003-1	M12x1, Angular, 4-pin Connector with 5m Cable

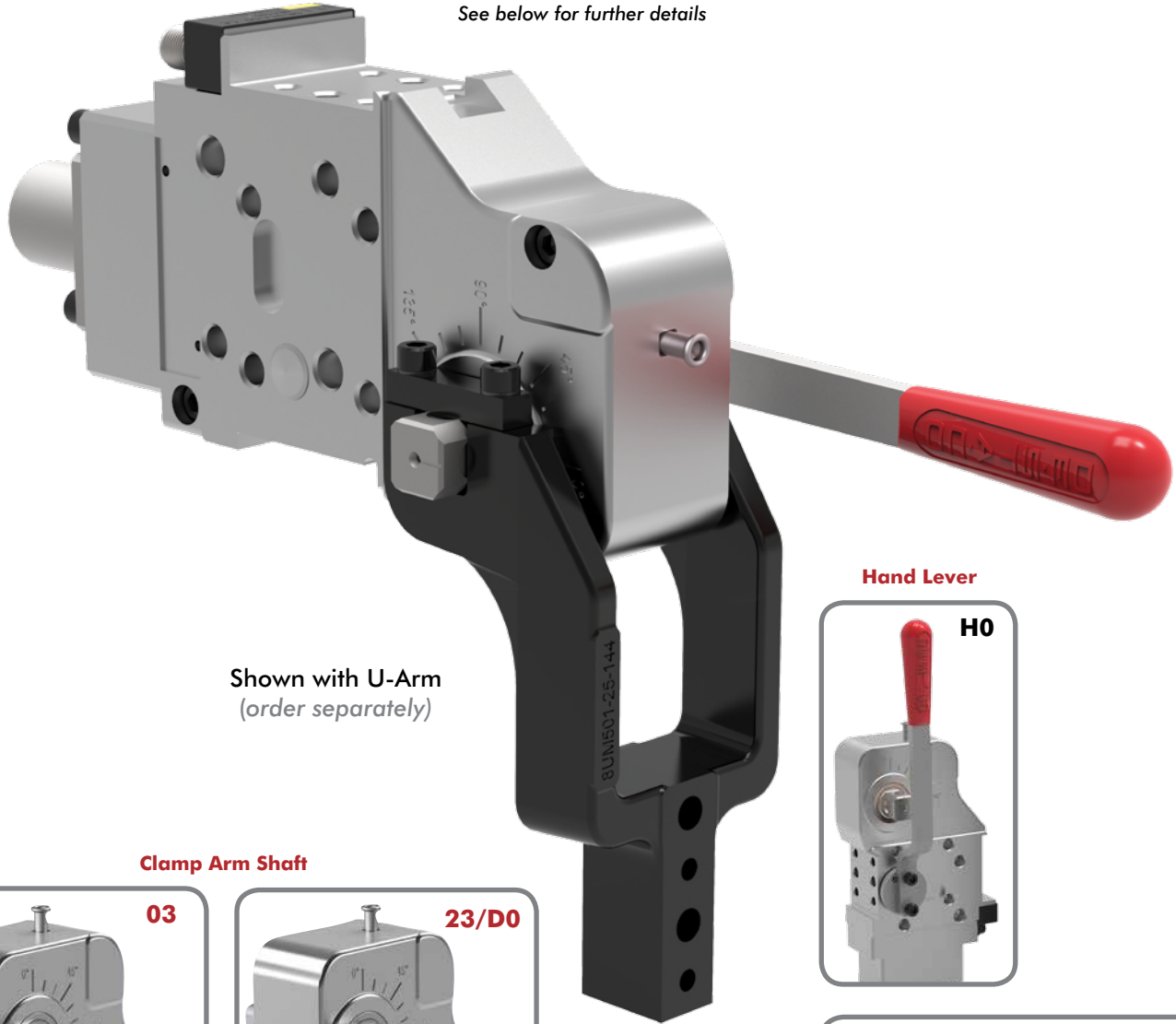
52H-3E SERIES

Pneumatic Power Clamps | Ordering Information

52H-3 **E** **23** **H0** **50** **L8**

Base Model	Mounting	Description	Clamp Arm Shaft	Description	Handle	Description
	E	Standard	03	for U-Arms	H0	Hand lever
	N	NAAMS (Size 63 only)	23	for Lateral Arms	HS	Hand Lever (Weldable)
			D0	for Lateral Arms (size 63 only)		

See below for further details



Shown with U-Arm
(order separately)

Clamp Arm Shaft

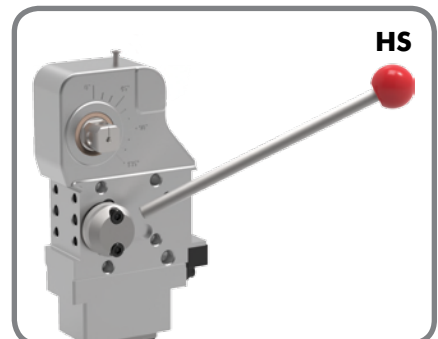


Size Shaft Length (L17)
50 12mm
63 12mm



23
Size Shaft Length (L17)
50 21mm
63 21mm
D0
Size Shaft Length (L17)
D0 26mm

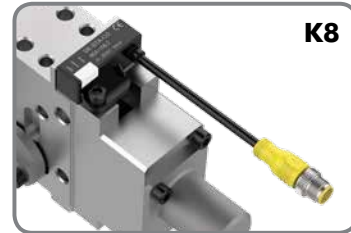
Hand Lever



52H-3E SERIES

Pneumatic Power Clamps | Ordering Information

Sensor	Description
00	No sensor
L8	Sensor with In-line Connector (Replacement Order No.: 8EA-146-2)
L9	Sensor with 90 deg Connection (Replacement Order No.: 8EA-147-2)
K8	Sensor with Cable Connection (Replacement Order No.: 8EA-158-2)



Size	Description
50	Size 50mm
63	Size 63mm



50

Max Holding Torque
1300 Nm



63

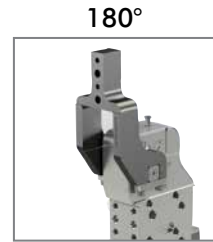
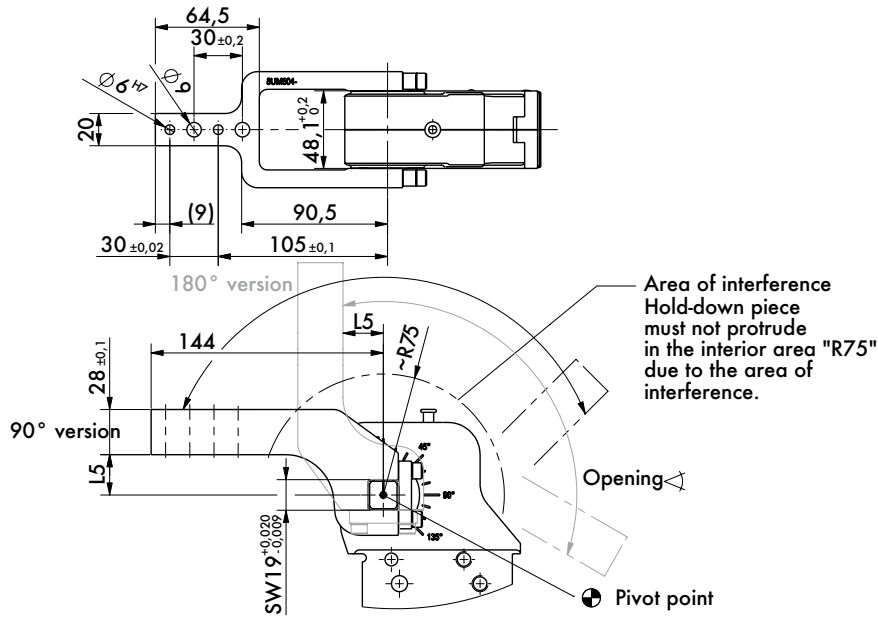
Max Holding Torque
1800 Nm

52H-3E..H.50/63
Modular manual
clamp, interchangeable
with 82M-3E...50/63

U-ARMS CENTER (ALUMINUM)

Pneumatic Power Clamps | Dimensions | Technical Specifications

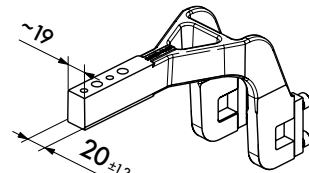
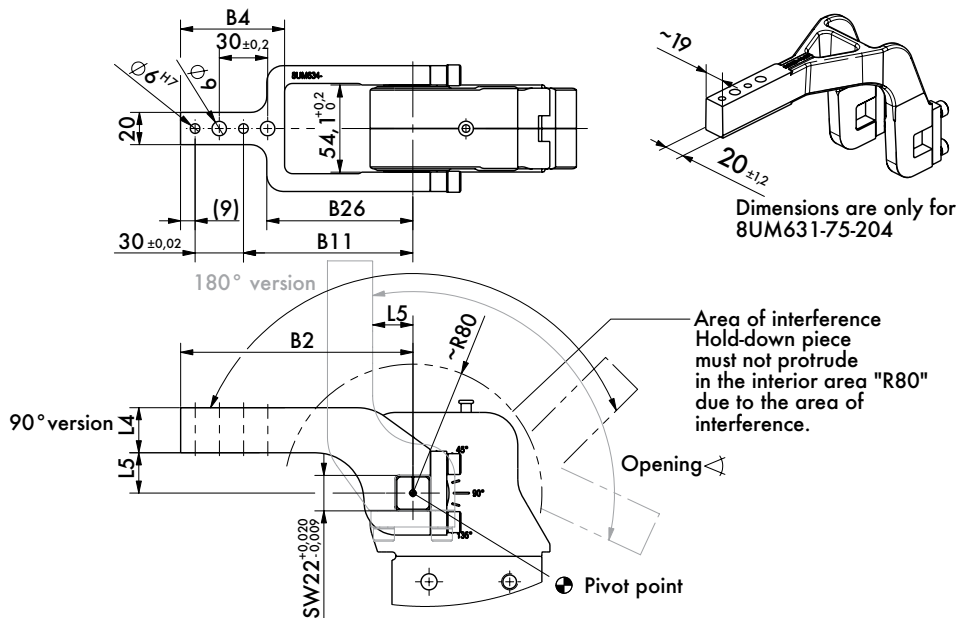
52H-3E...5... U-Arms Center (Steel)



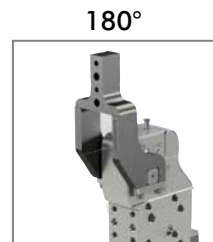
8UM504-15-144
8UM504-25-144
8UM504-45-144

Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight	L5
8UM504-15-144	135°	105°	0,44	15
8UM504-25-144		120°	0,45	25
8UM504-45-144		135°	0,48	45

52H-3...6... U-Arms Center (Steel)



Dimensions are only for 8UM631-75-204



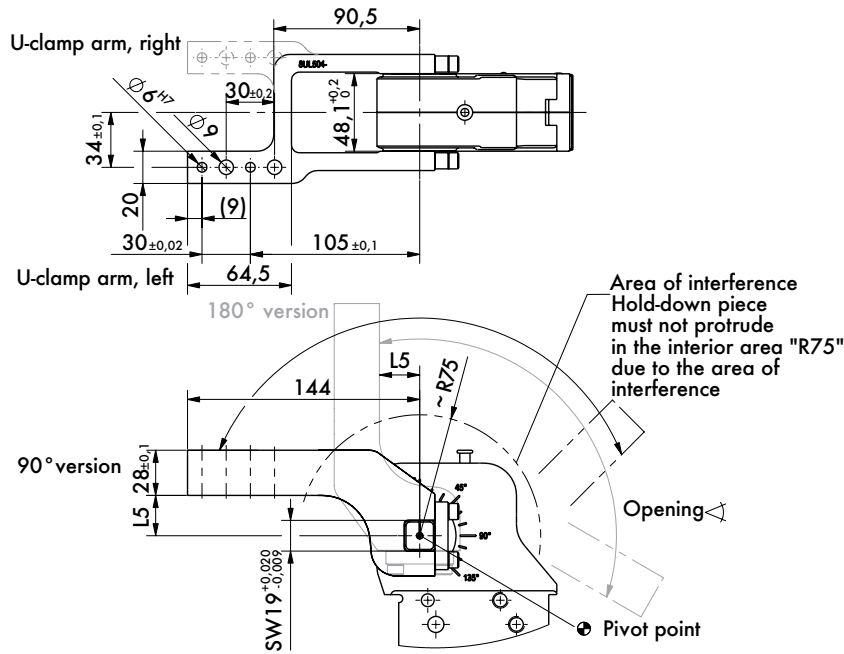
8UM634-15-144
8UM634-25-144
8UM634-45-144
8UM631-75-204**

Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight	B2	B4	B11 ±0,1	B26	L4 ±0,1	L5
8UM634-15-144	135°	105°	0,50	144	64,5	105	90,5	28	15
8UM634-25-144		120°	0,53						25
8UM634-45-144		135°	0,56						45
8UM631-75-204**		1,7	204						82

** only steel version available.

U-ARMS OFFSET (ALUMINUM)

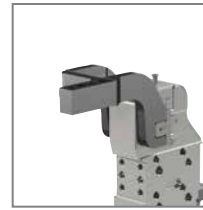
Pneumatic Power Clamps | Dimensions | Technical Specifications



52H-3E...5... U-Arms Offset (Steel)

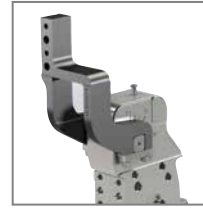
90° Left

90° Right



180° Right*

180° Left*

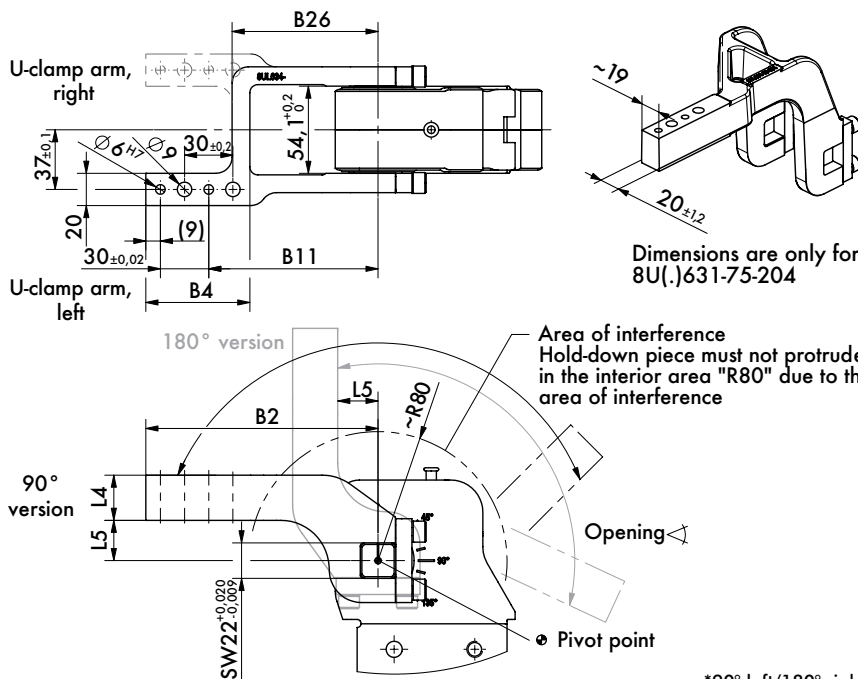


8UL504-15-144
8UL504-25-144
8UL504-45-144

8UR504-15-144
8UR504-25-144
8UR504-45-144

*90° left/180° right uses same clamp arm. 90° right/180° left uses same clamp arm.

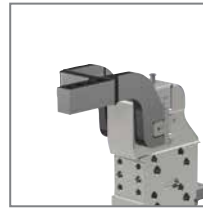
Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight	L5
8U(.)504-15-144	135°	105°	0,45	15
8U(.)504-25-144		120°	0,46	25
8U(.)504-45-144		135°	0,49	45



52H-3E...6... U-Arms Offset (Steel)

90° Left

90° Right



180° Right*

180° Left*



8UL631-15-144
8UL631-25-144
8UL631-45-144
8UL631-75-204**

8UR631-15-144
8UR631-25-144
8UR631-45-144
8UR631-75-204**

*90° left/180° right uses same clamp arm. 90° right/180° left uses same clamp arm.

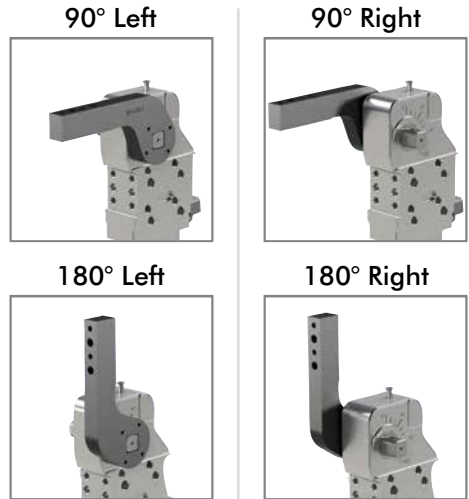
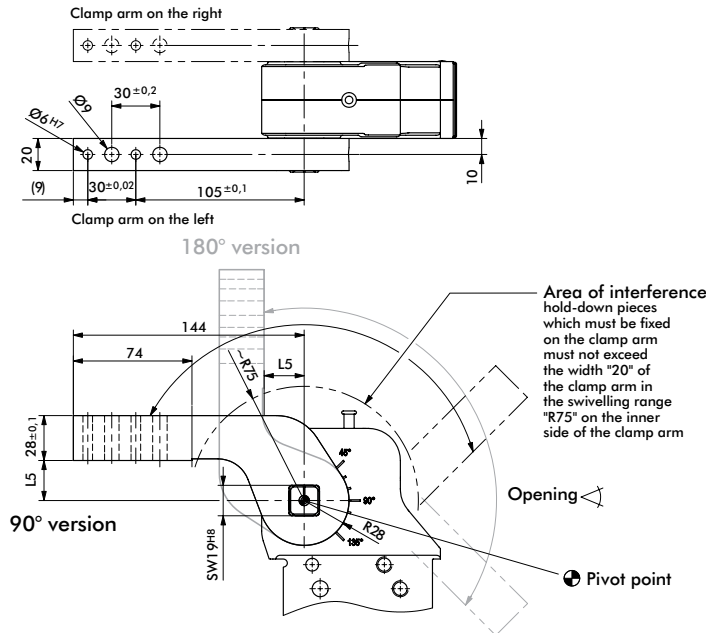
Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight	B2	B4	B11 ±0,1	B26	L4 ±0,1	L5
8U(.)634-15-144	135°	105°	0,52						15
8U(.)634-25-144		120°	0,54	144	64,5	105	90,5	28	25
8U(.)634-45-144		135°	0,58						45
8U(.)631-75-204**		1,9	204	82	165	119	30	75	

** only steel version available.

LATERAL (SIDE) ARMS

Pneumatic Power Clamps | Dimensions | Technical Specifications

52H-3E...5...

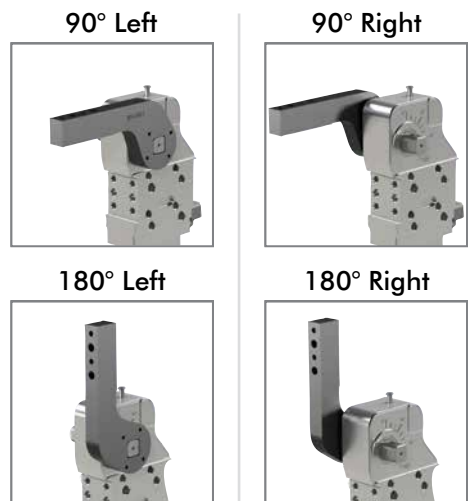
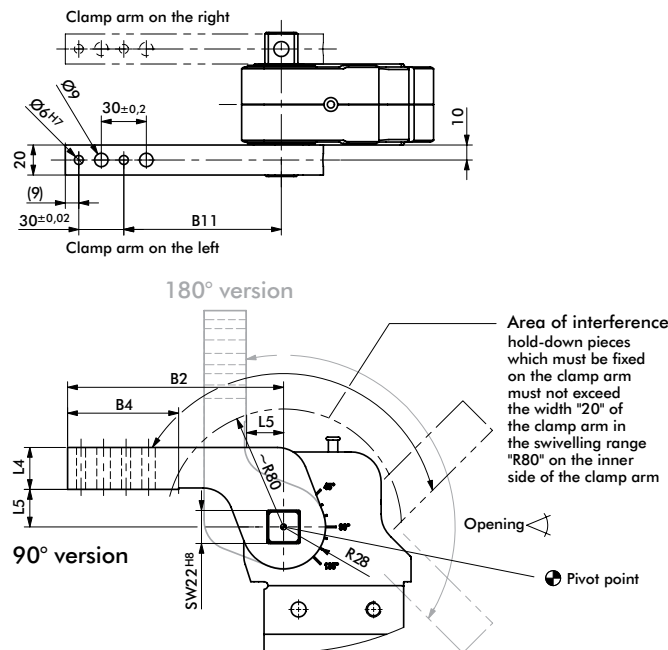


8JG-070-1-01
8S501-25-144

Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	L5
8JG-070-1-01	135°	135°	0,9	15
8S501-25-144			1,0	25

Models with 2 lateral clamp arms requires 2 clamp arm sets.

52H-3E...6...



8JG-080-1-01
8S631-25-144
8S631-45-144
8S631-75-204

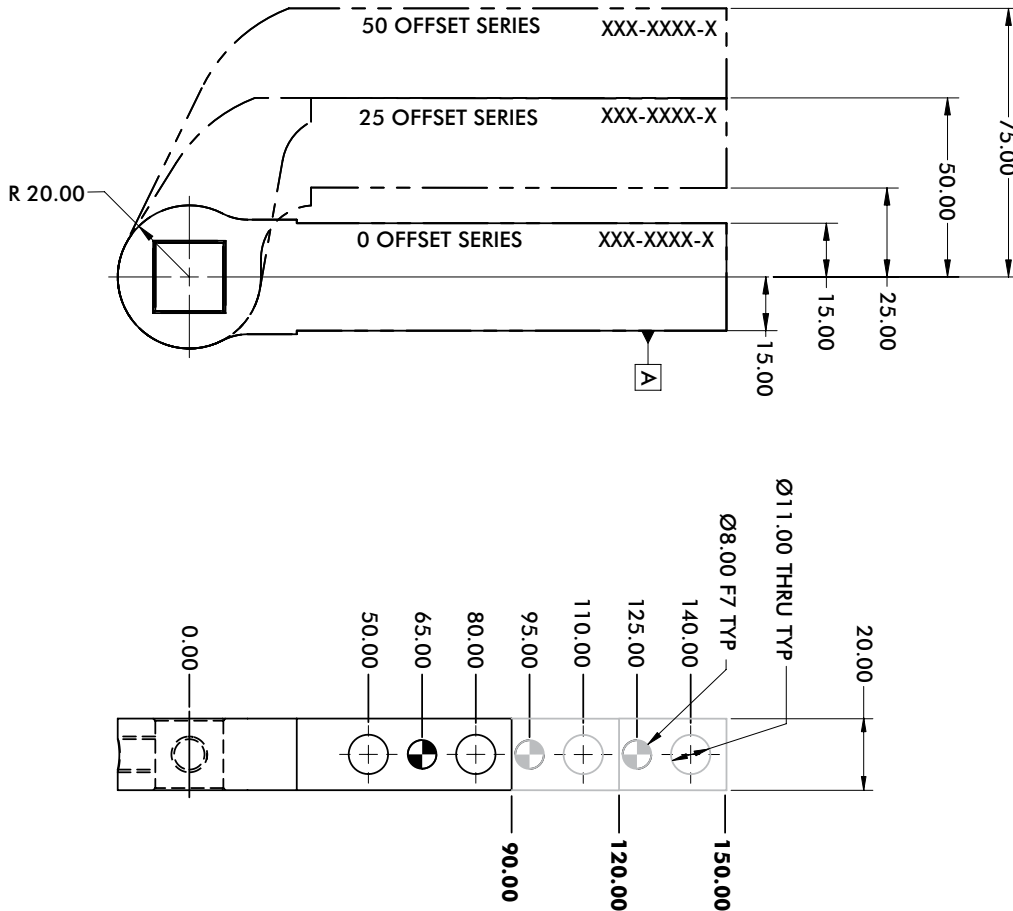
Arm Model No.	Max. Opening 90° Version	Max. Opening 180° Version	Weight (kg)	B2	B4	B11 ±0,1	L4 ±0,1	L5
8JG-080-1-01	135°	135°	0,9	144	74	105	28	15
8S631-25-144			1,0					25
8S631-45-144			1,1					45
8S631-75-204			1,5					204

Models with 2 lateral clamp arms requires 2 clamp arm sets.

LATERAL (SIDE) ARMS, NAAMS-STYLE

Pneumatic Power Clamps | Dimensions | Technical Specifications

52H-3E. 50mm



9mm Thru Hole (6.00 H7 Dowel)

90mm [3.54"] Arm Length			120mm [4.72"] Arm Length			150mm [5.90"] Arm Length		
Series	Arm Style	Model	Series	Arm Style	Model	Series	Arm Style	Model
50 Offset	▲ • 3256	B8JG-3256-1	50 Offset	▲ • 3257	B8JG-3257-1	50 Offset	▲ • 3258	B8JG-3258-1
25 Offset	▲ • 3246	B8JG-3246-1	25 Offset	▲ • 3247	B8JG-3247-1	25 Offset	▲ • 3248	B8JG-3248-1
0 Offset	▲ • 3236	B8JG-3236-1	0 Offset	▲ • 3237	B8JG-3237-1	0 Offset	▲ • 3238	B8JG-3238-1

11mm Thru Hole (8.00 F7 Dowel)

90mm [3.54"] Arm Length			120mm [4.72"] Arm Length			150mm [5.90"] Arm Length		
Series	Arm Style	Model	Series	Arm Style	Model	Series	Arm Style	Model
50 Offset	▲ • 1226	B8JG-1226-1	50 Offset	▲ • 1227	B8JG-1227-1	50 Offset	▲ • 1228	B8JG-1228-1
25 Offset	▲ • 1216	B8JG-1216-1	25 Offset	▲ • 1217	B8JG-1217-1	25 Offset	▲ • 1218	B8JG-1218-1
0 Offset	▲ • 1206	B8JG-1206-1	0 Offset	▲ • 1207	B8JG-1207-1	0 Offset	▲ • 1208	B8JG-1208-1

▲ Common in North America

(•) STANDARD ARM OFFERING

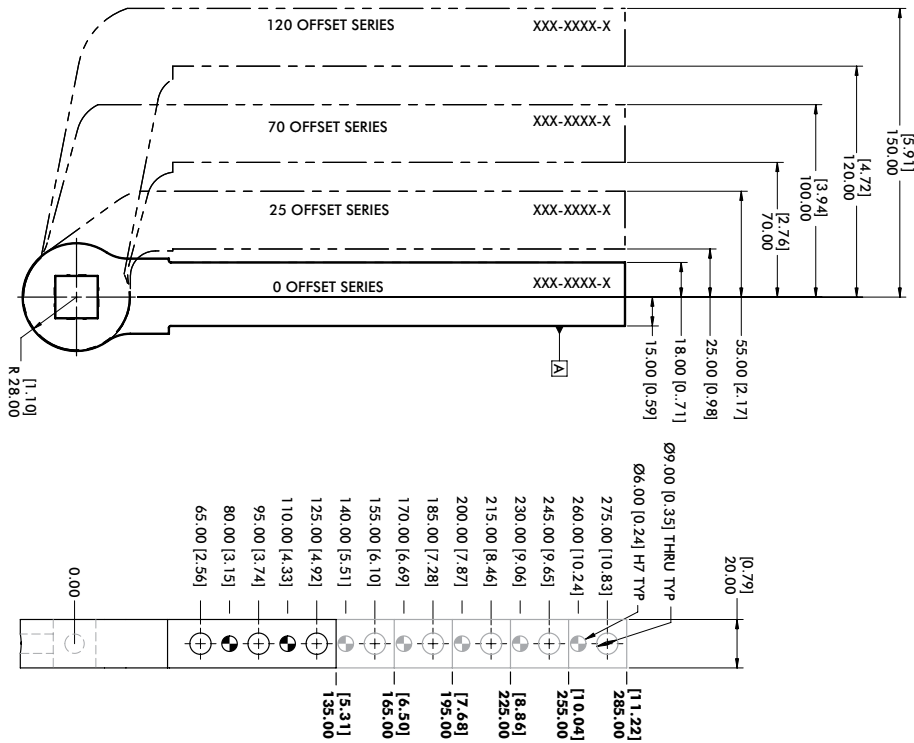
Maximum Opening Angle (shown in locked position)

Arm Styles	Image 1	Image 2	Image 3	Image 4	Image 5	Image 6
1206-1208/3236-3238	135°	135°	100°	100°	N/A	N/A
1216-1218/3246-3248	135°	N/A	50°	125°	N/A	30°
1226-1228/3256-3258	125°	N/A	35°	135°	N/A	50°

LATERAL (SIDE) ARMS, NAAMS-STYLE

Pneumatic Power Clamps | Dimensions | Technical Specifications

52H-3E. 63mm for 23 Clamp Arm Shaft Option



135mm [5.31"] Arm Length

Series	Arm Style	Model
120 Offset	▲ 1543	B8JG-1543-1
70 Offset	▲ 1531	B8JG-1531-1
25 Offset	▲ 1519	B8JG-1519-1
0 Offset	▲ 1507	B8JG-1507-1

165mm [6.50"] Arm Length

Series	Arm Style	Model
120 Offset	▲ 1544	B8JG-1544-1
70 Offset	▲ 1532	B8JG-1532-1
25 Offset	▲ 1520	B8JG-1520-1
0 Offset	▲ 1508	B8JG-1508-1

195mm [7.68"] Arm Length

Series	Arm Style	Model
120 Offset	▲ 1545	B8JG-1545-1
70 Offset	▲ 1533	B8JG-1533-1
25 Offset	▲ 1521	B8JG-1521-1
0 Offset	▲ 1509	B8JG-1509-1

225mm [8.86"] Arm Length

Series	Arm Style	Model
120 Offset	▲ 1546	B8JG-1546-1
70 Offset	▲ 1534	B8JG-1534-1
25 Offset	▲ 1522	B8JG-1522-1
0 Offset	▲ 1510	B8JG-1510-1

255mm [10.04"] Arm Length

Series	Arm Style	Model
120 Offset	▲ 1547	B8JG-1547-1
70 Offset	▲ 1535	B8JG-1535-1
25 Offset	▲ 1523	B8JG-1523-1
0 Offset	▲ 1511	B8JG-1511-1

285mm [11.22"] Arm Length

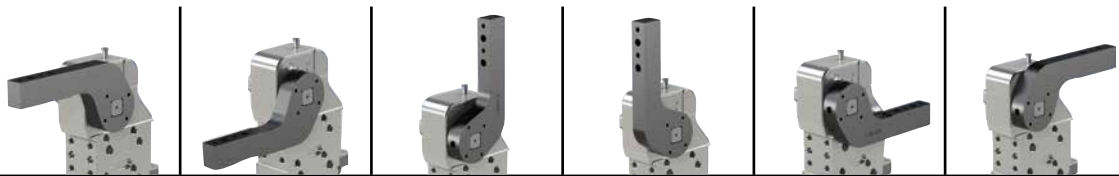
Series	Arm Style	Model
120 Offset	▲ 1548	B8JG-1548-1
70 Offset	▲ 1536	B8JG-1536-1
25 Offset	▲ 1524	B8JG-1524-1
0 Offset	▲ 1512	B8JG-1512-1

▲ Common in North America

(•) STANDARD ARM OFFERING

(i) NON-STANDARD ARM OFFERING (extended leadtimes apply)

Maximum Opening Angle (shown in locked position)

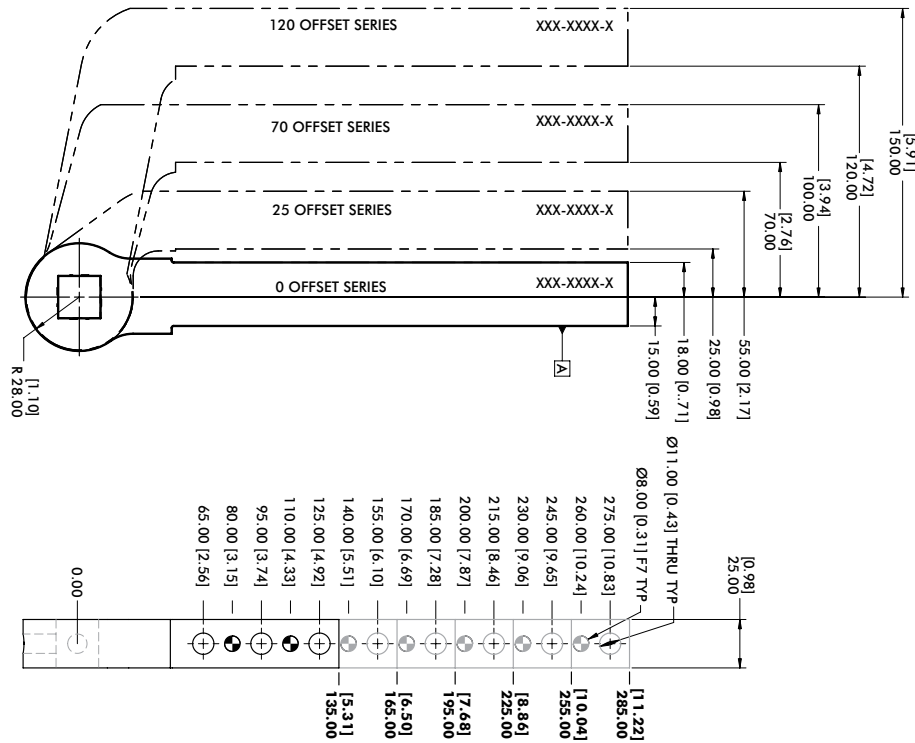


Arm Styles	135°	135°	100°	100°	N/A	N/A
1510-1512/1507-1509	135°	135°	100°	100°	N/A	N/A
1522-1524/1519-1521	135°	N/A	50°	130°	N/A	40°
1534-1536/1531-1533	115°	N/A	25°	135°	N/A	75°
1546-1548/1543-1545	110°	N/A	20°	135°	N/A	85°

LATERAL (SIDE) ARMS, NAAMS-STYLE

Pneumatic Power Clamps | Dimensions | Technical Specifications

52H-3E. 63mm for D0 Clamp Arm Shaft Option



135mm [5.31"] Arm Length

Series	Arm Style	Model
120 Offset	▲ • 1043	B8JG-1043-1
70 Offset	▲ • 1031	B8JG-1031-1
25 Offset	▲ • 1019	B8JG-1019-1
0 Offset	▲ • 1007	B8JG-1007-1

165mm [6.50"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ① 1044	B8JG-1044-1
70 Offset	▲ • 1032	B8JG-1032-1
25 Offset	▲ • 1020	B8JG-1020-1
0 Offset	▲ • 1008	B8JG-1008-1

195mm [7.68"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ① 1045	B8JG-1045-1
70 Offset	▲ • 1033	B8JG-1033-1
25 Offset	▲ ① 1021	B8JG-1021-1
0 Offset	▲ • 1009	B8JG-1009-1

225mm [8.86"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ① 1046	B8JG-1046-1
70 Offset	▲ • 1034	B8JG-1034-1
25 Offset	▲ ① 1022	B8JG-1022-1
0 Offset	▲ ① 1010	B8JG-1010-1

255mm [10.04"] Arm Length

Series	Arm Style	Model
120 Offset	▲ ① 1047	B8JG-1047-1
70 Offset	▲ • 1035	B8JG-1035-1
25 Offset	▲ ① 1023	B8JG-1023-1
0 Offset	▲ ① 1011	B8JG-1011-1

285mm [11.22"] Arm Length

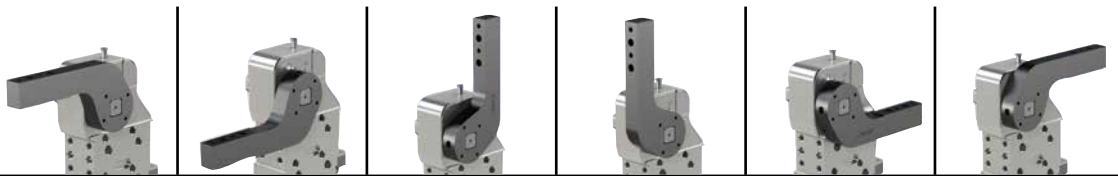
Series	Arm Style	Model
120 Offset	▲ ① 1048	B8JG-1048-1
70 Offset	▲ ① 1036	B8JG-1036-1
25 Offset	▲ ① 1024	B8JG-1024-1
0 Offset	▲ ① 1012	B8JG-1012-1

▲ Common in North America

(•) STANDARD ARM OFFERING

① NON-STANDARD ARM OFFERING (extended leadtimes apply)

Maximum Opening Angle (shown in locked position)



Arm Styles	1	2	3	4	5	6
1010-1012/1007-1009	135°	135°	100°	100°	N/A	N/A
1022-1024/1019-1021	135°	N/A	50°	130°	N/A	40°
1034-1036/1031-1033	115°	N/A	25°	135°	N/A	75°
1046-1048/1043-1045	110°	N/A	20°	135°	N/A	85°

870-2, 871-2 SERIES

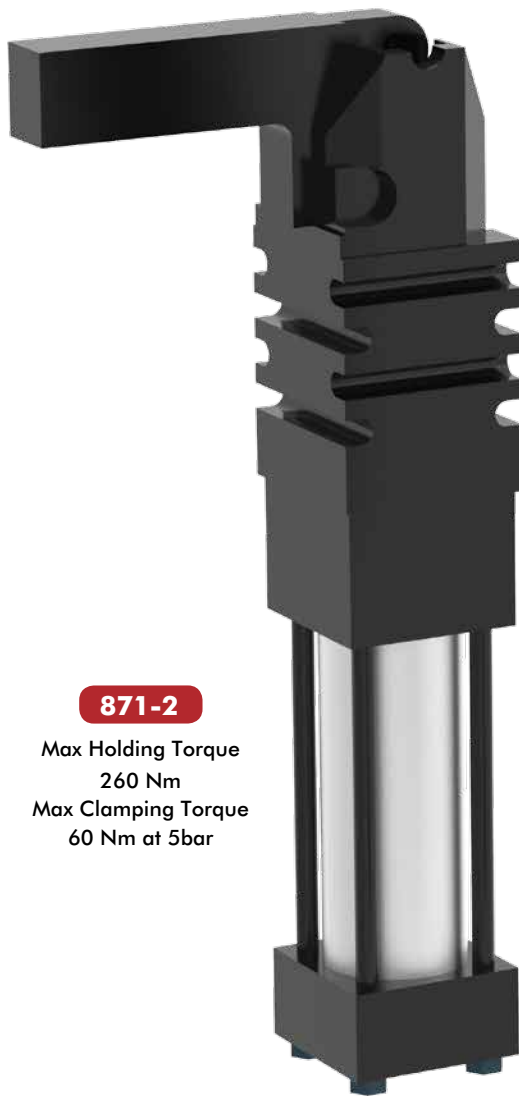
Pneumatic Power Clamps | Ordering Information

870-2

Base Model	Description
870-2	With Clamping Arm in Vertical Position
871-2	With Clamping Arm in Horizontal Position

Sensors	Description (order separately)
BIM-IKE-AP	Magnetic Sensor, 2 pieces required
810151	Magnetic Sensor, 2 pieces required
810153	Magnetic Sensor, 2 pieces required
810155	Magnetic Sensor, 2 pieces required
810157	Magnetic Sensor, 2 pieces required

See page PC-PPC-58 for sensor specifications.



871-2

Max Holding Torque
260 Nm
Max Clamping Torque
60 Nm at 5bar



870-2

Max Holding Torque
260 Nm
Max Clamping Torque
60 Nm at 5bar

860, 861, 890, 891, 1000, 1001 SERIES

Pneumatic Power Clamps | Ordering Information

860

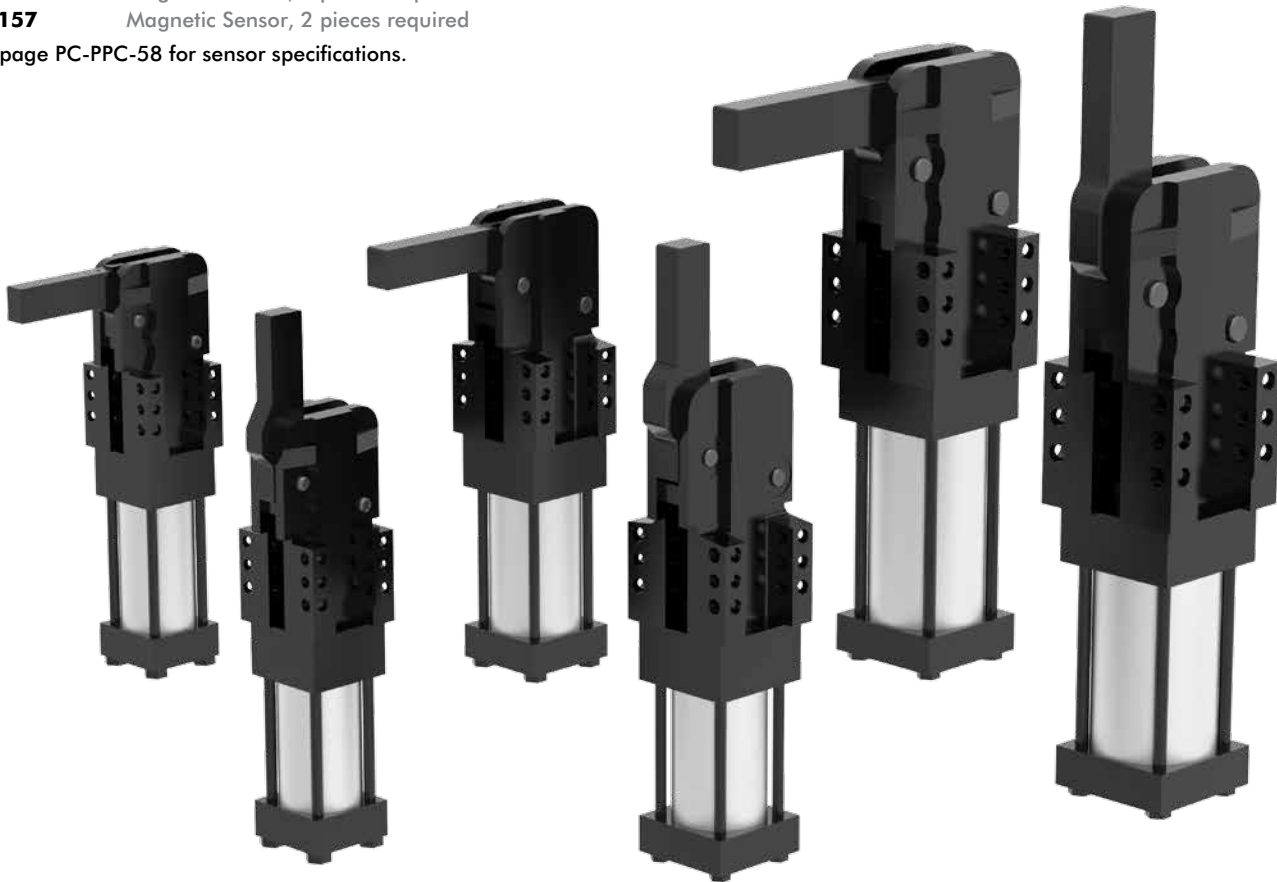
Base Model	Description
860	2 in. Cylinder Bore Size with Vertical Clamp Arm
861	2 in. Cylinder Bore Size with Horizontal Clamp Arm
890	2.5 in. mm Cylinder Bore Size with Vertical Clamp Arm
891	2.5 in. Cylinder Bore Size with Horizontal Clamp Arm
1000	3.25 in. Cylinder Bore Size with Vertical Clamp Arm
1001	3.25 in. Cylinder Bore Size with Horizontal Clamp Arm

Sensors	Description (order separately)
BIM-IKE-AP	Magnetic Sensor, 2 pieces required
810151	Magnetic Sensor, 2 pieces required
810153	Magnetic Sensor, 2 pieces required
810155	Magnetic Sensor, 2 pieces required
810157	Magnetic Sensor, 2 pieces required

See page PC-PPC-58 for sensor specifications.

Seal Kit	Description (order separately)
8610100	Seal Kit for Model 860, 861
8910100	Seal Kit for Model 890, 891
10010100	Seal Kit for Model 1000, 1001

Cylinder	Description (order separately)
865133-MR	Replacement Cylinder for Model 860
865132-MR	Replacement Cylinder for Model 861
895133-MR	Replacement Cylinder for Model 890
895132-MR	Replacement Cylinder for Model 891
1005134-MR	Replacement Cylinder for Model 1000
1005133-MR	Replacement Cylinder for Model 1001



861

Max Holding Torque
380 Nm
Max Clamping Torque
120 Nm at 5bar

891

Max Holding Torque
1300 Nm
Max Clamping Torque
270 Nm at 5bar

1001

Max Holding Torque
1800 Nm
Max Clamping Torque
420 Nm at 5bar

860

Max Holding Torque
380 Nm
Max Clamping Torque
120 Nm at 5bar

890

Max Holding Torque
1300 Nm
Max Clamping Torque
270 Nm at 5bar

1000

Max Holding Torque
1800 Nm
Max Clamping Torque
420 Nm at 5bar

82D40-2/82D63-5 SERIES

Pneumatic Power Clamps | Features and Benefits | Technical Information

Features:

- Compact, enclosed design
- Narrow design
- Adapts to various holding arm variants
- High accuracy of positioning due to internal holding arm stopper
- 2 lateral and 1 front mounting areas
- Low weight (aluminium body)
- Integrated inductive sensing module with LED display
- Cylinder diameter 40 mm or 64 mm

Application:

- Clamping, holding, gripping and positioning of metal sheets and other parts, mainly in jigs and handling systems.

Key areas of application:

- Automotive manufacturing, sheet processing industry, jig and general mechanical engineering.



- Automation power clamps, enclosed and narrow design for 2 clamping arms

Models: **82D40-2...**
82D63-5...

82D40-223C900
Base model with
2 U-clamping arms

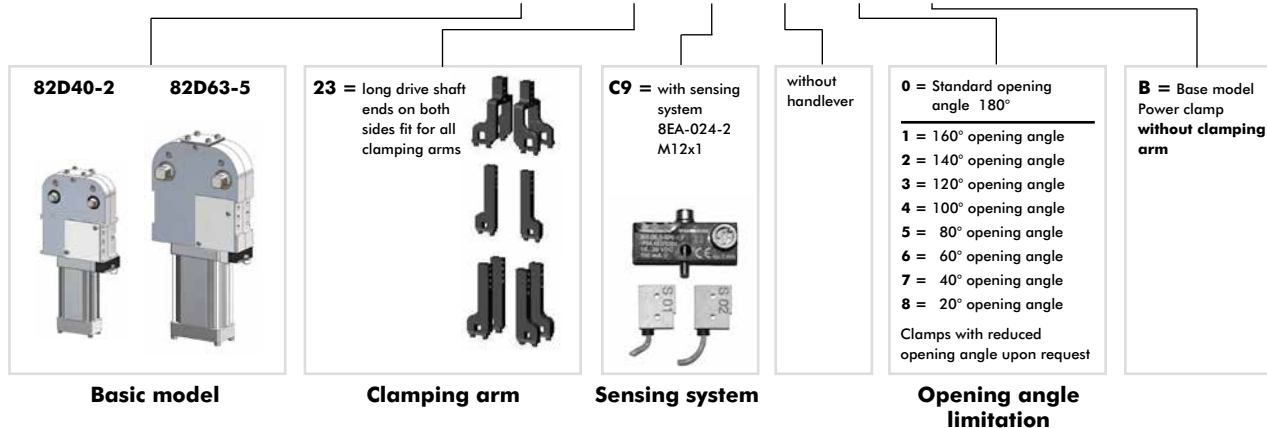
Technical Information

Model	Clamping position	Standard opening angle	Driveshaft	Max. holding torque Nm [lb ft]	Clamping torque at 5 bar Nm [lb ft]	Cylinder Ø mm [in]	Air consumption per double stroke at 5 bar dm ³ [ft ³]	Weight ~ kg [lbs]
82D40-223C900B	vertical	180°	lateral, both sides U-type clamping arms	55 [40]	55 [40]	40 [1.57]	1,2 [0.04]	2,5 [5.50]
82D63-523C900B	vertical	180°	lateral, both sides U-type clamping arms	120 [88]	120 [88]	63 [2.48]	3,8 [0.13]	4,5 [9.90]

Model	B1	B2	B3	L1	SW	G
82D40-223C900B	30	30	60	12,5	11	1/4
82D63-523C900B	47	47	94	21	19	1/4

How To Order

82D63-5 23 C9 0 0 B



U-ARMS CENTER (STEEL)

Pneumatic Power Clamps | Dimensions | Technical Specifications

- Clamping arm variants for **82D40-2**

Clamping arm variant U-type central clamping arm

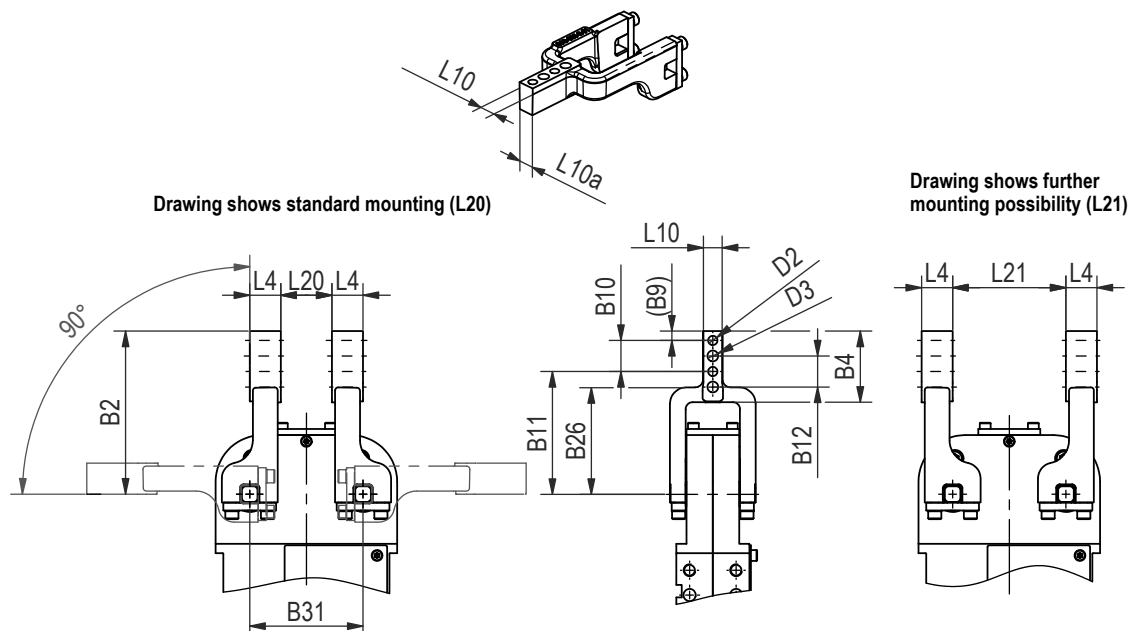


Base model with 2 U-type clamping arms, small gap between clamping arms

U-type central clamping arm | Technical Information

Model	Order no. for U-type clamping arm set (1 clamping arm)	Clamping position	Standard opening angle	B2	B4	B9	B10	B11	B12	B26			
82D40-223C900B	8JG-065-2-01	vertical	180°	105	45,3	6	±0,02	+0,1	±0,2	20	79	20	68,2

Model	Order no. for U-type clamping arm set (1 clamping arm)	B31	D2	D3	L4	L10	L10a	L20	L21
82D40-223C900B	8JG-065-2-01	±0,02	H7 ∅	∅		±1,1	~		
82D40-223C900B	8JG-065-2-01	73	6	7	20	12	11,3	33	73



U-ARMS CENTER (STEEL)

Pneumatic Power Clamps | Dimensions | Technical Specifications

- Clamping arm variants for **82D63-5**

Clamping arm variant U-type central clamping arm

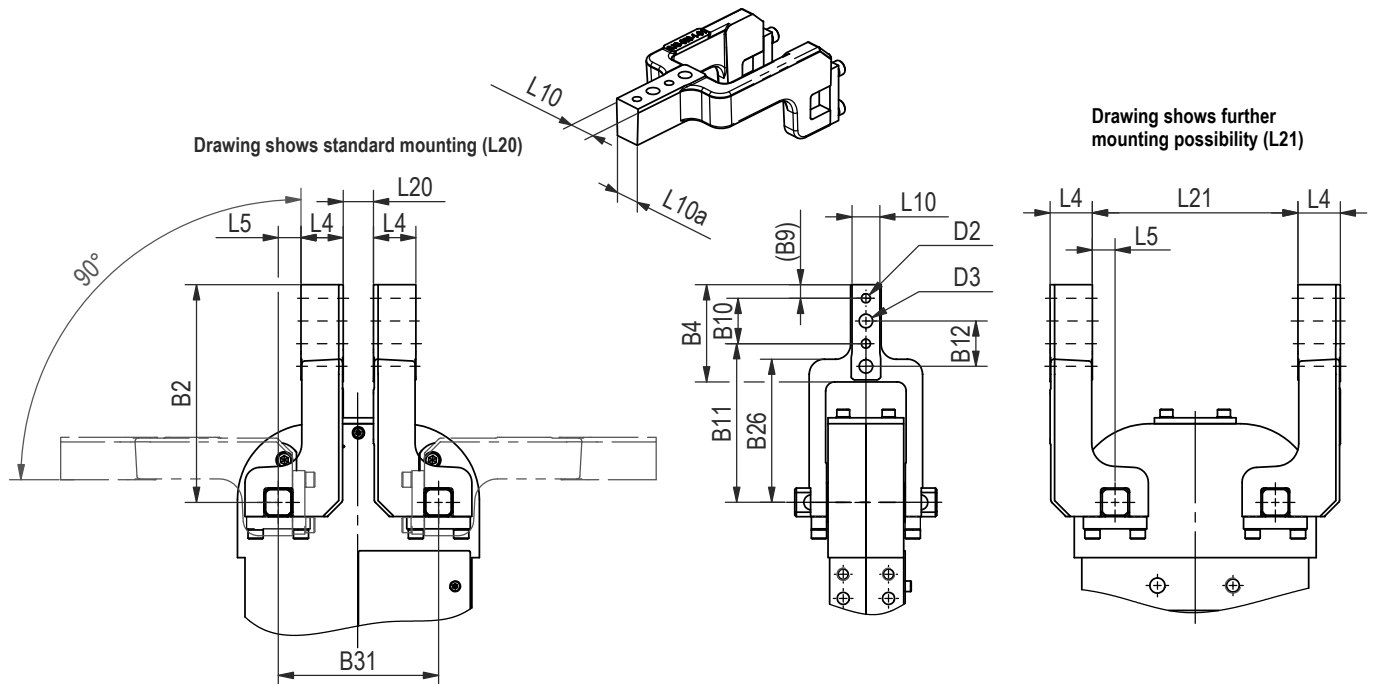


Base model with 2 U-type clamping arms, small gap between clamping arms

U-type central clamping arms | Technical Information

Model	Order no. for U-type clamping arm set (1 clamping arm)	Clamping position	Standard opening angle	B2	B4	B9	B10	B11	B12	B26
82D63-523C900B	8JG-069-1-01	vertical	180°	144	64,3	9	±0,02	+0,1	±0,2	95

Model	Order no. for U-type clamping arm set (1 clamping arm)	B31	D2	D3	L4	L5	L10	L10a	L20	L21
82D63-523C900B	8JG-069-1-01	±0,02	H7 ∅	∅	28	15	±1,2	~	20	136



LATERAL (SIDE) ARMS

Pneumatic Power Clamps | Dimensions | Technical Specifications

- Clamping arm variants for **82D40-2**

Clamping arm variant

- Lateral clamping arm left
- Lateral clamping arm right
- Lateral clamping arm both sides



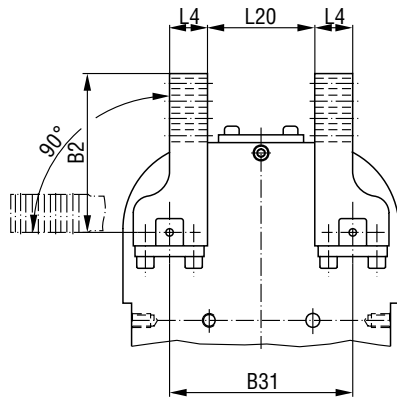
Base model with 4 lateral clamping arms, large gap between clamping arms

Lateral clamping arm | Technical Information

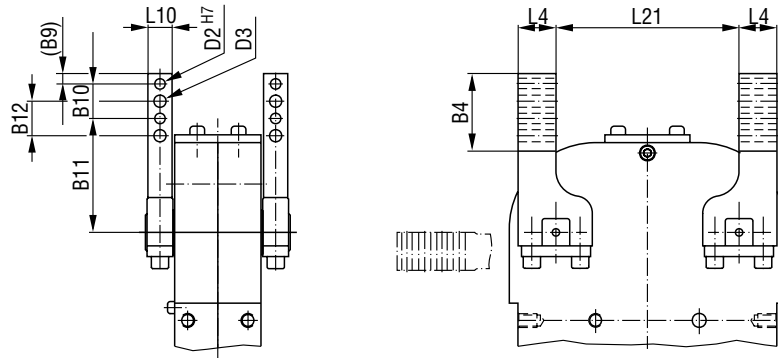
Model	Clamping arm variant	Order no. for 1 set of lateral clamping arms (1 clamping arm)	Clamping position	Standard opening angle	B2	B4	B9	B10	B11	B12
82D40-223C900B	lateral, left lateral, right lateral, both sides	8JG-066-1-01	vertical	180°	105	45	6	±0,02	+0,1	±0,2

Model	Clamping arm variant	Order no. for 1 set of lateral clamping arms (1 clamping arm)	B31	D2	D3	L4	L10	L20	L21
82D40-223C900B	lateral, left lateral, right lateral, both sides	8JG-066-1-01	±0,02	H7 ∅	∅		-0,1		
82D40-223C900B	lateral, left lateral, right lateral, both sides	8JG-066-1-01	73	6	7	20	12	33	73

Drawing shows standard mounting (L20) with four lateral clamp arms



Drawing shows further mounting possibility (L21)



LATERAL (SIDE) ARMS

Pneumatic Power Clamps | Dimensions | Technical Specifications

- Clamping arm variants for **82D63-5**

Clamping arm variant

- Lateral clamping arm left
- Lateral clamping arm right
- Lateral clamping arm both sides



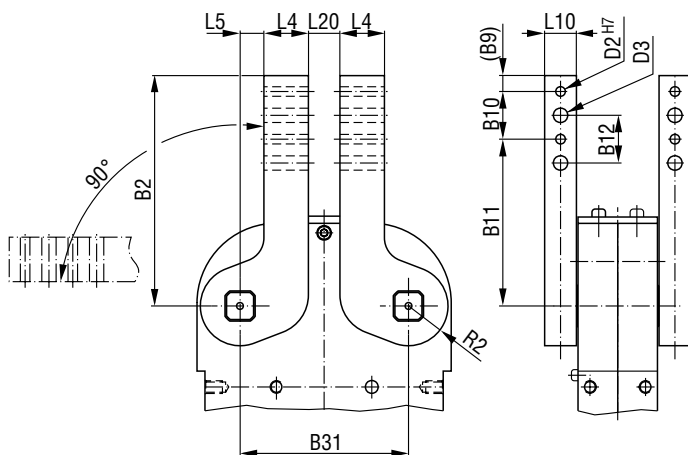
Base model with 4 lateral clamping arms, large gap between clamping arms

Lateral clamping arms | Technical Information

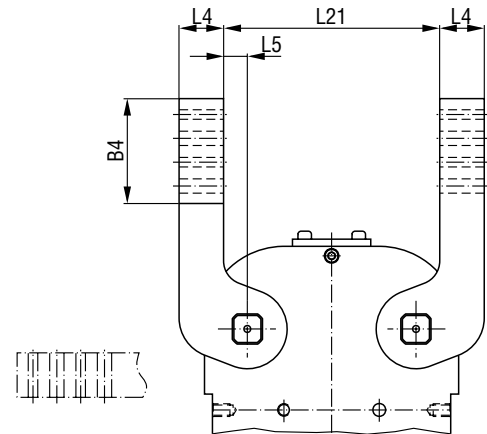
Model	Clamping arm variant	Order no. for 1 set of lateral clamping arms (1 clamping arm)	Clamping position	Standard opening angle	B2	B4	B9	B10	B11	B12
82D63-523C900B	lateral, left lateral, right lateral, both sides	8JG-070-1-01	vertical	180°	144	74	9	30	105	30

Model	Clamping arm variant	Order no. for 1 set of lateral clamping arms (1 clamping arm)	B31	D2	D3	L4	L5	L10	L20	L21	R2
82D63-523C900B	lateral, left lateral, right lateral, both sides	8JG-070-1-01	±0,02	H7 ∅	∅	28	15	20	20	136	28

Drawing shows standard mounting (L20) with four lateral clamp arms



Drawing shows further mounting possibility (L21)

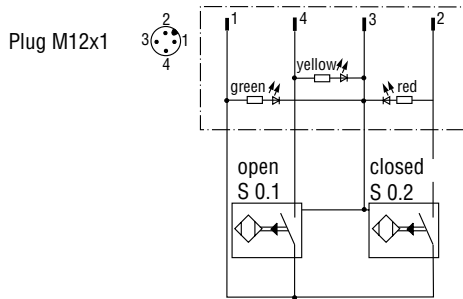
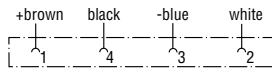


82D40-2/82D63-5 SERIES

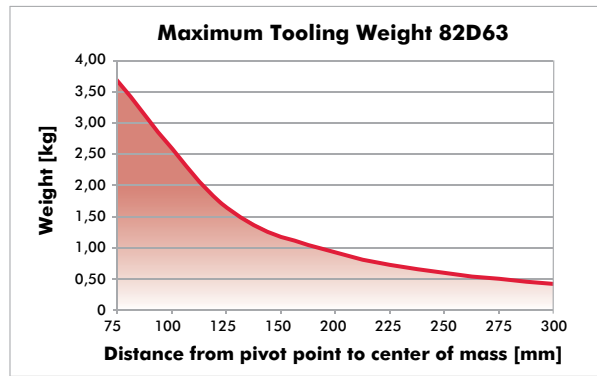
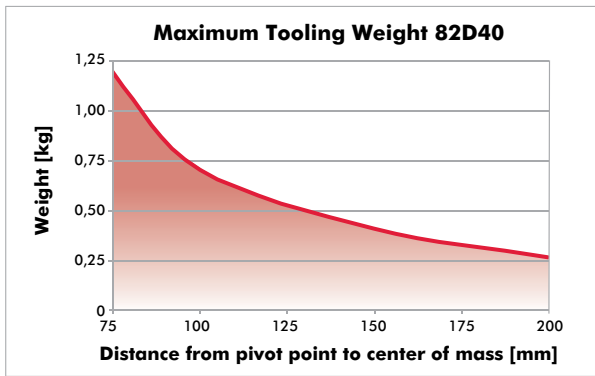
Pneumatic Power Clamps | Technical Specifications

Wiring diagram of electrical sensing system

Sensing system immune to interference from d.c. arc welding and a.c. arc welding

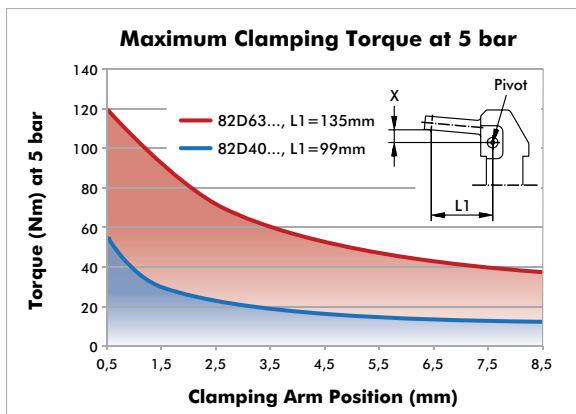


Concept guideline (with reference to axis of clamping arm rotation)



All details apply under an air pressure of 6 bar and opening and closure times of 1 second each

Diagram of clamping torque



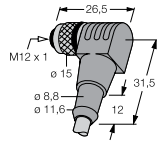
82D40-2/82D63-5 ACCESSORIES

Pneumatic Power Clamps | Technical Specifications

Clamping Arms		Order no. for Structural component		Comment
Clamping are variant	Clamping position	82D40-223C900B	82D63-523C900B	
U-central	vertical	8JG-065-1-01	8JG-069-1-01	sets of U-type clamping arms consist of clamping arm, links and screws
lateral right/left	vertical	8JG-066-1-01¹⁾	8JG-070-1-01²⁾	sets of lateral clamping arms consist of 1) clamping arm, links and screws 2) clamping arm and set screws you need 2 sets of clamping arms
lateral both sides	vertical	8JG-066-1-01¹⁾	8JG-070-1-01²⁾	you need 4 sets of clamping arms



Connector socket
M12x1 straight, 5-pin



Connector socket
M12x1 angular, 4-pin

Connector Cable (includes 1 connector socket & 5 m cable)	Order no. for Structural component	
	82D40-223C900	82D63-523C900
Connector socket M12x1 straight, 5-pin	8EL-002-1	8EL-002-1
Connector socket M12x1 angular, 4-pin	8EL-003-1	8EL-003-1

Opening Angle Limiter	Order no. for Structural component			
	82D40-223C900		82D63-523C900	
Angle	Length	Order No.	Length	Order No.
180° (Standard)	11,4mm	8CE-342-1	14,4mm	8CE-362-1
160°	15,1mm	8CE-340-1	20,0mm	8CE-360-1
140°	18,5mm	8CE-338-1	24,8mm	8CE-358-1
120°	22,2mm	8CE-336-1	29,6mm	8CE-356-1
100°	25,8mm	8CE-334-1	34,3mm	8CE-354-1
80°	28,0mm	8CE-332-1	39,0mm	8CE-352-1
60°	33,0mm	8CE-330-1	43,8mm	8CE-350-1
40°	37,0mm	8CE-328-1	49,1mm	8CE-348-1
20°	41,8mm	8CE-326-1	56,2mm	8CE-346-1

Shim Plates (for clamping arm)	Fit for model 82D40-2								Fit for model 82D63-5									
	Model	A1	A2	D2	D3	B9	B10	B12	L10	Model	A1	A2	D2	D3	B9	B10	B12	L10
	82ZB-SH4001		0,1							82ZB-SH5001		0,1						
	82ZB-SH4002		0,2							82ZB-SH5002		0,2						
	82ZB-SH4005	42	0,5	6,5	7	6	20	20	12	82ZB-SH5005	65	0,5	6,5	9	10	30	30	16
	82ZB-SH4010		1,0							82ZB-SH5010		1,0						
	82ZB-SH4020		2,0							82ZB-SH5020		2,0						
	82ZB-SH4050		5,0							82ZB-SH5050		5,0						

Spare Parts	Order no. for Structural component	
	82D40-2	82D63-5
Cylinder	8PW-016-1	8PW-024-2
Integrated sensing system C9 Connector plug M12x1	8EA-024-2	8EA-024-2

TECHNICAL APPENDIX

Manual Clamping Technology

Selecting The Proper DESTACO Clamp

The information contained in this catalog is designed to help you select the right clamp to accomplish your job. DESTACO distributor personnel, as well as DESTACO's Technical Service department, are qualified and willing to offer assistance in special or unusual applications. For most ordinary applications, however, consideration of the following points will lead to the proper clamp selection

- Size and shape of the parts to be held.
- Uniformity of part size (Should you consider a spring-loaded spindle to compensate for uneven parts?)
- Holding capacity required
- Strength and dexterity of the operator
- Operator's position (Should you use horizontal or vertical handle models?)
- Frequency of operation (Should you plan for a temporary or permanent fixture?)
- Time cycle of operation (Should you consider a turntable or conveyor set-up if curing time is required?)
- Cycling time and sequence (Should you consider air-operated models that can be operated faster and in sequence?)
- Environment (Should a stainless steel model be considered?)

Processing Applications

Remember, the same toggle action force multiplying principle can be applied to other tasks besides holding. Certain DESTACO models can be used to position parts, power fixtures or perform mechanical functions such as piercing sheet metal, staking rivets or locating.

OEM Applications

DESTACO clamps provide ready-made, compact devices for moving or holding components. A little imagination will often show the product designer a way to obtain motion or locking force with no tooling costs and often at less cost than custom designed components. Thousands of DESTACO clamps will be found installed as original equipment for cleanout door latches, wheel locks, positioning devices, etc.

Safety

Our concern is not only the constant high quality of our products, but also their fail-safe and foolproof handling. The knowledge gathered since 1936 guarantees a developed, safe and high-quality clamping unit.

A certain clamping force will be necessary to safely hold a part. This force is determined by taking the following into account:

- (A) the part material: such as, steel, wood, plastic or glass, etc.
- (B) the surface finish of the part: such as, polished, hard or soft, etc.
- (C) the machining or assembly operation: such as, milling, welding, drilling, bonding, joining or sealing a mold, etc.

In order to ensure clamp strength is not compromised, use all the mounting holes provided.

Red handle grips are provided on each model. Users should only locate their hand in this area when operating the clamp, thus reducing the possibility of injury.

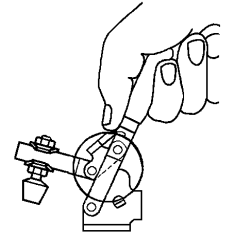
Safety Handle

This ergonomic handle provides greater operator comfort.



Safety Feature

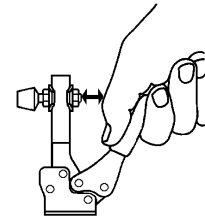
This safety link prevents accidental injury to an operator when opening the clamp.



Clamp Series 201, 202, 207, 210,247,267

Safety Distance

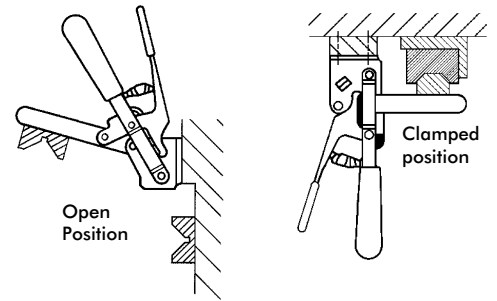
Exclusive handle design gives more hand clearance between bar and handle when clamp is in fully open position.



Clamp Series 213, 217, 227, 237, 245

DESTACO Toggle-Lock Plus Clamps

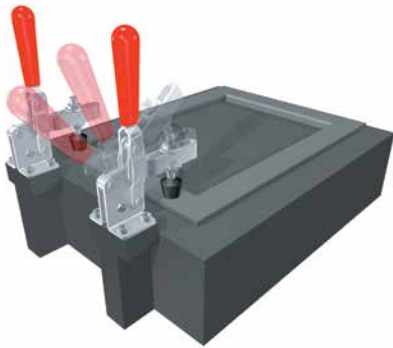
We have taken several of our most popular toggle clamps and have added a locking release lever for improved safety. The locking release lever helps ensure that the over-center locking condition is maintained. In order to unlock each clamp, the locking lever must first be released. The additional locking feature expands the range of applications where DESTACO clamps can be used. If a clamp application warrants concerns over accidental or unintentional opening, then a DESTACO Toggle-Lock Plus clamp is right for the job.



The most important models at a glance:

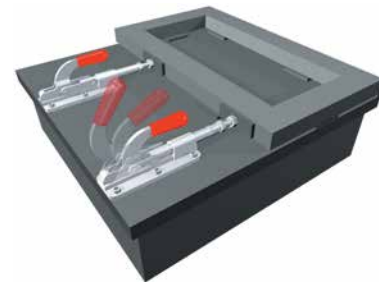
Vertical hold-down clamp

- Handle is vertical in clamped position
- Holding capacities up to 22,25kN [5000lbf.]
- Opening angle between 65° and 215°



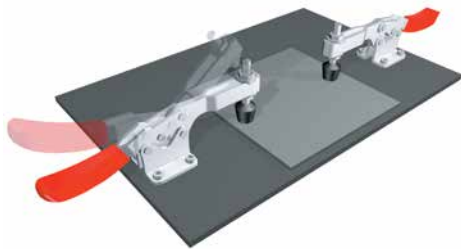
Straight line action clamp

- Forward movement of the handle pushes the plunger into the forward position
- Can be used as a push clamp and pull clamp, locking in two positions
- Holding capacities of 445N-71,2kN [100-6,000lbf.]



Horizontal hold-down clamp

- Very low profile
- Handle is horizontal in the clamped position
- Holding capacities up to 7,5kN [1,680lbf.]
- Opening angle between 90° and 105°



Latch clamp

- Convenient one-hand operation due to the patented thumb control lever
- Compact models
- Holding capacities up to 33,4kN [7,500lbf.]



Plier clamp

- Flexible clamping and fixturing
- Also equipped with quick release lever
- Holding capacities 450N-5340N [100-1200lbf.]



TECHNICAL APPENDIX

Manual Clamping Technology

How Toggle Action Works

Toggle action clamps operate through a linkage system of levers and pivots. The fixed-length levers, connected by pivot pins, supply the action and clamping force. Toggle action has an over-center lock point which is a fixed stop and linkage. Once in the over-center position, the clamp cannot move or unlock unless the linkage is moved. All types of toggle clamps have this same action, just oriented differently.

Toggle Action Force Factors

The maximum clamping or exerting force developed in any toggle action clamp is attained when the three pivot points of the mechanism are in a straight line. While this is theoretically true, it makes no allowance for vibration and intermittent load conditions found in industrial applications. Such conditions would soon unlock an improperly designed clamp. The proper amount of over-center travel to produce maximum holding force and yet ensure positive locking is a carefully calculated and controlled dimension developed by years of experimentation and experience.

Throughout this catalog each clamp is rated with its "holding capacity." This is the maximum load or force the clamp will sustain in the closed and locked position without permanent deflection. Exerting forces applied as the clamp closes are less than the holding capacity, and are dependent on variables such as the position of the operator's hand on the handle; amount of force applied; and position of the spindle on the bar.

What about the forces?

In the case of clamping products, a clear distinction must be made between exerting forces and holding capacities. Here are the essential features:

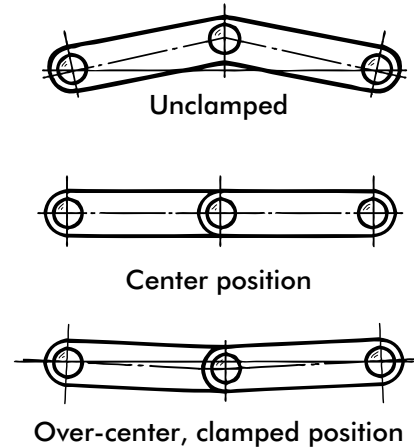
Exerting or Clamping Force

The "exerting force" of our air toggle clamps is well defined and can be found on page 7. Manually operated clamps present a series of variables to determine actual exerting force.

These variables are:

- the force exerted on the handle by the operator;
- the point on the handle where this force is applied;
- the mechanical advantage in the linkage; and
- the point on the work holding bar where the force will be measured. As a general rule, the mechanical advantage available throughout the line ranges 2:1 to 10:1

Toggle Action Principle

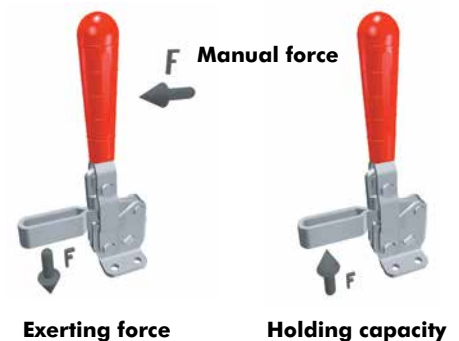


Toggle Action Clamps Compared with Cam Action Clamps

Cam action uses frictional force to effect a locking condition between the cam surface on the bar and the follower on the handle. Toggle action clamps have many advantages over cam action clamps, mainly because cam action clamps allow some movement while clamping. Toggle action clamps thus provide a more consistent clamping point, can be manufactured from inexpensive materials, and are available in stainless steel for outdoor or corrosive applications. If the material being clamped has a variable thickness, however, a cam action clamp has the ability to better accommodate this application.

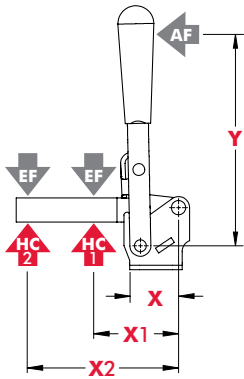
Holding Capacity

The "holding capacity" of DESTACO toggle clamps has been determined by actual tests. It is defined as the maximum amount of force which may be applied to the work holding bar, in the closed position, without creating permanent deformation of the clamp components. This maximum force is measured at a point closest to the base and diminishes as the spindle approaches the end of the bar. The ratings for holding capacity are maximum and should not be exceeded. These values include a safety factor.



Calculating Exerting or Clamping Force

The table below depicts holding capacity (HC) and clamping force (EF) data for a typical manual clamp. The clamping force (EF) is expressed as a ratio of the force that is applied to the clamp handle (AF). In this example, either 10:1 or 5.3:1 depending upon position of the clamping point on the clamp arm. That is, at position X1, the maximum clamping force (EF) that can be generated is 10 times the force that is applied to the clamp handle.



Model	X	X1	X2	Y	±HC1	±HC2	±EF(X1):AF	±EF(X2):AF
2007-()	[1.59] 40,5	[1.95] 49,5	[3.92] 99,5	[5.16] 131	[1000lbf.] 4450N	[470lbf.] 2090N	10:1	5.3:1

Dimensions shown "mm [inch]" ± HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
Refer to page MC-TEC-4 for additional information.

Examples:

- Find the force (AF) the operator would have to apply to the clamp to generate a clamping force of 400N [90lbf.] at the end of the clamp arm (X1).

$$AF = 400 \div 10 = 40N [9lbf.]$$

- What is the maximum clamp force that can be generated at X2 if the operator is only able to apply 20N [4.5lbf.] to the clamp handle?

$$EF = 20 \cdot 5,3 = 106N [24lbf.]$$

Calculating Holding Capacity

The holding capacity (HC) ratings shown in the table are in relation to the pivot point of the clamping arm. This is useful in estimating the holding capacity at an intermediate clamping point along the arm, or at a point beyond the length of the standard clamping arm.

Examples:

- Find the maximum holding capacity if the clamping point is 40mm [1.5in.] from the front of the base of the clamp.
 - Step 1 – find the clamping distance from the clamping point to the pivot point

$$X_c = 40mm + X = 40mm + 40,5mm = 80.5mm$$

- Step 2 – express the holding capacity as a moment

$$M = X1 \cdot HC1 = 49,5mm \times 4450N = 220275 \text{ N}\cdot\text{mm}$$

- Step 3 – calculate the holding capacity at Xc

$$HC = M \div X_c = 220275 \div 80,5 = 2736N [615lbf.]$$

- Find the maximum holding capacity if the clamp arm is extended by 25mm [1in.]

$$X_c = 25+X2 = 25 + 99,5 = 124,5mm$$

$$M = X2 \cdot HC2 = 99,5mm \cdot 2090mm = 207955 \text{ N}\cdot\text{mm}$$

$$HC = M \div X_c = 207955 \div 124,5 = 1670N [375lbf.]$$

TECHNICAL APPENDIX

General Specifications

Material, finishes, treatments, etc. of DESTACO products are changed from time-to-time to improve performance or reliability. These items are, naturally, subject to change without notice. In the interest of catalog longevity, they are not discussed in detail throughout the catalog. As of the date of going to press, however, the following specifications apply unless noted otherwise:

Materials

In general, light and medium duty clamp components are made from low carbon cold-rolled steel. Materials for other models vary depending upon the clamp model and specific engineering requirements. These materials include low to medium carbon steel castings and forgings, heat treated as necessary to obtain the desired mechanical properties.

Pivot pins for most light and medium duty clamps are cold headed from precision cold drawn type 430, EN 1.4016 stainless steel. Pins for heavy duty models are made from heat treated alloy steel. Bushings used in select models are made from low carbon, case-hardened steel for wear resistance and serrated on the outside diameter to prevent rotation.

Ergonomic grips are made from an oil-resistant plasticized PVC compound, while some handles and locking levers covered with plastisol dipping.

Stainless Steel

Stamped components in our stainless steel clamps are made from type 302/304, 1.4300 or 1.4301 (or comparable) stainless steel, annealed & cold rolled. Machined stainless steel components are type 303, EN1.4305 (or comparable).

Finishes

Most manual toggle clamps are electro-plated zinc per ASTM B633-98, SC1, type2 (or comparable). Most cast or forged components are finished black oxide with light oil to add corrosion protection.

Mounting

To properly secure the clamp to the mounting surface and achieve the clamp's rating, all mounting holes provided must be used.

Modifications

Making changes to the clamp may affect the performance of the product. The life expectancy of a clamp is dependent upon many factors, including alterations to the clamping bar, handle, or the addition of any tooling. Manual clamps are rated using hand power to actuate them. The use of "cheater bars" or hammers to impact the opening or closing of the clamp is expressly prohibited.

Maintenance

Manual clamps are generally maintenance free; however, lubrication of pivot points will extend the life of the clamp dramatically. Clamps are shipped from the factory with a light coating of oil, occasional lubrication with a lightweight machine oil at pivot points is recommended. A typical oil specification is ISO grade 22 or 46 (SAE No. 10W or 20).

Temperature Limits

DESTACO manual clamps are intended to be used at normal ambient temperatures. These limits are intended to be guidelines and you should contact DESTACO if you have a specific application concern. For low-carbon steel clamps: -65°F(-54°C) to 480°F(250°C); for stainless steel (type 304): up to 750°F (400°C). These values are based upon maintaining the tensile strength of the material, due to the many variables associated with operating clamps at elevated temperatures service life may be affected. Bear in mind that for low carbon steel parts that are zinc plated, the plating has a useful service temperature of up to 250°F(120°C), but corrosion inhibiting properties degrade above 140°F(60°C). These temperatures are NOT inclusive of any plastic grip, vinyl dipping, rubber spindle accessory, pneumatic, or hydraulic actuator.

End position sensing of pneumatic clamps for automated production.



Model 807-S with 2 integral groove mounted sensors (order separately)

Exerting Force vs. Holding Capacity

Due to the nature of the toggle action within the clamping mechanism combined with the line pressure of the cylinder, care should be taken in setting up Pneumatic Toggle Clamps.

The clamping force of a given pneumatic toggle clamp is determined by two factors - adjustment of the clamping spindle and the line pressure in the cylinder. If the line pressure remains constant, then the clamping force is solely determined by the vertical adjustment of the spindle. If the spindle is improperly adjusted, the clamp is capable of creating a clamping force that exceeds the rated holding capacity.

As a result of this condition care must be taken by properly adjusting the spindle OR by regulating the inlet pressure to the cylinder in order to insure the clamp does not exert a force higher than it's rated holding capacity.

Please consult the table and formulae on the next page. The Max M.A. is the highest mechanical advantage the clamp can create at the optimum spindle height while still toggle-locking.

Remote control and end position sensing

A particularly interesting advantage of DESTACO power clamps is the fact that they may be mounted on rather inaccessible places of clamping fixtures and they may be operated simultaneously while being controlled by a control valve. Power clamps with an end position sensing system allow fully automated operation within controlled manufacturing processes.

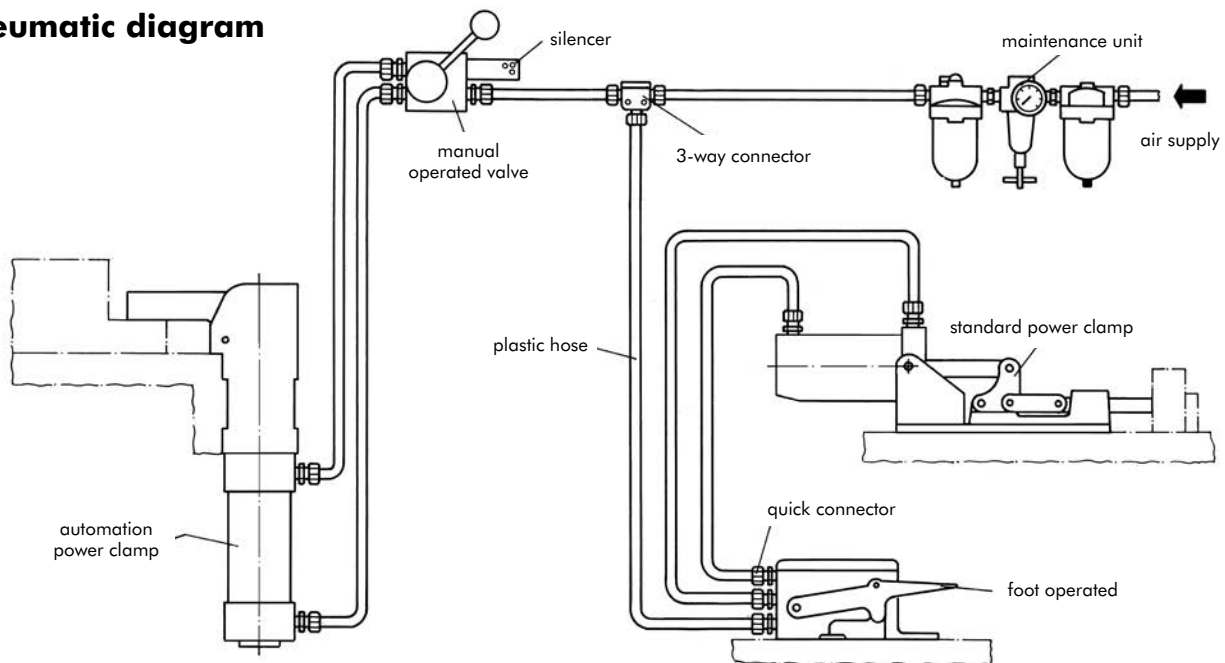
Safety

DESTACO power clamps are based on the toggle action principle (exceptions will be mentioned separately) and offer the same safety advantages as DESTACO manual clamps: no risk of accidental opening of the clamp arm - even in case of a sudden pressure drop.

The toggle action principle with over-center locking guarantees safety during operation and protects the parts from damage. (Provided that the power clamps are mounted correctly and the air supply is reliable.)

Note: Most pneumatic products are now supplied with a magnetic ring on the piston as a standard feature for sensing the position of the cylinder (open/closed).

Pneumatic diagram



TECHNICAL APPENDIX

Specifications

Model no.	Cylinder Bore		Rod Diameter		Cylinder Area (Clamping Stroke)		Cylinder Area (Opening Stroke)		Max. Mechanical Advantage (M.A.)		Distance From Pivot				Holding Capacity				Max Inlet Pressure at Max M.A.*				Max. Clamping Force at 5 bar [72 psi]			
											A		B		A		B		A		B		A		B	
	(in)	(mm)	(in)	(mm)	(in ²)	(mm ²)	(in ²)	(mm ²)	A	B	(in)	(mm)	(in)	(mm)	(lbf.)	(N)	(lbf.)	(N)	(PSIG)	(bar)	(PSIG)	(bar)	(lbf.)	(N)	(lbf.)	(N)
Hold Down Clamps																										
802-U	1.26	32	0.47	12	1.25	804	1.07	691	5.0	2.6	1.25	31.8	2.25	57.2	200	890	110	489	32	2.2	34	2.3	450	2010	234	1045
807-S	1.26	32	0.47	12	1.25	804	1.07	691	6.0	2.0	2.00	50.8	5.00	127.0	500	2220	260	1160	67	4.6	104	7.2	540	2412	180	804
807-U	1.26	32	0.47	12	1.25	804	1.07	691	6.4	3.3	2.00	50.8	3.75	95.3	375	1670	275	1220	47	3.2	67	4.6	576	2573	297	1327
810-S	1.57	40	0.63	16.0	1.95	1257	1.64	1056	5.0	2.9	2.38	60.5	5.31	134.9	750	3340	500	2220	77	5.3	89	6.1	702	3143	407	1823
810-U	1.57	40	0.63	16.0	1.95	1257	1.64	1056	6.1	2.9	2.38	60.3	4.88	123.8	600	2670	290	1290	50	3.5	51	3.5	856	3834	407	1823
812-U	0.75	19	0.25	6.4	0.4	258	0.39	253	4.3	2.9	1.25	31.8	2.25	57.2	100	440	55	245	53	3.6	43	3.0	136	613	92	413
846	1.57	40	0.63	16.0	1.95	1257	1.64	1056	5.6	3.5	2.25	57.2	3.25	82.6	750	3340	520	2310	69	4.7	76	5.3	786	3520	491	2200
847-S	2.05	50	0.63	16.0	3.29	2124	2.98	1923	4.0	1.8	3.25	82.6	6.50	165.1	1000	1118	650	2890	76	5.2	110	7.6	948	4248	426	1912
847-U	2.05	50	0.63	16.0	3.29	2124	2.98	1923	4.0	1.9	3.25	82.6	6.25	158.8	1000	4450	480	2135	76	5.2	77	5.3	948	4248	450	2018
858	2.48	63	0.98	25.0	4.83	3117	4.07	2626	4.4	2.3	3.00	76.2	7.00	177.8	4000	17800	2000	8900	145**	10.0**	145**	10.0**	1530	6857	800	3585
8021	1.26	32	0.47	12.0	1.07	691	1.25	8.4	2.2	1.3	1.70	43.2	2.60	66.0	390	1735	255	1135	145**	10.0**	145**	10.0**	169	760	100	449
8071	1.57	40	0.63	16.0	1.64	1056	1.95	1257	4.2	2.4	2.25	57.2	3.25	82.6	450	2000	310	1380	65	4.5	79	5.4	496	2218	283	1267
8101	2.05	50	0.63	16.0	2.98	1923	3.29	2124	2.3	1.2	2.35	59.7	4.45	113.0	700	3110	370	1645	103	7.1	105	7.3	491	2202	253	1135
817-S	1.26	32	0.47	12.0	1.25	804	1.07	691	4	2.25	2.75	69.9	4.94	125.5	450	2000	200	890	90	6.2	64	4.4	360	1608	225	1005
817-U	1.26	32	0.47	12.0	1.25	804	1.07	691	4.1	2.5	2.75	69.9	5.00	127.0	375	1670	200	890	73	5.1	64	4.4	369	1648	225	1005
827-S	1.57	40	0.63	16.0	1.95	1257	1.64	1056	3.5	2	2.50	63.5	5.30	134.6	700	3110	330	1470	103	7.1	85	5.8	491	2200	281	1257
827-U	1.57	40	0.63	16.0	1.95	1257	1.64	1026	3.5	2.2	2.13	54.1	3.25	82.6	600	2670	390	1735	88	6.1	91	6.3	491	2200	309	1383
868	2.48	63	0.98	25.0	4.83	3117	4.07	2626	4.9	2.3	5.00	127.0	8.25	209.6	4000	17800	2400	10675	145**	10.0**	145**	10.0**	1704	7637	800	3585

Model no.	Cylinder Bore		Rod Diameter		Cylinder Area (Clamping Stroke)		Cylinder Area (Opening Stroke)		Max. Mechanical Advantage (M.A.)	Holding Capacity		Max Inlet Pressure at Max M.A.				
	(in)	(mm)	(in)	(mm)	(in ²)	(mm ²)	(in ²)	(mm ²)		(lbf.)	(N)	(PSIG)	(bar)			
Straight Line Action Clamps																
803	1.26	32.0	0.47	12.0	1.25	804	1.07	691.2	7.5		600	2670	64	4.4	675	3015
816	0.75	19.1	0.25	6.4	0.44	285	0.39	253.4	7.7		100	400	30	2.0	244	1097
830	1.57	40.0	0.63	16.0	1.95	1257	1.64	1055.6	5.7		2500	11100	145**	10.0**	800	3582
850	2.05	52.0	0.63	16.0	3.29	2124	2.98	1922.7	5.2		16000	71200	145**	10.0**	1232	5522
8031	1.13	28.6	0.38	9.5	0.99	641	0.88	570.0	10.25		2000	890	145**	10.0**	731	3285

* Maximum cylinder pressure is 145 PSIG (10 bar). Never exceed this value

**Maximum inlet pressure in conjunction with maximum mechanical advantage does not exceed holding capacity. Do not exceed maximum cylinder pressure

Formula for calculating maximum allowable inlet pressure:

$$\text{Maximum Line Pressure} = \text{Holding Capacity} \div (\text{Cylinder Area} \times \text{Mechanical Advantage})$$

Formula for calculating max. exerting force:

$$\text{Exerting Force} = \text{Inlet Pressure} \times \text{Mechanical Advantage} \times \text{Cylinder Area}$$

Example for Model 830

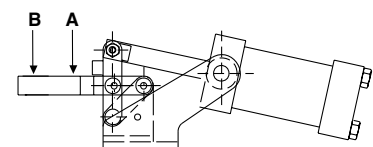
Holding Capacity = 11100N [2500lbf.]

Inlet Pressure 5bar (0,5 N/mm²) [72psig]

Cylinder Area = 1257mm² [1.95in²]

Maximum Line Pressure = 11100 ÷ (1257 X 5.7) = 1,5 N/mm² = 15bar

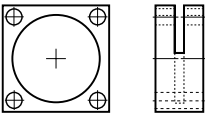
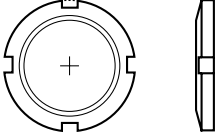

NOTE: This exceeds the maximum allowable cylinder pressure of 10bar



Spindle position to determine mechanical advantage.

HYDRAULIC POWER CLAMPS

Table of Contents

Hydraulic Clamping		Page MC-HYD-#
	010-210-400	3-4
	010-210-501	
	010-210-702	
	010-211-002	
	010-211-004	
	010-211-502	
	010-211-504	
	010-212-004	
	052-Series	4
	051-Series	4
	020-011-011DE	5
	020-012-021DE	
	020-013-031DE	

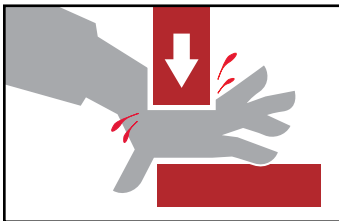
Hydraulic Clamping		Page MC-HYD-#
	030-1-S-475	7
	030-1-D-475	
	030-1-S-1100	8
	030-1-D-1100	
	030-1-S-2400	9
	030-1-D-2400	
	030-1-S-4000	10
	030-1-D-4000	10
	031-S-475	11-12
	031-L-475	
	031-S-1100	
	031-L-1100	
	031-S-2400	
	031-L-2400	
	031-S-4000	
	031-L-4000	
	039-101-000DE	13
	039-104-000DE	

BUILDING SAFE HYDRAULIC SYSTEMS

Hydraulic Power Clamps | Safety

Safety means paying attention to the smallest details. A hastily assembled workholding system can result in a hazardous operator environment. Hydraulic workholding is not a generic technique where most anything will work, nor is there one right or best answer for all situations. Each application is different and can be approached in many different ways. Because of this versatility, there is no rule-of-thumb to follow to guarantee safety. A careful balance of knowledge, fixture design and common sense are key to avoiding injuries.

Plan your fixture installation with operator safety in mind. By nature, most clamping devices have pinch points. Many times the fixture can be designed to shield the operator from a pinching hazard. Often the placement of the clamping device in the fixture can minimize the gap between the clamp and the workpiece, thus reducing or eliminating the pinch point. Perhaps the clamping control valve or switch can be located such that the operator cannot reach the fixture and the control at the same time. Dual palm buttons on electrically-actuated systems serve the same purpose.



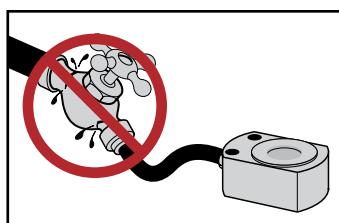
Do not require the operator to hold the workpiece in position during the clamping operation. Make sure that the workpiece is self-supporting and self-locating so that operator hands are out of

danger when the hydraulic system is actuated. Often a simple spring plunger is all that is necessary.

The lowest pressure rating of any component in the clamping system sets the *maximum* pressure rating for the entire system.

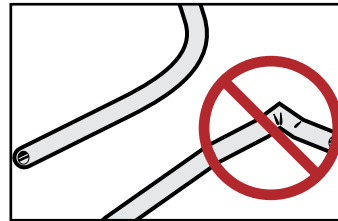
Most hydraulic workholding components are rated at 5,000 PSI maximum.

However, some components are rated at less than 5,000 PSI. The maximum pressure is listed on each product page of this catalog. *Never exceed this rating.*



Just having a clamp that is rated at 5,000 PSI is not enough. Every hose, fitting, valve, adapter and tube exposed to pressure must be rated at or above the maximum hydraulic system pressure. Most

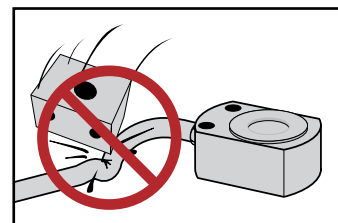
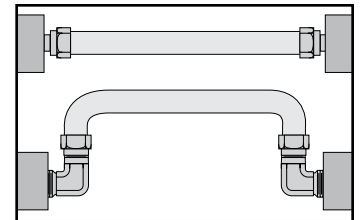
“hardware store” fittings are intended only for low pressure plumbing. *Never use water pipe fittings or copper tubing and brass fittings for hydraulic service.*



Use proper tools when bending tubing, and maintain proper minimum bend radii for hoses and tubing. If a hose or tube is ever kinked, replace it. Don't risk a rupture. Fluid escaping

under high pressure is dangerous. The resulting loss in pressure could release the workpiece from the fixture and cause serious injury and equipment damage by being ejected from the machine or breaking tooling.

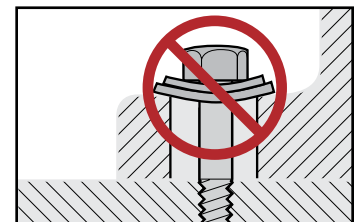
Tubing and hoses do flex when pressurized. Allow for that movement by supporting the fluid lines away from surfaces which could abrade the surface and eventually cause damage. Avoid straight lengths of hose and tubing. A bend will allow for this deflection without putting too much stress on the line.



Even if proper hydraulic tubing and fittings are specified, be sure to protect them from abuse. Components damaged from abrasion or accidental dropping of a workpiece will no longer

have the strength and safety of the original design.

Use **proper mounting hardware** when installing workholding clamps and other components. Always use the largest bolt available to fit in the mounting hole. In many cases, the recommended cap screw or thread is specified on the product page of this catalog. Sometimes the mounting hardware is included with the component. Always use supplied hardware.



Safety means paying attention to the smallest details.

010 SERIES

Hydraulic Power Clamps | Hydraulic Threaded Body Cylinders Product Overview

The single-action, spring-return hydraulic power cylinders are small pistons that can be used singly or combined. They offer tremendous force in a small, easily mounted package that can be used in any attitude and requires only a single inlet port. They are often used grouped together by a common manifold to provide as much force as needed for the operation. For a relatively small volume of oil, they provide exceptional exerting force, and are generally the best choice if stroke lengths can be kept short.



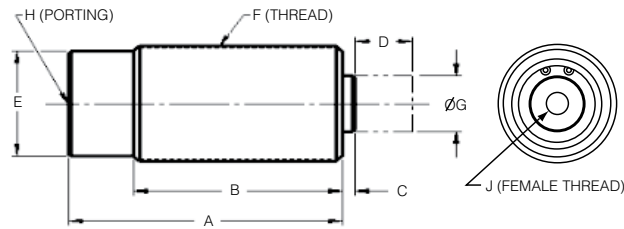
Features:

- Threaded body for easy mounting
- Small size permits "low profile" workholding
- Accessories available for easy mounting
- Available in metric or inch sizes (Metric on special request)
- Hardened piston and rod
- Single-acting for simple plumbing
- Wide variety of sizes and strokes
- Pressure capacity up to 5,000 PSIG, provided piston does not bottom out

Technical Information

Model no.	SAE Ports	Threaded Body	Stroke	Force at 3,000 PSIG	Oil Displacement	Effective Area For Clamping	Jam Nuts
010-210-400	#2	1/2-20	0.22	279 lbs.	0.024 cu. in.	0.110	Furnished
010-210-501	#4	3/4-16	0.31	588 lbs.	0.061 cu. in.	0.196	Furnished
010-210-702	#4	1-12	0.50	1,326 lbs.	0.221 cu. in.	0.442	Furnished
010-211-002	#4	1 5/16-16	0.50	2,355 lbs.	0.393 cu. in.	0.785	Optional
010-211-004	#4	1 5/16-16	1.00	2,355 lbs.	0.785 cu. in.	0.785	Optional
010-211-502	#4	1 7/8-16	0.50	5,301 lbs.	0.884 cu. in.	1.767	Optional
010-211-504	#4	1 7/8-16	1.00	5,301 lbs.	1.767 cu. in.	1.767	Optional
010-212-004	#4	2 1/2-16	1.00	9,423 lbs.	3.142 cu. in.	3.142	Optional

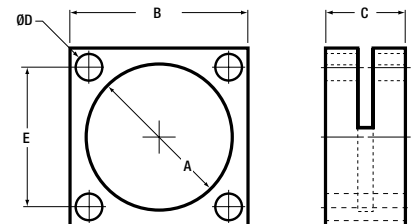
Hydraulic Power Clamps | Hydraulic Threaded Body Cylinders Product Overview



Model no.	Dimensions (In Inches)									
	A	B	C	D	E	F	G	H	J	
010-210-400	1.66	1.41	0.19	0.22	.044 Hex	1/2-20	0.15	SAE #2	-	
010-210-501	2.25	1.97	0.22	0.31	.062 Hex	3/4-16	0.22	SAE #4	-	
010-210-702	2.56	2.31	0.31	0.50	.075 Hex	1-12	.024	SAE #4	-	
010-211-002	2.63	2.25	0.13	0.50	1.00 Hex	1 5/16-16	0.64	SAE #4	1/4-20	
010-211-004	3.63	3.25	0.12	1.00	1.00 Hex	1 5/16-16	0.64	SAE #4	1/4-20	
010-211-502	2.94	2.57	0.13	0.50	1.50 Hex	1 7/8-16	1.00	SAE #4	5/16-18	
010-211-504	4.59	4.22	0.14	1.00	1.50 Hex	1 7/8-16	1.00	SAE #4	5/16-18	
010-212-004	4.13	3.76	0.13	1.00	2.00 Hex	2 1/2-16	1.50	SAE #4	5/16-18	

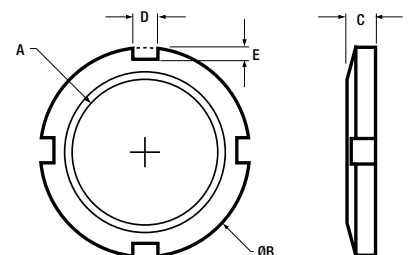
Series 052 Flange Mount

Model no.	Dimensions (In Inches)					
	A	B	C	øD	E	
052-112-160	1 1/8-16 UN 2B	1.50	0.50	0.22	1.030	
052-131-160	1 5/16-16 UN 2B	1.69	0.50	0.27	1.250	
052-137-180	1 3/8-16 UN 2B	1.75	0.50	0.27	1.340	
052-187-160	1 7/8-16 UN 2B	2.25	1.00	0.34	1.770	
052-250-160	2 1/2-16 UN 2B	3.00	1.00	0.34	2.170	



Series 051 Jam Nut

Model no.	Dimensions (In Inches)					
	A	B	C	D	E	
051-112-160	1 1/8-16 UN 2B	1.500	0.31	0.250	0.250	
051-131-160	1 5/16-16 UN 2B	1.688	0.31	0.250	0.250	
051-137-180	1 3/8-16 UN 2B	1.875	0.31	0.250	0.250	
051-187-160	1 7/8-16 UN 2B	2.625	0.38	0.312	0.132	
051-250-160	2 1/2-16 UN 2B	3.250	0.50	0.312	0.312	



020 SERIES

Hydraulic Power Clamps | Thru-Hole Hydraulic Ram Product Overview

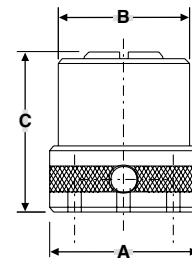
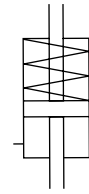
By inserting a rod through the hollow piston, these cylinders can be used to push or pull depending on the orientation of the ram. They will actuate a rod of any length or shape and are extremely effective in translating power to a remote location. Greater forces are generated in these thru-hole rams because of their larger piston area.

Features:

- Larger piston diameter for greater clamping forces
- Hardened steel piston and rod
- Single-acting for simple plumbing
- Optional threaded inserts
- Optional mounting plate (permits mounting ram with a single cap screw)



Symbol



Model no.	RAM I.D.*	Port	Stroke	Force at 3,000 PSIG	Oil Displacement	Dimensions		
						A	B	C
020-011-011DE	0.38	SAE #2	0.38	4,380 lbs.	0.547 cu. in.	2.13	1.88	2.25
020-012-021DE	0.50	SAE #4	0.50	8,100 lbs.	1.35 cu. in.	3.00	2.63	2.88
020-013-031DE	0.63	SAE #4	0.63	12,066 lbs.	2.51 cu. in.	3.25	3.00	3.63

* Clearance for rod or bolt of given dimension.

Maximum input pressure 3,500 PSIG.

Accessories

All size thru-hole rams are supplied with a thru-hole insert threaded into the top. Optional threaded inserts, inch or metric, are also available.

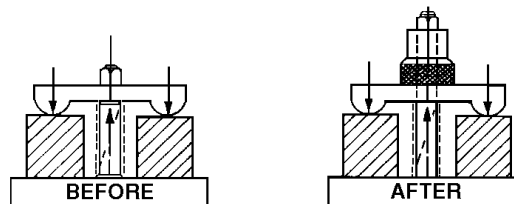
RAM no.	Thru-Hole Insert (supplied)
020-011-011DE	705384
020-012-021DE	705512
020-013-031DE	705634

Loads Transmitted by Various Diameter Screws

Bolt Size	Wrench Length	F-lbs. (Average)
1/4 UNF	4.00	2,400 lbs.
1/4 UNF	4.00	1,920 lbs.
3/8 UNF	5.75	3,000 lbs.
3/8 UNF	5.75	2,920 lbs.
1/2 UNF	8.00	4,200 lbs.
1/2 UNF	8.00	3,640 lbs.
5/8 UNF	9.00	5,600 lbs.
5/8 UNF	9.00	5,600 lbs.
3/4 UNF	9.00	4,800 lbs.
3/4 UNF	11.00	4,200 lbs.
7/8 UNF	12.00	50,400 lbs.

To determine how much force is needed to replace a manual clamp, use this chart as a guide.

A thru-hole ram easily converts a manual strap clamp into an automatic hydraulic powered clamp. Usually a longer bolt is the only part needed to make this conversion.



Calculation of Forces Using Straps and Levers

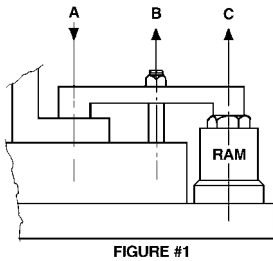


FIGURE #1

Figure #1

When the distance AB is equal to the distance BC the force upward from Model 020-011-011DE Ram "C" is equal to the downward force "A" on the part.

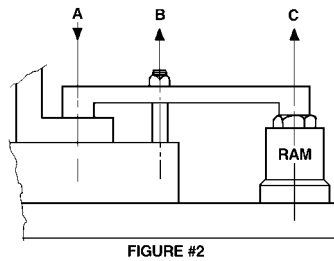


FIGURE #2

Figure #2

The downward force "A" is equal to the upward force "C" times a ratio of the distance BC:AB.

Example:

AB = 2", BC = 4", Force "C" = 1,000 lbs.

$$\text{Force "A"} = \text{Force "C"} \times \frac{BC}{AB}$$

$$\text{"A"} = 1,000 \text{ lbs.} \times \frac{4}{2}$$

$$\text{"A"} = 2,000 \text{ lbs.}$$

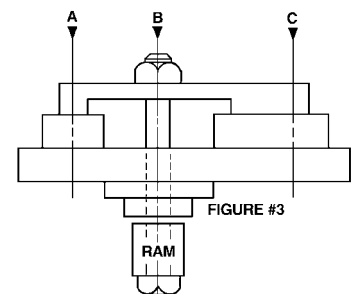


FIGURE #3

Figure #3

When Force "B" from Model 020-011-011DE Hollow Bore is divided between "A" & "C", the forces at "A" & "C" are in inverse ratio to the distance AB & BC respectively.

$$\text{Force "A"} = \text{Force "B"} \times \frac{BC}{AB}$$

$$\text{Force "C"} = \text{Force "B"} \times \frac{AB}{AC}$$

Example:

AB = 2", BC = 4," Force "B" = 1,000 lbs.

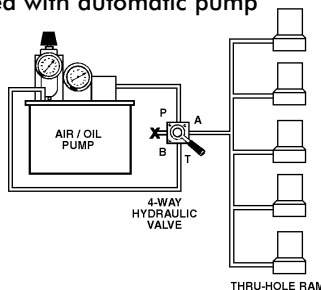
$$\text{Force "A"} = 1,000 \text{ lbs.} \times \frac{4}{6} = 666.7 \text{ lbs.}$$

$$\text{Force "C"} = 1,000 \text{ lbs.} \times \frac{2}{6} = 333.3 \text{ lbs.}$$

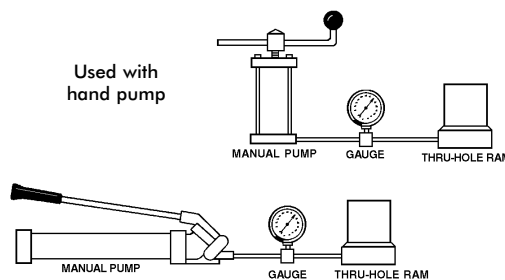
Power Sources

Thru-hole Rams can be powered by automatic pumps, hand pumps, boosters or existing machine hydraulics.

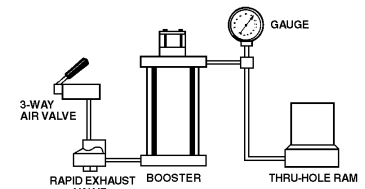
Used with automatic pump



Used with hand pump

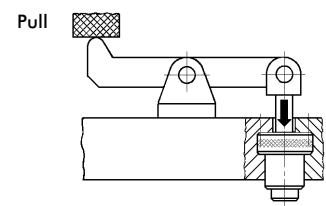
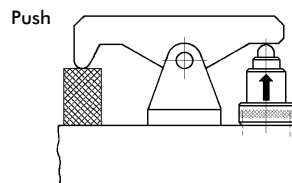
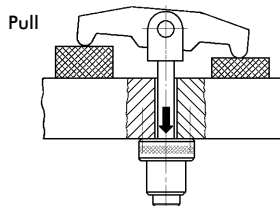
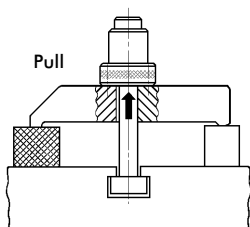


Used with booster



Multiple Uses

Thru-hole Rams can be used to push or pull depending on the position of the ram.



030 SERIES

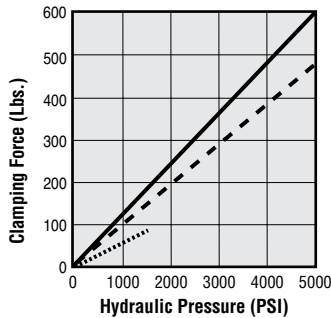
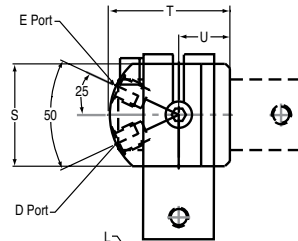
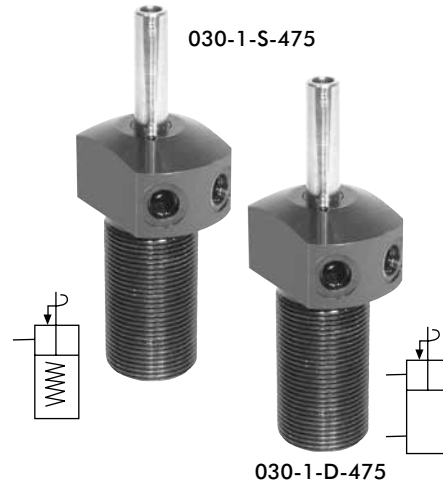
Hydraulic Power Clamps | Hydraulic Swing/Pull Clamps - 475 lb.

The DESTACO Threaded Body Swing/Pull Clamps are available in both single-acting and double-acting versions. They incorporate the latest hydraulic swing clamp technology. The top port design allows easy access for plumbing connections.

They are available with 90° left or right hand rotation, or with guided straight pull. The breather port on single-acting models may be replaced with tubing for remote venting. The optional arms clamp securely to the piston rod to reduce fatigue and deflection. Arms may be easily modified or custom arms may be substituted.

Features:

- Advanced seals and wipers utilize a special, highly wear-resistant construction for long cycle life and 5,000 PSI operation
- Triple track piston rod design for field adjustable swing direction
- Hardened and hard chrome plated piston rod for increased strength and wear resistance
- Advanced metal treated body for superior wear and corrosion resistance
- MRO interchange design
- Straight pull capacity 600 lbs. at 5,000 PSI max



Performance

- With 031-L-475 Arm (3.25" long)
- - - With 0-31-S-475 Arm (1.22" long)
- Straight Pull

For 475 lb. Swing/Pull Clamp Arms see Page MC-HYD-11

Cat. no.	Specifications							Max Oil Flow in ³ /m in
	Oper.	Swing Direction	*Force (lbs.)	Eff. Area (sq. In.) Clamp Unclamp	Oil Cap. (cu. In.) Clamp Unclamp			
030-1-S-475 (-X) †	Single-Acting	Left Hand (Counter Clockwise) Right Hand (Clockwise)	475	0.12	-	0.08	-	12
030-1-D-475 (-X) †	Double-acting	Straight Pull			0.24	0.15		

Ordering Notes:

- Left hand swing (ccw) is standard—no suffix
- Add -R suffix for right hand swing
- Add -S suffix for straight guided pull

Cat. no.	Specifications																			
	A Total Stroke	B Clamping Stroke	C	D Clamp Port	E Unclamp Port	F	G	H	J	K	L	M	N	P	Q	R	S	T	U	
030-1-S-475 †	0.65	0.210	0.59	SAE-2	SAE-2	1.929	2.086	3.07	4.429	0.8	M6x1	0.157	0.393	1-1/8-16UN	4.96	0.495	1.3	1.55	0.61	
030-1-D-475 †	0.65	0.32	0.59																	

† This item is available upon request

NOTE: *With 1.22" long arm at 5,000 PSI maximum operating pressure.
 ‡ Do not pressurize - single-acting only
 † See page MC-HYD-11 for arms, accessories and custom arm mounting



MC-HYD-7

Dimensions and technical information are subject to change without notice

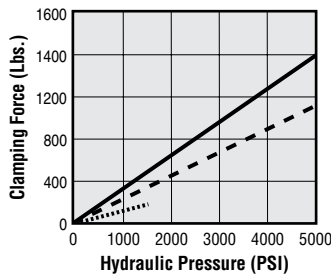
Hydraulic Power Clamps | Hydraulic Swing/Pull Clamps - 1,100lb.

The DESTACO Threaded Body Swing/Pull Clamps are available in both single-acting and double-acting versions. They incorporate the latest hydraulic swing clamp technology. The top port design allows easy access for plumbing connections.

They are available with 90° left or right hand rotation, or with guided straight pull. The breather port on single-acting models may be replaced with tubing for remote venting. The optional arms clamp securely to the piston rod to reduce fatigue and deflection. Arms may be easily modified or custom arms may be substituted.

Features:

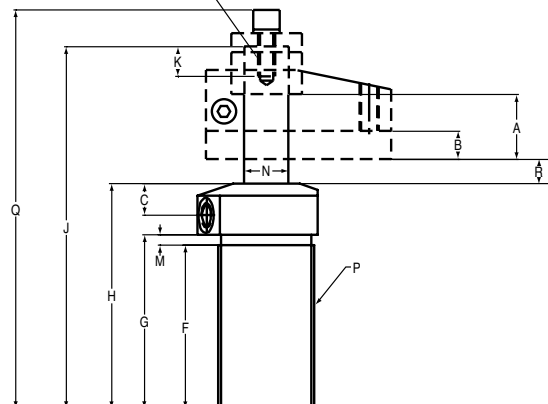
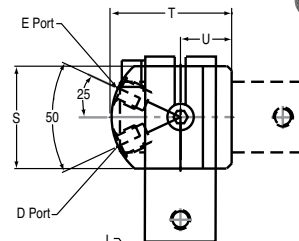
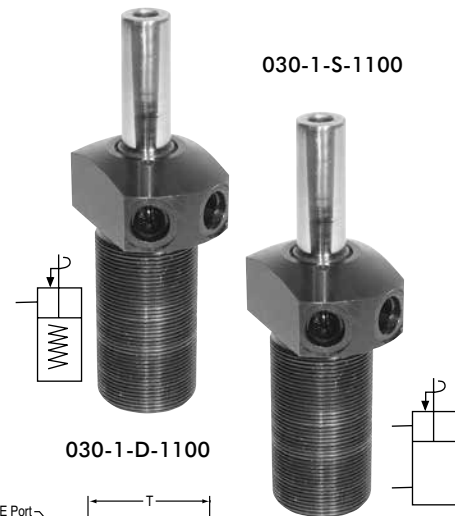
- Advanced seals and wipers utilize a special, highly wear-resistant construction for long cycle life and 5,000 PSI operation
- Triple track piston rod design for field adjustable swing direction
- Hardened and hard chrome plated piston rod for increased strength and wear resistance
- Advanced metal treated body for superior wear and corrosion resistance
- MRO interchange design
- Straight pull capacity 1,400 lbs. at 5,000 PSI max



Performance

- With 031-L-1100 Arm (5.31" long)
- - - With 031-S-1100 Arm (1.89" long)
- Straight Pull

For 1,100 lb. Swing/Pull Clamp Arms see Page MC-HYD-12



Ordering Notes:

- Left hand swing (ccw) is standard—no suffix
- Add -R suffix for right hand swing
- Add -S suffix for straight guided pull

Cat. no.	Specifications							Max Oil Flow in ³ /m in
	Oper.	Swing Direction	*Force (lbs.)	Eff. Area (sq. In.) Clamp Unclamp	Oil Cap. (cu. In.) Clamp Unclamp			
030-1-S-1000 (-X) ⓘ	Single-Acting	Left Hand (Counter Clockwise)	1100	0.28	-	0.25	-	25
030-1-D-1000 (-X) ⓘ	Double-acting	Right Hand (Clockwise) Straight Pull			0.59		0.52	

Cat. no.	Specifications																		
	A Total Stroke	B Clamping Stroke	C	D Clamp Port	E Unclamp Port	F	G	H	J	K	L	M	N	P	Q	R	S	T	U
030-1-S-1100 ⓘ	0.89	0.39	0.6	SAE-4	SAE-4	2.4	2.6	3.58	5.305	0.94	M8 x 1.25	0.196	0.629	1-3/8-18UN	5.965	0.400	1.5	1.87	0.75
030-1-D-1100 ⓘ																			

ⓘ This item is available upon request

NOTE: *With 1.89" long arm at 5,000 PSI maximum operating pressure.
 †Do not pressurize – single-acting only
 ‡ See page MC-HYD-12 for arms, accessories and custom arm mounting

030 SERIES

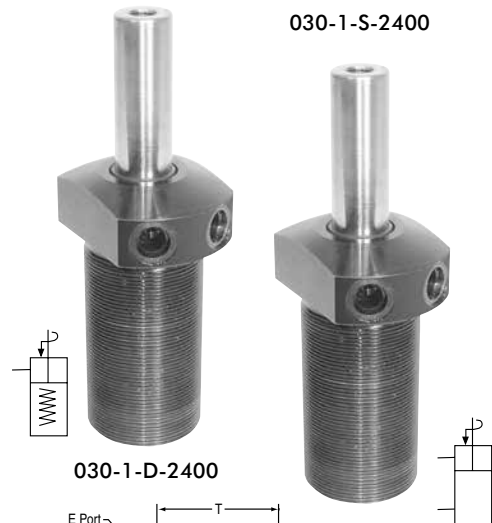
Hydraulic Power Clamps | Hydraulic Swing/Pull Clamps - 2,400 lb.

The DESTACO Threaded Body Swing/Pull Clamps are available in both single-acting and double-acting versions. They incorporate the latest hydraulic swing clamp technology. The top port design allows easy access for plumbing connections.

They are available with 90° left or right hand rotation, or with guided straight pull. The breather port on single-acting models may be replaced with tubing for remote venting. The optional arms clamp securely to the piston rod to reduce fatigue and deflection. Arms may be easily modified or custom arms may be substituted.

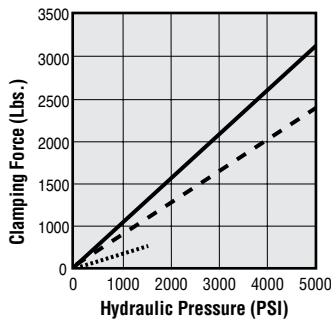
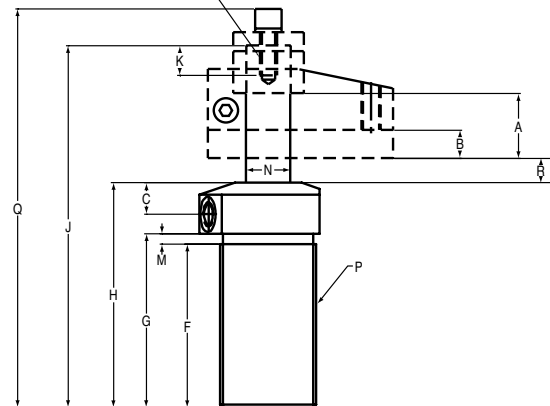
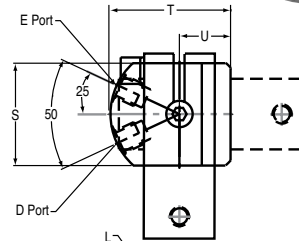
Features:

- Advanced seals and wipers utilize a special, highly wear-resistant construction for long cycle life and 5,000 PSI operation
- Triple track piston rod design for field adjustable swing direction
- Hardened and hard chrome plated piston rod for increased strength and wear resistance
- Advanced metal treated body for superior wear and corrosion resistance
- MRO interchange design
- Straight pull capacity 3,150 lbs. at 5,000 PSI max



030-1-D-2400

030-1-S-2400



For 2,400 lb. Swing/Pull Clamp Arms see Page MC-HYD-11

Performance

- With 031-L-2400 Arm (6.36" long)
- - - - With 031-S-2400 Arm (2.43" long)
- ——— Straight Pull

Cat. no.	Specifications								Max Oil Flow in ³ /m in
	Oper.	Swing Direction	*Force (lbs.)	Eff. Area (sq. In.)	Oil Cap. (cu. In.)	Clamp	Unclamp		
030-1-S-2400 (-X) ⓘ	Single-Acting	Left Hand (Counter Clockwise)	2400	0.63	0.7	-	-	100	
030-1-D-2400 (-X) ⓘ	Double-acting	Right Hand (Clockwise) Straight Pull				1.23	1.10		

Ordering Notes:

- Left hand swing (ccw) is standard—no suffix
- Add -R suffix for right hand swing
- Add -S suffix for straight guided pull

Cat. no.	Specifications																		
	A Total Stroke	B Clamping Stroke	C	D Clamp Port	E Unclamp Port	F	G	H	J	K	L	M	N	P	Q	R	S	T	U
030-1-S-2400 ⓘ	1.12	0.5	0.62	SAE-4	SAE-4	†	3.38	4.38	6.8	1.28	M10x1.5	0.196	0.87	1-7/8-16UN	7.543	0.517	2.0	2.38	1.0
030-1-D-2400 ⓘ																			

ⓘ This item is available upon request

NOTE: *With 2.43" long arm at 5,000 PSI maximum operating pressure.

‡Do not pressurize - single-acting only

† See page MC-HYD-11 for arms, accessories and custom arm mounting



MC-HYD-9

Dimensions and technical information are subject to change without notice

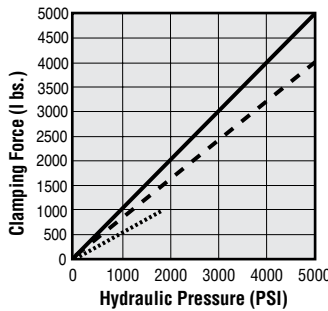
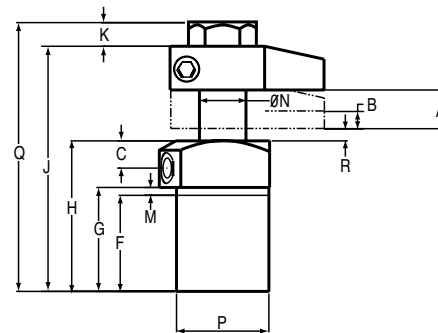
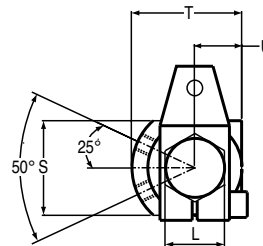
Hydraulic Power Clamps | Hydraulic Swing/Pull Clamps - 4,000 lb.

The DESTACO Threaded Body Swing/Pull Clamps are available in both single-acting and double-acting versions. They incorporate the latest hydraulic swing clamp technology. The top port design allows easy access for plumbing connections.

They are available with 90° left or right hand rotation, or with guided straight pull. The breather port on single-acting models may be replaced with tubing for remote venting. The optional arms clamp securely to the piston rod to reduce fatigue and deflection. Arms may be easily modified or custom arms may be substituted.

Features:

- Advanced seals and wipers utilize a special, highly wear-resistant construction for long cycle life and 5,000 PSI operation
- Triple track piston rod design for field adjustable swing direction
- Hardened and hard chrome plated piston rod for increased strength and wear resistance
- Advanced metal treated body for superior wear and corrosion resistance
- MRO interchange design
- Straight pull capacity 5,500 lbs. at 5,000 PSI max



Performance

- With 031-L-4000 Arm (X.XX" long)
- - - With 031-S-4000 Arm (X(7.01" long)
- Straight Pull (2.75" long)

For 4,000 lb.
Swing/Pull Clamp Arms
see Page MC-HYD-11

Cat. no.	Specifications							Max Oil Flow in ³ /m in
	Oper.	Swing Direction	*Force (lbs.)	Eff. Area (sq. In.) Clamp Unclamp	Oil Cap. (cu. In.) Clamp Unclamp			
030-1-S-4000 (-X) ⓘ	Single-Acting	Left Hand (Counter Clockwise)	4000	1.10	-	1.22	-	140
030-1-D-4000 (-X) ⓘ	Double-acting	Right Hand (Clockwise) Straight Pull						

- Ordering Notes:
- Left hand swing (ccw) is standard—no suffix
 - Add -R suffix for right hand swing
 - Add -S suffix for straight guided pull

ⓘ This item is available upon request

Cat. no.	Specifications																		
	A Total Stroke	B Clamping Stroke	C	D Clamp Port	E Unclamp Port	F	G	H	J	K	L	M	N	P	Q	R	S	T	U
030-1-S-4000 ⓘ	1.07	0.45	0.75	SAE#4	SAE#4	2.70	2.83	4.09	6.67	0.64	1.61	0.14	1.26	2-1/2-16 UN	7.30	0.33	2.56	2.99	1.28
030-1-D-4000 ⓘ																			

ⓘ This item is available upon request

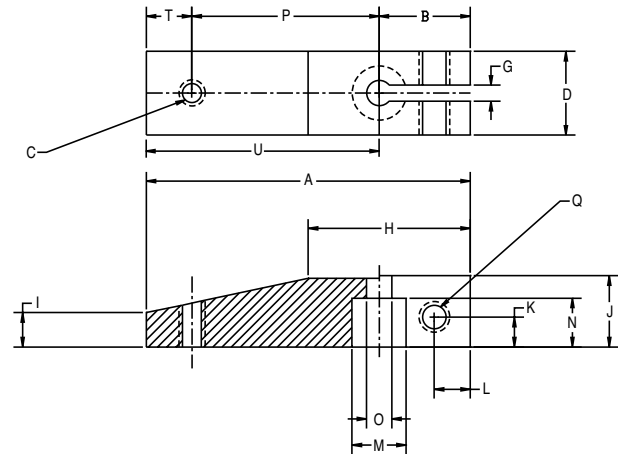
NOTE: *With 2.75" long arm at 5,000 PSI maximum operating pressure.
[‡]Do not pressurize - single-acting only
[†] See page MC-HYD-11 for arms, accessories and custom arm mounting

030 SERIES

Hydraulic Power Clamps | Hydraulic Swing/Pull Clamps 475-2,400 lb. Arms

Custom built arms of any length must clamp to the swing/pull clamp's piston rod in a manner similar to the DESTACO arms or some derating of the clamp will be necessary.

The design feature "K," in the chart and drawing at the bottom of this page, is recommended for all applications of custom, single arms. See the accompanying chart for design details. In applications where there is no bending stress being transferred into the piston rod (like push/pull linkages and equalizing double arms), this design detail may be eliminated. In these applications, the clamp's full capacity (referred to as "straight pull" capacity) is available.



Cat. no.	Specifications																	Weight (lbs.)
	A	B	C	D	G	H	I	J	K	L	M	N	O	P	Q	T	U	
031-S-475	1.929	0.709	M6	0.63	0.126	1.139	0.394	0.630	0.236	0.217	0.394	0.394	0.256	0.984	M6	0.236	1.220	0.159
031-L-475	3.959	0.709	-	0.63		1.166	0.394	0.630			0.394	0.394	0.256	-	M6	-	3.250	0.348
031-S-1100	2.598	0.709	M8	0.748		1.294	0.433	0.748			0.630	0.472	0.33	1.575	M6	0.315	1.889	0.286
031-L-1100	6.019	0.709	-	0.748		1.412	0.433	0.748			0.630	0.472	0.335	-	M6	-	5.310	0.721
031-S-2400	3.268	0.866	M10	1.125		1.459	0.633	1.00			0.866	0.709	0.413	1.969	M8	0.433	2.402	0.634
031-L-2400	7.226	0.866	-	1.125		1.696	0.633	1.00			0.866	0.709	0.413	-	M8	-	6.360	1.564

IMPORTANT: Any clamp using a modified or custom arm that is longer or heavier than DESTACO's standard arms must be derated to prevent internal damage.
Do not exceed the maximum speed and pressure ratings for DESTACO's standard arms.
For maximum hydraulic pressure and speed ratings, see the accompanying charts
Do not use meter-out circuitry for controlling double-acting clamp speeds
Contact DESTACO if further design assistance is required

Custom Arm Mounting Dimensions for Swing/Pull Clamps

Shaft Dia.	Specifications										
	A	B	C	D	E	F	G	H	J	K	M
10 MM	0.394	0.256	0.63	0.63	0.709	1.26	0.394	0.236	0.217	0.30	M6 x 1.0
16MM	0.630	0.335	0.748	0.748	0.709		0.472	0.236	0.217		M6 x 1.0
22 MM	0.866	0.413	1.00	1.00	0.866		0.709	0.236	0.217		M8 x 1.25

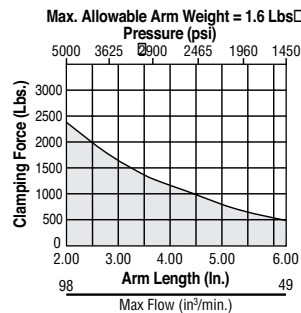
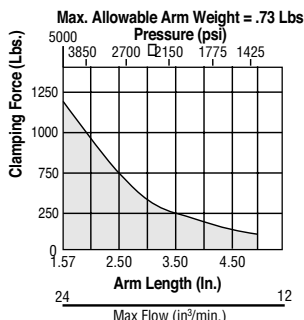
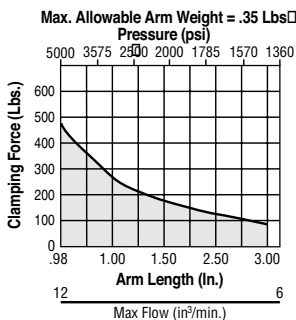
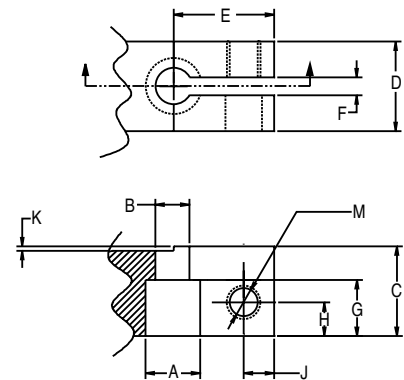


Chart Legend

- Maximum Length / Pressure
- Operating Range

Clamps must operate at or below maximum arm length/pressure curve:

To approximate clamping force with any arm at less than maximum pressure:

$$FORCE = P \times A \times [1 - (P/M \times .23)]$$

P = Hyd. system operating pressure (PSI)

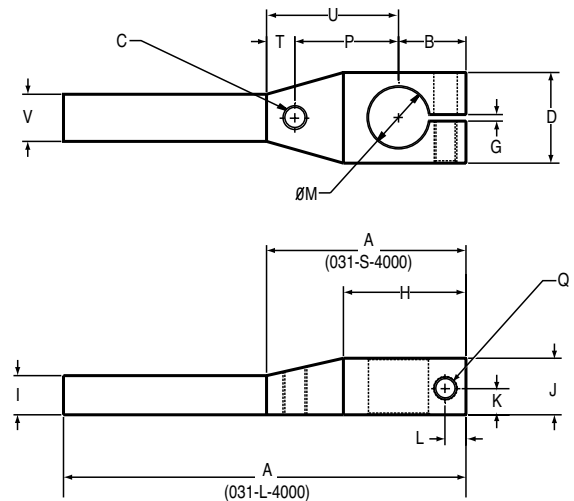
A = Clamp effective area (sq. in.)

M = Max. rated pressure of chosen arm length (PSI)

Hydraulic Power Clamps | Hydraulic Swing/Pull Clamps - 4,000 lb. Arms

Custom built arms of any length must clamp to the swing/pull clamp's piston rod in a manner similar to the DESTACO arms or some derating of the clamp will be necessary.

The design feature "K," in the chart and drawing at the bottom of this page, is recommended for all applications of custom, single arms. See the accompanying chart for design details. In applications where there is no bending stress being transferred into the piston rod (like push/pull linkages and equalizing double arms), this design detail may be eliminated. In these applications, the clamp's full capacity (referred to as "straight pull" capacity) is available.

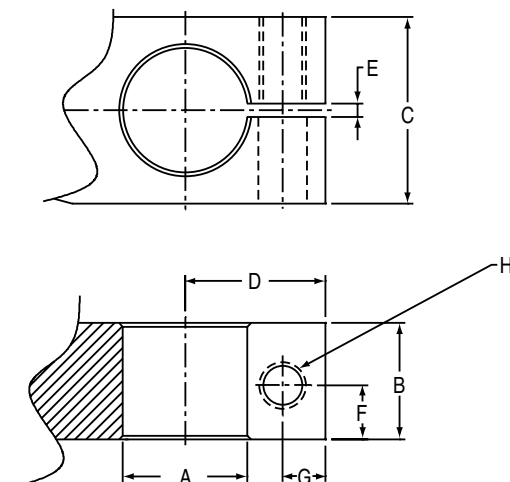


Cat no.	Specifications																Weight (lbs.)
	A	B	C	D	G	H	I	J	K	L	M	P	Q	T	U	V	
031-S-4000	4.17	1.42	1/2-13	1.89	0.138	2.56	0.83	1.18	0.55	0.43	1.26	2.17	M12	0.58	2.75	0.98	1.80
031-L-4000	8.43	1.42	1/2-13	1.89	0.138	2.56	0.83	1.18	0.55	0.43	1.26	-	M12	-	7.01	0.98	2.80

IMPORTANT: Any clamp using a modified or custom arm that is longer or heavier than DESTACO's standard arms must be derated to prevent internal damage.
 Do not exceed the maximum speed and pressure ratings for DESTACO's standard arms.
 For maximum hydraulic pressure and speed ratings, see the accompanying charts
 Do not use meter-out circuitry for controlling double-acting clamp speeds
 Contact DESTACO if further design assistance is required

Custom Arm Mounting Dimensions for 4,000 lb. Swing/Pull Clamps

Cat no.	Specifications							
	A	B	C	D	E	F	G	H
32MM	1.26	1.18	1.89	1.42	0.138	0.55	0.43	M12 x 1.75



031-S-4000 • 031-L-4000

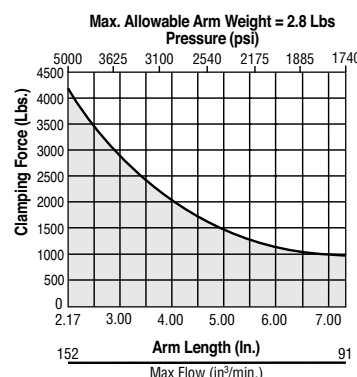


Chart Legend

- Maximum Length / Pressure
- ▭ Operating Range

Clamps must operate at or below maximum arm length/pressure curve:

To approximate clamping force with any arm at less than maximum pressure:

$$FORCE = P \times A \times [1 - (P/M \times .23)]$$

P = Hyd. system operating pressure (PSI)

A = Clamp effective area (sq. in.)

M = Max. rated pressure of chosen arm length (PSI)

039 SERIES

Hydraulic Power Clamps | Air/Hydraulic Power Boosters

The DESTACO Air/Hydraulic Power Booster converts normal shop-line air pressure to high-pressure hydraulic power. The two models available provide oil displacements ranging from 1 cu. in. to 4 cu. in. per stroke.

With the system filled, the volume of oil required to actuate a cylinder or pressure point is only equal to the cubic content of the piston displacement. The small booster, producing 1 cu. in. of usable oil per stroke, can operate 50 of the tiny 1/2-20 pressure points a full .22 max. stroke, and even more when strokes are kept to a minimum.

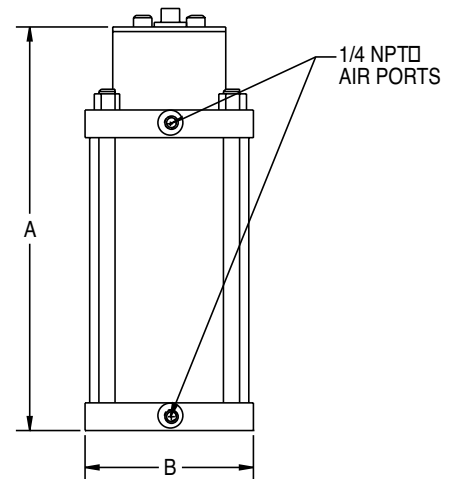
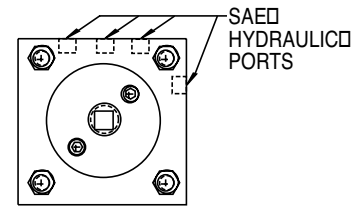
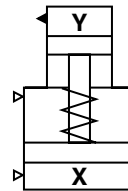
Features:

- Built-in manifold
- Complete automatic bleeding with each return stroke
- Automatic relief of system overcharge
- Automatic bleeding feature eliminates pre-filling
- Large volume visible oil reservoir automatically

replenishes the system with reserve oil capacity

- Corrosion and wear-resistant materials
- Wear rings on hydraulic piston tube
- Unique self-centering air piston assures long life
- Increases hydraulic pressure to 3,000 PSIG from 100 PSIG air-line pressure
- All models supplied with SAE hydraulic ports
- NPT hydraulic ports available on request

039-104-000DE



Model no.	Press Ratio	Displacement Per Stroke	Nominal Reservoir Capacity	Weight	Dimensions		Ports
					A	B (Square)	
039-101-000DE	33.87:1	1 cu. in.	10.4 cu. in.	9 lbs.	10.88	4.50	SAE #4
039-104-000DE	32.41:1	4 cu. in.	42 cu. in.	23 lbs.	16.38	6.50	SAE #4

(100 PSIG max. input air pressure)

Note: Special High Temperature Seals available for applications where Viton® Seals are required. Order as H/T option.

CLAMPING TECHNOLOGY

Product Index

Model No.	Page	Model No.	Page	Model No.	Page
010-210-400	MC-HYD-3	052-187-160	MC-HYD-4	2013-U	MC-HHD-3
010-210-501	MC-HYD-3	052-250-160	MC-HYD-4	2013-U-LS-BLK	MC-HHD-3
010-210-702	MC-HYD-3	1000	PC-PPC-59	2013-UR	MC-HHD-3
010-211-002	MC-HYD-3	1001	PC-PPC-59	2013208-M	MC-ACC-2
010-211-004	MC-HYD-3	10010100	PC-PPC-59	2017-U	MC-HHD-5
010-211-502	MC-HYD-3	1005133-MR	PC-PPC-59	2017-U-LS-BLK	MC-HHD-5
010-211-504	MC-HYD-3	1005134-MR	PC-PPC-59	2017-UR	MC-HHD-5
010-212-004	MC-HYD-3	102111	MC-ACC-6	201943	MC-ACC-4
020-011-011DE	MC-HYD-5	102208	MC-ACC-2	201943-M	MC-ACC-4
020-012-021DE	MC-HYD-5	102911	MC-ACC-6	202	MC-VHD-13
020-013-031DE	MC-HYD-5	105106	MC-ACC-6	202-B	MC-VHD-13
030-1-D-1100	MC-HYD-8	105203	MC-ACC-4	202-SS	MC-VHD-13
030-1-D-2400	MC-HYD-9	105208	MC-ACC-2	202-T	MC-VHD-13
030-1-D-4000	MC-HYD-10	105906	MC-ACC-6	202-TU	MC-VHD-13
030-1-D-475	MC-HYD-7	12/100	MC-VSC-4	202-U	MC-VHD-13
030-1-S-1100	MC-HYD-8	12/200	MC-VSC-4	202-U-L	MC-VHD-13
030-1-S-2400	MC-HYD-9	12/300	MC-VSC-4	202-U-L-BLK	MC-VHD-13
030-1-S-4000	MC-HYD-10	1200	MC-PTC-29	202-UB	MC-VHD-13
030-1-S-475	MC-HYD-7	1200-E	MC-PTC-29	202-UB-L	MC-VHD-13
031-L-1100	MC-HYD-11	16/100	MC-VSC-4, 7	202-UB-L-BLK	MC-VHD-13
031-L-2400	MC-HYD-11	16/200	MC-VSC-4, 7	202-UL	MC-VHD-13
031-L-4000	MC-HYD-12	16/300	MC-VSC-4, 7	202-USS	MC-VHD-13
031-L-475	MC-HYD-11	186-13	MC-CVR-3	202203	MC-ACC-4
031-S-1100	MC-HYD-11	2002-S	MC-VHD-3	202208	MC-ACC-2
031-S-2400	MC-HYD-11	2002-SB	MC-VHD-3	202208-M	MC-ACC-2
031-S-4000	MC-HYD-12	2002-SBR	MC-VHD-3	202305	MC-VHD-13
031-S-475	MC-HYD-11	2002-SR	MC-VHD-3	2027-U	MC-HHD-7
035-125-190	MC-PSC-32	2002-U	MC-VHD-3	2027-U-LS-BLK	MC-HHD-7
035-125-290	MC-PSC-32	2002-U-LS-BLK	MC-VHD-3	2027-UR	MC-HHD-7
035-132-190	MC-PSC-32	2002-U207	MC-VHD-3	202943	MC-ACC-4
035-132-290	MC-PSC-32	2002-UB	MC-VHD-3	202943-M	MC-ACC-4
035-140-190	MC-PSC-32	2002-UB-LS-BLK	MC-VHD-3	205-S	MC-HHD-19
035-140-290	MC-PSC-32	2002-UBR	MC-VHD-3	205-SB	MC-HHD-19
035-150-190	MC-PSC-32	2002-UR	MC-VHD-3	205-SL	MC-HHD-19
035-150-290	MC-PSC-32	2002-UR207	MC-VHD-3	205-SR	MC-HHD-19
035-225-190	MC-PSC-32	2002115-E	MC-ACC-6	205-SSS	MC-HHD-19
035-225-290	MC-PSC-32	2007-S	MC-VHD-7	205-U	MC-HHD-19
035-232-190	MC-PSC-32	2007-SB	MC-VHD-7	205-UB	MC-HHD-19
035-232-290	MC-PSC-32	2007-SBR	MC-VHD-7	205-UL	MC-HHD-19
035-240-190	MC-PSC-32	2007-SR	MC-VHD-7	205-UR	MC-HHD-19
035-240-290	MC-PSC-32	2007-U	MC-VHD-7	205-USS	MC-HHD-19
035-250-190	MC-PSC-32	2007-U-LS-BLK	MC-VHD-7	205203	MC-ACC-4
035-250-290	MC-PSC-32	2007-UB	MC-VHD-7	205203-M	MC-ACC-4
036-551-01	MC-PSC-35	2007-UB-LS-BLK	MC-VHD-7	205208-M	MC-ACC-2
036-551-02	MC-PSC-35	2007-UBR	MC-VHD-7	205943	MC-ACC-4
036-630-01	MC-PSC-35	2007-UR	MC-VHD-7	205943-M	MC-ACC-4
036-630-02	MC-PSC-35	2007115-E	MC-ACC-6	206-HSS	MC-HHD-29
036-787-01	MC-PSC-35	2007208-M	MC-ACC-2	206-SS	MC-HHD-29
036-787-02	MC-PSC-35	201-TU	MC-VHD-11	207-L	MC-VHD-17
039-101-000DE	MC-HYD-13	201-U	MC-VHD-11	207-LB	MC-VHD-17
039-104-000DE	MC-HYD-13	201-UB	MC-VHD-11	207-LBR	MC-VHD-17
051-112-160	MC-HYD-4	201-USS	MC-VHD-11	207-LR	MC-VHD-17
051-131-160	MC-HYD-4	2010-S	MC-VHD-9	207-S	MC-VHD-17
051-137-180	MC-HYD-4	2010-SB	MC-VHD-9	207-SB	MC-VHD-17
051-150-160	MC-PSC-36	2010-SBR	MC-VHD-9	207-SF	MC-VHD-17
051-187-160	MC-PSC-36, MC-HYD-4	2010-SR	MC-VHD-9	207-TU	MC-VHD-17
		2010-U	MC-VHD-9	207-TUL	MC-VHD-17
051-225-160	MC-PSC-36	2010-UB	MC-VHD-9	207-U	MC-VHD-17
051-250-160	MC-PSC-36 MC-HYD-4	2010-UBR	MC-VHD-9	207-U-L	MC-VHD-17
		2010-UR	MC-VHD-9	207-U-L-BLK	MC-VHD-17
052-112-160	MC-HYD-4	2010115-E	MC-ACC-6	207-UB	MC-VHD-17
052-131-160	MC-HYD-4	201208	MC-ACC-2	207-UB-L	MC-VHD-17
052-137-180	MC-HYD-4	201208-M	MC-ACC-2	207-UB-L-BLK	MC-VHD-17

Model No.	Page	Model No.	Page	Model No.	Page
207-UF	MC-VHD-17	217-USS	MC-HHD-11	267-S	MC-VHD-23
207-UL	MC-VHD-17	22/100	MC-VSC-4	267-U	MC-VHD-23
207-ULB	MC-VHD-17	22/200	MC-VSC-4	267102	MC-ACC-6
207-UR	MC-VHD-17	22/300	MC-VSC-4	267203-M	MC-ACC-4
207-USS	MC-VHD-17	220203	MC-ACC-4	267208	MC-ACC-2
207105	MC-ACC-6	220203-M	MC-ACC-4	267902	MC-ACC-6
207105-M	MC-ACC-6	225-U	MC-HHD-23	290-13	MC-CVR-3
207203	MC-ACC-4	225-UB	MC-HHD-23	301	MC-PAL-21
207203-M	MC-ACC-4	225-UBSS	MC-HHD-23	301-SS	MC-PAL-21
207206	MC-ACC-3	225-UR	MC-HHD-23	3011	MC-PAL-22
207206-M	MC-ACC-3	225-USS	MC-HHD-23	305-U	MC-HHD-27
207209	MC-ACC-3	225119	MC-ACC-5	305-UR	MC-HHD-27
207305	MC-VHD-17	225208	MC-ACC-2	305-USS	MC-HHD-27
207426-Q	MC-ACC-10	225208-M	MC-ACC-2	3051	MC-PAL-3
207943	MC-ACC-4	225219	MC-ACC-5	3051-R	MC-PAL-3
207943-M	MC-ACC-4	225219-M	MC-ACC-5	305203	MC-ACC-4
210-S	MC-VHD-21	225319	MC-ACC-5	305208	MC-ACC-3
210-SB	MC-VHD-21	227-U	MC-HHD-13	305208-M	MC-ACC-2
210-SR	MC-VHD-21	227-U-L	MC-HHD-13	307-U	MC-HHD-27
210-TU	MC-VHD-21	227-U-L-BLK	MC-HHD-13	307-UR	MC-HHD-27
210-U	MC-VHD-21	227-UB	MC-HHD-13	307-USS	MC-HHD-27
210-UB	MC-VHD-21	227-UB-L	MC-HHD-13	307208-M	MC-ACC-2
210-UR	MC-VHD-21	227-UB-L-BLK	MC-HHD-13	309-U	MC-HHD-27
210-USS	MC-VHD-21	227-UB-LS-BLK	MC-HHD-13	309-UR	MC-HHD-27
210114	MC-ACC-6	227-USS	MC-HHD-13	309-USS	MC-HHD-27
210114-M	MC-ACC-6	229	MC-VHD-41	311	MC-PAL-21
210203	MC-ACC-4	235-U	MC-HHD-25	317-S	MC-VHD-37
210203-M	MC-ACC-4	235-UB	MC-HHD-25	317-U	MC-VHD-37
210206	MC-ACC-3	235-UR	MC-HHD-25	323	MC-PAL-8
210206-M	MC-ACC-3	235-USS	MC-HHD-25	323-R	MC-PAL-8
210208	MC-ACC-3	235106	MC-ACC-6	323-RSS	MC-PAL-8
210209	MC-ACC-3	235110	MC-ACC-5	323-SS	MC-PAL-8
210440-Q	MC-ACC-10	235119	MC-ACC-5	323215	MC-PAL-11
213-U	MC-HHD-9	235208	MC-ACC-2	323215-M-100	MC-PAL-11
213-U-L	MC-HHD-9	235208-M	MC-ACC-2	323215-M-25	MC-PAL-11
213-U-LS-BLK	MC-HHD-9	235219	MC-ACC-5	323215-M-50	MC-PAL-11
213-UB	MC-HHD-9	235219-M	MC-ACC-5	323915	MC-PAL-11
213-UB-L	MC-HHD-9	235319	MC-ACC-5	323915-M-100	MC-PAL-11
213-UB-LS-BLK	MC-HHD-9	235906	MC-ACC-6	323915-M-25	MC-PAL-11
213-USS	MC-HHD-9	237-U	MC-HHD-15	323915-M-50	MC-PAL-11
213208	MC-ACC-3	237-USS	MC-HHD-15	324	MC-PAL-17
213208-M	MC-ACC-2	237943	MC-ACC-4	324-R	MC-PAL-17
213208-M-L	MC-ACC-2	237943-M	MC-ACC-4	324-SS	MC-PAL-17
215-S	MC-HHD-21	240203	MC-ACC-4	324-ZB1	MC-PAL-11, MC-PAL-20
215-U	MC-HHD-21	240203-M	MC-ACC-4		
215-UB	MC-HHD-21	240208	MC-ACC-2	324215	MC-PAL-20
215-USS	MC-HHD-21	240208-M	MC-ACC-2	324215-M-100	MC-PAL-20
215105	MC-ACC-6	245-U	MC-HHD-17	324215-M-25	MC-PAL-20
215119	MC-ACC-5	245943	MC-ACC-4	324215-M-50	MC-PAL-20
215208	MC-ACC-2	245943-M	MC-ACC-4	324915	MC-PAL-20
215208-M	MC-ACC-2	247-S	MC-VHD-23	324915-M-100	MC-PAL-20
215219	MC-ACC-5	247-U	MC-VHD-23	324915-M-25	MC-PAL-20
215219-M	MC-ACC-5	247-UB	MC-VHD-23	324915-M-50	MC-PAL-20
215319	MC-ACC-5	247109	MC-ACC-6	325	MC-SAP-2
215905	MC-ACC-6	247110	MC-ACC-6	325-SS	MC-SAP-2
217-U	MC-HHD-11	247110-M	MC-ACC-6	325203	MC-ACC-4
217-U-L	MC-HHD-11	247208	MC-ACC-2	32MM	MC-VSC-11
217-U-L-BLK	MC-HHD-11	247208-M	MC-ACC-2	330	MC-PAL-4
217-U-LS-BLK	MC-HHD-11	247909	MC-ACC-6	330-SS	MC-PAL-4
217-UB	MC-HHD-11	250121	MC-ACC-6	330-ZB1	MC-PAL-8, MC-PAL-11
217-UB-L	MC-HHD-11	250203	MC-ACC-4	330-ZB1 (cont.)	MC-PAL-11
217-UB-L-BLK	MC-HHD-11	250206	MC-ACC-3	330215	MC-PAL-7
217-UB-LS-BLK	MC-HHD-11	250206-M	MC-ACC-3	330215-M-100	MC-PAL-7

CLAMPING TECHNOLOGY

Product Index

Model No.	Page	Model No.	Page	Model No.	Page
330215-M-25	MC-PAL-7	351215	MC-PAL-7	424208-M	MC-ACC-2
330215-M-50	MC-PAL-7	351215-M-100	MC-PAL-7	425	MC-SAP-6
330915	MC-PAL-7	351215-M-25	MC-PAL-7	431	MC-SAP-5
330915-M-100	MC-PAL-7	351215-M-50	MC-PAL-7	431208	MC-ACC-2
330915-M-25	MC-PAL-7	351915	MC-PAL-7	431208-M	MC-ACC-2
330915-M-50	MC-PAL-7	351915-M-100	MC-PAL-7	435	MC-SAP-6
331	MC-PAL-8	351915-M-25	MC-PAL-7	441	MC-SAP-4
331-R	MC-PAL-8	351915-M-50	MC-PAL-7	441-2	MC-SAP-4
331-RSS	MC-PAL-8	353-35	MC-PAL-23	441203	MC-ACC-4
331-SS	MC-PAL-8	353-65	MC-PAL-23	461203	MC-ACC-4
331215	MC-PAL-11	371	MC-PAL-4	461203-M	MC-ACC-4
331215-M-100	MC-PAL-11	371-R	MC-PAL-4	462	MC-SAP-7
331215-M-25	MC-PAL-11	371-SS	MC-PAL-4	462-2	MC-SAP-7
331215-M-50	MC-PAL-11	371-ZB1	MC-PAL-6	463	MC-SAP-7
331915	MC-PAL-11	371215	MC-PAL-7	468206	MC-ACC-3
331915-M-100	MC-PAL-11	371215-M-100	MC-PAL-7	468206-M	MC-ACC-3
331915-M-25	MC-PAL-11	371215-M-25	MC-PAL-7	482	MC-SAP-7
331915-M-50	MC-PAL-11	371215-M-50	MC-PAL-7	484	MC-SAP-7
334	MC-PAL-17	371915	MC-PAL-7	486	MC-SAP-7
334-R	MC-PAL-17	371915-M-100	MC-PAL-7	491203	MC-ACC-4
334-SS	MC-PAL-17	371915-M-25	MC-PAL-7	491203-M	MC-ACC-4
334-ZB1	MC-PAL-20	371915-M-50	MC-PAL-7	501-B	MC-VHD-43
334215	MC-PAL-20	374	MC-PAL-17	501-LB	MC-VHD-43
334215-M-100	MC-PAL-20	374215	MC-PAL-20	501501	MC-VHD-46
334215-M-25	MC-PAL-20	374215-M-100	MC-PAL-20	501503	MC-VHD-46
334215-M-50	MC-PAL-20	374215-M-25	MC-PAL-20	503-MB	MC-VHD-43
334915	MC-PAL-20	374215-M-50	MC-PAL-20	503-MBLSC	MC-VHD-43
334915-M-100	MC-PAL-20	375	MC-PAL-12	503-MLB	MC-VHD-43
334915-M-25	MC-PAL-20	375-B	MC-PAL-12	503-MLBLSC	MC-VHD-43
334915-M-50	MC-PAL-20	375-BR	MC-PAL-12	503501	MC-VHD-46
341	MC-PAL-8	375-R	MC-PAL-12	503502	MC-VHD-46
341-R	MC-PAL-8	375-ZB1	MC-PAL-16, 20	503503-L	MC-VHD-46
341-RSS	MC-PAL-8	375215	MC-PAL-13	505-MB	MC-VHD-43
341-SS	MC-PAL-8	375509	MC-PAL-12, 14	505-MBLSC	MC-VHD-43
341-ZB1	MC-PAL-11	381	MC-PAL-4	505-MLB	MC-VHD-43
341215	MC-PAL-11	381-SS	MC-PAL-4	505-MLBLSC	MC-VHD-43
341215-M-100	MC-PAL-11	381-ZB1	MC-PAL-4	505501	MC-VHD-46
341215-M-25	MC-PAL-11	381215	MC-PAL-8	505502	MC-VHD-46
341215-M-50	MC-PAL-11	381215-M-100	MC-PAL-7	505503-L	MC-VHD-46
341915	MC-PAL-11	381215-M-25	MC-PAL-7	506-MB	MC-VHD-43
341915-M-100	MC-PAL-11	381215-M-50	MC-PAL-7	506-MBLSC	MC-VHD-43
341915-M-25	MC-PAL-11	381915	MC-PAL-7	506-MLB	MC-VHD-43
341915-M-50	MC-PAL-11	381915-M-100	MC-PAL-7	506-MLBLSC	MC-VHD-43
344	MC-PAL-17	381915-M-25	MC-PAL-7	506501	MC-VHD-46
344-R	MC-PAL-17	381915-M-50	MC-PAL-7	506502	MC-VHD-46
344-SS	MC-PAL-17	385	MC-PAL-7	506503-L	MC-VHD-46
344-ZB1	MC-PAL-20	385-L	MC-PAL-14	507107	MC-ACC-6
344215	MC-PAL-20	385-R	MC-PAL-14	507206	MC-ACC-3
344215-M-100	MC-PAL-20	385-V2A	MC-PAL-14	507206-M	MC-ACC-3
344215-M-25	MC-PAL-20	385-ZB1	MC-PAL-16	507208	MC-ACC-2
344215-M-50	MC-PAL-20	385102	MC-PAL-12, 14	507208-M	MC-ACC-2
344915	MC-PAL-20	385215	MC-PAL-16	507209	MC-ACC-3
344915-M-100	MC-PAL-20	385215-M-100	MC-PAL-16	507907	MC-ACC-6
344915-M-25	MC-PAL-20	385215-M-25	MC-PAL-16	509208	MC-ACC-3
344915-M-50	MC-PAL-20	385215-M-50	MC-PAL-16	5105	MC-VHD-29
345	MC-SAP-3	385915	MC-PAL-16	5110	MC-VHD-29
345-G	MC-SAP-3	385915-M-100	MC-PAL-16	5130	MC-SLA-21
351	MC-PAL-4	385915-M-25	MC-PAL-16	5130-B	MC-SLA-21
351-B	MC-PAL-4	385915-M-50	MC-PAL-16	5130-M	MC-SLA-21
351-BSS	MC-PAL-4	424	MC-SAP-4	5130-MB	MC-SLA-21
351-R	MC-PAL-4	424-2	MC-SAP-4	5131	MC-SLA-21
351-SS	MC-PAL-4	424107	MC-ACC-5	5131-B	MC-SLA-21
351-ZB1	MC-PAL-6	424208	MC-ACC-2	5131-M	MC-SLA-21

Model No.	Page	Model No.	Page	Model No.	Page
5131-MB	MC-SLA-21	604-SS	MC-SLA-25	8031	MC-PTC-26
5133	MC-SLA-21	604106	MC-SLA-28	807-S	MC-PTC-7
5133-B	MC-SLA-21	604106-M	MC-SLA-28	807-SE	MC-PTC-7
5133-M	MC-SLA-21	605	MC-SLA-9	807-U	MC-PTC-7
5133-MB	MC-SLA-21	605-M	MC-SLA-9	807-UE	MC-PTC-7
5150	MC-SLA-23	606	MC-SLA-10	8071	MC-PTC-19
5150-B	MC-SLA-23	606-M	MC-SLA-10	8071-UE	MC-PTC-19
5150-M	MC-SLA-23	607	MC-SLA-11	810-S	MC-PTC-9
5150-MB	MC-SLA-23	607-M	MC-SLA-11	810-SE	MC-PTC-9
519208	MC-ACC-3	607-SQ	MC-SLA-11	810-U	MC-PTC-9
527	MC-VHD-39	607-SQM	MC-SLA-11	810-UE	MC-PTC-9
527-F	MC-VHD-39	608	MC-SLA-7	810151	MC-PSC-40
527203	MC-ACC-4	608-M	MC-SLA-7	810153	MC-PSC-40
527208	MC-ACC-2	609	MC-SLA-12	810155	MC-PSC-40
528	MC-VHD-31	609-B	MC-SLA-12	810156	MC-PSC-40
528-F	MC-VHD-31	610	MC-SLA-13	810157	MC-PSC-40
52H-3E...50	PC-PPC-47	610-M	MC-SLA-13	810158	MC-PSC-40
52H-3E...63	PC-PPC-47	614-M	MC-SLA-29	810169	MC-PSC-40
5305	MC-HHD-31	615	MC-SLA-14	810170	MC-PSC-40
5310	MC-HHD-31	620	MC-SLA-15	810171	MC-PSC-40
533-L	MC-VHD-33	620-M	MC-SLA-15	810173	MC-PSC-40
533-LB	MC-VHD-33	624	MC-SLA-25	810174	MC-PSC-40
535-L	MC-VHD-33	624-MM	MC-SLA-25	8115	MC-PSC-19
535-LB	MC-VHD-33	624-SS	MC-SLA-25	8116	MC-PSC-19
548	MC-VHD-32	624106-M	MC-SLA-28	812-U	MC-PTC-3
558	MC-VHD-35	630	MC-SLA-16	817-S	MC-PTC-21
578	MC-VHD-32	630-M	MC-SLA-16	817-SE	MC-PTC-21
5905	MC-VHD-27	630-MR	MC-SLA-16	817-U	MC-PTC-21
5910	MC-VHD-27	630-R	MC-SLA-16	817-UE	MC-PTC-21
5915	MC-VHD-27	640	MC-SLA-17	81L-12-1....	PC-PPC-3
6001	MC-SLA-3	640-M	MC-SLA-17	81L-16-1....	PC-PPC-3
6001-M	MC-SLA-3	640-MR	MC-SLA-17	81L-20-1....	PC-PPC-3
6001-MSS	MC-SLA-3	640-R	MC-SLA-17	81L-25-1....	PC-PPC-3
6001-SS	MC-SLA-3	650	MC-SLA-18	8215	MC-PSC-28
6004	MC-SLA-27	650-M	MC-SLA-18	821512	MC-PSC-22, 31
6004-MM	MC-SLA-27	670-1MBPLS	MC-SLA-31	821513	MC-PSC-22, 31
6004-MMR	MC-SLA-27	675-1MBPLS	MC-SLA-31	821553	MC-PSC-31
6004-R	MC-SLA-27	690-1MBPLS	MC-SLA-31	821556	MC-PSC-22, 31
601	MC-SLA-4	695-1MBPLS	MC-SLA-31	8216	MC-PSC-28
601-M	MC-SLA-4	705384	MC-HYD-5	827-S	MC-PTC-21
601-O	MC-SLA-4	705512	MC-HYD-5	827-SE	MC-PTC-21
601-OSS	MC-SLA-4	705634	MC-HYD-5	827-U	MC-PTC-21
601-SS	MC-SLA-4	7-58	MC-VHD-40	827-UE	MC-PTC-21
6015	MC-SLA-5	7-59	MC-VHD-40	82D40-2...	PC-PPC-61
6015-M	MC-SLA-5	7-60	MC-VHD-40	82D63-5...	PC-PPC-61
6015-MR	MC-SLA-5	7-101	MC-VHD-40	82L-12-4...	PC-PPC-7
6015-MSS	MC-SLA-5	800	MC-PTC-29	82L-16-4...	PC-PPC-7
6015-R	MC-SLA-5	800-E	MC-PTC-29	82L-20-4...	PC-PPC-7
6015-SS	MC-SLA-5	8007-E	MC-PTC-13	82L-25-4...	PC-PPC-7
602	MC-SLA-25	8007-EHL	MC-PTC-13	82L2G-2...	PC-PPC-15
602-MM	MC-SLA-25	8007-EHR	MC-PTC-13	82L3G-2...	PC-PPC-15
602-MMSS	MC-SLA-25	8015	MC-PSC-28	82L3N-2...	PC-PPC-15
602-SS	MC-SLA-25	801528	MC-PSC-22, 31	82L4G-2...	PC-PPC-15
602106-M	MC-SLA-28	801529	MC-PSC-22, 31	82L4N-2...	PC-PPC-15
603	MC-SLA-7	801532	MC-PSC-22, 31	82M-3E..H040..	PC-PPC-45
603-M	MC-SLA-7	801553	MC-PSC-31	82M-3E..H05...	PC-PPC-45
603-MR	MC-SLA-7	8016	MC-PSC-28	82M-3E..H06..	PC-PPC-45
603-MSS	MC-SLA-7	802-U	MC-PTC-5	82M-3E..H08..	PC-PPC-45
603-R	MC-SLA-7	802-UE	MC-PTC-5	82M-3E...40	PC-PPC-25
603-SS	MC-SLA-7	8021	MC-PTC-19	82M-3E...5.	PC-PPC-25
604	MC-SLA-25	8021-UE	MC-PTC-19	82M-3E...6.	PC-PPC-25
604-MM	MC-SLA-25	803	MC-PTC-25	82M-3E...8.	PC-PPC-25
604-MMSS	MC-SLA-25	803-ME	MC-PTC-25	82ZB-004-1	PC-PPC-4, 8

CLAMPING TECHNOLOGY

Product Index

Model No.	Page	Model No.	Page	Model No.	Page
82ZB-036-1	PC-PPC-22	89B50-025-1R	MC-PSC-14	8EA-137-1	PC-PPC-23
82ZB-037-1	PC-PPC-22	89B63-008-1L	MC-PSC-14	8EA-138-1	PC-PPC-23
82ZB-038-1	PC-PPC-22	89B63-008-1R	MC-PSC-14	8EA-139-1	PC-PPC-23
82ZB-039-1	PC-PPC-46	89E20-010-1L	MC-PSC-23	8EL-002-1	PC-PPC-23, 46, 68
82ZB-084-1	PC-PPC-46	89E20-010-1R	MC-PSC-23	8EL-003-1	PC-PPC-23, 46, 68
82ZB-SH4001	PC-PPC-23, 68	89E30-010-1L	MC-PSC-23	8EL-007-1	PC-PPC-23
82ZB-SH4002	PC-PPC-23, 68	89E30-010-1R	MC-PSC-23	8EL-009-1	PC-PPC-23
82ZB-SH4005	PC-PPC-23, 68	89E40-010-1L	MC-PSC-23	8JG-065-2-01	PC-PPC-20, 23, 63, 68
82ZB-SH4010	PC-PPC-23, 68	89E40-010-1R	MC-PSC-23	8JG-066-1-01	PC-PPC-20, 23, 65, 68
82ZB-SH4020	PC-PPC-23, 68	89E50-025-1L	MC-PSC-23	8JG-067-2-01	PC-PPC-20, 23
82ZB-SH4050	PC-PPC-68	89E50-025-1R	MC-PSC-23	8JG-068-1-01	PC-PPC-20, 23
82ZB-SH5001	PC-PPC-68	89E63-008-1L	MC-PSC-23	8JG-069-1-01	PC-PPC-64, 68
82ZB-SH5002	PC-PPC-68	89E63-008-1R	MC-PSC-23	8JG-070-1-01	PC-PPC-39, 53, 66, 68
82ZB-SH5005	PC-PPC-68	89R20-010-2	MC-PSC-8	8JG-075-3-01	PC-PPC-20, 23
82ZB-SH5010	PC-PPC-68	89R32-010-2	MC-PSC-8	8JG-080-1-01	PC-PPC-40, 53
82ZB-SH5020	PC-PPC-68	89R40-010-2	MC-PSC-8	8JG-1179-1-01	PC-PPC-40
82ZB-SH5050	PC-PPC-68	89R40-025-2	MC-PSC-8	8JG-169-2-01	PC-PPC-36
830	MC-PTC-27	89R50-025-2	MC-PSC-8	8JG-17(+)-2-01	PC-PPC-38
830-ME	MC-PTC-27	89R63-025-2	MC-PSC-8	8JG-215-1	MC-PSC-11, 17, 26
8315	MC-PSC-19	8AB-151-1	PC-PPC-46	8JG-217-1	MC-PSC-11, 17, 26
8316	MC-PSC-19	8AB-152-1	PC-PPC-46	8JG-218-1	MC-PSC-11, 17, 26
8415	MC-PSC-28	8AB-153-1	PC-PPC-46	8JG-219-1	MC-PSC-11, 17, 26
841550	MC-PSC-31	8AB-154-1	PC-PPC-46	8JG-220-1	MC-PSC-11, 17, 26
8416	MC-PSC-28	8CE-282-1	PC-PPC-23	8JG-363-1-01	PC-PPC-21, 23
846	MC-PTC-11	8CE-284-1	PC-PPC-23	8JG-364-1-01	MC-SLA-21, 23
847-S	MC-PTC-15	8CE-286-1	PC-PPC-23	8JG-401-1-01	PC-PPC-13
847-U	MC-PTC-15	8CE-288-1	PC-PPC-23	8JG-402-1-01	PC-PPC-13
850	MC-PTC-28	8CE-290-1	PC-PPC-23	8JG-403-1-01	PC-PPC-13
850-ME	MC-PTC-28	8CE-292-1	PC-PPC-23	8JG-404-1-01	PC-PPC-13
858	MC-PTC-17	8CE-296-1	PC-PPC-23	8KB-031-1	MC-SLA-23
858-E	MC-PTC-17	8CE-298-1	PC-PPC-23	8KB-032-1	MC-SLA-23
860	MC-PPC-59	8CE-300-1	PC-PPC-23	8MA-061-1	MC-PSC-13
861	MC-PPC-59	8CE-302-1	PC-PPC-23	8MA-063-1	MC-PSC-13
8610100	MC-PPC-59	8CE-304-1	PC-PPC-23	8MA-064-1	MC-PSC-13
865132-MR	MC-PPC-59	8CE-306-1	PC-PPC-23	8MA-065-1	MC-PSC-13
865133-MR	MC-PPC-59	8CE-310-1	PC-PPC-23	8MA-066-1	MC-PSC-13
868	MC-PTC-23	8CE-312-1	PC-PPC-23	8MA-084-1	MC-PSC-11, 17, 26
868-E	MC-PTC-23	8CE-314-1	PC-PPC-23	8MA-086-1	MC-PSC-11, 17, 26
870-2	MC-PPC-57	8CE-316-1	PC-PPC-23	8MA-087-1	MC-PSC-11, 17, 26
871-2	MC-PPC-57	8CE-318-1	PC-PPC-23	8MA-088-1	MC-PSC-11, 17, 26
8725	MC-PSC-37	8CE-320-1	PC-PPC-23	8MA-089-1	MC-PSC-11, 17, 26
872550	MC-PSC-39	8CE-326-1	PC-PPC-68	8MA-089-1	MC-PSC-12
8732	MC-PSC-37	8CE-328-1	PC-PPC-68	8MA-092-1	MC-PSC-12
873250	MC-PSC-39	8CE-330-1	PC-PPC-68	8MA-094-1	MC-PSC-12
8732G	MC-PSC-37	8CE-332-1	PC-PPC-68	8MA-095-1	MC-PSC-12
8740	MC-PSC-37	8CE-334-1	PC-PPC-68	8MA-096-1	MC-PSC-27
874050	MC-PSC-39	8CE-336-1	PC-PPC-68	8MA-219-1	MC-PSC-27
8740G	MC-PSC-37	8CE-338-1	PC-PPC-68	8MA-220-1	MC-PSC-27
8750	MC-PSC-37	8CE-340-1	PC-PPC-68	8MA-221-1	MC-PSC-27
875050	MC-PSC-39	8CE-342-1	PC-PPC-68	8MA-222-1	MC-PSC-27
8750G	MC-PSC-37	8CE-346-1	PC-PPC-68	8MA-223-1	MC-PSC-12
890	MC-PPC-59	8CE-348-1	PC-PPC-68	8MW-018-1	MC-PSC-12
891	MC-PPC-59	8CE-350-1	PC-PPC-68	8MW-020-1	MC-PSC-12
8910100	MC-PPC-59	8CE-352-1	PC-PPC-68	8MW-021-1	PC-PPC-68
895132-MR	MC-PPC-59	8CE-354-1	PC-PPC-68	8MW-022-1	PC-PPC-68
895133-MR	MC-PPC-59	8CE-356-1	PC-PPC-68	8MW-023-1	PC-PPC-68
89B20-010-1L	MC-PSC-14	8CE-358-1	PC-PPC-68	8PW-016-1	PC-PPC-68
89B20-010-1R	MC-PSC-14	8CE-360-1	PC-PPC-68	8PW-016-1-00	MC-PSC-12
89B30-010-1L	MC-PSC-14	8CE-362-1	PC-PPC-68	8PW-024-1-00	MC-PSC-12
89B30-010-1R	MC-PSC-14	8EA-024-2	PC-PPC-68	8PW-024-2	MC-PSC-12
89B40-010-1L	MC-PSC-14	8EA-109-1	MC-PSC-40,	8PW-095-1-00	PC-PPC-23
89B40-010-1R	MC-PSC-14		MC-SLA-3,7	8PW-095-2	PC-PPC-23
89B50-025-1L	MC-PSC-14	8EA-120-1	MC-PSC-40	8PW-096-1-00	PC-PPC-23

Model No.	Page
8PW-096-2	PC-PPC-23
8PW-097-1-00	PC-PPC-23
8PW-097-2	PC-PPC-23
8PW-102-2	PC-PPC-23
8PW-103-2	PC-PPC-23
8S401-15-117	PC-PPC-39
8S501-25-144	PC-PPC-39, 53
8S631-25-144	PC-PPC-40, 53
8S631-45-144	PC-PPC-40, 53
8S631-75-204	PC-PPC-40, 53
8S801-45-204	PC-PPC-40
8U(*)405-00-117	PC-PPC-37
8U(*)405-15-117	PC-PPC-37
8U(*)405-25-117	PC-PPC-37
8U(*)405-45-107	PC-PPC-37
8U(*)501-15-144	PC-PPC-37, 52
8U(*)501-25-144	PC-PPC-52
8U(*)501-45-144	PC-PPC-37, 52
8U(*)631-15-144	PC-PPC-37, 52
8U(*)631-25-144	PC-PPC-38, 52
8U(*)631-45-144	PC-PPC-38, 52
8U(*)631-75-204	PC-PPC-38, 52
8UM405-00-117	PC-PPC-35
8UM405-15-117	PC-PPC-35
8UM405-25-117	PC-PPC-35
8UM405-45-107	PC-PPC-35
8UM501-15-144	PC-PPC-35, 51
8UM501-25-144	PC-PPC-35, 51
8UM501-45-144	PC-PPC-35, 51
8UM631-15-144	PC-PPC-36, 51
8UM631-25-144	PC-PPC-36, 51
8UM631-45-144	PC-PPC-36, 51
8UM631-75-204	PC-PPC-36, 51
8UM801-45-204	PC-PPC-36
905	MC-ACC-3
905-M	MC-ACC-3
91090	MC-VHD-36
920	MC-ACC-3
920-M	MC-ACC-3
95030	MC-SLA-19
95040	MC-SLA-19
95050	MC-SLA-19
95060	MC-SLA-19
9522-2L	MC-PSC-3
9522-2R	MC-PSC-3
9522150	MC-PSC-7
9522153	MC-PSC-7
952260	MC-PSC-6
952261	MC-PSC-6
952262	MC-PSC-6
9530-2GL	MC-PSC-3
9530-2GR	MC-PSC-3
9530-2L	MC-PSC-3
9530-2R	MC-PSC-3
953060	MC-PSC-6
953061	MC-PSC-6
953062	MC-PSC-6
9540-2GL	MC-PSC-3
9540-2GR	MC-PSC-3
9540-2L	MC-PSC-3
9540-2R	MC-PSC-3
9540150	MC-PSC-7
9540153	MC-PSC-7

Model No.	Page
954060	MC-PSC-6
954061	MC-PSC-6
9550-2GL	MC-PSC-3
9550-2GR	MC-PSC-3
9550-2L	MC-PSC-3
9550-2R	MC-PSC-3
9550150	MC-PSC-7
9550153	MC-PSC-7
955060	MC-PSC-6
955061	MC-PSC-6
955062	MC-PSC-6
B8JG-1007-1	PC-PPC-43, 56
B8JG-1008-1	PC-PPC-43, 56
B8JG-1009-1	PC-PPC-43, 56
B8JG-1010-1	PC-PPC-43, 56
B8JG-1011-1	PC-PPC-43, 56
B8JG-1012-1	PC-PPC-43, 56
B8JG-1019-1	PC-PPC-43, 56
B8JG-1020-1	PC-PPC-43, 56
B8JG-1021-1	PC-PPC-43, 56
B8JG-1022-1	PC-PPC-43, 56
B8JG-1023-1	PC-PPC-43, 56
B8JG-1024-1	PC-PPC-43, 56
B8JG-1031-1	PC-PPC-43, 56
B8JG-1032-1	PC-PPC-43, 56
B8JG-1033-1	PC-PPC-43, 56
B8JG-1034-1	PC-PPC-43, 56
B8JG-1035-1	PC-PPC-43, 56
B8JG-1036-1	PC-PPC-43, 56
B8JG-1043-1	PC-PPC-43, 56
B8JG-1044-1	PC-PPC-43, 56
B8JG-1045-1	PC-PPC-43, 56
B8JG-1046-1	PC-PPC-43, 56
B8JG-1047-1	PC-PPC-43, 56
B8JG-1048-1	PC-PPC-43, 56
B8JG-1110-1	PC-PPC-44
B8JG-1111-1	PC-PPC-44
B8JG-1112-1	PC-PPC-44
B8JG-1113-1	PC-PPC-44
B8JG-1114-1	PC-PPC-44
B8JG-1115-1	PC-PPC-44
B8JG-1116-1	PC-PPC-44
B8JG-1117-1	PC-PPC-44
B8JG-1118-1	PC-PPC-44
B8JG-1130-1	PC-PPC-44
B8JG-1131-1	PC-PPC-44
B8JG-1132-1	PC-PPC-44
B8JG-1133-1	PC-PPC-44
B8JG-1134-1	PC-PPC-44
B8JG-1135-1	PC-PPC-44
B8JG-1136-1	PC-PPC-44
B8JG-1137-1	PC-PPC-44
B8JG-1138-1	PC-PPC-44
B8JG-1150-1	PC-PPC-44
B8JG-1151-1	PC-PPC-44
B8JG-1152-1	PC-PPC-44
B8JG-1153-1	PC-PPC-44
B8JG-1154-1	PC-PPC-44
B8JG-1155-1	PC-PPC-44
B8JG-1156-1	PC-PPC-44
B8JG-1157-1	PC-PPC-44
B8JG-1158-1	PC-PPC-44
B8JG-1170-1	PC-PPC-44

Model No.	Page
B8JG-1171-1	PC-PPC-44
B8JG-1172-1	PC-PPC-44
B8JG-1173-1	PC-PPC-44
B8JG-1174-1	PC-PPC-44
B8JG-1175-1	PC-PPC-44
B8JG-1176-1	PC-PPC-44
B8JG-1177-1	PC-PPC-44
B8JG-1178-1	PC-PPC-44
B8JG-1206-1	PC-PPC-41, 54
B8JG-1207-1	PC-PPC-41, 54
B8JG-1208-1	PC-PPC-41, 54
B8JG-1216-1	PC-PPC-41, 54
B8JG-1217-1	PC-PPC-41, 54
B8JG-1218-1	PC-PPC-41, 54
B8JG-1226-1	PC-PPC-41, 54
B8JG-1227-1	PC-PPC-41, 54
B8JG-1228-1	PC-PPC-41, 54
B8JG-1507-1	PC-PPC-42, 55
B8JG-1508-1	PC-PPC-42, 55
B8JG-1509-1	PC-PPC-42, 55
B8JG-1510-1	PC-PPC-42, 55
B8JG-1511-1	PC-PPC-42, 55
B8JG-1512-1	PC-PPC-42, 55
B8JG-1519-1	PC-PPC-42, 55
B8JG-1520-1	PC-PPC-42, 55
B8JG-1521-1	PC-PPC-42, 55
B8JG-1522-1	PC-PPC-42, 55
B8JG-1523-1	PC-PPC-42, 55
B8JG-1524-1	PC-PPC-42, 55
B8JG-1531-1	PC-PPC-42, 55
B8JG-1532-1	PC-PPC-42, 55
B8JG-1533-1	PC-PPC-42, 55
B8JG-1534-1	PC-PPC-42, 55
B8JG-1535-1	PC-PPC-42, 55
B8JG-1536-1	PC-PPC-42, 55
B8JG-1543-1	PC-PPC-42, 55
B8JG-1544-1	PC-PPC-42, 55
B8JG-1545-1	PC-PPC-42, 55
B8JG-1546-1	PC-PPC-42, 55
B8JG-1547-1	PC-PPC-42, 55
B8JG-1548-1	PC-PPC-42, 55
B8JG-3236-1	PC-PPC-41, 54
B8JG-3237-1	PC-PPC-41, 54
B8JG-3238-1	PC-PPC-41, 54
B8JG-3246-1	PC-PPC-41, 54
B8JG-3247-1	PC-PPC-41, 54
B8JG-3248-1	PC-PPC-41, 54
B8JG-3256-1	PC-PPC-41, 54
B8JG-3257-1	PC-PPC-41, 54
B8JG-3258-1	PC-PPC-41, 54
BIM-IKE-AP	MC-SLA-47
BK-R25-82L25-1	PC-PPC-21
BK-R25-82L32-1	PC-PPC-21
BK-R25-82L40-1	PC-PPC-21
CABL-010	MC-PSC-41
CABL-013	MC-PSC-41
F-160	MC-VSC-3
FL-120/--	MC-VSC-3
FL-121/45	MC-VSC-3
FL-122/45	MC-VSC-3
FL-160/--	MC-VSC-3
FL-161/60	MC-VSC-3
FL-162/60	MC-VSC-3

CLAMPING TECHNOLOGY

Product Index

Model No.	Page	Model No.	Page	Model No.	Page
FO-082/40	MC-VSC-3	L-227-1-02	MC-ACC-8	WK400-30-6-1	MC-PPC-6
FO-120/--	MC-VSC-3	L-227-1-03	MC-ACC-8	WK400-50-6-1	MC-PPC-6
FO-121/45	MC-VSC-3	L-227-1-04	MC-ACC-8	WK400-70-6-1	MC-PPC-6
FO-122/45	MC-VSC-3	L-227-2-01	MC-ACC-8	WK4500-120-6-1	MC-PPC-6
FO-160/--	MC-VSC-3	L-227-2-02	MC-ACC-8	WK4500-15-6-1	MC-PPC-6
FO-161/60	MC-VSC-3	L-227-3-01	MC-ACC-9	WK4500-200-6-1	MC-PPC-6
FO-162/60	MC-VSC-3	L-227-4-01	MC-ACC-10	WK4500-30-6-1	MC-PPC-6
FO-220/--	MC-VSC-3	SMB-102157	MC-PPC-10	WK4500-50-6-1	MC-PPC-6
FO-221/80	MC-VSC-3	T186-12	MC-CVR-5	WK4500-70-6-1	MC-PPC-6
G-082/40	MC-VSC-3	T186-20	MC-CVR-5	WK600-120-6-1	MC-PPC-6
G-120/--	MC-VSC-3	T186-24	MC-CVR-3	WK600-15-6-1	MC-PPC-6
G-121-45	MC-VSC-3	T186-36	MC-CVR-3	WK600-200-6-1	MC-PPC-6
G-122-45	MC-VSC-3	T186-6	MC-CVR-5	WK600-30-6-1	MC-PPC-6
K-1222	MC-VSC-7	T257-24	MC-CVR-5	WK600-50-6-1	MC-PPC-6
K-508	MC-VSC-7	T257-36	MC-CVR-5	WK600-70-6-1	MC-PPC-6
K-612	MC-VSC-7	T257-84	MC-CVR-3	WK6000-120-6	MC-PPC-6
K-816	MC-VSC-7	T285-18	MC-CVR-5	WK6000-30-6	MC-PPC-6
K1000-120-7-1	MC-PPC-3	T285-36	MC-CVR-3	WK6000-50-6	MC-PPC-6
K1000-15-7-1	MC-PPC-3	T285-60	MC-CVR-3	WK6000-70-6	MC-PPC-6
K1000-200-7-1	MC-PPC-3	T285-84	MC-CVR-3	WR 2000-120-7	MC-PPC-9
K1000-30-7-1	MC-PPC-3	T285-9	MC-CVR-5	WR 2000-15-7	MC-PPC-9
K1000-50-7-1	MC-PPC-3	T290-18	MC-CVR-5	WR 2000-30-7	MC-PPC-9
K1000-70-7-1	MC-PPC-3	T290-36	MC-CVR-3	WR 2000-50-7	MC-PPC-9
K3000-120-6-1	MC-PPC-3	T290-40	MC-CVR-5	WR 2000-70-7	MC-PPC-9
K3000-15-6-1	MC-PPC-3	T290-60	MC-CVR-3	WK XXXX-...-A	MC-PPC-10
K3000-200-6-1	MC-PPC-3	T290-84	MC-CVR-3	WK XXXX-...-K	MC-PPC-11
K3000-30-6-1	MC-PPC-3	T290-9	MC-CVR-5		
K3000-50-6-1	MC-PPC-3	T321-10	MC-CVR-5		
K3000-70-6-1	MC-PPC-3	T321-24	MC-CVR-3		
K400-120-6-1	MC-PPC-3	T321-36	MC-CVR-3		
K400-15-6-1	MC-PPC-3	T321-60	MC-CVR-3		
K400-200-6-1	MC-PPC-3	T400-4	MC-CVR-9		
K400-30-6-1	MC-PPC-3	T400-6	MC-CVR-9		
K400-50-6-1	MC-PPC-3	T400-8	MC-CVR-9		
K400-70-6-1	MC-PPC-3	T402-12	MC-CVR-9		
K4500-120-6-1	MC-PPC-3	T402-18	MC-CVR-9		
K4500-15-6-1	MC-PPC-3	T402-24	MC-CVR-9		
K4500-200-6-1	MC-PPC-3	T402-6	MC-CVR-9		
K4500-30-6-1	MC-PPC-3	T600-4	MC-CVR-9		
K4500-50-6-1	MC-PPC-3	T600-6	MC-CVR-9		
K4500-70-6-1	MC-PPC-3	T600-8	MC-CVR-9		
K600-120-6-1	MC-PPC-3	T602-12	MC-CVR-9		
K600-15-6-1	MC-PPC-3	T602-18	MC-CVR-9		
K600-200-6-1	MC-PPC-3	T602-6	MC-CVR-9		
K600-30-6-1	MC-PPC-3	T614-0	MC-CVR-7		
K600-50-6-1	MC-PPC-3	T614-1	MC-CVR-7		
K600-70-6-1	MC-PPC-3	T614-2	MC-CVR-7		
K XXXX-...-A	MC-PPC-10	T813400	MC-CVR-9		
K XXXX-...-K	MC-PPC-11	WK1000-120-7-1	MC-PPC-5		
L-213-1-01	MC-ACC-8	WK1000-15-7-1	MC-PPC-6		
L-213-1-02	MC-ACC-8	WK1000-200-7-1	MC-PPC-6		
L-213-2-01	MC-ACC-8	WK1000-30-7-1	MC-PPC-6		
L-213-2-02	MC-ACC-8	WK1000-50-7-1	MC-PPC-6		
L-213-3-01	MC-ACC-9	WK1000-70-7-1	MC-PPC-6		
L-213-4-01	MC-ACC-10	WK3000-120-6-1	MC-PPC-6		
L-217-1-01	MC-ACC-8	WK3000-15-6-1	MC-PPC-6		
L-217-1-02	MC-ACC-8	WK3000-200-6-1	MC-PPC-6		
L-217-1-03	MC-ACC-8	WK3000-30-6-1	MC-PPC-6		
L-217-2-01	MC-ACC-8	WK3000-50-6-1	MC-PPC-6		
L-217-2-02	MC-ACC-8	WK3000-70-6-1	MC-PPC-6		
L-217-3-01	MC-ACC-9	WK400-120-6-1	MC-PPC-6		
L-217-4-01	MC-ACC-10	WK400-15-6-1	MC-PPC-6		
L-227-1-01	MC-ACC-8	WK400-200-6-1	MC-PPC-6		

OUR PORTFOLIO OF PRODUCTS



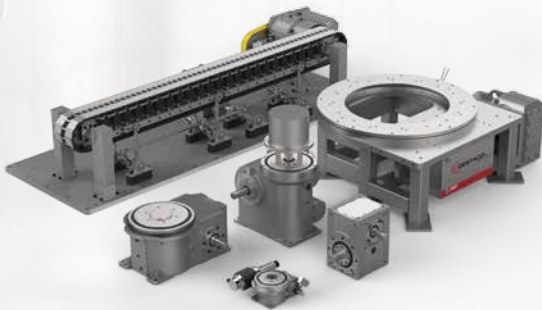
End Effectors (EE)

- Tool Changers
- End-of-Arm Tooling
- Vacuum Products
- Palletizing Solutions



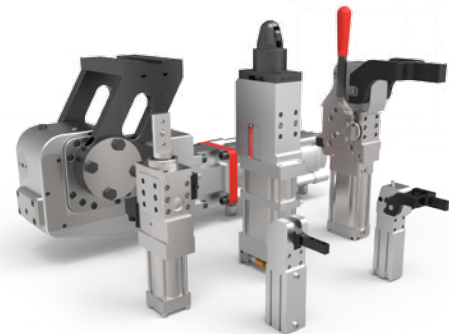
Grippers (GR)

- Electric Grippers
- Pneumatic and Sheet Metal Grippers
- Rotates
- Slides



Indexers (IN)

- Precision Conveyors
- Dial Indexers
- Shaft and Flange Indexers
- Part Handlers



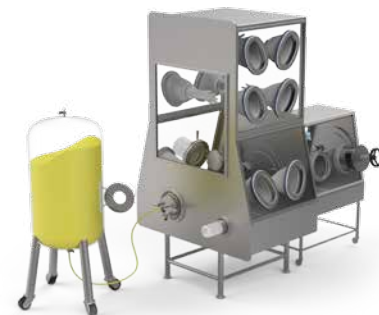
Power Clamps (PC)

- Power Clamps
- Pin Clamps and Packages
- Pivot Units
- Power Cylinders



Manual Clamps (MC)

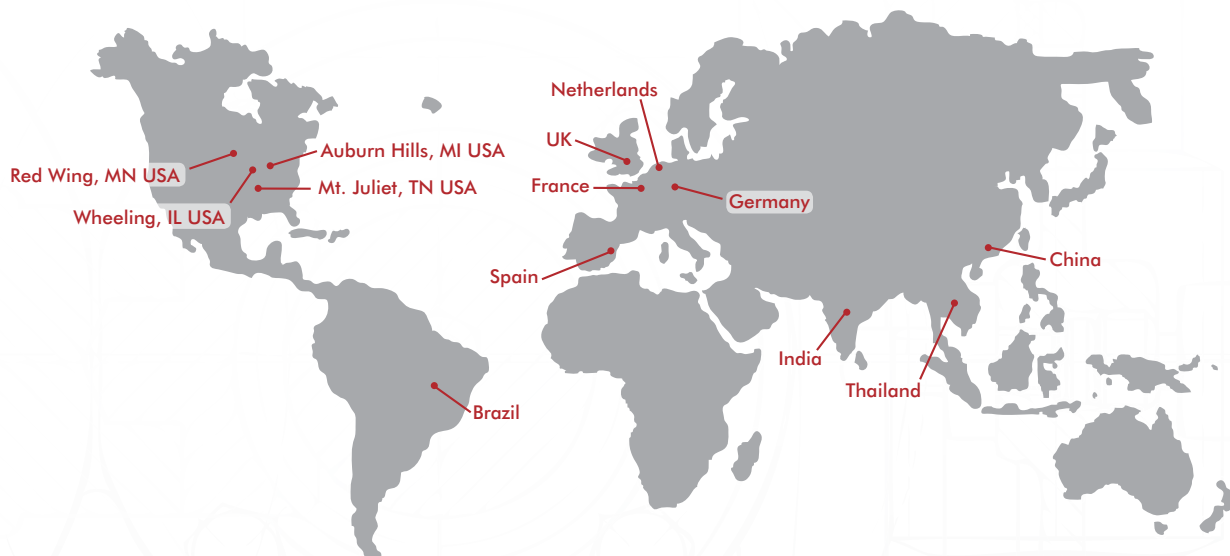
- Hold Down
- Squeeze Action
- Plunger, Hook and Latch
- Pneumatic Toggle and Swing



Remote Handling (RH)

- Gloveport Systems
- Transfer Systems
- Telemanipulators
- Waste Drum Systems

Precision in Productivity



GLOBAL LOCATIONS

NORTH AMERICA

DESTACO Headquarters

Auburn Hills, Michigan
Toll Free: 1.888.DESTACO
Marketing: marketing@destaco.com
Customer Service: customerservice@destaco.com

Mt. Juliet, Tennessee
Tel: 1.888.DESTACO
Customer Service: customerservice@destaco.com

Wheeling, Illinois
Tel: 1.800.645.5207
Customer Service: camco@destaco.com

Red Wing, Minnesota (Central Research Laboratories)
Tel: 651.385.2142
Customer Service: sales@centres.com

SOUTH AMERICA

Brazil
Tel: 0800-124070
Customer Service: samerica@destaco.com

ASIA

Thailand
Tel: +66-2-326-0812
Customer Service: info@destaco.com

China
Tel: +86-21-6081-2888
Customer Service: china@destaco.com

India
Tel: +91-80-41123421-426
Customer Service: india@destaco.com

EUROPE

Germany
Tel: +49-6171-705-0
Customer Service: europa@destaco.com

France
Tel: +33-4-7354-5001
Customer Service: france@destaco.com

UK
Tel: +44-1902-797980
Customer Service: uk@destaco.com

Spain
Tel: +34-936361680
Customer Service: spain@destaco.com

Netherlands
Tel: +31-297285332
Customer Service: benelux@destaco.com