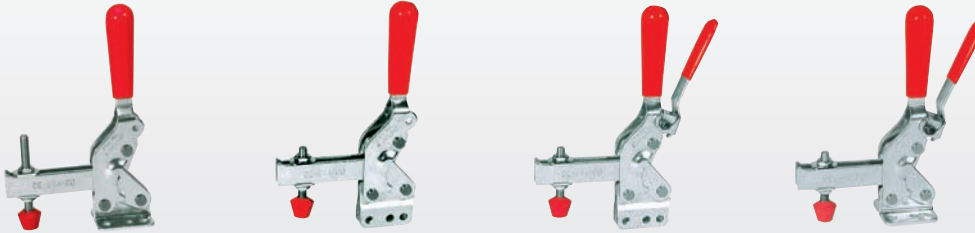




**The new 2000-Series: Strong and Compact**

This revolutionary new DE-STA-CO toggle clamp series features high holding forces and a compact design, greater clearance, pinch point elimination, vertical movement of the spindle, no workpiece movement, open, long clamping arm for more flexibility and optimized stop point location for more durability.



page **2.12**

## Product group – vertical clamps

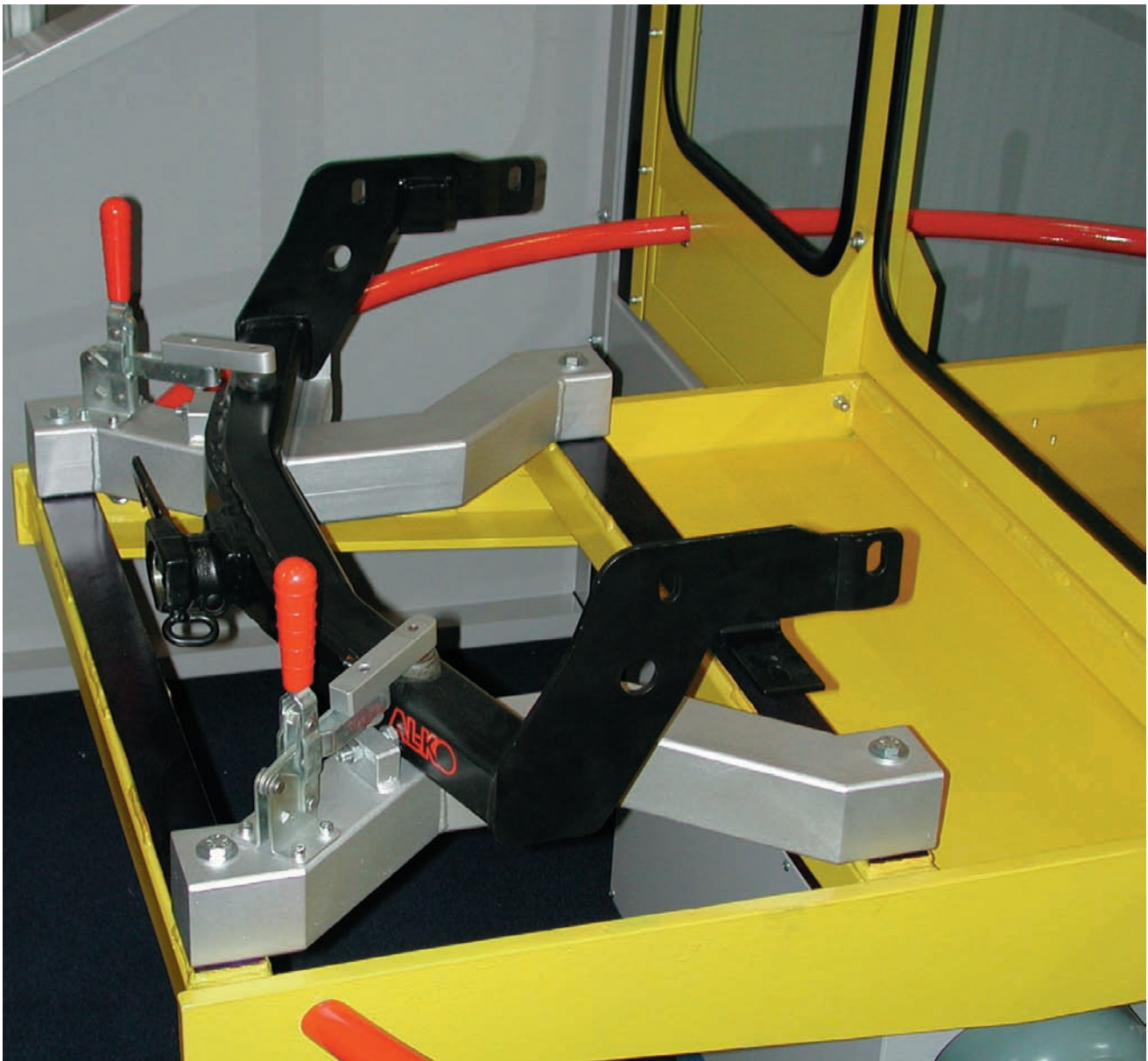
### Application areas

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 90° 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

















Model 210-U clamping a frame



## Product group – vertical clamps

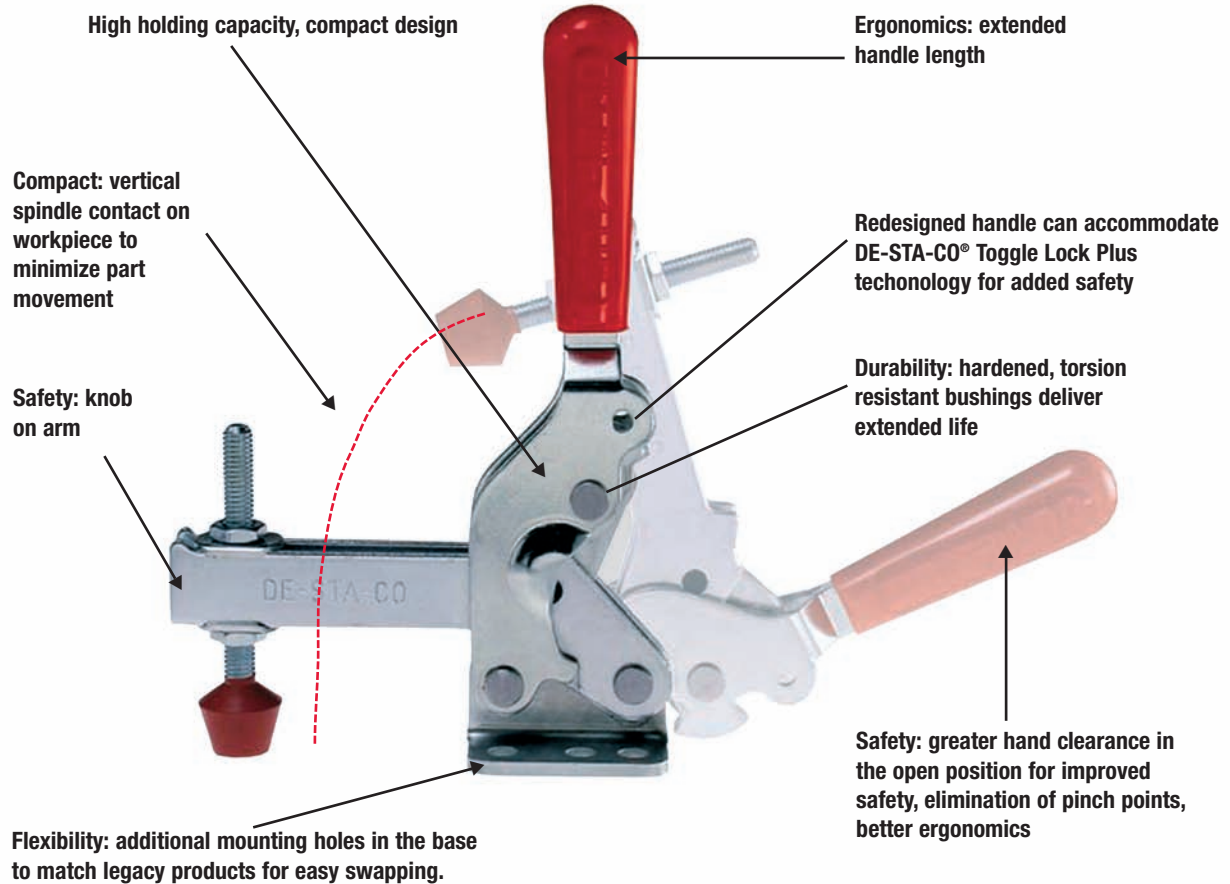
	Model no.	Holding Capacity max. [lbs.]	Category	Page		Model no.	Holding Capacity max. [lbs.]	Category	Page
	2002-S 2007-S 2010-S	600 1,000 1,400	<b>NEW!</b> Standard <b>NEW!</b> Standard <b>NEW!</b> Standard	2.7		202 207-L 207-S 210-S 247-S 267-S	200 500 500 750 1,000 1,200	Standard Standard Standard Standard Standard Standard	2.12
	2002-SB 2007-SB 2010-SB	600 1,000 1,400	<b>NEW!</b> Standard <b>NEW!</b> Standard <b>NEW!</b> Standard	2.7		202-B 207-LB 207-SB 210-SB 247-SB	200 500 500 750 1,000	Standard Standard Standard Standard Standard	2.13
	2002-SBR 2007-SBR 2010-SBR	600 1,000 1,400	<b>NEW!</b> DE-STA-CO® Toggle Lock Plus <b>NEW!</b> DE-STA-CO® Toggle Lock Plus <b>NEW!</b> DE-STA-CO® Toggle Lock Plus	2.8		207-LR 210-SR	500 750	DE-STA-CO® Toggle Lock Plus DE-STA-CO® Toggle Lock Plus DE-STA-CO® Toggle Lock Plus	2.14
	2002-SR 2007-SR 2010-SR	600 1,000 1,400	<b>NEW!</b> DE-STA-CO® Toggle Lock Plus <b>NEW!</b> DE-STA-CO® Toggle Lock Plus <b>NEW!</b> DE-STA-CO® Toggle Lock Plus	2.8		207-LBR 210-SBR	500 750	DE-STA-CO® Toggle Lock Plus DE-STA-CO® Toggle Lock Plus	2.15
	2002-U 2007-U 2010-U	600 1,000 1,400	<b>NEW!</b> Standard <b>NEW!</b> Standard <b>NEW!</b> Standard	2.9		202-T 207-TS 210-TS	200 500 750	Standard Standard Standard	2.16
	2002-UB 2007-UB 2010-UB	600 1,000 1,400	<b>NEW!</b> Standard <b>NEW!</b> Standard <b>NEW!</b> Standard	2.9		202-TB	200	Standard	2.16
	2002-UBR 2007-UBR 2010-UBR	600 1,000 1,400	<b>NEW!</b> DE-STA-CO® Toggle Lock Plus <b>NEW!</b> DE-STA-CO® Toggle Lock Plus <b>NEW!</b> DE-STA-CO® Toggle Lock Plus	2.10		201-TU 202-TU 207-TU 207-TUL 210-TU	100 200 375 375 600	Standard Standard Standard Standard Standard	2.17
	2002-UR 2007-UR 2010-UR	600 1,000 1,400	<b>NEW!</b> DE-STA-CO® Toggle Lock Plus <b>NEW!</b> DE-STA-CO® Toggle Lock Plus <b>NEW!</b> DE-STA-CO® Toggle Lock Plus	2.11		201-U 202-U 202-UL 207-U 207-UL 207-UO 210-U 247-U 267-U	100 200 375 375 375 375 600 1,000 1,200	Standard Standard Standard Standard Standard Standard Standard Standard Standard	2.18

## Product group – vertical clamps

	Model no.	Holding Capacity max. [lbs.]	Category	Page		Model no.	Holding Capacity max. [lbs.]	Category	Page
	201-UB 202-UB 207-UB 207-ULB 210-UB 247-UB 267-UB	100 200 375 375 600 1,000 1,200	Standard Standard Standard Standard Standard Standard Standard	2.20		558 568	2,500 3,300	Heavy-duty Heavy-duty	2.29
	207-UR 210-UR	375 600	DE-STA-CO® Toggle Lock Plus DE-STA-CO® Toggle Lock Plus	2.22		533-L 535-L	1,500 2,200	<b>NEW!</b> Heavy-duty <b>NEW!</b> Heavy-duty	2.30
	207-UBR 210-UBR	375 600	DE-STA-CO® Toggle Lock Plus DE-STA-CO® Toggle Lock Plus	2.23		533-LB 535-LB 536-LB	1,500 2,200 2,900	<b>NEW!</b> Heavy-duty <b>NEW!</b> Heavy-duty <b>NEW!</b> Heavy-duty	2.31
	219 229	350 1,000	Standard Standard	2.24		501-B 503-MB 503-MBLSC 505-MB 505-MBLSC 506-MB 506-MBLSC	560 1,500 1,500 2,400 2,400 5,000 5,000	Modular Modular Modular Modular Modular Modular Modular	2.33
	516 516-B	750 750	Standard Standard	2.25		501-LB 503-MLB 503-MLBSC 505-MLB 505-MLBSC 506-MLB 506-MLBSC	560 1,500 1,500 2,400 2,400 5,000 5,000	Modular Modular Modular Modular Modular Modular Modular	2.34
	518	500	Standard	2.26		7-101 7-58 7-59 7-60 7-61	475 600 1,000 1,600 3,750	Cam Action Cam Action Cam Action Cam Action Cam Action	2.36
	528 528-F	1,000 1,000	Heavy-duty Heavy-duty	2.27		207-SF	500	<b>NEW!</b> Standard	2.37
	548 578 588	2,000 4,000 6,200	Heavy-duty Heavy-duty Heavy-duty	2.28		207-UF	375	<b>NEW!</b> Standard	2.38

	Model no.	Holding Capacity max. [lbs.]	Category	Page
	317-S	375	Standard	2.39
	317-U	375	Standard	2.40
	527	1,000	Standard	2.41
	527-F	1,000	Standard	2.42
	557	2,500	Standard	2.42
	91090 91140	385 1,000	Standard	2.43
	VH3	200	Composite	2.43

## Strength: 2-3 times higher Holding Capacity



### Main Benefits:

1. High holding capacity, compact design
2. Greater hand clearance, pinch point elimination
3. Vertical movement of the spindle, no workpiece movement
4. Open, long clamping bar for more flexibility
5. Optimized handle stop location for more durability

### Application areas:

Ideal for fixtures and applications with restricted space where high holding capacity is required.

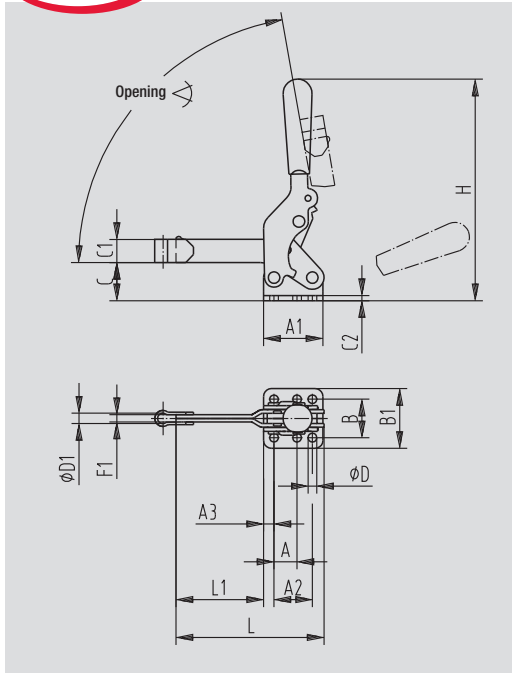
### Product features:

- All pivot points are bushed yielding high lifecycles
- Rivets made of stainless steel to reduce wear
- Improved material thickness for high durability
- Ergonomically shaped handle for operator comfort

Patent No.  
6,595,507

**NEW**

## Models 2002-S, 2007-S, 2010-S



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔗 Bolt Retainer	Spindle Size (Not Supplied)
2002-S	600	75°	85°	0.48	2002115-E	1/4 or M6
2007-S	1,000	80°	76°	1.20	2007115-E	5/16 or M8
2010-S	1,400	80°	83°	2.56	2010115-E	3/8 or M10

See additional adjustment spindles beginning on page 9.1

- Solid clamping bar with bolt retainer
- Flanged base

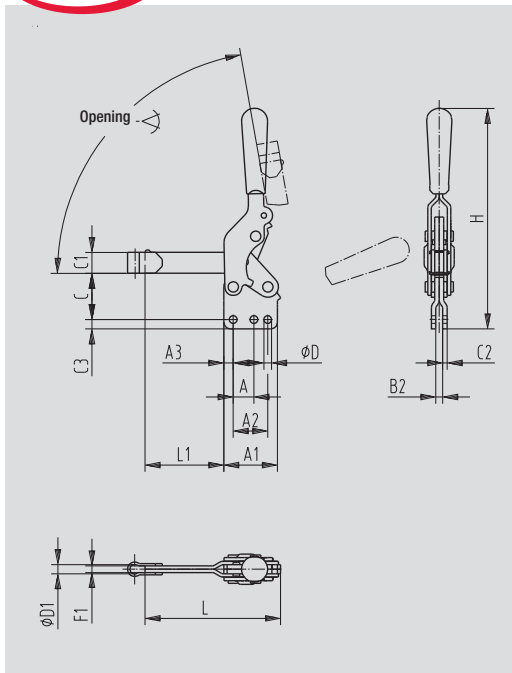
Patent No.  
6,595,507



Model no.	A	A1	A2	A3	B	B1	C	C1	C2	φD	φD1	F1	H	L	L1
2002-S	0.50	1.36	0.90	0.24	1.06	1.52	0.95	0.49	0.12	0.22	0.22	0.25	5.47	3.29	1.93
2007-S	0.75	1.93	1.25	0.33	1.25	1.94	1.25	1.24	0.16	0.28	0.28	0.34	7.64	4.81	2.88
2010-S	-	2.53	1.25	0.63	1.78	2.62	1.70	1.12	0.20	0.34	0.34	0.44	9.61	6.09	3.56

**NEW**

## Models 2002-SB, 2007-SB, 2010-SB



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔗 Bolt Retainer	Spindle Size (Not Supplied)
2002-SB	600	75°	85°	0.48	2002115-E	1/4 or M6
2007-SB	1,000	80°	76°	1.20	2007115-E	5/16 or M8
2010-SB	1,400	80°	83°	2.56	2010115-E	3/8 or M10

See additional adjustment spindles beginning on page 9.1

- Solid clamping bar with bolt retainer
- Straight base

Patent No.  
6,595,507



Model no.	A	A1	A2	A3	B2	C	C1	C2	φD	φD1	F1	H	L	L1
2002-SB	0.50	1.36	0.90	0.24	0.24	1.27	0.49	0.12	0.22	0.22	0.25	5.47	3.29	1.93
2007-SB	0.75	1.93	1.25	0.33	0.24	1.68	1.24	0.16	0.28	0.28	0.34	7.64	4.81	2.88
2010-SB	-	2.53	1.25	0.63	0.31	2.20	1.12	0.20	0.34	0.34	0.44	9.61	6.09	3.56

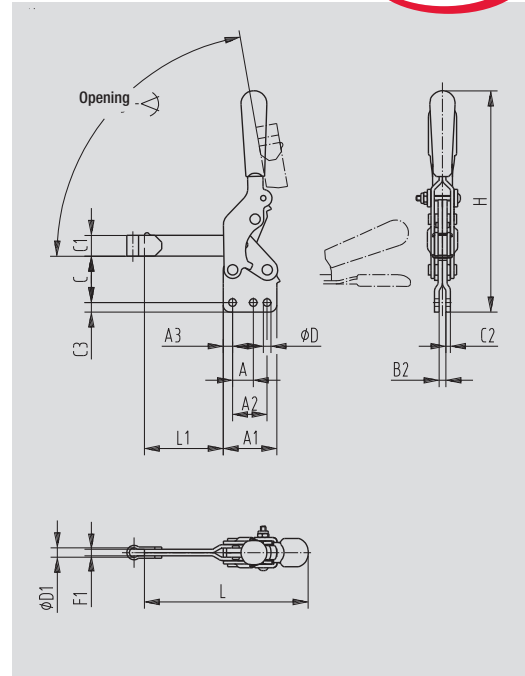
## Models 2002-SBR, 2007-SBR, 2010-SBR



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔗 Bolt Retainer	Spindle Size (Not Supplied)
2002-SBR	600	75°	85°	0.48	2002115-E	1/4 or M6
2007-SBR	1,000	80°	76°	1.20	2007115-E	5/16 or M8
2010-SBR	1,400	80°	83°	2.56	2010115-E	3/8 or M10

See additional adjustment spindles beginning on page 9.1.

- DE-STA-CO® Toggle Lock Plus
- Solid bar with bolt retainer
- Straight base



Model no.	A	A1	A2	A3	B2	C	C1	C2	øD	øD1	F1	H	L	L1
2002-SBR	0.50	1.36	0.90	0.24	0.24	1.27	0.49	0.12	0.22	0.22	0.25	5.47	4.17	1.93
2007-SBR	0.75	1.93	1.25	0.33	0.24	1.68	1.24	0.16	0.28	0.28	0.34	7.64	5.94	2.88
2010-SBR	–	2.53	1.25	0.63	0.31	2.20	1.12	0.20	0.34	0.34	0.44	9.61	7.28	3.56

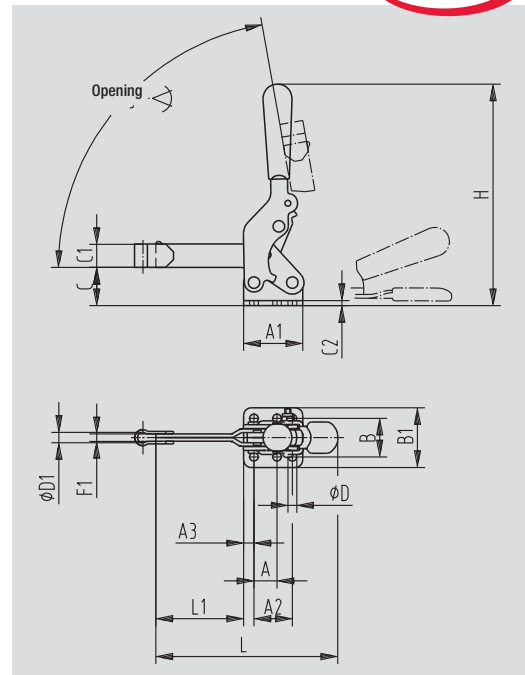
## Models 2002-SR, 2007-SR, 2010-SR



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔗 Bolt Retainer	Spindle Size (Not Supplied)
2002-SR	600	75°	85°	0.48	2002115-E	1/4 or M6
2007-SR	1,000	80°	76°	1.20	2007115-E	5/16 or M8
2010-SR	1,400	80°	83°	2.56	2010115-E	3/8 or M10

See additional adjustment spindles beginning on page 9.1.

- DE-STA-CO® Toggle Lock Plus
- Solid bar with bolt retainer
- Flanged base

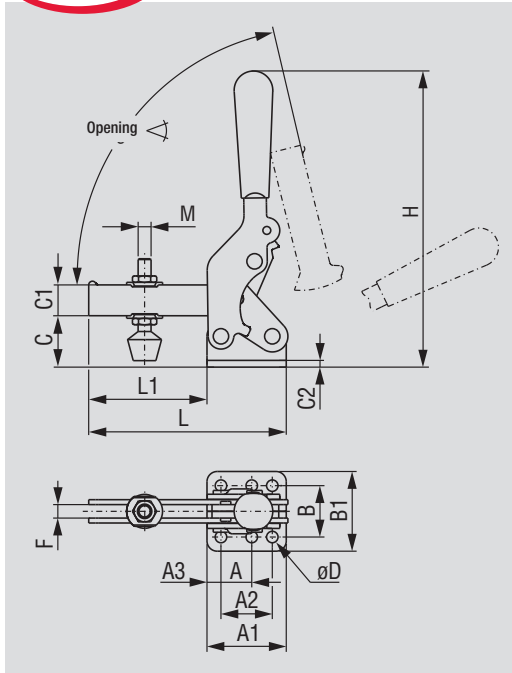


Model no.	A	A1	A2	A3	B	B1	C	C1	C2	øD	øD1	F1	H	L	L1
2002-SR	0.50	1.36	0.90	0.24	1.06	1.52	0.95	0.49	0.12	0.22	0.26	0.25	4.73	4.17	1.93
2007-SR	0.75	1.93	1.25	0.33	1.25	1.94	1.25	1.24	0.16	0.28	0.33	0.34	7.21	5.94	2.88
2010-SR	–	2.53	1.25	0.63	1.78	2.62	1.70	1.12	0.20	0.34	0.45	0.44	9.00	7.28	3.56



**NEW**

## Models 2002-U, 2007-U, 2010-U



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment	🔩 Flanged Washers
2002-U	60	75°	85°	0.48	215208-M	215105
2002-U-LS					without spindle	215105
2007-U	1,000	80°	76°	1.20	2007208-M	507107
2007-U-LS					without spindle	507107
2010-U	1,400	80°	83°	2.56	240208-M	235106
2037-U-LS					without spindle	235106

See additional adjustment spindles beginning on page 9.1.

- U-bar
- Flanged base

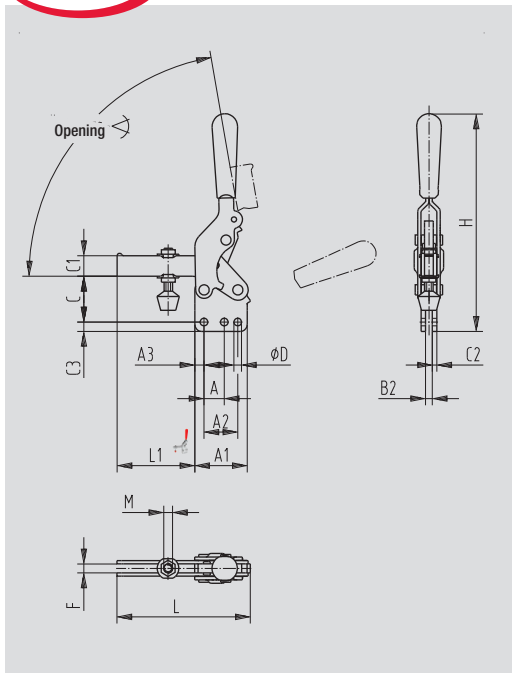
Patent No.  
6,595,507



Model no.	A	A1	A2	A3	B	B1	C	C1	C2	øD	F	H	L	L1	M
2002-U	0.50	1.36	0.90	0.24	1.06	1.52	0.95	0.49	0.12	0.22	0.25	4.73	3.29	1.93	M6
2007-U	0.75	1.93	1.25	0.33	1.25	1.94	1.25	1.24	0.16	0.28	0.34	7.21	4.81	2.88	M8
2010-U	—	2.53	1.25	0.63	1.78	2.62	1.70	1.12	0.20	0.34	0.44	9.00	6.09	3.56	M10

**NEW**

## Models 2002-UB, 2007-UB, 2010-UB

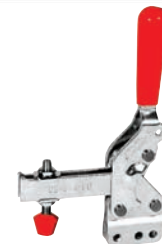


Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment	🔩 Flanged Washers
2002-UB	600	75°	85°	0.48	215208-M	215105
2002-UB-LS					without spindle	215105
2007-UB	1,000	80°	76°	1.20	2007208-M	507107
2007-UB-LS					without spindle	507107
2010-UB	1,400	80°	83°	2.56	240208-M	235106
2037-UB-LS					without spindle	235106

See additional adjustment spindles beginning on page 9.1.

- U-bar
- Straight base

Patent No.  
6,595,507



Model no.	A	A1	A2	A3	B2	C	C1	C2	øD	F	H	L	L1	M
2002-UB	0.50	1.36	0.90	0.24	0.24	1.27	0.49	0.12	0.22	0.25	5.07	3.29	1.93	M6
2007-UB	0.75	1.93	1.25	0.33	0.24	1.68	1.24	0.16	0.28	0.34	7.64	4.81	2.88	M8
2010-UB	—	2.53	1.25	0.63	0.31	2.20	1.12	0.20	0.34	0.44	9.61	6.09	3.56	M10

# Models 2002-UBR, 2007-UBR, 2010-UBR

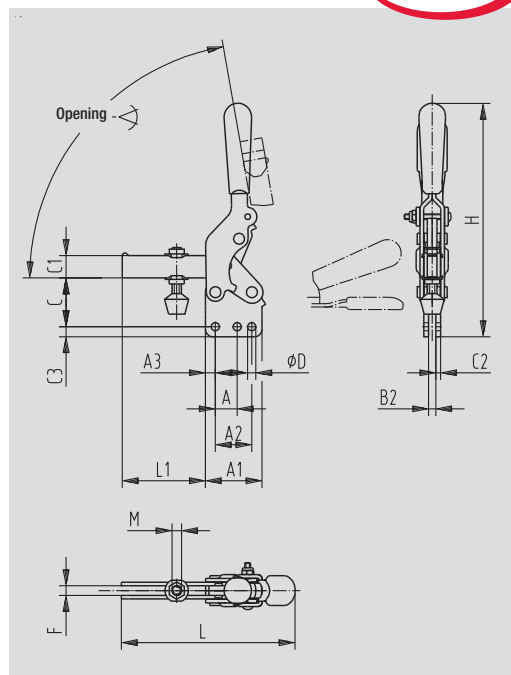
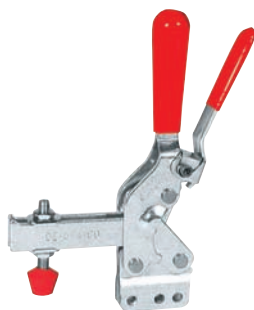


Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment	🔩 Flanged Washers
2002-UBR	600	75°	85°	0.48	215208-M	215105
2002-UBR-LS					without spindle	215105
2007-UBR	1,000	80°	76°	1.20	2007208-M	507107
2007-UBR-LS					without spindle	507107
2010-UBR	1,400	80°	83°	2.56	240208-M	235106
2037-UBR-LS					without spindle	235106

See additional adjustment spindles beginning on page 9.1.

- DE-STA-CO® Toggle Lock Plus
- U-bar
- Straight base

Patent No.  
6,595,507

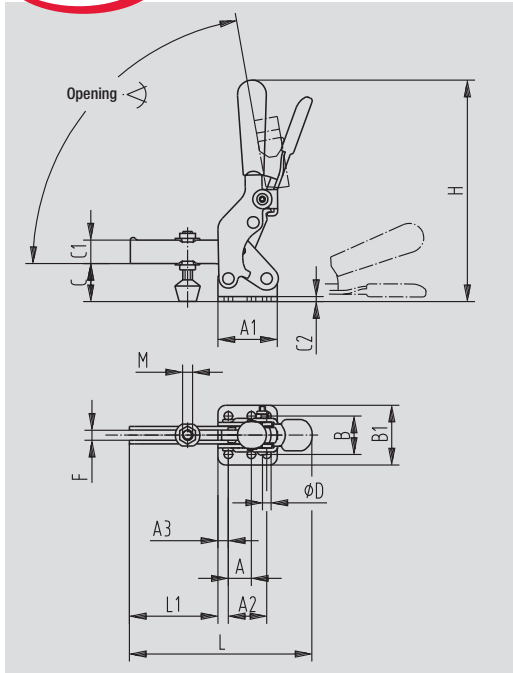


Model no.	A	A1	A2	A3	B2	C	C1	C2	øD	F	H	L	L1	M
2002-UBR	0.50	1.36	0.90	0.24	0.24	1.27	0.49	0.12	0.22	0.25	5.07	4.17	1.93	M6
2007-UBR	0.75	1.93	1.25	0.33	0.24	1.68	1.24	0.16	0.28	0.34	7.64	5.94	2.88	M8
2010-UBR	–	2.53	1.25	0.63	0.31	2.20	1.12	0.20	0.34	0.44	9.61	7.28	3.56	M10

**NEW**

# Models 2002-UR, 2007-UR, 2010-UR

Vertical Clamps



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment	🔩 Flanged Washers
2002-UR	600	75°	85°	0.48	215208-M	215105
2002-UR-LS					without spindle	215105
2007-UR	1,000	80°	76°	1.20	2007208-M	507107
2007-UR-LS					without spindle	507107
2010-UR	1,400	80°	83°	2.56	240208-M	235106
2037-UR-LS					without spindle	235106

See additional adjustment spindles beginning on page 9.1 forward

- DE-STA-CO® Toggle Lock Plus
- U-bar
- Flanged base

Patent No.  
6,595,507



Model no.	A	A1	A2	A3	B	B1	C	C1	C2	øD	F	H	L	L1	M
2002-UR	0.50	1.36	0.90	0.24	1.06	1.52	0.95	0.49	0.12	0.22	0.25	4.73	4.17	1.93	M6
2007-UR	0.75	1.93	1.25	0.33	1.25	1.94	1.25	1.24	0.16	0.28	0.34	7.21	5.94	2.88	M8
2010-UR	-	2.53	1.25	0.63	1.78	2.62	1.70	1.12	0.20	0.34	0.44	9.00	7.28	3.56	M10

## Standard vertical clamps – flanged or straight base, solid bar

- Solid clamp bar
- Base flanged or straight

### Application areas

Ideal for all sectors in which work is performed with holding capacities of up to 1,200 lbs. The heavy-duty clamping bar is highly suitable for adaptation to fixtures where it can be individually cut in lengths at a specific angle.

Applications include assembling, drilling, testing, gluing and other processing operations. Suitable for use in welding fixtures and gauge manufacturing, as well as in all sectors of the woodworking industry.

### Product features

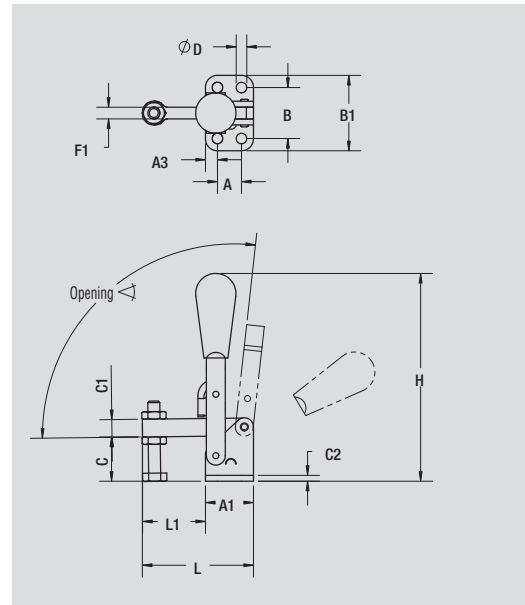
- Torsion-protected, hardened bushings
- Rivets made of stainless steel
- Zinc plated
- Oil-resistant, ergonomically shaped DE-STA-CO handle grip
- Patented intermediate safety link

### Accessories

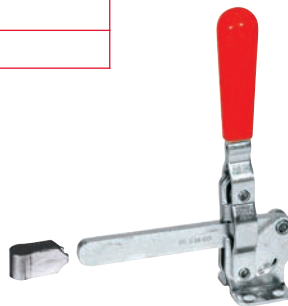
- Vertical clamps with solid bars are delivered with bolt retainers that can be welded to the clamping bar.

## Models 202, 207-L, 207-S, 210-S, 247-S, 267-S

Model no.	Holding Capacity [lbs.]	Bar Opening +10°	Handle Moves	[lbs.]	Standard equipment	Bolt Retainer
202	200	104°	64°	0.33	202208-M	–
207-L	500	115°	62°	0.74	without spindle	207105
207-S	500	115°	62°	0.69	without spindle	207105
210-S	750	106°	58°	1.29	without spindle	210114
247-S	1,000	136°	75°	2.39	without spindle	247110
267-S	1,200	140°	70°	4.36	without spindle	110122

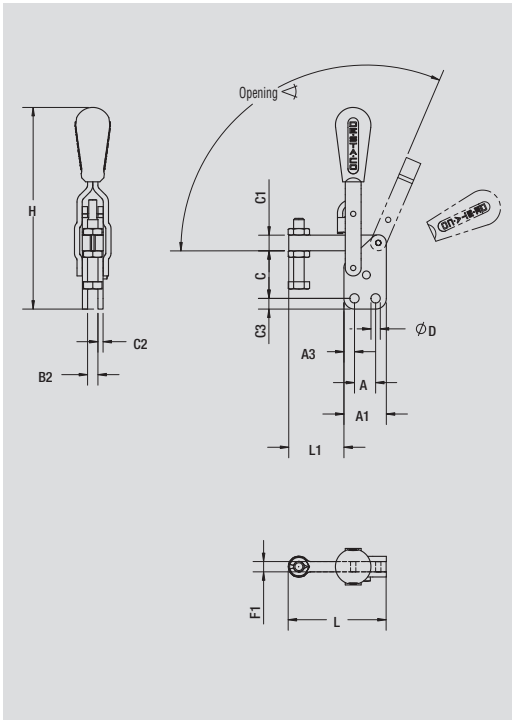


ALSO AVAILABLE		
As Air Hydraulic	Model 807-S Model 810-S Model 847-S	Page 11.8 Page 11.8 Page 11.8
As DE-STA-CO® Toggle Lock Plus	Model 207-LR Model 210-SR	Page 2.22 Page 2.22
See accessories beginning on page 9.1.		
See section 16 for holding capacity charts.		



Model no.	A	A1	A3	A6	B	B1	C	C1	C2	øD	øD1	F1	H	L	L1	Spindle Size
202	0.50	1.00	0.25	–	1.06	1.56	0.94	0.37	0.12	0.22	0.39	0.24	4.21	2.31	1.31	M6 or 1/4
207-L	0.75	1.38	0.31	0.15	1.25	1.75	1.25	0.63	0.12	0.28	0.32	0.24	6.89	5.02	3.45	M8 or 5/16
207-S	0.75	1.38	0.31	0.15	1.25	1.75	1.25	0.63	0.12	0.28	0.32	0.24	6.89	3.75	2.19	M8 or 5/16
210-S	1.25	1.91	0.31	0.42	1.78	2.53	1.67	0.79	0.12	0.33	0.53	0.31	8.15	5.53	3.63	M12 or 1/2
247-S	1.25	2.00	0.37	0.47	1.78	2.53	2.00	0.87	0.19	0.34	0.57	0.38	8.69	6.87	4.87	M12 or 1/2
267-S	2.00	3.00	0.49	–	2.75	3.75	3.08	1.26	0.19	0.48	0.65	0.37	11.88	8.88	5.88	M14 or 5/8

# Models 202-B, 207-LB, 207-SB, 210-SB, 247-SB



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ▲ +10°	Handle Moves	▲ [lbs.]	▲ Standard equipment	▲ Bolt Retainer
202-B	200	104°	64°	0.33	202208-M	-
207-LB	500	115°	62°	0.74	without spindle	207105
207-SB	500	115°	62°	0.69	without spindle	207105
210-SB	750	106°	58°	1.29	without spindle	210114
247-SB ▲	1,000	136°	75°	2.39	without spindle	247110

ALSO AVAILABLE		
As Stainless Steel	Model 202-BSS	Page 8.4
As DE-STA-CO® Toggle Lock Plus	Model 207-LBR Model 210-SBR	Page 2.23 Page 2.23
See accessories beginning on page 9.1.		
See section 16 for holding capacity charts.		



Model no.	A	A1	A3	A6	B2	C	C1	C2	C3	øD	øD1	F1	H	L	L1	Spindle Size
202-B	0.50	1.00	0.25	-	0.25	1.13	0.37	0.12	0.24	0.22	0.39	0.24	4.40	2.31	1.31	M6 or 1/4
207-LB	0.75	1.38	0.31	0.15	0.25	1.55	0.63	0.12	0.25	0.28	0.32	0.24	7.48	5.02	3.45	M8 or 5/16
207-SB	0.75	1.38	0.31	0.15	0.25	1.55	0.63	0.12	0.25	0.28	0.32	0.24	7.48	3.75	2.19	M8 or 5/16
210-SB	1.25	1.91	0.31	0.47	0.31	2.19	0.79	0.12	0.39	0.33	0.53	0.31	8.16	5.53	3.63	M12 or 1/2
247-SB ▲	1.25	2.00	0.37	-	0.38	2.25	0.87	0.19	0.37	0.34	0.57	0.38	8.94	6.87	4.87	M12 or 1/2

▲ Available upon request, as are a number of other modifications

## Vertical clamps with DE-STA-CO® Toggle Lock Plus

- Solid clamp bar
- Base flanged or straight

### Application areas

The additional release lever holds the clamp in the opened and closed position. Unintentional opening and closing of the clamp is therefore impossible.

This clamp is preferred for more difficult clamping conditions, e.g. vibrating conditions, transporting of sensitive parts and where the clamp arm is set at an angle to the base.

### Product features

- Additional locking device for secure clamping
- Torsion-protected, hardened bushings
- Rivets made of stainless steel

- Zinc plated
- Oil-resistant, ergonomically shaped DE-STA-CO handle grip
- Patented intermediate safety link

### Accessories

Vertical clamps with solid clamp bars are only delivered with bolt retainers that can be welded to the clamping bar.

### Safety instructions

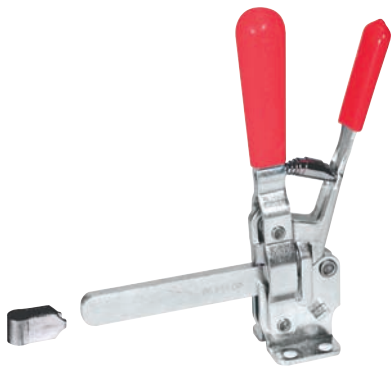
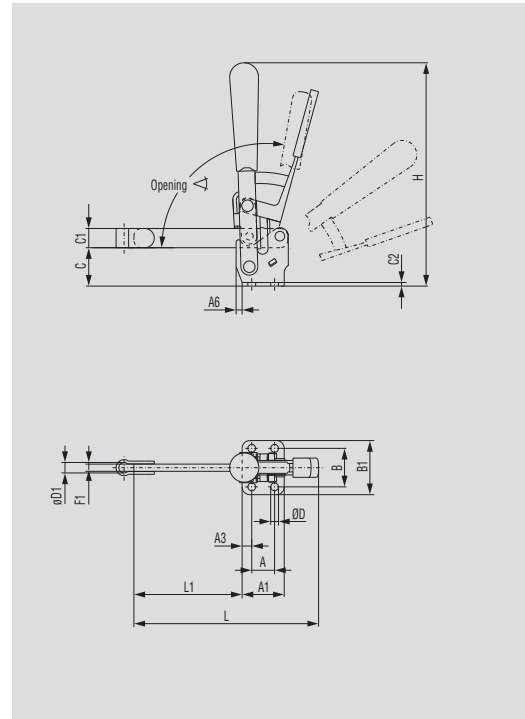
To guarantee secure locking, the clamp must be adjusted to lock in the over-center position.

## Models 207-LR, 210-SR

Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment	🔗 Bolt Retainer
207-LR	500	100°	62°	1.00	without spindle	207105
210-SR	750	103°	58°	1.60	without spindle	210114

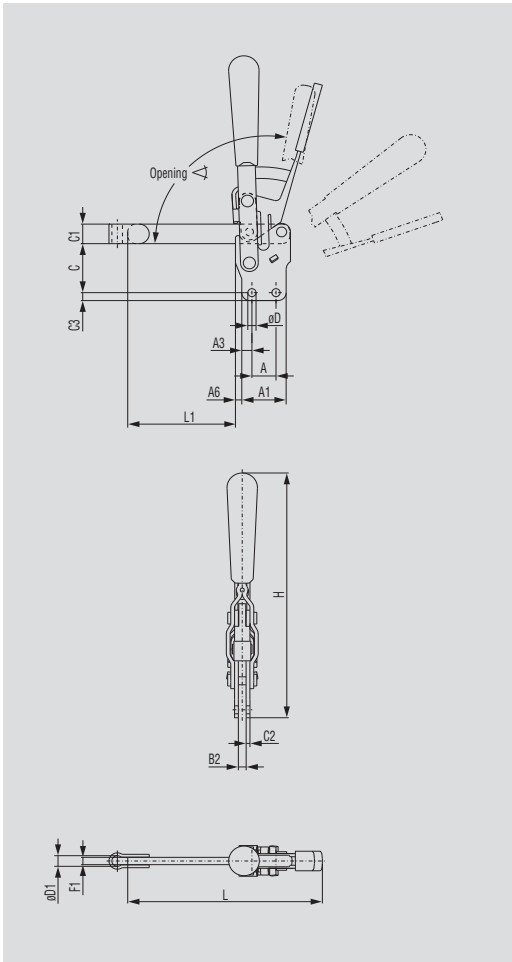
See additional adjustment spindles beginning on page 9.1.

See section 16 for holding capacity charts.



Model no.	A	A1	A3	A6	B	B1	C	C1	C2	øD	øD1	F1	H	L	L1	Spindle Size
207-LR	0.75	1.38	0.31	0.15	1.25	1.70	1.25	0.63	0.12	0.28	0.32	0.24	6.90	4.58	3.45	M8 or 5/16
210-SR	1.25	1.89	0.31	0.42	1.75	2.50	1.68	0.79	0.12	0.33	0.53	0.31	8.15	6.61	3.56	M12 or 1/2

# Models 207-LBR, 210-SBR



Model no.	Holding Capacity [lbs.]	Bar Opening $\angle +10^\circ$	Handle Moves	[lbs.]	Standard equipment	Bolt Retainer
207-LBR ▲	500	100°	62°	1.00	without spindle	207105
210-SBR ▲	750	103°	58°	1.60	without spindle	210114

See additional adjustment spindles beginning on page 9.1

See section 16 for holding capacity charts.



Model no.	A	A1	A3	A6	B2	C	C1	C2	C3	øD	øD1	F1	H	L	L1	Spindle Size
207-LBR ▲	0.75	1.38	0.31	0.15	0.24	1.56	0.63	0.12	0.25	0.28	0.32	0.24	7.44	4.58	3.45	M8 or 5/16
210-SBR ▲	1.25	1.89	0.31	0.42	0.31	2.20	0.79	0.12	0.39	0.33	0.53	0.31	9.04	6.61	3.56	M12 or 1/2

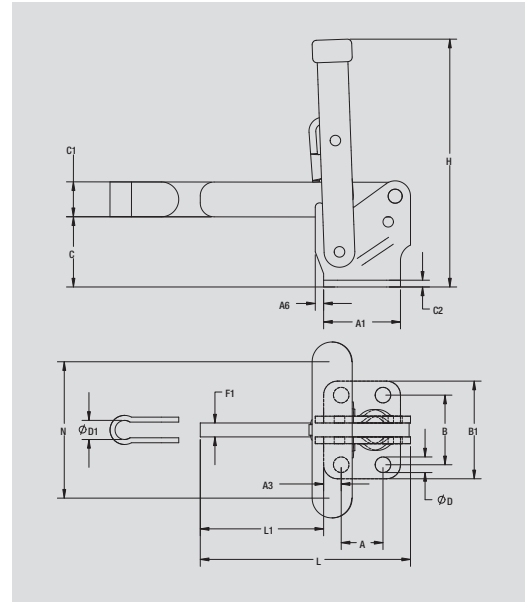
▲ Available upon request, as are a number of other modifications

## Models 202-T, 207-TS, 210-TS

Model no.	Holding Capacity ↑ [lbs.]	Bar Opening ↗ +10°	Handle Moves	[lbs.]	Standard equipment	Bolt Retainer
202-T	200	104°	64°	0.36	202208-M	-
207-TS	500	115°	62°	0.74	without spindle	207105
210-TS ▲	750	106°	58°	1.36	without spindle	235106

See additional adjustment spindles beginning on page 9.1

- Solid clamping bar
- T-handle has shorter profile and can be operated from right or left hand side
- Flanged base



Model no.	A	A1	A3	A6	B	B1	C	C1	C2	øD	F	H	L	L1	L2	L3	N	Spindle Size
202-T	0.50	1.00	0.26	-	1.06	1.56	0.94	0.38	0.12	0.22	0.25	2.81	2.73	1.73	0.51	0.98	3.56	M6 or 1/4
207-TS	0.75	1.38	0.31	0.15	1.25	1.75	1.25	0.63	0.11	0.28	0.33	4.36	3.75	2.15	0.50	1.30	3.00	M8 or 5/16
210-TS ▲	1.25	1.91	0.31	0.42	1.78	2.53	1.67	0.79	0.11	0.33	0.40	5.38	5.53	3.63	0.94	2.40	6.02	M12 or 1/2

▲ Available upon request

## Model 202-TB

Model no.	Holding Capacity ↑ [lbs.]	Bar Opening ↗ +10°	Handle Moves	[lbs.]	Standard equipment	Bolt Retainer
202-TB ▲	200	104°	64°	0.36	202208-M	215105

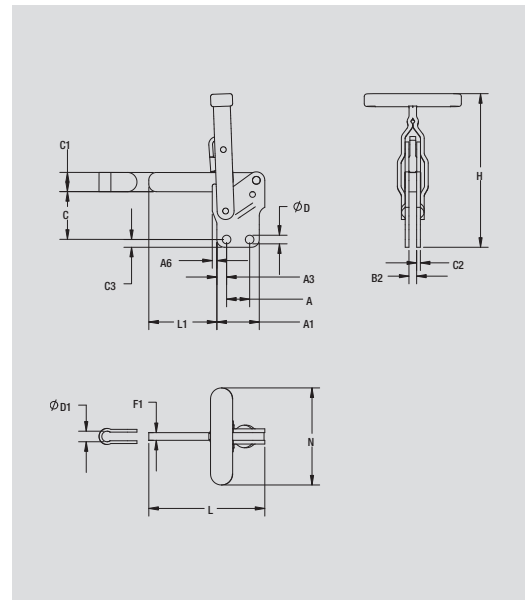
See additional adjustment spindles beginning on page 9.1

See section 16 for holding capacity charts.

- Solid clamping bar
- T-handle
- Straight base



Model 202-TB

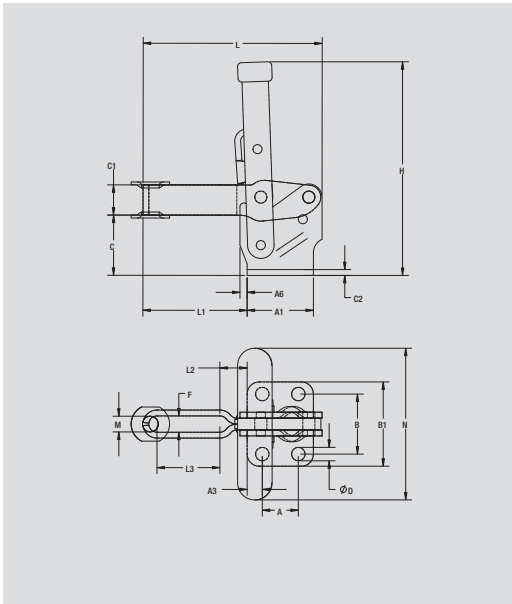


Model no.	A	A1	A3	A6	B2	C	C1	C2	C3	øD	F	H	L	L1	L2	L3	Spindle Size	N
202-TB ▲	0.50	1.00	0.26	-	0.25	1.13	0.38	0.12	0.12	0.22	0.25	3.00	2.73	1.73	0.51	0.98	M6 or 1/4	3.56

▲ Available upon request



# Models 201-TU, 202-TU, 207-TU, 207-TUL, 210-TU



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment	🔩 Flanged Washers
201-TU	100	110°	60°	0.17	305208-M	102111
202-TU	200	104°	64°	0.38	202208-M	215105
207-TU	375	115°	62°	0.72	without spindle	507107
207-TUL	375	115°	62°	0.72	without spindle	501107
210-TU	600	106°	58°	1.36	without spindle	235106

See additional adjustment spindles beginning on page 9.1

See section 16 for holding capacity charts.

- U-bar
- T-handle
- Flanged base



Model no.	A	A1	A3	A6	B	B1	C	C1	C2	øD	F	H	L	L1	L2	L3	M	N
201-TU	0.63	1.00	0.19	—	0.94	1.31	0.63	0.31	0.08	0.17	0.21	2.25	2.02	1.02	0.13	0.73	M5 or 10-32	1.92
202-TU	0.50	1.00	0.26	—	1.06	1.56	0.94	0.38	0.12	0.22	0.25	2.81	2.73	1.73	0.51	0.98	M6 or 1/4	3.56
207-TU	0.75	1.38	0.31	0.15	1.25	1.75	1.25	0.63	0.11	0.28	0.33	4.36	3.75	2.15	0.50	1.30	M8 or 5/16	3.00
207-TUL	0.75	1.38	0.31	0.15	1.25	1.75	1.25	0.63	0.11	0.28	0.33	4.36	5.41	3.85	0.50	2.75	M8 or 5/16	3.00
210-TU	1.25	1.91	0.31	0.42	1.78	2.53	1.67	0.79	0.11	0.33	0.40	5.38	5.53	3.63	0.94	2.40	M10 or 3/8	6.02

## Standard vertical clamps

- U-shaped clamping bar
- Flanged base

### Application areas

Ideal for all areas in which work is performed with holding capacities of up to 1,200 lbs. For example, assembling, drilling, testing, gluing and other processing operations. Suitable for use in welding fixtures and in checking fixtures, as well as in all sectors of the woodworking industry.

### Product features

- Torsion-protected, hardened bushings in models with a holding capacity greater than 375 lbs.
- Rivets made of stainless steel
- Zinc plated
- Oil-resistant, ergonomically shaped DE-STA-CO handle grip
- Patented intermediate safety link

### Accessories

Vertical clamps with a U-shaped clamping bar can be ordered in two varieties:

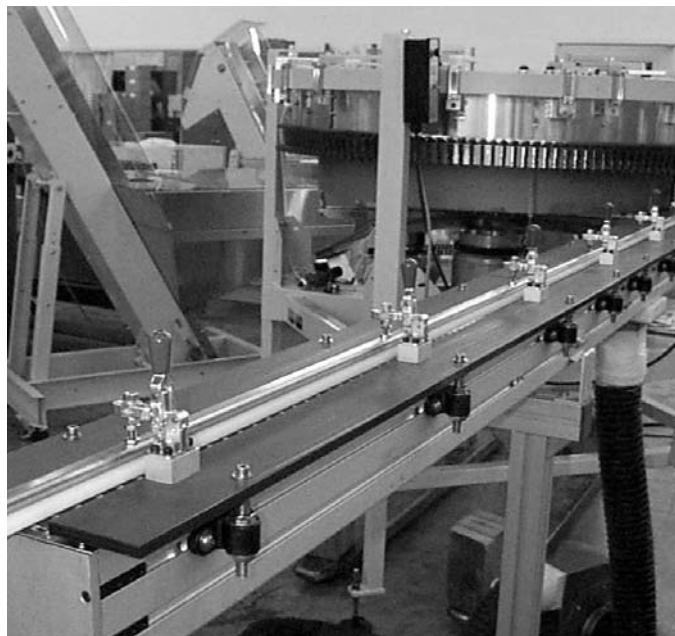
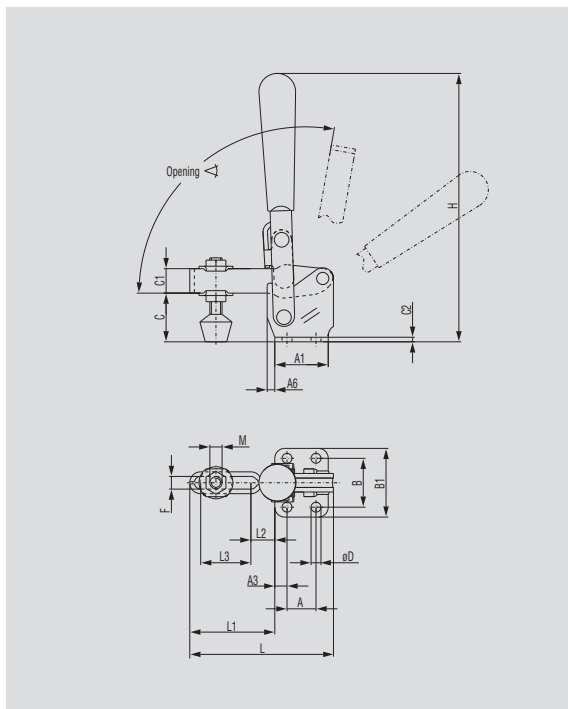
- Standard model number: The matching standard adjustment spindle is included.
- Model number contains the addition “-LS”: The model is delivered with two flange washers without an adjustment spindle.

## Models 201-U, 202-U, 202-UL, 207-U, 207-UL, 207-UO, 210-U, 247-U, 267-U

Model no.	Holding Capacity [lbs.]	Bar Opening +10°	Handle Moves	[lbs.]	Standard equipment	Flanged Washers
201-U	100	110°	60°	0.15	305208-M	102111
201-U-LS					without spindle	102111
202-U	200	104°	64°	0.35	202208-M	215105
202-U-LS					without spindle	215105
202-UL	200	104°	64°	0.36	202208-M	215105
207-U	375	100°	62°	0.67	225208-M	507107
207-U-LS					without spindle	507107
207-UL	375	100°	62°	0.67	225208-M	507107
207-UO	375	100°	62°	0.67	without spindle	507107
210-U	600	106°	58°	1.29	240208-M	235106
210-U-LS					without spindle	235106
247-U	1,000	136°	75°	2.36	247208-M	247109
247-U-LS					without spindle	247109
267-U	1,200	140°	70°	4.80	267203-M	267102
267-U-LS					without spindle	267102

ALSO AVAILABLE		
As Air Hydraulic	Model 807-U Model 810-U Model 812-U Model 847-U	Page 11.7 Page 11.7 Page 11.7 Page 11.7
As Stainless Steel	Model 201-USS Model 202-USS Model 207-USS Model 210-USS	Page 8.3 Page 8.3 Page 8.3 Page 8.3
As DE-STA-CO® Toggle Lock Plus	Model 207-UR Model 210-UR	Page 2.30 Page 2.30
See accessories beginning on page 9.1.		
See section 16 for holding capacity charts.		





Several Model 201-U clamps, with hex-head spindles, are used to secure a guide in a bottle capping application.

Model no.	A	A1	A3	A6	B	B1	C	C1	C2	øD	F	H	L	L1	L2	L3	M
201-U	0.63	1.00	0.19	—	0.94	1.31	0.63	0.31	0.08	0.17	0.21	3.03	2.02	1.02	0.13	0.73	M5 or 10-32
202-U	0.50	1.00	0.26	—	1.06	1.56	0.94	0.38	0.12	0.22	0.25	4.21	2.73	1.73	0.51	0.98	M6 or 1/4
202-UL	0.50	1.00	0.26	—	1.06	1.56	0.94	0.38	0.12	0.22	0.25	4.21	3.27	2.27	0.51	1.54	M6 or 1/4
207-U	0.75	1.38	0.31	0.15	1.25	1.75	1.25	0.63	0.11	0.28	0.33	6.89	3.68	2.15	0.50	1.30	M8 or 5/16
207-UL	0.75	1.38	0.31	0.15	1.25	1.75	1.25	0.63	0.11	0.28	0.33	6.89	5.41	3.85	0.50	2.75	M8 or 5/16
207-UO	0.75	1.38	0.31	0.15	1.25	1.75	1.25	0.63	0.11	0.28	0.33	5.63	3.75	2.15	0.50	1.30	M8 or 5/16
210-U	1.25	1.91	0.31	0.42	1.78	2.53	1.67	0.79	0.11	0.33	0.40	8.15	5.54	3.63	0.94	2.40	M10 or 3/8
247-U	1.25	2.00	0.37	0.47	1.78	2.53	2.00	0.83	0.19	0.34	0.53	8.69	6.87	4.87	1.36	3.06	M12 or 1/2
267-U	2.00	3.00	0.49	—	2.75	3.75	3.08	1.26	0.19	0.48	0.65	11.88	8.92	5.92	1.44	4.00	M16 or 5/8

## Standard vertical clamps

- U-shaped clamping bar
- Straight base

### Application areas

Ideal for all sectors in which work is performed with holding capacities of up to 1,200 lbs., including assembling, drilling, testing, gluing and other processing operations. Suitable for use in welding fixtures and in checking fixtures, as well as in all sectors of the woodworking industry.

### Product features

- Torsion-protected, hardened bushings in models with a holding force greater than 375 lbs.
- Rivets made of stainless steel
- Zinc plated
- Oil-resistant, ergonomically shaped DE-STA-CO handle grip
- Patented intermediate safety link

### Accessories

Vertical clamps with a U-shaped clamping bar can be ordered in two varieties:

- Standard model number: The matching standard adjustment spindle is included.
- Model number contains the addition “-LS”: The model is delivered with two flange washers without an adjustment spindle.

## Models 201-UB, 202-UB, 207-UB, 207-ULB, 210-UB, 247-UB

Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	▲ [lbs.]	Standard equipment	Flanged Washers
201-UB	100	110°	60°	0.15	305208-M	102111
201-UB-LS					without spindle	102111
202-UB	200	104°	64°	0.35	202208-M	215105
202-UB-LS					without spindle	215105
207-UB	375	100°	62°	0.67	225208-M	507107
207-UB-LS					without spindle	507107
207-ULB	375	100°	62°	0.67	240208-M	507107
210-UB	600	106°	58°	1.29	247208-M	235106
210-UB-LS					without spindle	235106
247-UB ▲	1,000	136°	75°	2.36	247208-M	247109
247-UB-LS					without spindle	247109

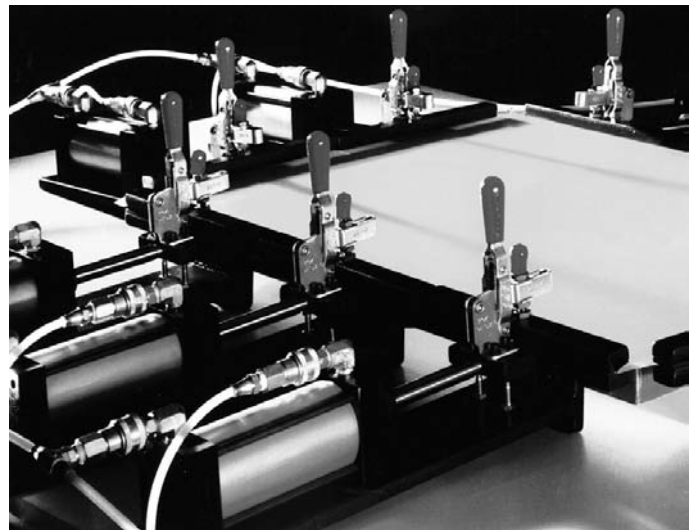
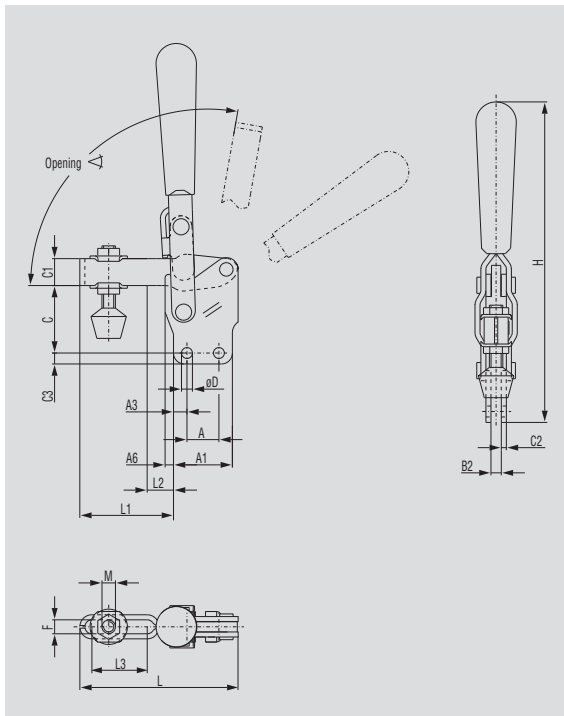
### ALSO AVAILABLE

As Stainless Steel	Model 202-UBSS	Page 8.5
As DE-STA-CO® Toggle Lock Plus	Model 207-UBR Model 210-UBR	Page 2.31 Page 2.31

See accessories beginning on page 9.1.

See section 16 for holding capacity charts.





Model 207-UO hold-down clamps used in fixturing material in a silk screening application.

Model no.	A	A1	A3	A6	B2	C	C1	C2	C3	øD	F	H	L	L1	L2	L3	M
201-UB	0.63	1.00	0.19	—	0.16	0.88	0.31	0.08	0.08	0.17	0.21	3.13	2.02	1.02	0.13	0.73	M5
202-UB	0.50	1.00	0.26	—	0.24	1.13	0.38	0.12	0.12	0.22	0.25	4.40	2.73	1.73	0.51	0.98	M6
207-UB	0.75	1.38	0.31	0.15	0.25	1.55	0.63	0.11	0.11	0.28	0.33	7.48	3.68	2.15	0.50	1.30	M8
207-ULB	0.75	1.38	0.31	0.15	0.25	1.55	0.63	0.11	0.11	0.28	0.33	7.48	5.41	3.85	0.50	2.75	M8
210-UB	1.25	1.91	0.31	0.42	0.31	2.19	0.79	0.11	0.11	0.33	0.40	8.16	5.54	3.63	0.94	2.40	M10
247-UB ▲	1.25	2.00	0.37	0.47	0.38	2.25	0.83	0.19	0.19	0.34	0.53	8.94	6.87	4.87	1.36	3.06	M12

▲ Available upon request

## Vertical clamps with DE-STA-CO® Toggle Lock Plus

- U-shaped clamping bar
- Flanged or straight base

### Application areas

The additional release lever holds the clamp in the opened and closed position. Unintentional opening and closing of the clamp is therefore impossible.

This clamp is preferred for more difficult clamping conditions, e.g. vibrating conditions, transporting of sensitive parts and where the clamp bar is set at an angle to the base.

### Product features

- Additional locking device for secure clamping
- Torsion-protected, hardened bushings
- Rivets made of stainless steel
- Zinc plated

- Oil-resistant, ergonomically shaped DE-STA-CO handle grip
- Patented intermediate safety link

### Accessories

Vertical clamps with a U-shaped clamping bar can be ordered in two varieties:

- Standard model number: The matching standard adjustment spindle is included.
- Model number contains the addition “-LS”: The model is delivered with two flange washers without an adjustment spindle.

### Safety instructions

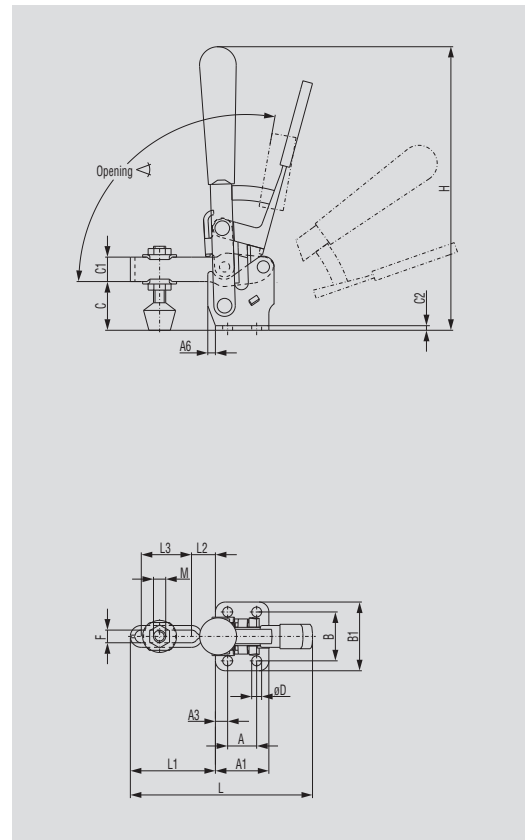
To guarantee secure locking, the clamp must be adjusted to lock in the over-center position.

## Models 207-UR, 210-UR

Model no.	Holding Capacity [lbs.]	Bar Opening $\angle +10^\circ$	Handle Moves	[lbs.]	Standard equipment	Flanged Washers
207-UR	375	100°	62°	1.00	225208-M	507107
207-UR-LS					without spindle	507107
210-UR	600	100°	58°	1.60	240208-M	235106
210-UR-LS					without spindle	235106

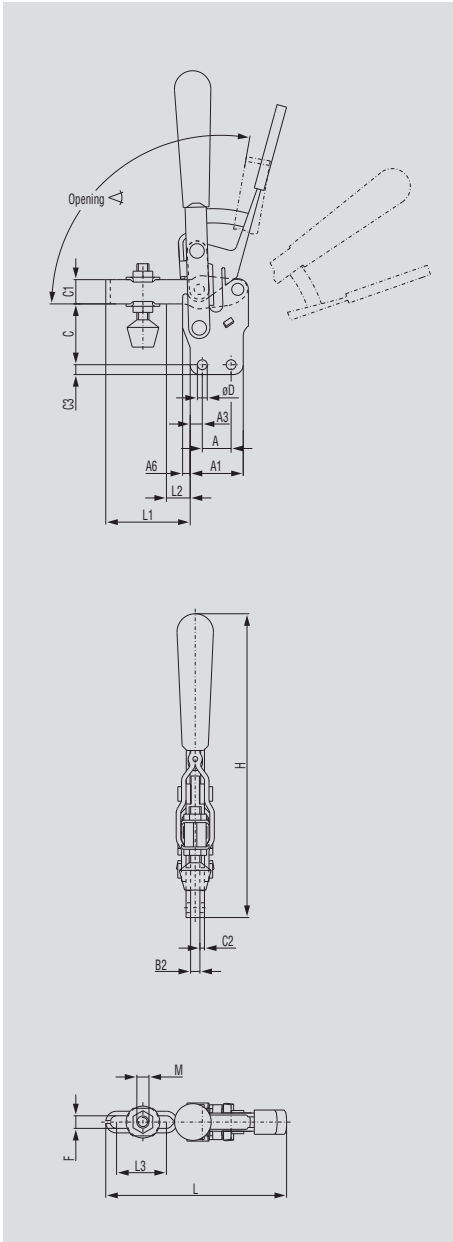
See additional adjustment spindles beginning on page 9.1

See section 16 for holding capacity charts.



Model no.	A	A1	A3	A6	B	B1	C	C1	C2	øD	F	H	L	L1	L2	L3	M
207-UR	0.75	1.38	0.31	0.15	1.25	1.70	1.25	0.63	0.12	0.28	0.33	6.90	4.58	2.09	0.50	1.30	M8 or 5/16
210-UR	1.25	1.89	0.31	0.42	1.75	2.50	1.68	0.79	0.12	0.33	0.25	8.15	6.72	3.66	0.94	2.41	M10 or 3/8

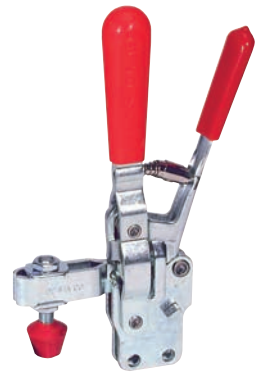
# Models 207-UBR, 210-UBR



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment	🔩 Flanged Washers
207-UBR ▲	375	100°	62°	1.00	225208-M	507107
207-UBR-LS					without spindle	507107
210-UBR ▲	600	103°	58°	1.60	240208-M	235106
210-UBR-LS					without spindle	235106

See additional adjustment spindles beginning on page 9.1

See section 16 for holding capacity charts.



Model no.	A	A1	A3	A6	B2	C	C1	C2	C3	øD	F	H	L	L1	L2	L3	M
207-UBR ▲	0.75	1.38	0.31	0.15	0.24	1.56	0.63	0.12	0.25	0.28	0.33	7.44	4.58	2.09	0.50	1.30	M8 or 5/16
210-UBR ▲	1.25	1.89	0.31	0.42	0.31	2.20	0.79	0.12	0.39	0.33	0.25	9.04	6.72	3.66	0.94	2.41	M10 or 3/8

▲ Available upon request

# Models 219, 229




## Applications areas

Featuring a unique cam action, these clamps will hold workpieces of inconsistent height. Ideal for castings or forgings, these models – once set for the nominal or average piece height – allow for a deviation larger or smaller than average.

Model 219 has an overall clamping range of 13/64", while Model 229 has an overall clamping range of 5/16" and accommodates any 1/2", M10, or M12 spindle,

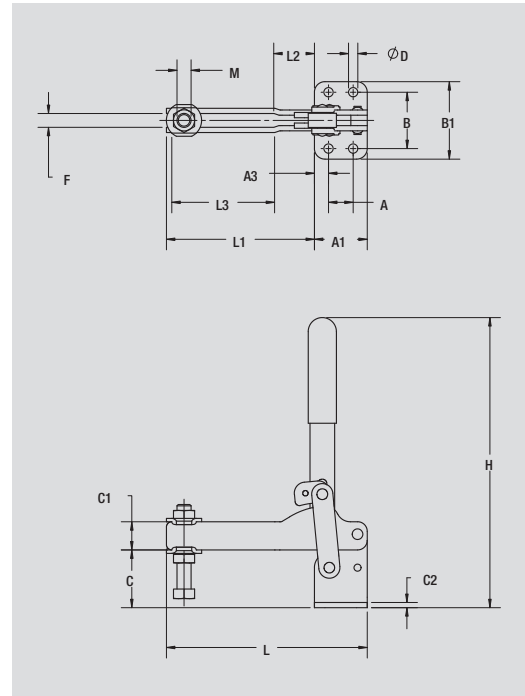
## Product features

- Torsion-protected, hardened bushings in models with a holding force greater than 375 lbs.
- Rivets made of stainless steel
- Zinc plated
- Oil-resistant, ergonomically shaped DE-STA-CO handle grip

Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	 [lbs.]	 Standard equipment	 Flanged Washers
219 ▲	350	115°	180°	1.75	210203	235106
229	1,000	115°	180°	2.59	229203	247109

See additional adjustment spindles beginning page 9.1

See section 16 for holding capacity charts.



Model no.	A	A1	A3	B	B1	C	C1	C2	øD	F	H	L	L1	L2	L3	M
219 ▲	0.75	1.50	0.38	1.50	2.26	1.56	0.75	0.12	0.28	0.46	7.50	5.75	4.25	1.25	3.00	M8 or 5/16
229	0.88	1.88	0.50	2.00	2.75	2.05	1.00	0.19	0.33	0.49	9.94	7.14	5.26	1.45	3.81	M12 or 1/2

▲ Available upon request



## Heavy-duty vertical clamps

- Solid clamping bar
- Flanged base
- Straight base

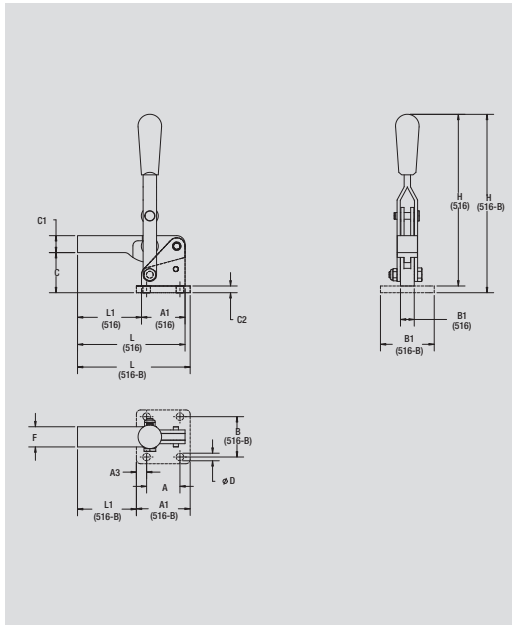
### Applications areas

This series of models is extremely robust. Heavy-duty clamping tasks are easily fulfilled and rough handling is not a problem for this series. The heavy-duty vertical clamps are therefore especially suitable for welding and milling applications, for locking foam molds and similar sever clamping applications. The heavy-duty clamping bar can be shortened, welded to or have holes drilled to suit the application.

### Product features

- Hardened, polished bushings
- Parts drop forged
- Oil-resistant, ergonomically shaped DE-STA-CO handle grip

## Models 516, 516-B



Model no.	Holding Capacity ↑ [lbs.]	Bar Opening ∠ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment
516	750	122°	66°	1.25	none
516-B	750	122°	66°	1.69	none

### ALSO AVAILABLE

As Air Hydraulic      Model 846      Page 11.1

See section 16 for holding capacity charts.



Model no.	A	A1	A3	B	B1	C	C1	C2	φD	F	H	L	L1				
516	—	1.62	—	—	0.51	1.24	0.63	—	—	0.75	6.38	4.00	2.38				
516-B	1.24	2.00	0.38	1.50	2.00	1.49	0.63	0.25	0.28	0.75	6.38	4.19	2.19				

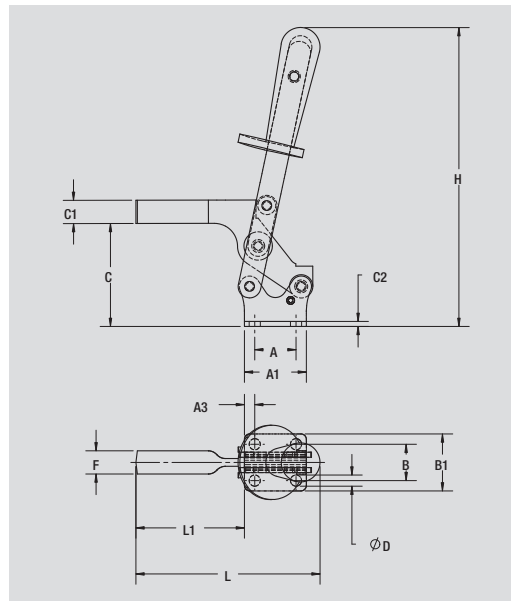
# Model 518

## Applications areas

This model features a forged hold-down bar and improved ergonomic grip with handle stop built in. The forged hold-down bar can be cut or welded to suit the user's fixture. One of the major features of this clamp is the greater clearance under the bar. Due to the bar design, there is twice the normal clearance in this size clamp.

Model no.	Holding Capacity ↑ [lbs.]	Bar Opening ↔ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment
518	500	90°	75°	0.82	none

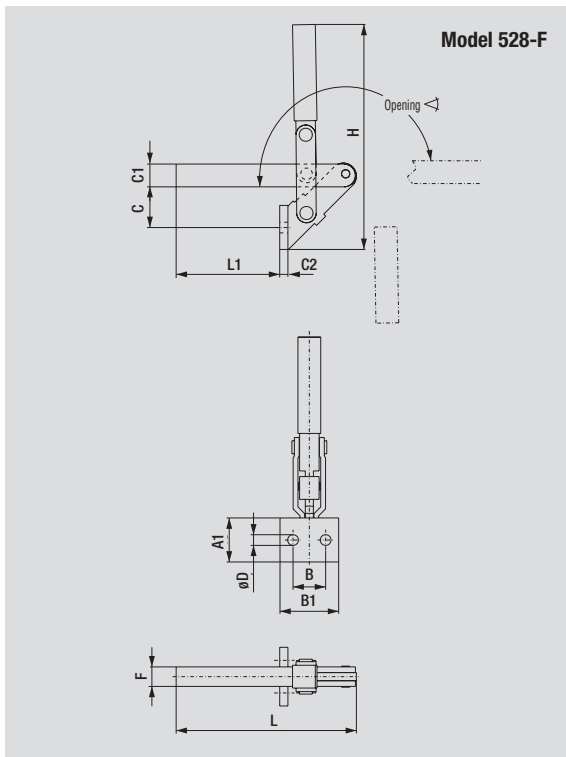
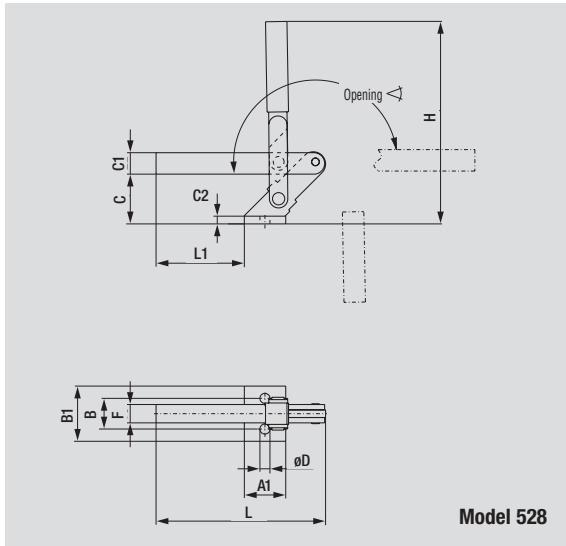
See section 16 for holding capacity charts.



Model no.	A	A1	A3	B	B1	C	C1	C2	øD	F	H	L	L1				
518	1.00	1.50	0.25	0.88	1.38	2.49	0.56	0.12	0.27	0.56	7.24	4.46	2.63				

## Applications areas

For tough, heavy-duty workholding. Clamps have square cold-drawn steel hold-down bars. Pivot points have serrated, hardened bushings. Models 527 and 528 are supplied with flanged base. Also available with front mounting base as Model 527-F. Models 528 and 528-F are vertical handle variations of Models 527 and 527-F. All models provided with red handle grip. Hold-down bars can be machined to meet the application requirements.





Model no.	Holding Capacity [lbs.]	Bar Opening $\angle +10^\circ$	Handle Moves	[lbs.]	Standard equipment
528	1,000	195°	65°	2.50	None
528-F	1,000	195°	65°	2.50	None

See section 16 for holding capacity charts.

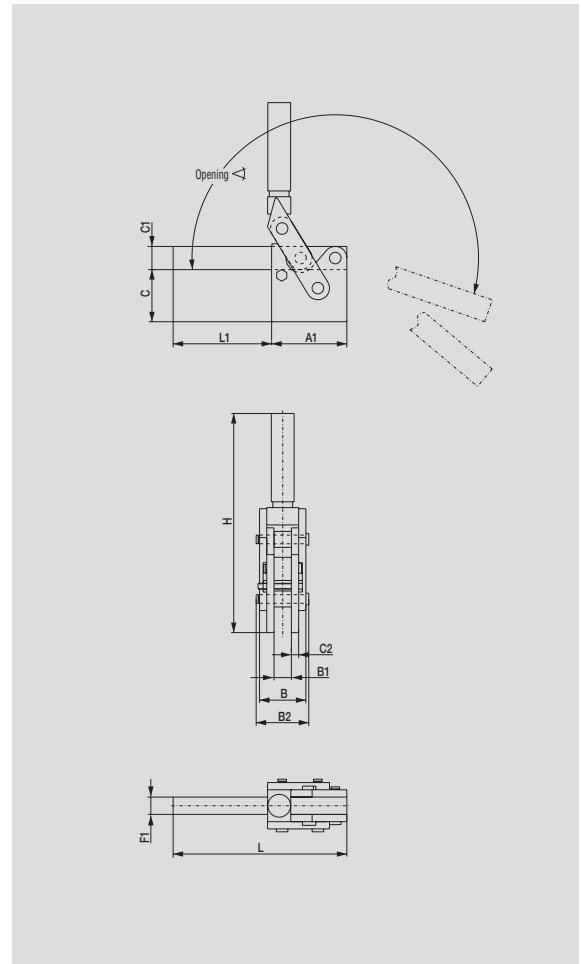


Model no.	A1	B	B1	C	C1	C2	øD	F	H	L	L1							
528	1.50	1.25	2.25	2.09	0.88	0.21	0.41	0.75	8.13	6.88	3.63							
528-F	1.50	1.25	2.25	1.84	0.88	0.21	0.41	0.75	7.38	6.88	4.00							

## Models 548, 578, 588

Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	 [lbs.]	 Standard equipment
548	2,500	199°	129°	5.30	None
578	4,000	199°	129°	9.12	None
588	6,000	199°	129°	14.75	None

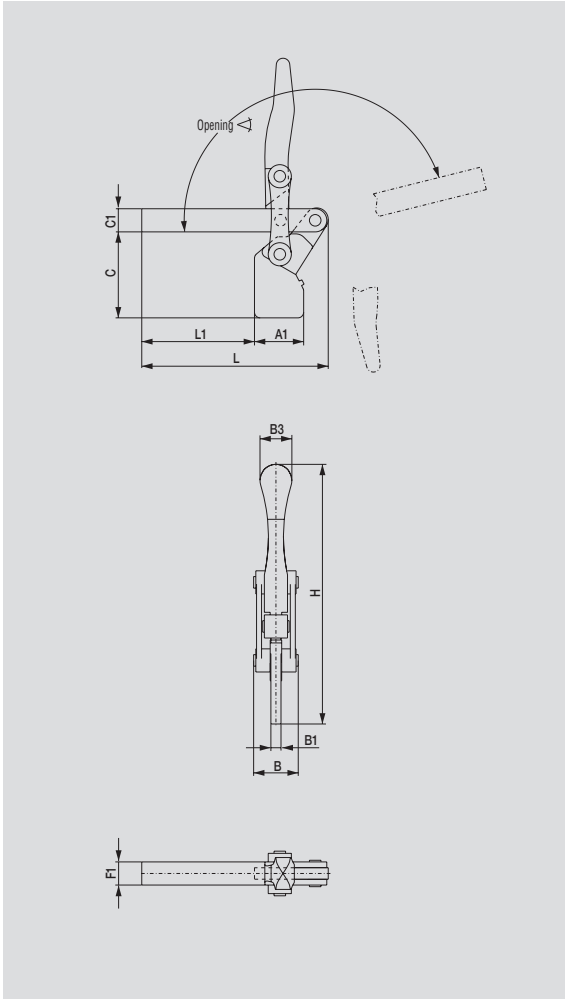
See section 16 for holding capacity charts.



Model no.	A1	B	B1	B2	C	C1	C2	F1	H	L	L1						
548	3.25	2.01	0.75	2.00	2.25	1.00	0.31	0.75	9.20	7.50	4.25						
578	4.00	1.38	0.88	2.38	2.75	1.25	0.63	0.88	10.92	8.63	4.63						
588	5.00	1.38	1.00	2.75	3.25	1.50	0.63	1.00	12.70	9.75	4.75						

## Applications areas

These clamps are designed for the most rugged production jobs. Handle and links are forged alloy steel, coined and machined to close tolerances. Have hardened pivot pins and serrated hardened bushings. Model 557 has a variable position straight base. Model 558 is a vertical handle variation of Model 557. All hold-down bars can be machined to meet your needs.



Model no.	Holding Capacity [lbs.]	Bar Opening $\angle +10^\circ$	Handle Moves	[lbs.]	Standard equipment
558	2,500	192°	64°	5.00	None
568	3,300	186°	64°	5.95	None

ALSO AVAILABLE		
As Air Hydraulic	Model 858	Page 11.13
See additional adjustment spindles beginning page 9.1.		
See section 16 for holding capacity charts.		



Model no.	A1	B	B1	B3	C	C1	F1	H	L	L1
558 ▲	2.13	1.93	0.44	1.38	3.75	1.00	1.00	11.25	8.00	4.81
568 ▲	2.13	1.93	0.44	1.38	3.35	1.38	0.98	11.25	8.00	4.81

▲ Available upon request

## Heavy-duty vertical clamps

- Heavy-duty clamping bar
- Flanged or straight bases with standard hole pattern

### Application areas

This series of models is extremely robust. Heavy-duty clamping tasks are easily fulfilled and rough handling is not a problem for this series. The heavy-duty vertical clamps are especially suitable for welding and milling applications, for locking foam molds and similar severe clamping applications. The heavy-duty clamping bar can be shortened, welded to or have holes drilled to suit the application.

### Product features

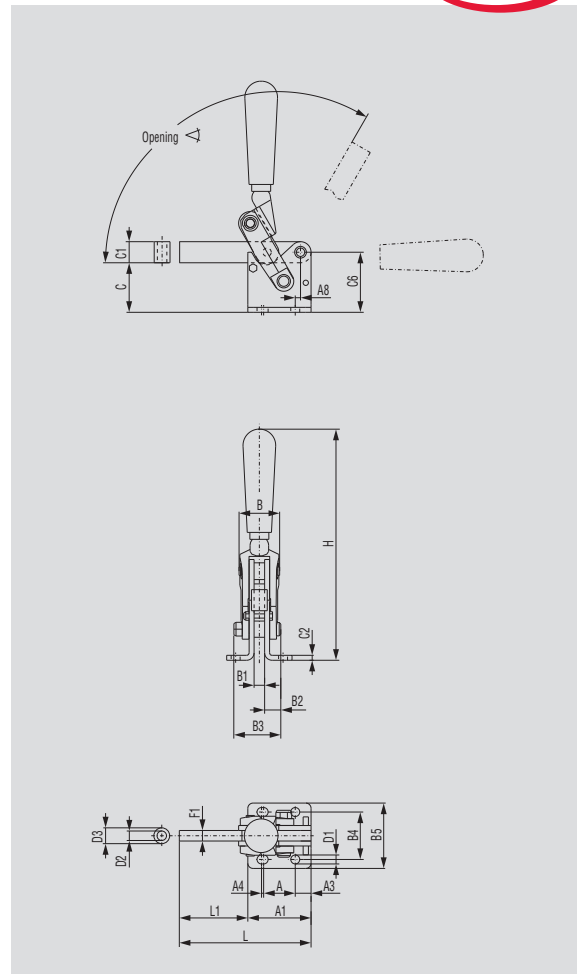
- Hardened, polished bushings
- Hardened, polished bolts
- Parts drop-forged
- Adjustable bar guide
- Oil-resistant, ergonomically shaped DE-STA-CO handle grip

## Models 533-L, 535-L



Model no.	Holding Capacity ↑ [lbs.]	Bar Opening ↙ +10°	[lbs.]	Bolt Retainer and Spacer
533-L ▲	1,500	120°	2.20	533108-M
535-L ▲	2,200	120°	4.08	535108-M

See additional adjustment spindles beginning page 9.1

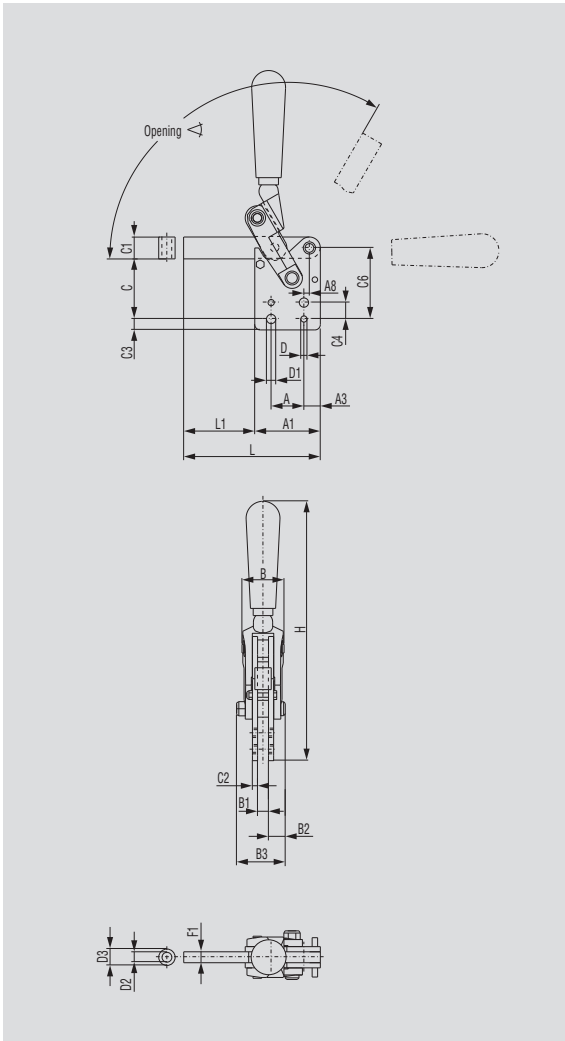


Model no.	A	A1	A3	A4	A8	B	B1	B2	B3
533-L ▲	1.18	2.36	0.59	0.08	0.20	1.52	0.39	0.61	1.75
535-L ▲	1.77	2.95	0.59	0.12	0.10	1.89	0.47	0.77	2.13

Model no.	B4	B5	C	C1	C2	C6	D1	D2	D3	F1	H	L	L1					
533-L ▲	1.77	2.44	1.85	0.79	0.19	2.24	0.33	0.35	0.59	0.39	8.62	4.92	2.56					
535-L ▲	2.05	2.87	2.64	0.98	0.19	3.13	0.41	0.43	0.79	0.47	10.3	6.30	3.35					

▲ Available upon request

# Models 533-LB, 535-LB, 536-LB



Model no.	Holding Capacity [lbs.]	Bar Opening $\angle +10^\circ$	[lbs.]	Bolt retainer and Spacer
533-LB ▲	1,500	120°	2.20	533108-M
535-LB ▲	2,200	120°	4.08	535108-M
536-LB ▲	2,900	120°	7.72	536108-M

See additional adjustment spindles beginning page 9.1



Model no.	A	A1	A3	A8	B	B1	B2	B3	C
533-LB ▲	1.18	2.36	0.59	0.20	1.52	0.39	0.61	1.75	2.17
535-LB ▲	1.77	2.95	0.59	0.10	1.89	0.47	0.77	2.18	2.95
536-LB ▲	2.17	3.74	0.79	0.20	2.36	0.63	0.91	2.62	3.74

Model no.	C1	C2	C3	C4	C6	D	D1	D2	D3	F1	H	L	L1
533-LB ▲	0.79	0.19	0.39	0.59	2.56	0.22	0.33	0.35	0.59	0.39	9.33	4.92	2.56
535-LB ▲	0.98	0.19	0.59	0.79	3.44	0.30	0.41	0.43	0.79	0.47	11.28	6.30	3.35
536-LB ▲	1.18	0.25	0.59	0.98	4.33	0.38	0.49	0.51	0.87	0.63	13.15	8.07	4.33

▲ Available upon request

## Vertical clamps in modular design

- Weldable clamping bar
- Handle accessory can be welded in place
- Base plate
- Swivel base version or mounting plate accessory available
- LSC version with locking spring for securing the open position

### Application areas

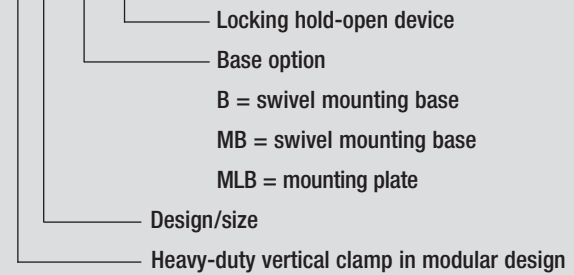
This clamp can be modified to suit the requirements of your fixture. The clamp bar, handles and base plates are welded onto the basic clamp linkage. This series of models is especially robust and precise due to its manufacturing process. These highly flexible vertical handle clamps are, therefore, especially suitable for welding operations in the automobile manufacturing sector, milling operations, locking foam molds and containers and all applications in which precision and high forces are required.

### Product features

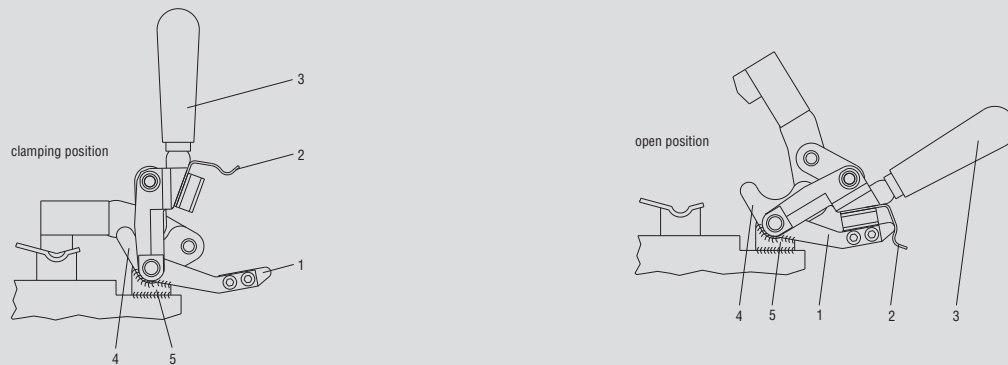
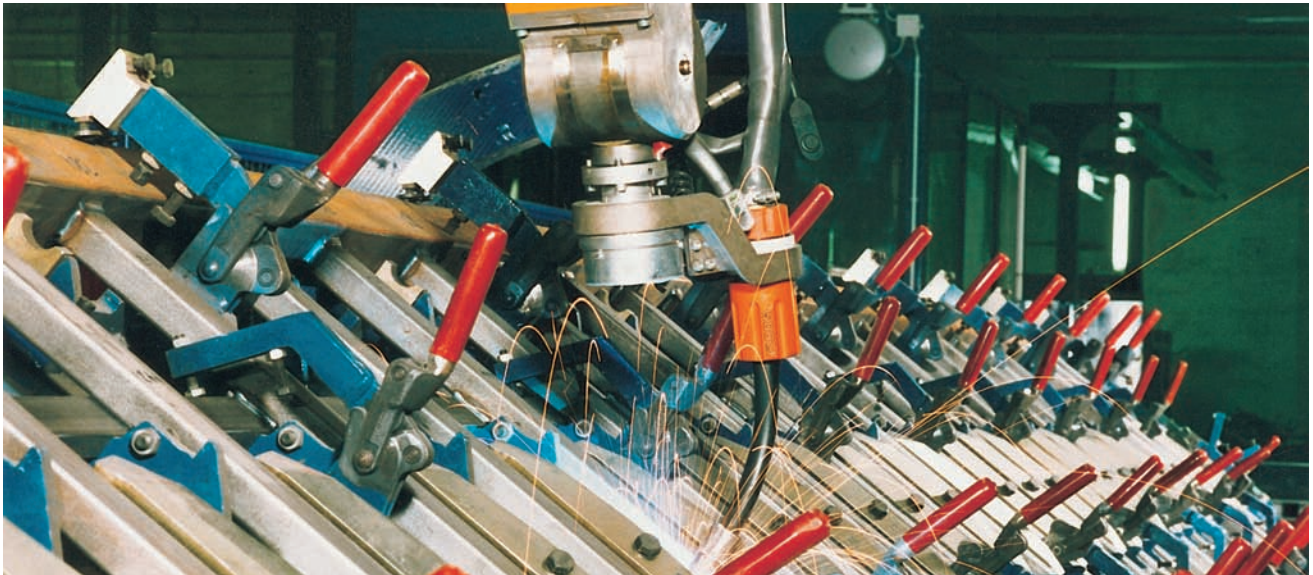
- Hardened, polished bushings
- Hardened, polished bolts
- Parts drop-forged
- Adjustable clamping bar opening angle on LSC versions

### Model number code

#### 5 03-MB LSC



Model 505-MLB in a robot-type welding fixture

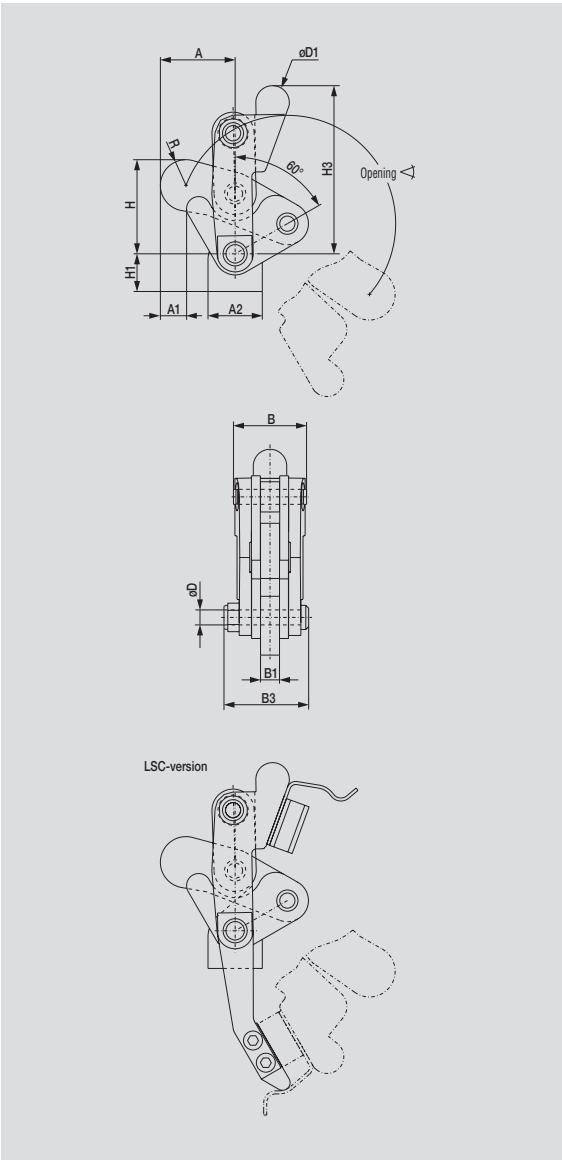


### Patented hold-open device

1. Mount and close the clamp
2. Weld guide links 4 to the base 5
3. Weld the base 5 to the fixture
4. Lock the hold-open arm 1 in the leaf spring 2
5. Set the clamp in the desired opening position
6. Maintain this position and weld the hold-open arm 1 to the side of the clamp 4



# Models 501-B, 503-MB, 503-MBLSC, 505-MB, 505-MBLSC, 506-MB, 506-MBLSC



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	⚖ [lbs.]
501-B ▲	560	200°	0.50
503-MB	1,500	200°	1.50
503-MBLSC	1,500	200°	1.50
505-MB	2,400	200°	3.00
505-MBLSC	2,400	200°	3.00
506-MB	5,000	200°	5.70
506-MBLSC	5,000	200°	5.70

Model 503-MB



Model 503-MBLSC




Model no.	A	A1	A2	B	B1	B3	øD	øD1	H	H1	H3	R			
501-B ▲	28.50	14.50	19.00	28.00	6.40	28.00	4.70	12.00	28.00	20.00	56.00	9.50			
503-MB	39.50	13.00	28.50	38.50	10.00	45.00	7.90	18.00	51.00	20.00	88.50	13.50			
503-MBLSC	39.50	13.00	28.50	38.50	10.00	45.00	7.90	18.00	51.00	20.00	88.50	13.50			
505-MB	56.50	25.00	35.00	48.00	12.30	54.00	9.50	22.00	71.50	28.00	110.00	18.00			
505-MBLSC	56.50	25.00	35.00	48.00	12.30	54.00	9.50	22.00	71.50	28.00	110.00	18.00			
506-MB	72.00	32.50	51.00	60.00	16.00	67.00	12.70	28.00	87.50	33.00	135.00	21.00			
506-MBLSC	72.00	32.50	51.00	60.00	16.00	67.00	12.70	28.00	87.50	33.00	135.00	21.00			

▲ Available upon request

Note: Dimensions are shown in metric (mm).

# Models 501-LB, 503-MLB, 503-MLBLSC, 505-MLB, 505-MLBLSC, 506-MLB, 506-MLBLSC

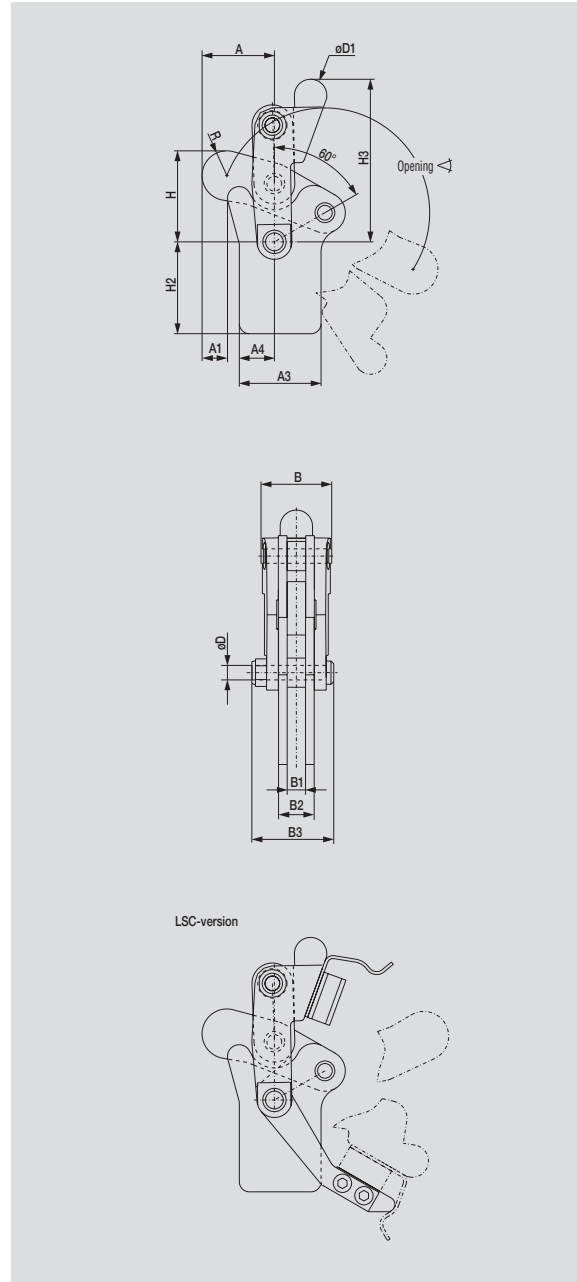
Model no.	Holding Capacity [lbs.]	Bar Opening $\angle +10^\circ$	 [lbs.]
501-LB ▲	560	200°	0.50
503-MLB ▲	1,500	200°	1.50
503-MLBLSC ▲	1,500	200°	1.50
505-MLB ▲	2,400	200°	3.00
505-MLBLSC ▲	2,400	200°	3.00
506-MLB ▲	5,000	200°	5.70
506-MLBL ▲	5,000	200°	5.70



Model 503-MLB



Model 503-MLBLSC

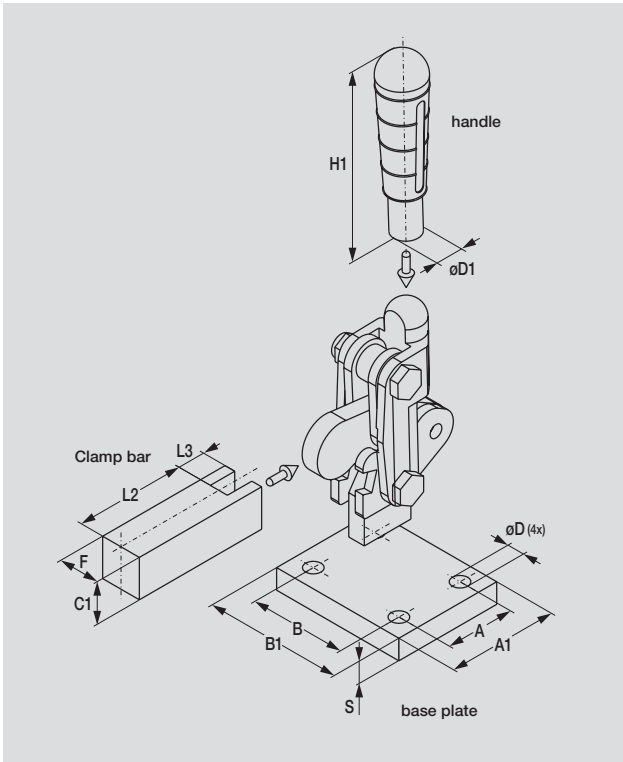


Model no.	A	A1	A3	A4	B	B1	B2	B3	oD	oD1	H	H2	H3	R
501-LB ▲	28.50	15.00	27.00	13.50	28.00	6.40	13.00	28.00	4.70	12.00	28.00	33.50	56.00	9.50
503-MLB ▲	39.50	14.00	44.50	19.00	38.50	10.00	19.50	45.00	7.90	18.00	51.00	50.00	88.50	13.50
503-MLBLSC ▲	39.50	14.00	44.50	19.00	38.50	10.00	19.50	45.00	7.90	18.00	51.00	50.00	88.50	13.50
505-MLB ▲	56.50	29.00	53.00	27.50	48.00	12.30	21.50	54.00	9.50	22.00	71.50	63.50	110.0	18.00
505-MLBLSC ▲	56.50	29.00	53.00	27.50	48.00	12.30	21.50	54.00	9.50	22.00	71.50	63.50	110.0	18.00
506-MLB ▲	72.00	35.50	65.50	37.00	60.00	16.00	28.50	67.00	12.70	28.00	87.50	76.00	135.5	21.00
506-MLBLSC ▲	72.00	35.50	65.50	37.00	60.00	16.00	28.50	67.00	12.70	28.00	87.50	76.00	135.5	21.00

▲ Available upon request

Note: Dimensions are shown in millimeters

## Vertical clamps in modular design/accessories




The modular design of this series of models allows you to set up the vertical clamp according to your specific requirements.

The clamping bar, the baseplate and the handle can be adapted to suit the fixture.

### Important note

The forged parts must be heated up to 400° F (200° C) prior to the welding operation. For this reason, the handle and clamping arm should be welded together with the disassembled mating parts of the clamp. Ideal for welding in the cold state, welding additives must be used.

Completion parts (made of low carbon steel)		Handle	Clamping Bar				Baseplate					Model no.	
			C1	F	L2	L3	A	A1	B	B1	$\phi D$		S
Fitting the vertical clamps Heavy version See pages 2.25 and 2.26	$\phi D1$	~H1											
Series 501 (all models)	6x10	61	-	-	-	-	-	-	-	-	-	-	501503
Model 501-B	-	-	15	15	40	10	-	-	-	-	-	-	501501
	-	-	-	-	-	-	25	40	35	50	6.3	8	503502
Series 503 (all models)	$\phi 18$	104.5	-	-	-	-	-	-	-	-	-	-	503503
	$\phi 18$	129.5	-	-	-	-	-	-	-	-	-	-	503503-L
Models 503-MB, 503-MBLSC	-	-	25	20	50	8	-	-	-	-	-	-	503501
	-	-	-	-	-	-	25	40	35	50	6.3	8	503502
Series 505 (all models)	$\phi 22$	114	-	-	-	-	-	-	-	-	-	-	505503
	$\phi 22$	159	-	-	-	-	-	-	-	-	-	-	505503-L
Models 505-MB, 505-MBLSC	-	-	30	25	60	12	-	-	-	-	-	-	505501
	-	-	-	-	-	-	40	60	30	50	8.1	8	505502
Series 506 (all models)	$\phi 28$	123	-	-	-	-	-	-	-	-	-	-	506503
	$\phi 28$	188	-	-	-	-	-	-	-	-	-	-	506503-L
Model 506-MB, 506-MBL	-	-	35	30	75	15	-	-	-	-	-	-	506501
	-	-	-	-	-	-	50	70	45	65	8.1	8	506502

Note: Dimensions are shown in millimeters

## Cam action clamps for variable workpiece thickness

- Ideal for variable workpiece thickness
- Heavy-duty clamping bar
- Flanged base

### Application areas

The DE-STA-CO cam clamps have a high-to-low limit clamping range that automatically compensates for part thickness variation and therefore eliminates time-consuming readjustments. The cam action resists vibrational loosening. They are built to take abuse. The clamps are available in five sizes. Part variation thickness allowance is from 1/8" to 3/8".

### Product features

- Parts casted
- Hardened bushings
- Includes mounting holes

## Models 7-101, 7-58, 7-59, 7-60, 7-61

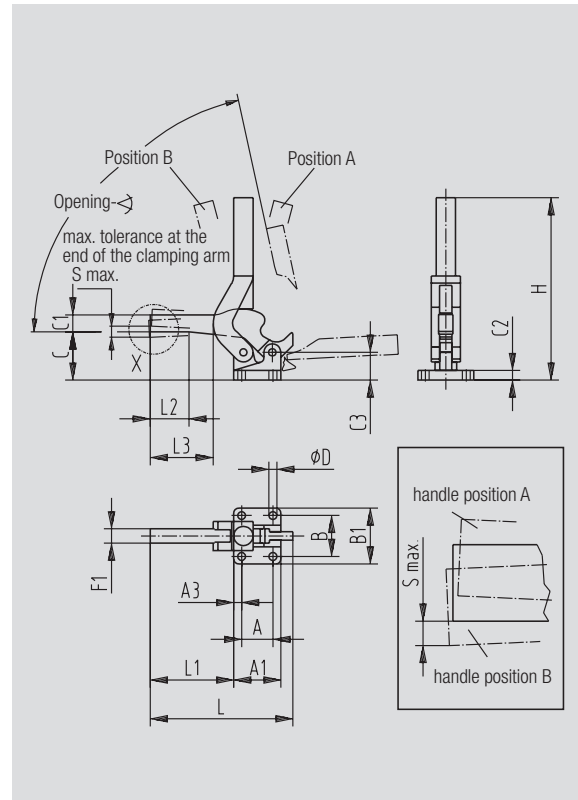
Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	⚖ [lbs.]
7-101	475	80°	1.00
7-58	600	95°	2.00
7-59	1,000	95°	3.00
7-60	1,600	80°	5.00
7-61	3,750	90°	15.00



Model 7-101



Model 7-60



Model no.	A	A1	A3	B	B1	C	C1	C2	C3	$\phi D$	F1	H	L	L1	L2	S Max.
7-101	0.75	1.25	0.25	1.25	1.75	1.44	0.50	0.31	1.00	0.22	0.49	5.00	4.62	3.12	-	0.13
7-58	1.00	1.69	0.34	1.62	2.25	1.87	0.56	0.38	1.12	0.28	0.50	7.00	6.99	2.55	-	0.13
7-59	1.38	2.06	0.39	1.88	2.50	2.19	0.63	0.44	1.25	0.34	0.63	8.50	6.00	3.50	1.24	0.19
7-60	1.62	2.44	0.44	2.12	2.88	2.50	0.88	0.50	1.44	0.41	0.75	9.50	7.40	4.38	1.97	0.25
7-61	2.00	3.00	0.50	3.50	4.50	2.86	1.25	0.62	1.68	0.53	1.13	13.93	9.76	5.93	-	0.38

## Vertical clamps with front attachment

### ■ U-shaped or solid clamping bar

#### Application areas

Ideal for applications in the assembly industry in which workholding is performed with clamping forces of up to 500 lbs., including assembling, drilling, testing, positioning, milling and other processing operations.

#### Product features

- Torsion-protected, hardened bushings
- Rivets made of stainless steel
- Zinc plated
- Oil-resistant, ergonomically shaped DE-STA-CO handle grip

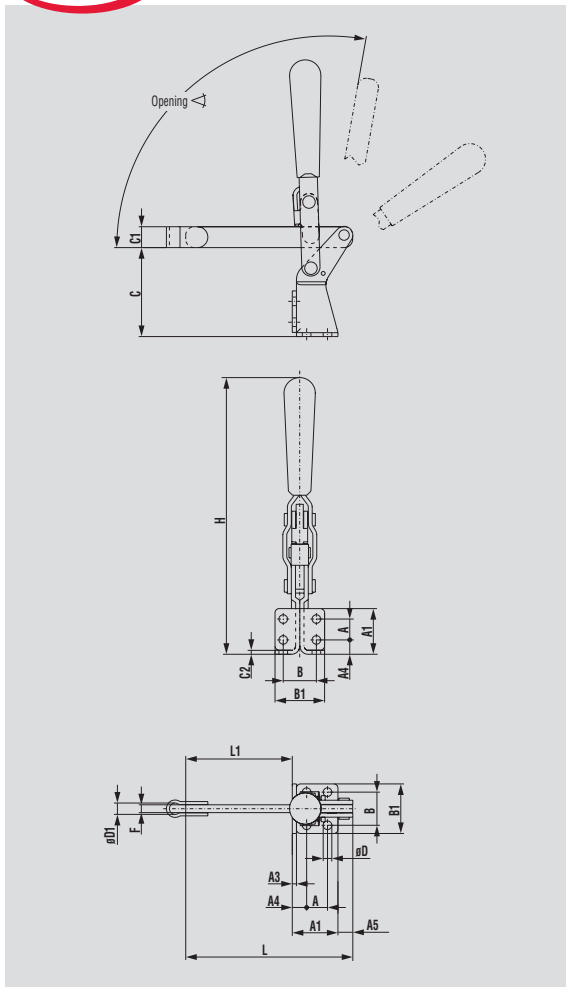
#### Accessories

Vertical handle clamps with a U-shaped clamping arm can be ordered in two varieties:

- Standard model number: The matching standard adjustment spindle is included
- Model number containing “-LS”: The model is delivered with two flanged washers without an adjustment spindle.



## Model 207-SF



Model no.	Holding Capacity [lbs.]	Bar Opening $\angle +10^\circ$	[lbs.]	Bolt Retainer
207-SF ▲	500	90°	0.84	207105

See additional adjustment spindles beginning on page 9.1.



Model no.	A	A1	A3	A4	A5	B	B1	C	C1	C2	øD	øD1	F	H	L	L1	M
207-SF ▲	0.63	1.38	0.12	0.43	0.45	1.00	1.50	2.68	0.63	0.12	0.26	0.33	0.24	8.15	5.04	3.21	M8

▲ Available upon request



# Model 207-UF

Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ▲ +10°	[lbs.]	Standard equipment	Flanged Washers
207-UF ▲	375	90°	0.94	225208-M	507107
207-UF-LS				without spindle	507107

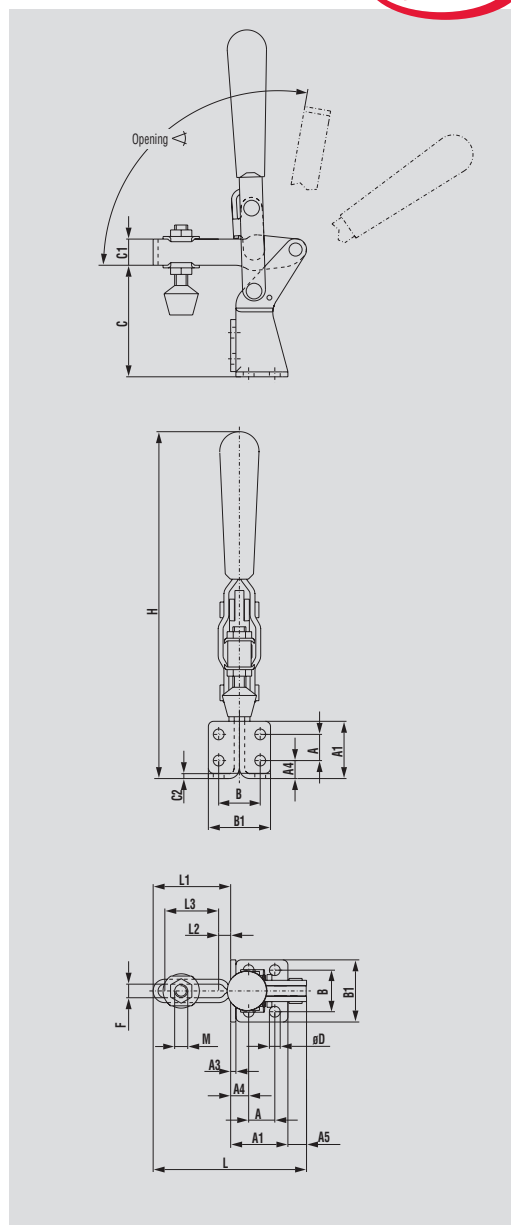
See additional adjustment spindles beginning on page 9.1



Model no.	A	A1	A3	A4	A5	B	B1	C	C1
207-UF ▲	0.63	1.38	0.12	0.43	0.45	1.00	1.50	2.68	0.63

Model no.	C2	øD	F	H	L	L1	L2	L3	M
207-UF ▲	0.12	0.26	0.33	8.15	3.70	1.87	0.30	1.30	M8

▲ Available upon request



## With very large opening angle

### Application areas

Ideal for all areas of the assembly industry in which workholding is performed with holding capacities of up to 375 lbs. For example, assembling, drilling, testing, positioning, milling and other processing operations.

### Product features

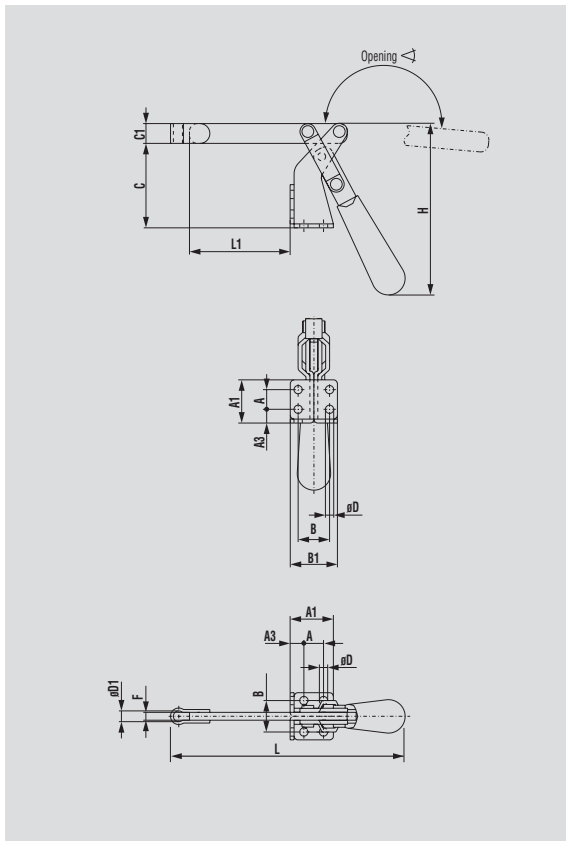
- Extremely large arm opening angle (185°)
- Handle position is identical in clamped position and open position
- Torsion-protected, hardened bushings
- Rivets made of stainless steel
- Zinc plated
- Oil-resistant, ergonomically shaped DE-STA-CO handle grip

### Accessories

Vertical clamps with a U-shaped clamping bar can be ordered in two varieties:

- Standard model number: The standard adjustment spindle is included
- Model number containing “-LS”: The model is delivered with two flange washers without an adjustment spindle

## Model 317-S



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔩 Bolt Retainer
317-S	375	185°	60°	0.75	207105

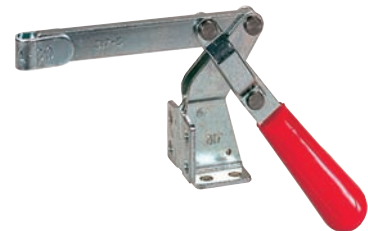
### ALSO AVAILABLE

As Air Hydraulic      Model 817-S      Page 11.14

See accessories beginning on page 9.1.



See section 16 for holding capacity charts.

- Solid clamping bar
- Dual position mounting base



Model no.	A	A1	A3	B	B1	C	C1	øD	øD1	F	H	L	L1				
317-S	0.63	1.38	0.44	1.00	1.50	2.69	0.63	0.27	0.33	0.25	5.54	6.57	3.20				

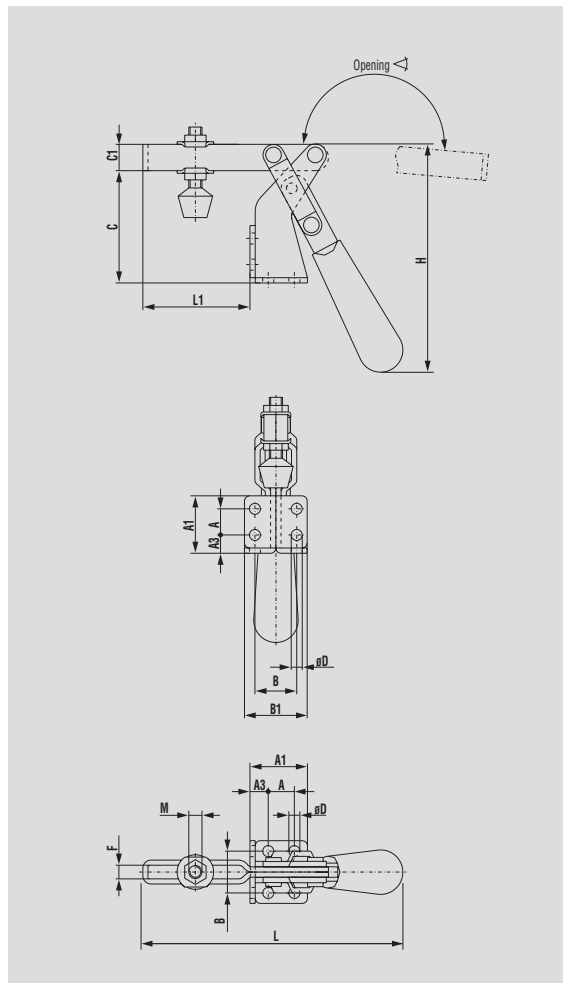
# Model 317-U

Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves ◁	 [lbs.]	 Standard equipment
317-U	375	185°	60°	0.75	507208-M
317-U-LS					without spindle

**ALSO AVAILABLE**

As Air Hydraulic	Model 817-U	Page 11.15
See accessories beginning on page 9.1.		
See section 16 for holding capacity charts.		

- U-shaped clamping bar
- Dual position mounting base



Model no.	A	A1	A3	B	B1	C	C1	øD	F	H	L	L1	M				
317-U	0.63	1.38	0.44	1.00	1.50	2.68	0.63	0.27	0.34	5.64	5.90	2.53	M8 or 5/16				



- Heavy-duty clamping bar
- With flanged base or front mount

**Application areas**

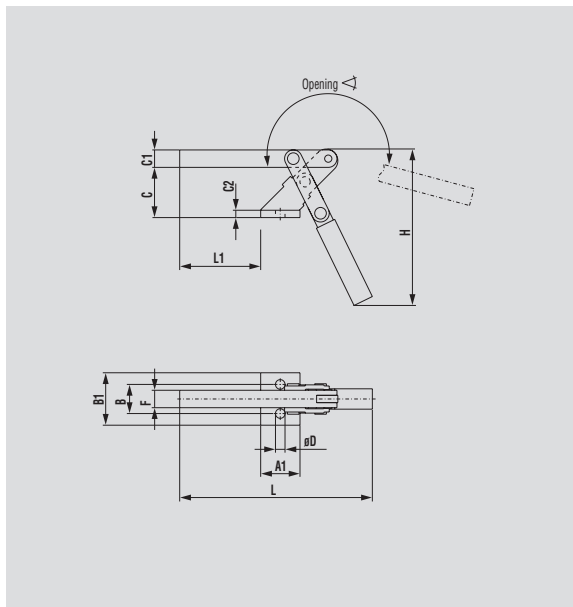
Ideal for all areas in which workholding is performed with holding capacities of up to 2,500 lbs. Due to design, these models are especially suitable for use in demanding work environments, including assembling, drilling, testing, positioning, milling and other processing operations.

The heavy-duty clamping bar can be shortened or lengthened to the desired length, and holes can be drilled (for spindle assembly).

**Product features**

- Extremely large opening angle (195°)
- Handle position is identical in the clamped position and open position
- Torsion-protected, hardened bushings
- Rivets made of stainless steel
- Additional lever added to the link to facilitate one-handed operation for opening and closing.

**Model 527**



Model no.	Holding Capacity [lbs.]	Bar Opening $\angle +10^\circ$	Handle Moves	[lbs.]	Standard equipment
527	1,000	195°	65°	2.50	none

- Solid clamping bar
- Flanged base

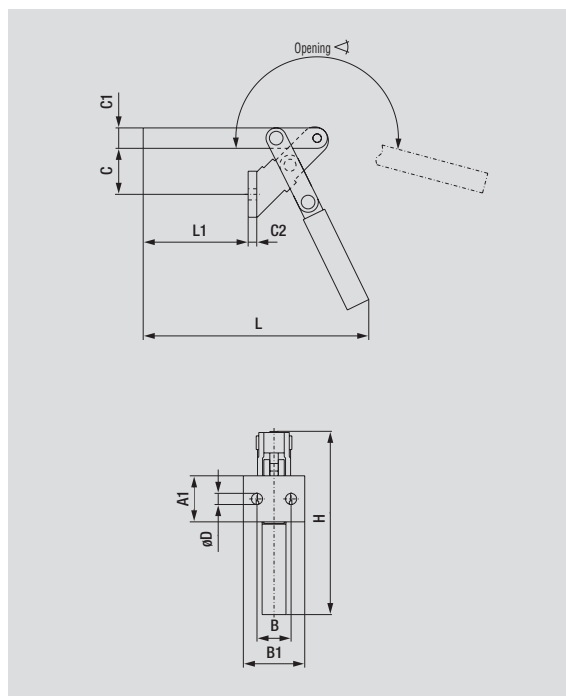


Model no.	A1	B	B1	C	C1	C2	øD	F	H	L	L1
527	1.77	1.25	2.25	2.20	0.75	0.21	0.41	0.75	7.08	8.63	3.27

## Model 527-F

	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment
Model no.					
527-F	1,000	195°	65°	2.50	none

- Solid clamping bar
- Front mounting base

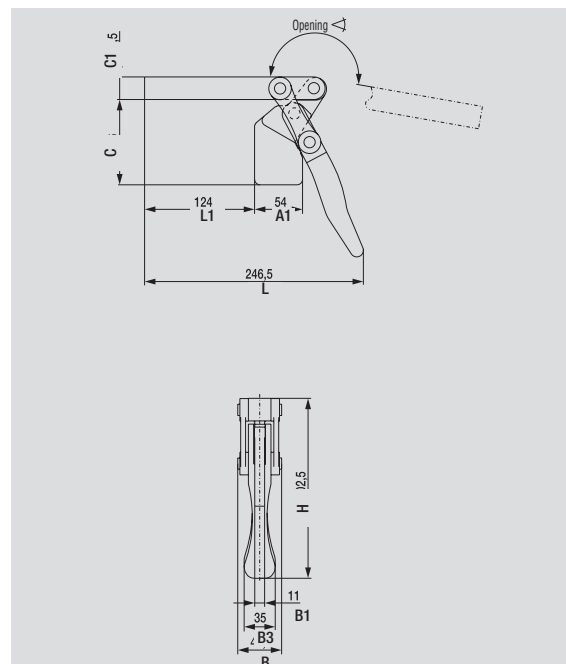


Model no.	A1	B	B1	C	C1	C2	øD	F	H	L	L1
527-F	1.77	1.25	2.25	1.92	0.75	0.21	0.41	0.75	7.34	8.65	3.81

## Model 557

	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	🔩 Standard equipment
Model no.					
557 ▲	2,500	192°	64°	5.00	none

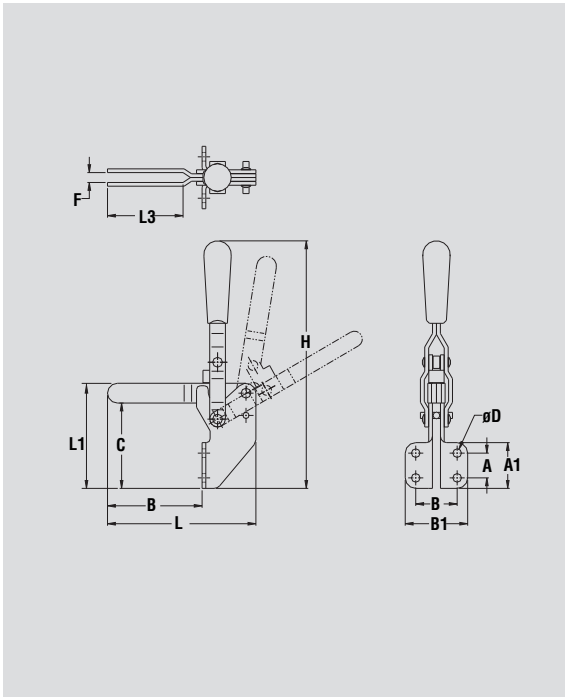
- Solid clamping bar
- Straight base



Model no.	A1	B	B1	B3	C	C1	F1	H	L	L1
557 ▲	2.13	1.93	0.44	1.38	3.75	1.00	1.00	8.13	9.31	4.81

▲ Available upon request

# Models 91090, 91140



Model no.	Holding Capacity ▲ [lbs.]	Bar Opening ◁ +10°	Handle Moves	⚖️ [lbs.]	Standard Equipment
91090	385	100°	60°	0.81	None
91140	1,000	100°	65°	3.10	None

See additional adjustment spindles beginning on page 9.1.



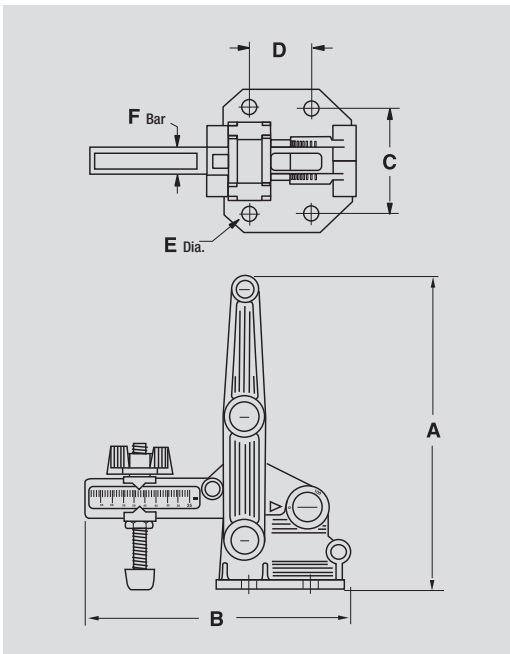
Model no.	A	A1	B	B1	C	øD	F	H	L	L1	L3
91090	0.80	1.32	1.29	2.09	2.68	0.28	0.33	7.68	4.72	3.09	2.40
91140	1.26	2.17	1.81	2.74	5.24	0.33	0.43	11.06	7.87	5.24	4.41

# Model VH3

### Information

Vertical handle toggle clamps for workholding. Toggle action locks the workpiece securely. The arm opens 100° for loading. Reinforced polymer spindle assembly with neoprene tip is included, and can be positioned on the arm using the convenient indicator.

- Lightweight, non-conductive, chemical resistant
- Locking toggle action
- Spindle assembly included
- Constructed of reinforced polymers combining high strength and light weight



Model no.	Holding Capacity ▲ [lbs.]	⚖️ [lbs.]	Standard equipment
VH3	200	0.25	Rubber-tipped composite spindle

See additional adjustment spindles beginning on page 9.1.



Model no.	A	B	C	D	E	F
VH3	5.63	4.75	1.89	1.10	0.28	0.47

Notes

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