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/USS
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/URSS
Flanged Base
U-Bar
DESTACO®
Toggle Lock Plus

2002-SR
Flanged Base
Solid Bar
DESTACO®
Toggle Lock Plus

2002-UBR
Straight Base
U-Bar

2002-SBR
Straight Base
Solid Bar
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

- USS Stainless Steel Model

- URSS Stainless Steel Model

This item is available upon request

Dimensions and technical information are subject to change without notice
### 2002 SERIES

**Vertical Hold Down Clamps | Technical Information**

#### Model

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>2002-U</td>
<td>2700 N [600 lbf]</td>
<td>75°</td>
<td>66°</td>
<td>0.22kg [0.48lb]</td>
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<td>2002-USS</td>
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<td>2002-U-LS-BLK</td>
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<tr>
<td>2002-S</td>
<td>--</td>
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<td>--</td>
<td>--</td>
</tr>
<tr>
<td>2002-UB</td>
<td>--</td>
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</tr>
<tr>
<td>2002-UB-LS-BLK</td>
<td>--</td>
<td>--</td>
<td>--</td>
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<tr>
<td>2002-SB</td>
<td>--</td>
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<td>2002-UR</td>
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<td>2002-URSS</td>
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<td>2002-UR207</td>
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### Accessories (Supplied)

<table>
<thead>
<tr>
<th>Bolt Retainer</th>
<th>Spindle Assembly</th>
<th>Flanged Washers</th>
</tr>
</thead>
<tbody>
<tr>
<td>215208-M</td>
<td>215105</td>
<td></td>
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<tr>
<td>202943-M</td>
<td>215905</td>
<td></td>
</tr>
<tr>
<td>2002115-E</td>
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<td>215208-M</td>
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<td></td>
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<tr>
<td>2002115-E</td>
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<td>2002115-E</td>
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<td>2002115-E</td>
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<td>215208-M</td>
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<td>2002115-E</td>
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<td>215208-M</td>
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<td>2002115-E</td>
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<td>2002115-E</td>
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This item is available upon request.

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### Holding Capacities

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<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>X2</th>
<th>Y</th>
<th>‡HC1</th>
<th>‡HC2</th>
<th>‡EF(X1):AF</th>
<th>‡EF(X2):AF</th>
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<td>28.5</td>
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<td>[2.64]</td>
<td>[3.66]</td>
<td>[600 lbf]</td>
<td>[295 lbf]</td>
<td>11:1</td>
<td>5:1</td>
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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/-USS/-S/-UB/-SB/-UR/-URSS/-SR/-UBR/-SBR

---

**2002-U**
Flanged Base
U-Bar

**2002-SB**
Straight Base
Solid Bar

---

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

---

Dimensions and technical information are subject to change without notice

---

**Model** | A | B
--- | --- | ---
2002-U-207 | 90° | 72°
2002-UR207 | 75° | 57°
VERTICAL HOLD DOWN CLAMPS

Notes

________________________________________________________________________
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________________________________________________________________________
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/UBS
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/URSS
Flanged Base U-Bar

2007-SR
Flanged Base Solid Bar

2007-UBR
Straight Base U-Bar

2007-SBR
Straight Base Solid Bar

DESTACO®
Toggle Lock Plus

DESTACO®
Toggle Lock

- USS Stainless Steel Model
- URSS Stainless Steel Model

---

Technical Information

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
<th>Accessories (Supplied)</th>
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<tbody>
<tr>
<td>2007-U</td>
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<td>2007-USS</td>
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<tr>
<td>2007-S</td>
<td></td>
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<td>2007-UB</td>
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<td>2007-UB-LS-BLK</td>
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<tr>
<td>2007-SB</td>
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<td>2007-UR</td>
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<td>2007-SBR</td>
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① This item is available upon request
2007 SERIES

Vertical Hold Down Clamps | Holding Capacities

<table>
<thead>
<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>X2</th>
<th>Y</th>
<th>‡HC1</th>
<th>‡HC2</th>
<th>‡EF(X1):AF</th>
<th>‡EF(X2):AF</th>
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<tbody>
<tr>
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<td>[1.59]</td>
<td>[1.95]</td>
<td>[3.92]</td>
<td>[5.16]</td>
<td>[1000 lbf.]</td>
<td>[4450 N]</td>
<td>10:1</td>
<td>5.3:1</td>
</tr>
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</table>

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/-URSS/-SR/-UBR/-SBR

2007-U
Flanged Base
U-Bar

2007-SB
Straight Base
Solid Bar

Dimensions and technical information are subject to change without notice
Technical Information

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>2010-U</td>
<td>6230 N [1400 lbf]</td>
<td>78°</td>
<td>66°</td>
<td>1.16kg [2.56lbs]</td>
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<tr>
<td>2010-S</td>
<td>---</td>
<td>---</td>
<td>---</td>
<td>---</td>
</tr>
<tr>
<td>2010-UB</td>
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<td>---</td>
</tr>
<tr>
<td>2010-SB</td>
<td>---</td>
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</table>

Accessories (Supplied)

<table>
<thead>
<tr>
<th>Bolt Retainer</th>
<th>Spindle Assembly</th>
<th>Flanged Washers</th>
</tr>
</thead>
<tbody>
<tr>
<td>---</td>
<td>240208-M</td>
<td>235106</td>
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<tr>
<td>2010115-E</td>
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</tr>
<tr>
<td>---</td>
<td>240208-M</td>
<td>235106</td>
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<tr>
<td>2010115-E</td>
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<tr>
<td>---</td>
<td>240208-M</td>
<td>235106</td>
</tr>
<tr>
<td>2010115-E</td>
<td>---</td>
<td>---</td>
</tr>
</tbody>
</table>

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 SERIES

**Vertical Hold Down Clamps | Holding Capacities**

<table>
<thead>
<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>X2</th>
<th>Y</th>
<th>‡HC1</th>
<th>‡HC2</th>
<th>‡EF(X1):AF</th>
<th>‡EF(X2):AF</th>
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<tr>
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</table>

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

### 2010-U
Flanged Base U-Bar

### 2010-SB
Straight Base Solid Bar

Dimensions and technical information are subject to change without notice
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-1)

201-U/UB
Flanged Base U-Bar

201-UB
Straight Base

201-TU
Flanged Base U-Bar T-Handle

Technical Information

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
<th>Accessories (Supplied)</th>
</tr>
</thead>
<tbody>
<tr>
<td>201-U</td>
<td>440 N [100 lbf]</td>
<td>100°</td>
<td>55°</td>
<td>0,70kg [0.15lbs]</td>
<td>Spindle Assembly: 305208-M, Flanged Washers: 102111</td>
</tr>
<tr>
<td>201-UB</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>201-TU</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>201-USS</td>
<td>560 N [125 lbf]</td>
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Also Available:
See page MC-VHD | Overview 201 Series

Holding Capacities

<table>
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<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>X2</th>
<th>Y</th>
<th>HC1</th>
<th>HC2</th>
<th>EF(X1):AF</th>
<th>EF(X2):AF</th>
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<tbody>
<tr>
<td>U/UB</td>
<td>0.87</td>
<td>1.06</td>
<td>1.75</td>
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<td>[2.25]</td>
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<td>[100 lbf.]</td>
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<td>22</td>
<td>27</td>
<td>44.5</td>
<td></td>
<td>[1.38]</td>
<td>35</td>
<td>[55 lbf.]</td>
<td>6:1</td>
</tr>
<tr>
<td>TU</td>
<td>[2.25]</td>
<td>57</td>
<td>[125 lbf.]</td>
<td></td>
<td>[440 N]</td>
<td>[245 N]</td>
<td>8.4:1</td>
<td>4:4:1</td>
</tr>
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<td>USS</td>
<td>[2.25]</td>
<td>57</td>
<td>[60 lbf.]</td>
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<td>[560 N]</td>
<td>[270 N]</td>
<td>9:1</td>
<td>6:1</td>
</tr>
</tbody>
</table>

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

See page MC-TEC-4 for additional information.

Dimensions and technical information are subject to change without notice.
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 ¼” 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-3)

202-U/USS
Flanged Base U-Bar
- USS Stainless Steel Model

202-UL
Flanged Base Long U-Bar
- SS Stainless Steel Model

202/SS
Flange Base Solid Bar

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-BLK
Blackout Series Straight Base Open U-Bar

202305

This item is available upon request

Dimensions and technical information are subject to change without notice
## Vertical Hold Down Clamps | Technical Information

### 202 Series

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
<th>Spindle Assembly</th>
<th>Flanged Washers</th>
</tr>
</thead>
<tbody>
<tr>
<td>202-U</td>
<td>890 N [200 lbf]</td>
<td>105°</td>
<td>65°</td>
<td>0,16kg</td>
<td>202208-M</td>
<td>215105</td>
</tr>
<tr>
<td>202-UL</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>202-USS</td>
<td>1110 N [250 lbf]</td>
<td></td>
<td></td>
<td>0,15kg</td>
<td>202943-M</td>
<td>215905</td>
</tr>
<tr>
<td>202</td>
<td>890 N [200 lbf]</td>
<td></td>
<td></td>
<td>0,15kg</td>
<td>202208-M</td>
<td></td>
</tr>
<tr>
<td>202-SS</td>
<td>1110 N [250 lbf]</td>
<td></td>
<td></td>
<td>0,16kg</td>
<td>205943-M</td>
<td></td>
</tr>
<tr>
<td>202-UB</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>202-B</td>
<td></td>
<td></td>
<td></td>
<td>0,15kg</td>
<td>202208-M</td>
<td>215105</td>
</tr>
<tr>
<td>202-TU</td>
<td></td>
<td></td>
<td></td>
<td>0,17kg</td>
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<tr>
<td>202-T</td>
<td>890 N [200 lbf]</td>
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<td></td>
<td>0,16kg</td>
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<td>202-U-UB-L-BLK</td>
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<tr>
<td>202-U-UB-L-BLK</td>
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**Accessories (Supplied)**

<table>
<thead>
<tr>
<th>Spindle Assembly</th>
<th>Flanged Washers</th>
</tr>
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<tbody>
<tr>
<td>202208-M</td>
<td>215105</td>
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<td>202943-M</td>
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<td>205943-M</td>
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<tr>
<td>202208-M</td>
<td>215105</td>
</tr>
<tr>
<td>202208-M</td>
<td>215105</td>
</tr>
<tr>
<td>202208-M</td>
<td>215105</td>
</tr>
<tr>
<td>202208-M</td>
<td>215105</td>
</tr>
<tr>
<td>202208-M</td>
<td>215105</td>
</tr>
</tbody>
</table>

1. **This item is available upon request**

### Holding Capacities

<table>
<thead>
<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>X2</th>
<th>Y</th>
<th>‡HC1</th>
<th>‡HC2</th>
<th>‡EF(X1):AF</th>
<th>‡EF(X2):AF</th>
</tr>
</thead>
</table>

**Dimensions shown “mm [inch]”**

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

1. **This item is available upon request**

Dimensions and technical information are subject to change without notice.
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]  [0.98]  [44,1]  25
202-UL  [2.29]  [1.51]  [58,1]  38,4
202/202-B/202-T/202-SS  [1.08]  [1.50]  27,4
202-U-L  202-UB-L  [1.50]  38,1

This item is available upon request

Dimensions and technical information are subject to change without notice
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-6)
807-S Pneumatic toggle clamp
(See page MC-PTC-6)

Accepts M8 or 5/16 spindle accessories

207-U Flanged Base U-Bar
207-UL Flanged Base Long 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 DESTACO® Toggle Lock Plus
207-LR Flanged Base Long Solid Bar 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 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 Flange Base Open Bar
207-UB-L-BLK Blackout Series Straight Base Open U-Bar

207305

This item is available upon request
### Model Details

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
<th>Accessories (Supplied)</th>
</tr>
</thead>
<tbody>
<tr>
<td>207-U</td>
<td>1670 N [375 lbf]</td>
<td></td>
<td></td>
<td>0.30kg [0.67lb]</td>
<td>--- 225208-M 507107</td>
</tr>
<tr>
<td>207-UR</td>
<td>1670 N [375 lbf]</td>
<td></td>
<td></td>
<td>0.45kg [1.00lb]</td>
<td>--- 225208-M 507107</td>
</tr>
<tr>
<td>207-UL</td>
<td>2220 N [500 lbf]</td>
<td>99°</td>
<td>57°</td>
<td>0.31kg [0.69lb]</td>
<td>207105 --- ---</td>
</tr>
<tr>
<td>207-USS</td>
<td>2000 N [450 lbf]</td>
<td></td>
<td></td>
<td>0.32kg [0.70lb]</td>
<td>--- 207943-M 507907</td>
</tr>
<tr>
<td>207-S</td>
<td>2220 N [500 lbf]</td>
<td></td>
<td></td>
<td>0.34kg [0.74lb]</td>
<td>207105 --- ---</td>
</tr>
<tr>
<td>207-L</td>
<td>1670 N [375 lbf]</td>
<td></td>
<td></td>
<td>0.45kg [1.00lb]</td>
<td>207105 --- ---</td>
</tr>
<tr>
<td>207-LR</td>
<td>1670 N [375 lbf]</td>
<td></td>
<td></td>
<td>0.33kg [0.72lb]</td>
<td>--- 225208-M 507107</td>
</tr>
<tr>
<td>207-UB</td>
<td>1670 N [375 lbf]</td>
<td></td>
<td></td>
<td>0.31kg [0.69lb]</td>
<td>--- 225208-M 507107</td>
</tr>
<tr>
<td>207-ULB</td>
<td>2220 N [500 lbf]</td>
<td></td>
<td></td>
<td>0.34kg [0.75lb]</td>
<td>207105 --- ---</td>
</tr>
<tr>
<td>207-SB</td>
<td>2220 N [500 lbf]</td>
<td></td>
<td></td>
<td>0.45kg [1.00lb]</td>
<td>207105 --- ---</td>
</tr>
<tr>
<td>207-LB</td>
<td>1670 N [375 lbf]</td>
<td></td>
<td></td>
<td>0.33kg [0.72lb]</td>
<td>--- 225208-M 507107</td>
</tr>
<tr>
<td>207-LBR</td>
<td>1670 N [375 lbf]</td>
<td></td>
<td></td>
<td>0.38kg [0.84lb]</td>
<td>207105 --- ---</td>
</tr>
<tr>
<td>207-TU</td>
<td>2220 N [500 lbf]</td>
<td></td>
<td></td>
<td>0.38kg [0.84lb]</td>
<td>207105 --- ---</td>
</tr>
<tr>
<td>207-TUL</td>
<td>1670 N [375 lbf]</td>
<td></td>
<td></td>
<td>0.33kg [0.72lb]</td>
<td>--- 225208-M 507107</td>
</tr>
<tr>
<td>207-UF</td>
<td>1670 N [375 lbf]</td>
<td>96°</td>
<td>56°</td>
<td>0.43kg [0.94lb]</td>
<td>--- 225208-M 507107</td>
</tr>
<tr>
<td>207-SF</td>
<td>2220 N [500 lbf]</td>
<td>90°</td>
<td></td>
<td>0.38kg [0.84lb]</td>
<td>207105 --- ---</td>
</tr>
<tr>
<td>207-U-L</td>
<td>2220 N [500 lbf]</td>
<td>90°</td>
<td></td>
<td>0.38kg [0.84lb]</td>
<td>207105 --- ---</td>
</tr>
<tr>
<td>207-U-L-BLK</td>
<td>1670 N [375 lbf]</td>
<td>99°</td>
<td>57°</td>
<td>0.38kg [0.84lb]</td>
<td>--- 225208-M 507107</td>
</tr>
<tr>
<td>207-UB-L</td>
<td>1670 N [375 lbf]</td>
<td>96°</td>
<td>56°</td>
<td>0.43kg [0.94lb]</td>
<td>--- 225208-M 507107</td>
</tr>
<tr>
<td>207-UB-L-BLK</td>
<td>1670 N [375 lbf]</td>
<td>99°</td>
<td>57°</td>
<td>0.38kg [0.84lb]</td>
<td>--- 225208-M 507107</td>
</tr>
</tbody>
</table>

**Accessories (Supplied)**
- Bolt Retainer
- Spindle Assembly
- Flanged Washers

### Accessories

- **207 Series**
- **Dimensions and technical information are subject to change without notice**

### Technical Information

- **Vertical Hold Down Clamps**
- **Model X X1 X2 Y +HC1 +HC2 +EF(X1):AF +EF(X2):AF**

- **U/UB/UR**
  - [2.00] [50,8]
  - [3.75] [95,3]
  - [3.66] [95,3]
  - [3.75] [1670N]
  - [375 lbf] [1670N]
  - [225 lbf] [1000N]
  - [150 lbf] [670N]

- **UL/ULB**
  - [1.28] [32,6]

- **USB**
  - [2.00] [50,8]
  - [3.75] [95,3]
  - [3.66] [95,3]
  - [3.75] [1670N]
  - [375 lbf] [1670N]
  - [225 lbf] [1000N]
  - [150 lbf] [670N]

- **S/SB**
  - [2.00] [50,8]
  - [3.75] [95,3]
  - [3.66] [95,3]
  - [3.75] [1670N]
  - [375 lbf] [1670N]
  - [225 lbf] [1000N]
  - [150 lbf] [670N]

- **L/LR LB/LBR**
  - [2.00] [50,8]
  - [3.75] [95,3]
  - [3.66] [95,3]
  - [3.75] [1670N]
  - [375 lbf] [1670N]
  - [225 lbf] [1000N]

- **TU**
  - [2.00] [50,8]
  - [3.75] [95,3]
  - [3.66] [95,3]
  - [3.75] [1670N]
  - [375 lbf] [1670N]
  - [225 lbf] [1000N]

- **TUL**
  - [2.00] [50,8]
  - [3.75] [95,3]
  - [3.66] [95,3]
  - [3.75] [1670N]
  - [375 lbf] [1670N]
  - [225 lbf] [1000N]

- **U-L**
  - [2.00] [50,8]
  - [3.75] [95,3]
  - [3.66] [95,3]
  - [3.75] [1670N]
  - [375 lbf] [1670N]
  - [225 lbf] [1000N]

- **UB-L**
  - [2.00] [50,8]
  - [3.75] [95,3]
  - [3.66] [95,3]
  - [3.75] [1670N]
  - [375 lbf] [1670N]

### Notes

- Dimensions shown “mm [inch]”
- HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
- This item is available upon request
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-UL/207-ULB/207-TUL | [3.84] 97,6 | [2.94] 74,6 |
| 207-S/207-SB | [2.21] 56,2 | --- |

This item is available upon request

Dimensions and technical information are subject to change without notice
Open Bar Option

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

Stainless Steel

Dimensions and technical information are subject to change without notice
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-7)
810-S Pneumatic Toggle Clamp
(See page MC-PTC-7)

Technical Information

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
<th>Accessories (Supplied)</th>
</tr>
</thead>
<tbody>
<tr>
<td>210-U</td>
<td>2670 N [600 lbf]</td>
<td>103°</td>
<td>58°</td>
<td>0.59kg [1.29lbs]</td>
<td>Bolt Retainer 240208-M, Spindle Assembly 237943-M, Flanged Washers 235106</td>
</tr>
<tr>
<td>210-USS</td>
<td>3340 N [750 lbf]</td>
<td></td>
<td></td>
<td></td>
<td>210114 237943-M, ---</td>
</tr>
<tr>
<td>210-S</td>
<td>2670 N [600 lbf]</td>
<td></td>
<td></td>
<td>0.59kg [1.29lbs]</td>
<td>210114 240208-M, 235106</td>
</tr>
<tr>
<td>210-UB</td>
<td>3340 N [750 lbf]</td>
<td></td>
<td></td>
<td>0.59kg [1.29lbs]</td>
<td>---</td>
</tr>
<tr>
<td>210-SB</td>
<td>2670 N [600 lbf]</td>
<td></td>
<td></td>
<td>0.59kg [1.29lbs]</td>
<td>210114 240208-M, 235106</td>
</tr>
<tr>
<td>210-UR</td>
<td>3340 N [750 lbf]</td>
<td></td>
<td></td>
<td>0.59kg [1.29lbs]</td>
<td>---</td>
</tr>
<tr>
<td>210-SR</td>
<td>2670 N [600 lbf]</td>
<td></td>
<td></td>
<td>0.59kg [1.29lbs]</td>
<td>210114 240208-M, 235106</td>
</tr>
<tr>
<td>210-TU</td>
<td>3340 N [750 lbf]</td>
<td></td>
<td></td>
<td>0.59kg [1.29lbs]</td>
<td>---</td>
</tr>
</tbody>
</table>

Dimensions and technical information are subject to change without notice
210 SERIES

Vertical Hold Down Clamps | Holding Capacities

<table>
<thead>
<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>X2</th>
<th>Y</th>
<th>‡HC1</th>
<th>‡HC2</th>
<th>‡EF(X1):AF</th>
<th>EF(X2):AF</th>
</tr>
</thead>
<tbody>
<tr>
<td>TU</td>
<td>[2.38] 60.5</td>
<td>[4.88] 124</td>
<td>[600lbf.] 2670N</td>
<td>[290lbf.] 1290N</td>
<td>5:1</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Dimensions shown “mm [inch]” ‡ HC = Holding Capacity, EF = Exerting Force, AF = Applied Force

See page MC-TEC-4 for additional information.
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-13)
847-S Pneumatic Toggle Clamp
(See page MC-PTC-13)

Technical Information

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
<th>Bolt Retainer</th>
<th>Spindle Assembly</th>
<th>Flanged Washers</th>
</tr>
</thead>
<tbody>
<tr>
<td>247-U</td>
<td>4400 N [1000 lbf]</td>
<td>120°</td>
<td>67°</td>
<td>1,07kg [2.36lbs]</td>
<td>---</td>
<td>247208-M</td>
<td>247109</td>
</tr>
<tr>
<td>247-S</td>
<td>4400 N [1000 lbf]</td>
<td>120°</td>
<td>67°</td>
<td>1,08kg [2.36lbs]</td>
<td>247110</td>
<td>---</td>
<td>---</td>
</tr>
<tr>
<td>247-UB</td>
<td>5340 N [1200 lbf]</td>
<td>140°</td>
<td>72°</td>
<td>2,18kg [4.80lbs]</td>
<td>---</td>
<td>267203-M</td>
<td>267102</td>
</tr>
<tr>
<td>267-UB</td>
<td>5340 N [1200 lbf]</td>
<td>140°</td>
<td>72°</td>
<td>1,98kg [4.36lbs]</td>
<td>110122</td>
<td>---</td>
<td>---</td>
</tr>
</tbody>
</table>

Note:
Clamps shown with included accessories.

Also Available:
See page MC-ACC-1 for accessories
847-U Pneumatic Toggle Clamp
(See page MC-PTC-13)
847-S Pneumatic Toggle Clamp
(See page MC-PTC-13)

Holding Capacities

<table>
<thead>
<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>X2</th>
<th>Y</th>
<th>‡HC1</th>
<th>‡HC2</th>
<th>‡EF(X1):AF</th>
<th>‡EF(X2):AF</th>
</tr>
</thead>
<tbody>
<tr>
<td>247-S</td>
<td>[4.56]</td>
<td>115,8</td>
<td>[7.00]</td>
<td>177,8</td>
<td>[4800lbf.]</td>
<td>[4450N]</td>
<td>10:1</td>
<td>5:1</td>
</tr>
<tr>
<td>267-U</td>
<td>[4.00]</td>
<td>101,6</td>
<td>[8.00]</td>
<td>[8.75]</td>
<td>[8200lbf.]</td>
<td>[5340N]</td>
<td>18:1</td>
<td>8:1</td>
</tr>
</tbody>
</table>

Dimensions shown “mm [inch]”  ‡HC = Holding Capacity, EF = Exerting Force, AF = Applied Force
See page MC-TEC-4 for additional information.  ① 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

Dimensions and technical information are subject to change without notice
## 267 SERIES

Vertical Hold Down Clamps | Dimensions

<table>
<thead>
<tr>
<th>267-U</th>
<th>Flanged Base</th>
<th>U-Bar</th>
</tr>
</thead>
<tbody>
<tr>
<td>[11.97]</td>
<td>304</td>
<td>[5.87]</td>
</tr>
<tr>
<td>[3.08]</td>
<td>78.3</td>
<td>[3.92]</td>
</tr>
<tr>
<td>[1.61]</td>
<td>40.8</td>
<td></td>
</tr>
</tbody>
</table>

M16 OR 5/8 IF SUPPLIED

<table>
<thead>
<tr>
<th>267-S</th>
<th>Flanged Base</th>
<th>Solid Bar</th>
</tr>
</thead>
<tbody>
<tr>
<td>[0.64]</td>
<td>Ø 16.3</td>
<td>[0.50]</td>
</tr>
<tr>
<td>[0.38]</td>
<td>9.5</td>
<td>[3.00]</td>
</tr>
<tr>
<td>[2.75]</td>
<td>69.8</td>
<td>[2.00]</td>
</tr>
<tr>
<td>[3.74]</td>
<td>95</td>
<td></td>
</tr>
</tbody>
</table>

Dimensions and technical information are subject to change without notice.
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

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (±10°)</th>
<th>Handle Opening (±10°)</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>5905</td>
<td>[750lbf.] 3340N</td>
<td>135°</td>
<td>70°</td>
<td>[1.08lbs] 0.49kg</td>
</tr>
<tr>
<td>5905-B</td>
<td></td>
<td></td>
<td></td>
<td>[0.82lbs] 0.37kg</td>
</tr>
<tr>
<td>5910</td>
<td>[1600lbf.] 7120N</td>
<td>132°</td>
<td>71°</td>
<td>[2.84lbs] 1.29kg</td>
</tr>
<tr>
<td>5910-B</td>
<td></td>
<td></td>
<td></td>
<td>[2.24lbs] 1.02kg</td>
</tr>
<tr>
<td>5915</td>
<td>[2750lbf.] 12230N</td>
<td>147°</td>
<td>74°</td>
<td>[6.16lbs] 2.79kg</td>
</tr>
<tr>
<td>5915-B</td>
<td></td>
<td></td>
<td></td>
<td>[5.11lbs] 2.32kg</td>
</tr>
</tbody>
</table>

Removable handle stop can be repositioned to limit opening angle to 90°.
## 5905, 5910, 5915 Series

Heavy-Duty Vertical Hold Down Clamps | Dimensions

![Diagram of Heavy-Duty Vertical Hold Down Clamps](image)

### Dimensions Table

<table>
<thead>
<tr>
<th>Model</th>
<th>A</th>
<th>A1</th>
<th>A2</th>
<th>A3</th>
<th>A4</th>
<th>A5</th>
<th>B</th>
<th>B1</th>
<th>B2</th>
<th>B3</th>
<th>C</th>
<th>C1</th>
<th>C2</th>
<th>D</th>
<th>F</th>
<th>H</th>
<th>H1</th>
<th>L</th>
</tr>
</thead>
<tbody>
<tr>
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<th>A</th>
<th>A1</th>
<th>A2</th>
<th>A3</th>
<th>A4</th>
<th>A5</th>
<th>B</th>
<th>B1</th>
<th>B2</th>
<th>B3</th>
<th>C</th>
<th>C1</th>
<th>C2</th>
<th>D</th>
<th>F</th>
<th>H</th>
<th>H1</th>
<th>L</th>
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<td>1.02</td>
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<td>0.75</td>
<td>19.1</td>
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<td>39.9</td>
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<tr>
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<td>2.99</td>
<td>76</td>
<td>125</td>
<td>0.98</td>
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<td>1.97</td>
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</table>

Dimensions and technical information are subject to change without notice.

---

MC-VHD | 26

DESTACO | a U.S. company
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-BR/5110-BR
Solid Base with
DESTACO®
Toggle Lock
Plus™

---

**Technical Information**

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>5105</td>
<td>[700lb.] 3100N</td>
<td>89°</td>
<td>159°</td>
<td>[1.12lbs] 0.51kg</td>
</tr>
<tr>
<td>5105-B</td>
<td>[1.06lbs] 0.48kg</td>
<td>89°</td>
<td>159°</td>
<td>[1.12lbs] 0.51kg</td>
</tr>
<tr>
<td>5105-R</td>
<td>[1.10lbs] 0.50kg</td>
<td>89°</td>
<td>159°</td>
<td>[1.17lbs] 0.53kg</td>
</tr>
<tr>
<td>5105-BR†</td>
<td>[1.17lbs] 0.53kg</td>
<td>89°</td>
<td>159°</td>
<td>[1.17lbs] 0.53kg</td>
</tr>
<tr>
<td>5110</td>
<td>[1150lb.] 5100N</td>
<td>74°</td>
<td>138°</td>
<td>[2.98lbs] 1.35kg</td>
</tr>
<tr>
<td>5110-B</td>
<td>[2.95lbs] 1.34kg</td>
<td>74°</td>
<td>138°</td>
<td>[2.98lbs] 1.35kg</td>
</tr>
<tr>
<td>5110-R</td>
<td>[3.00lbs] 1.36kg</td>
<td>74°</td>
<td>138°</td>
<td>[3.00lbs] 1.36kg</td>
</tr>
<tr>
<td>5110-BR†</td>
<td>[3.02lbs] 1.37kg</td>
<td>74°</td>
<td>138°</td>
<td>[3.02lbs] 1.37kg</td>
</tr>
</tbody>
</table>

† This item is available upon request.

‡ Toggle Lock Plus™ locks the handle in the closed position only.

Dimensions and technical information are subject to change without notice.
5105, 5110 SERIES
Heavy-Duty Vertical Hold Down Clamps | Dimensions

![Diagram of heavy-duty vertical hold down clamps]

### 5105, 5110 Series

**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 | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- |
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 | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- | -- |

### Table: Dimensions

| 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 | | | | | |
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 | | | | | |

① This item is available upon request

Dimensions and technical information are subject to change without notice

MC-VHD | 28
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 Series
Heavy-Duty Vertical Hold Down Clamps | Product Overview

Technical Information

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>528</td>
<td>4450 N [1000 lbf]</td>
<td>180°</td>
<td>177°</td>
<td>[2.50lbs] 1,13kg</td>
</tr>
<tr>
<td>528-F</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

This item is available upon request

Holding Capacities | Dimensions

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

Dimensions and technical information are subject to change without notice
**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

#### Technical Information

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>548</td>
<td>11100N (2500lbf)</td>
<td>199°</td>
<td>129°</td>
<td>2.40kg [5.30lbs]</td>
</tr>
<tr>
<td>578</td>
<td>17800N (4000lbf)</td>
<td>262°</td>
<td>178°</td>
<td>4.14kg [9.12lbs]</td>
</tr>
</tbody>
</table>

#### Holding Capacities | Dimensions

<table>
<thead>
<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>X2</th>
<th>Y</th>
<th>HC1</th>
<th>HC2</th>
<th>EF(X1):AF</th>
<th>EF(X2):AF</th>
</tr>
</thead>
<tbody>
<tr>
<td>548</td>
<td>[2.75]</td>
<td>[3.50]</td>
<td>[6.00]</td>
<td>[7.50]</td>
<td>[2500lbf]</td>
<td>[11100N]</td>
<td>4.5:1</td>
<td>3.4:1</td>
</tr>
<tr>
<td>578</td>
<td>[4.25]</td>
<td>[4.50]</td>
<td>[7.00]</td>
<td>[10.31]</td>
<td>[4000lbf]</td>
<td>[17800N]</td>
<td>7.6:1</td>
<td>4.2:1</td>
</tr>
</tbody>
</table>

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

### Dimensions and Technical Information are subject to change without notice
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

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
<th>Accessories (Supplied)</th>
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</thead>
<tbody>
<tr>
<td>533-L</td>
<td>7000 N [1575 lbf]</td>
<td>120°</td>
<td>90°</td>
<td>1,00kg [2.20lbs]</td>
<td>533108-M</td>
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<tr>
<td>533-LB</td>
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<tr>
<td>535-LB</td>
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Dimensions and technical information are subject to change without notice.
### 533, 535 Series

**Heavy-Duty Vertical Hold Down Clamps | Dimensions**

#### 533-L
- **Flanged Base**
- **Solid Bar**

#### 535-L
- **Flanged Base**
- **Solid Bar**

<table>
<thead>
<tr>
<th>Model</th>
<th>A</th>
<th>A1</th>
<th>A3</th>
<th>A4</th>
<th>A8</th>
<th>B</th>
<th>B1</th>
<th>B2</th>
<th>B3</th>
<th>B4</th>
<th>B5</th>
<th>C</th>
<th>C1</th>
<th>C2</th>
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</thead>
<tbody>
<tr>
<td>533-L</td>
<td>[1.18]</td>
<td>30</td>
<td>[0.59]</td>
<td>[0.08]</td>
<td>[0.20]</td>
<td>[0.20]</td>
<td>51</td>
<td>1.52</td>
<td>38.6</td>
<td>0.39</td>
<td>[0.69]</td>
<td>[0.69]</td>
<td>15,5</td>
<td>44,5</td>
</tr>
<tr>
<td>533-LB</td>
<td>45</td>
<td>[2.95]</td>
<td>74,9</td>
<td></td>
<td></td>
<td></td>
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<td></td>
<td></td>
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<td></td>
<td></td>
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</tr>
<tr>
<td>535-L</td>
<td>[1.77]</td>
<td>45</td>
<td></td>
<td>[0.18]</td>
<td>[0.18]</td>
<td>4.6</td>
<td>1.89</td>
<td>11.9</td>
<td>0.47</td>
<td>[0.89]</td>
<td>22,6</td>
<td>[2.13]</td>
<td>54,1</td>
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</tr>
<tr>
<td>535-LB</td>
<td>[0.98]</td>
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<table>
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<th>C5</th>
<th>C6</th>
<th>C7</th>
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<th>D1</th>
<th>D2</th>
<th>D3</th>
<th>F1</th>
<th>H</th>
<th>H1</th>
<th>L</th>
<th>L1</th>
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<tbody>
<tr>
<td>533-L</td>
<td>--</td>
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<td>--</td>
<td>[2.24]</td>
<td>[0.33]</td>
<td>56.9</td>
<td>--</td>
<td>--</td>
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<td>[8.6]</td>
<td>218,4</td>
<td>--</td>
<td>[4.92]</td>
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<td>[0.39]</td>
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<td>[1.86]</td>
<td>[0.22]</td>
<td>55.1</td>
<td>[2.56]</td>
<td>[0.35]</td>
<td>8,9</td>
<td>[9.31]</td>
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<td>160</td>
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<td>--</td>
<td>[3.13]</td>
<td>[0.41]</td>
<td>[0.41]</td>
<td>[10.4]</td>
<td>0.39</td>
<td>[0.47]</td>
<td>[10.35]</td>
<td>262,9</td>
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<td>[11.26]</td>
<td>286</td>
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<tr>
<td>535-LB</td>
<td>[0.59]</td>
<td>15</td>
<td>[0.79]</td>
<td>[2.95]</td>
<td>[0.43]</td>
<td>[0.43]</td>
<td>10,9</td>
<td>[0.79]</td>
<td>[0.47]</td>
<td>[11.26]</td>
<td>286</td>
<td>--</td>
<td>[6.30]</td>
<td>160</td>
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</tbody>
</table>

Dimensions and technical information are subject to change without notice.
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-15

Technical Information

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>558</td>
<td>11100 N [2500 lbf]</td>
<td>192°</td>
<td>64°</td>
<td>2,27kg [5.0lbs]</td>
</tr>
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</table>

Holding Capacities | Dimensions

<table>
<thead>
<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>HC1</th>
<th>HC2</th>
</tr>
</thead>
<tbody>
<tr>
<td>558</td>
<td>65.8 [2.59]</td>
<td>76.2 [3.00]</td>
<td>2500 lbf</td>
<td>6680 N</td>
</tr>
<tr>
<td></td>
<td>11100 N</td>
<td>203,2</td>
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<td></td>
</tr>
</tbody>
</table>

Dimensions shown "mm [inch]", **HC** = Holding Capacity
91090 Series
Vertical Hold Down Clamps | Product Overview

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

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
<th>Bolt Retainer</th>
<th>Spindle Assembly</th>
<th>Flanged Washers</th>
</tr>
</thead>
<tbody>
<tr>
<td>91090</td>
<td>1710 N [385 lbf]</td>
<td>100°</td>
<td>60°</td>
<td>0.37kg [0.81lbs]</td>
<td>---</td>
<td>507208-M</td>
<td>507107</td>
</tr>
</tbody>
</table>

Recommended Accessories

Dimensions and technical information are subject to change without notice.

Dimensions and technical information are subject to change without notice.

Dimensions and technical information are subject to change without notice.

Dimensions and technical information are subject to change without notice.
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-19)
817-S Pneumatic Toggle Clamp
(See page MC-PTC-19)

317-U
U-Bar

317-S
Solid Bar

Technical Information

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
<th>Accessories (Supplied)</th>
</tr>
</thead>
<tbody>
<tr>
<td>317-U</td>
<td>1670 N [375 lbf]</td>
<td>185°</td>
<td>60°</td>
<td>0.34kg [0.75lbs]</td>
<td>---</td>
</tr>
<tr>
<td>317-S</td>
<td>1780 N [400 lbf]</td>
<td>207105</td>
<td>---</td>
<td>---</td>
<td></td>
</tr>
</tbody>
</table>

Holding Capacities

<table>
<thead>
<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>X2</th>
<th>Y</th>
<th>HC1</th>
<th>HC2</th>
<th>EF(X1):AF</th>
<th>EF(X2):AF</th>
</tr>
</thead>
<tbody>
<tr>
<td>317-U</td>
<td>[1.57]</td>
<td>50</td>
<td>95.3</td>
<td>[4.00]</td>
<td>1670 N</td>
<td>200lb.</td>
<td>17:1</td>
<td>8:1</td>
</tr>
<tr>
<td>317-S</td>
<td>40</td>
<td>63.5</td>
<td>127.0</td>
<td>101.6</td>
<td>1780 N</td>
<td>190lb.</td>
<td>13:1</td>
<td>5:1</td>
</tr>
</tbody>
</table>

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

Dimensions and technical information are subject to change without notice.
317 SERIES

Vertical Hold Down Clamps | Dimensions

317-U
U-Bar

317-S
Solid Bar

Dimensions and technical information are subject to change without notice
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

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>527</td>
<td>4450 N [1000 lbf]</td>
<td>195°</td>
<td>65°</td>
<td>1,13kg</td>
</tr>
<tr>
<td>527-F</td>
<td>[2.50lbf]</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

‡ This item is available upon request

Holding Capacities | Dimensions

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

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>7-101</td>
<td>2110 N [475 lbf]</td>
<td>80°</td>
<td>0.45kg [1.0lbs]</td>
</tr>
<tr>
<td>7-58</td>
<td>2670 N [600 lbf]</td>
<td>95°</td>
<td>0.91kg [2.0lbs]</td>
</tr>
<tr>
<td>7-59</td>
<td>4450 N [1000 lbf]</td>
<td>95°</td>
<td>1.36kg [3.0lbs]</td>
</tr>
<tr>
<td>7-60</td>
<td>7120 N [1600 lbf]</td>
<td>80°</td>
<td>2.27kg [5.0lbs]</td>
</tr>
</tbody>
</table>

### Dimensions and Technical Information

Dimensions and technical information are subject to change without notice.

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**Model** | **A** | **A1** | **A3** | **B** | **B1** | **C** | **C1** | **C2** | **C3** | **D** | **F1** | **H** | **L** | **L1** | **L2** | **S max.**
---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
7-101 | 0.75 | 0.25 | 0.25 | 1.25 | 1.25 | 1.75 | 1.44 | 0.50 | 0.31 | 1.00 | 0.22 | 0.50 | 0.50 | 5.00 | 4.62 | 3.12 | 0.13 |
7-58  | 1.00 | 0.34 | 0.34 | 1.69 | 1.62 | 2.25 | 1.87 | 0.56 | 0.38 | 1.12 | 0.28 | 0.50 | 0.50 | 6.93 | 4.62 | 2.55 | 3.3 |
7-59  | 1.38 | 0.39 | 0.39 | 2.06 | 2.06 | 2.50 | 2.19 | 0.63 | 0.44 | 1.25 | 0.34 | 0.63 | 0.63 | 8.50 | 6.60 | 3.45 | 1.24 |
7-60  | 1.62 | 0.44 | 0.44 | 2.44 | 2.12 | 2.88 | 2.50 | 0.88 | 0.50 | 1.44 | 0.41 | 0.75 | 0.75 | 9.44 | 7.38 | 1.97 | 0.25 |

---

**NOTE**: Dimensions and technical information are subject to change without notice.
**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 ½” accessories

**Applications:**
- Assembly & test
- Light machining
- Welding

**Also Available:**
See page MC-ACC-1 for accessories

---

229
Flanged Base
Open Bar

---

**Technical Information**

<table>
<thead>
<tr>
<th>Model</th>
<th>Max. Holding Capacity</th>
<th>Clamp Bar Opening (+10°)</th>
<th>Handle Opening (+10°)</th>
<th>Weight</th>
<th>Accessories (Supplied)</th>
</tr>
</thead>
</table>

**Holding Capacities**

<table>
<thead>
<tr>
<th>Model</th>
<th>X</th>
<th>X1</th>
<th>X2</th>
<th>Y</th>
<th>‡HC1</th>
<th>‡HC2</th>
<th>‡EF(X1):AF</th>
<th>‡EF(X2):AF</th>
</tr>
</thead>
<tbody>
<tr>
<td>229</td>
<td>[1.53]</td>
<td>[3.00]</td>
<td>[6.12]</td>
<td>[7.06]</td>
<td>[1000lbf.]</td>
<td>[500lbf.]</td>
<td>7:1</td>
<td>3:1</td>
</tr>
<tr>
<td></td>
<td>38.9</td>
<td>76.2</td>
<td>155.4</td>
<td>179.3</td>
<td>4450N</td>
<td>2230N</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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

Vertical Hold Down Clamps | Dimensions

Dimensions and technical information are subject to change without notice
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-44 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

505-MB
Swivel Base

505-MLB
Long Base

505-MBLSC
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

503-MLBLSC
Long Base with Locking Spring Clip

Model 505-MLB in a robotic welding fixture

This item is available upon request

Dimensions and technical information are subject to change without notice
### Model | Max. Holding Capacity | Clamp Bar Opening (+10°) | Weight | 
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>501-B</td>
<td>2000 N [450 lbf]</td>
<td>200°</td>
<td>0.18kg [0.40lbs]</td>
</tr>
<tr>
<td>501-LB</td>
<td></td>
<td></td>
<td>0.20kg [0.44lbs]</td>
</tr>
<tr>
<td>503-MB</td>
<td>7000 N [1575 lbf]</td>
<td></td>
<td>0.80kg [1.76lbs]</td>
</tr>
<tr>
<td>503-MLB</td>
<td></td>
<td></td>
<td>0.70kg [1.54lbs]</td>
</tr>
<tr>
<td>503-MBLSC</td>
<td></td>
<td></td>
<td>1.00kg [2.20lbs]</td>
</tr>
<tr>
<td>503-MLBLSC</td>
<td></td>
<td></td>
<td>0.90kg [1.98lbs]</td>
</tr>
<tr>
<td>505-MB</td>
<td>11000 N [2475 lbf]</td>
<td>200°</td>
<td>1.40kg [3.09lbs]</td>
</tr>
<tr>
<td>505-MLB</td>
<td></td>
<td></td>
<td>1.50kg [3.31lbs]</td>
</tr>
<tr>
<td>505-MBLSC</td>
<td></td>
<td></td>
<td>1.60kg [3.53lbs]</td>
</tr>
<tr>
<td>505-MLBLSC</td>
<td></td>
<td></td>
<td>2.60kg [5.73lbs]</td>
</tr>
<tr>
<td>506-MB</td>
<td>22500 N [5060 lbf]</td>
<td>200°</td>
<td>2.80kg [6.17lbs]</td>
</tr>
<tr>
<td>506-MLB</td>
<td></td>
<td></td>
<td>3.00kg [6.61lbs]</td>
</tr>
<tr>
<td>506-MBLSC</td>
<td></td>
<td></td>
<td>3.00kg [6.61lbs]</td>
</tr>
</tbody>
</table>

---

**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.

---

**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
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/-MLBLSC

### Swivel Base Dimensions

<table>
<thead>
<tr>
<th>Model</th>
<th>A</th>
<th>A1</th>
<th>A2</th>
<th>B</th>
<th>B1</th>
<th>B3</th>
<th>ØD</th>
<th>ØD1</th>
<th>H</th>
<th>H1</th>
<th>H3</th>
<th>R</th>
</tr>
</thead>
<tbody>
<tr>
<td>501-B①</td>
<td>28.6</td>
<td>14.3</td>
<td>19.1</td>
<td>0.79</td>
<td>20.0</td>
<td>0.25</td>
<td>6.4</td>
<td>0.50</td>
<td>27.8</td>
<td>0.9</td>
<td>4.8</td>
<td>1.12</td>
</tr>
<tr>
<td>503-MB</td>
<td>39.2</td>
<td>12.8</td>
<td>28.5</td>
<td>0.79</td>
<td>38.5</td>
<td>0.39</td>
<td>46.2</td>
<td>0.31</td>
<td>17.5</td>
<td>0.96</td>
<td>44.9</td>
<td>2.21</td>
</tr>
<tr>
<td>503-MBLSC①</td>
<td>56.5</td>
<td>25.9</td>
<td>12.3</td>
<td>0.48</td>
<td>58.6</td>
<td>0.37</td>
<td>22.2</td>
<td>0.87</td>
<td>70.8</td>
<td>4.33</td>
<td>49.8</td>
<td>4.43</td>
</tr>
<tr>
<td>505-MB</td>
<td>2.22</td>
<td>1.02</td>
<td>1.38</td>
<td>1.89</td>
<td>48</td>
<td>0.48</td>
<td>58.6</td>
<td>9.5</td>
<td>22.2</td>
<td>70.8</td>
<td>1.10</td>
<td>110.1</td>
</tr>
<tr>
<td>505-MBLSC①</td>
<td>2.82</td>
<td>1.27</td>
<td>1.97</td>
<td>1.91</td>
<td>48</td>
<td>0.63</td>
<td>22.3</td>
<td>0.94</td>
<td>32.8</td>
<td>5.30</td>
<td>134.6</td>
<td>21.4</td>
</tr>
</tbody>
</table>

### Long Base Dimensions

<table>
<thead>
<tr>
<th>Model</th>
<th>A</th>
<th>A1</th>
<th>A2</th>
<th>B</th>
<th>B1</th>
<th>B3</th>
<th>ØD</th>
<th>ØD1</th>
<th>H</th>
<th>H1</th>
<th>H3</th>
<th>R</th>
</tr>
</thead>
<tbody>
<tr>
<td>501-LB①</td>
<td>28.6</td>
<td>14.3</td>
<td>19.1</td>
<td>0.79</td>
<td>20.0</td>
<td>0.25</td>
<td>6.4</td>
<td>0.50</td>
<td>27.8</td>
<td>0.9</td>
<td>4.8</td>
<td>1.12</td>
</tr>
<tr>
<td>503-MB</td>
<td>39.2</td>
<td>12.8</td>
<td>28.5</td>
<td>0.79</td>
<td>38.5</td>
<td>0.39</td>
<td>46.2</td>
<td>0.31</td>
<td>17.5</td>
<td>0.96</td>
<td>44.9</td>
<td>2.21</td>
</tr>
<tr>
<td>503-MBLSC①</td>
<td>56.5</td>
<td>25.9</td>
<td>12.3</td>
<td>0.48</td>
<td>58.6</td>
<td>0.37</td>
<td>22.2</td>
<td>0.87</td>
<td>70.8</td>
<td>4.33</td>
<td>49.8</td>
<td>4.43</td>
</tr>
<tr>
<td>505-MB</td>
<td>2.22</td>
<td>1.02</td>
<td>1.38</td>
<td>1.89</td>
<td>48</td>
<td>0.48</td>
<td>58.6</td>
<td>9.5</td>
<td>22.2</td>
<td>70.8</td>
<td>1.10</td>
<td>110.1</td>
</tr>
<tr>
<td>505-MBLSC①</td>
<td>2.82</td>
<td>1.27</td>
<td>1.97</td>
<td>1.91</td>
<td>48</td>
<td>0.63</td>
<td>22.3</td>
<td>0.94</td>
<td>32.8</td>
<td>5.30</td>
<td>134.6</td>
<td>21.4</td>
</tr>
</tbody>
</table>

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# 500 SERIES

**Weldable Vertical Hold Down Clamps | Accessories**

## 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-41 for clamp linkage

---

### Use with Part No.

<table>
<thead>
<tr>
<th>Handle</th>
<th>Clamping Bar</th>
<th>Base Plate</th>
</tr>
</thead>
<tbody>
<tr>
<td>ØD1</td>
<td>H1</td>
<td>C1</td>
</tr>
<tr>
<td>501503</td>
<td>6x10</td>
<td>61</td>
</tr>
<tr>
<td>501501</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>503502</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>503503-L</td>
<td>Ø18</td>
<td>129.5</td>
</tr>
<tr>
<td>503501</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>503502</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>505503-L</td>
<td>Ø22</td>
<td>159</td>
</tr>
<tr>
<td>505501</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>505502</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>506503-L</td>
<td>Ø28</td>
<td>188</td>
</tr>
<tr>
<td>506501</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>506502</td>
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</tr>
</tbody>
</table>

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

Dimensions and technical information are subject to change without notice