PRODUCTS FOR ROTATIONAL MOLDERS

NEW

Product Catalog

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THE BEST PRODUCTS. UNMATCHED SERVICE. WORLDWIDE

With a support network spanning the globe, DE-STA-CO offers consistent, comprehensive service to any location in the world. Whether your operations are localized or span multiple continents, you will always have access to the highest levels of customer service and technical support.

Since our founding in 1915, DE-STA-CO continues to provide innovative workholding and automation solutions. We are honored to work alongside our global customers to achieve our key mission, which encompasses:

- Providing world-class service and operational excellence
- Increasing customer productivity through customized solutions
- Developing products to meet unique application needs
- Consistency in our on-time delivery promise
- Ensuring top value throughout our product catalog

DE-STA-CO provides productivity solutions to a diverse range of market segments

- Aerospace
- Automotive/transportation
- Consumer products
- Food and packaging
- Plastic injection molding
- Medical
- Defense
- Nuclear
- Life Science
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<th>Page</th>
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</thead>
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<td>15</td>
</tr>
</tbody>
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DE-STA-CO’s HMC-100 Rotomold Clamp

Designed to Hold – Fast and True

This Rotomold Clamp represents the next generation in parting line clamping of aluminum molds. Designed and developed by experts in mold making industry this innovative product brings several valuable advantages to both the mold builder and the molder.

- Rapid action, easy to lock and unlock for faster cycle times
- Less framework required for cost and weight savings
- True parting line clamping eliminates distortion of the mold flange
- Adjustable yet constant clamping force
- Integrated design features for fast and easy mold separation
- Heavy-Duty cast iron construction

Old clamping method

Clamping method with DE-STA-CO Rotomolding clamps
Weight: 1.27kg [2.8lb.]

Min: 20 mm
Max: 40 mm

M8x1.25 or Ø9.0 THRU
DE-STA-CO’s newest addition to the rotomolding family of products. The 604 series of retractable insert holders are designed to **save molders time and money** when loading and unloading inserts into their molds. The inserts is placed directly on the retaining pin and is **precisely** and **securely** held in place during the molding process thanks to the toggle-locking action. Once the part is ready for de-molding, the handle of the locator is opened to **rapidly retract** the retaining pin for **worry free** extraction.

- **Quick** and **easy** method for placing inserts in rotational molds
- Fully retracts for **fast de-molding**
- **Four** sizes available – for insert sizes M4, M5, M6, and M8
- **Easily mounted** via a ring welded to the mold
- Handle may be **adjusted** to any radial position
- **Toggle locking** device for **secure positioning** of the insert
- **Fully supported** shaft for **smooth** and **reliable** operation
- Features a full **28 mm** [1.50 in.] of stroke
- **Optimal Heattransfer**
## 604 Series Retractable Insert Holder

<table>
<thead>
<tr>
<th>Model</th>
<th>B2</th>
<th>C1</th>
<th>L1</th>
<th>L2</th>
<th>L3</th>
<th>L4</th>
<th>L5</th>
<th>L6</th>
<th>L7</th>
<th>H</th>
<th>M</th>
<th>SW</th>
</tr>
</thead>
<tbody>
<tr>
<td>604-MM-501-M4</td>
<td>33</td>
<td>15</td>
<td>128,9</td>
<td>111,2</td>
<td>76,2</td>
<td>58,8</td>
<td>50</td>
<td>32</td>
<td>6</td>
<td>106</td>
<td>M4</td>
<td>30</td>
</tr>
<tr>
<td>604-MM-501-M5</td>
<td>33</td>
<td>15</td>
<td>128,9</td>
<td>111,2</td>
<td>76,2</td>
<td>58,8</td>
<td>50</td>
<td>32</td>
<td>6</td>
<td>106</td>
<td>M5</td>
<td>30</td>
</tr>
<tr>
<td>604-MM-501-M6</td>
<td>33</td>
<td>15</td>
<td>128,9</td>
<td>111,2</td>
<td>76,2</td>
<td>58,8</td>
<td>50</td>
<td>32</td>
<td>6</td>
<td>106</td>
<td>M6</td>
<td>30</td>
</tr>
<tr>
<td>604-MM-501-M8</td>
<td>33</td>
<td>15</td>
<td>128,9</td>
<td>111,2</td>
<td>76,2</td>
<td>58,8</td>
<td>50</td>
<td>32</td>
<td>6</td>
<td>106</td>
<td>M8</td>
<td>30</td>
</tr>
</tbody>
</table>

**On request:**

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Dimensions and technical information are subject to change without notice.
**Horizontal Hold-Down Action Clamps**

**Models 217-201, 227-201, 237-201, 245-200**

These clamps are ideal for closing fill-ports, but because of their low-profile design they can be used in applications where overhead clearance is an issue. These models offer a combination of safety design and a patented bar guide feature. The bar guide gives extra lateral support and rigidity to the hold-down bar at the front of the base. The units are designed to give more hand clearance between the bar and handle when the clamps are in the full open position. The 1/8" hole drilled into the base of the clamp and the bar is supplied to accept a cotter pin, which secures the clamp in the closed position during the molding process. Clamps are not supplied with grips.

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Material</th>
<th>Holding Capacity</th>
<th>Weight</th>
<th>Handle Moves</th>
<th>Bar Opens</th>
<th>Dimensions</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>A</td>
<td>B</td>
</tr>
<tr>
<td>217-201</td>
<td>Carbon</td>
<td>890 N 200 lbs.</td>
<td>0.18 kg</td>
<td>76°</td>
<td>92°</td>
<td>50.0</td>
</tr>
<tr>
<td>227-201</td>
<td>Carbon</td>
<td>2224 N 500 lbs.</td>
<td>0.31 kg</td>
<td>62°</td>
<td>92°</td>
<td>60.7</td>
</tr>
<tr>
<td>237-201</td>
<td>Carbon</td>
<td>3336 N 750 lbs.</td>
<td>0.73 kg</td>
<td>63°</td>
<td>92°</td>
<td>79.0</td>
</tr>
<tr>
<td>245-200</td>
<td>Carbon</td>
<td>4448 N 1000 lbs.</td>
<td>1.31 kg</td>
<td>67°</td>
<td>105°</td>
<td>110.5</td>
</tr>
</tbody>
</table>

Dimensions and technical information are subject to change without notice.

CLAMPING TECHNOLOGY

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Vertical Hold Down Clamps

Vertical Hold-Down Clamps Series 207-LR

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.

- 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

---

Accessories (Supplied)

<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>207-LR</td>
<td>1670 N [375 lbf]</td>
<td>99°</td>
<td>57°</td>
<td>0.45kg [1.00lb]</td>
<td>207105</td>
<td>---</td>
<td>---</td>
</tr>
</tbody>
</table>

Dimensions and technical information are subject to change without notice.

destaco.com
Vertical Hold-Down Clamps Series 207, 210, 247

The vertical hold-down clamps offered by DE-STA-CO are the popular choice for work-holding solutions in a variety of rotational molding applications. You will find these clamps functional and flexible, and the appropriate choice to hold core pins, close fill-ports, or secure sections of multi-piece molds. Clamps for the rotational molding market are supplied without a grip. A 1/8" hole is drilled into the clamp arm for accepting a standard cotter pin, which is used to secure the clamp in the closed position during the rotation cycle of the mold. Two different base options – flanged or straight base – allow these clamps to be welded or bolted to the mold frame. Clamp Series 207 and 210 are available in stainless steel to prevent corrosion during the cool down process.

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Material</th>
<th>Holding Capacity</th>
<th>Weight</th>
<th>Handle Moves</th>
<th>Bar Opens</th>
<th>Dimensions</th>
</tr>
</thead>
<tbody>
<tr>
<td>207-201</td>
<td>Carbon</td>
<td>1670 N</td>
<td>0.30 kg</td>
<td>57°</td>
<td>99°</td>
<td>169.9</td>
</tr>
<tr>
<td>207-202</td>
<td>Carbon</td>
<td>1670 N</td>
<td>0.30 kg</td>
<td>57°</td>
<td>99°</td>
<td>171.5</td>
</tr>
<tr>
<td>207-203</td>
<td>Stainless Steel</td>
<td>2000 N</td>
<td>0.30 kg</td>
<td>57°</td>
<td>99°</td>
<td>139.7</td>
</tr>
<tr>
<td>207-204</td>
<td>Stainless Steel</td>
<td>3340 N</td>
<td>0.58 kg</td>
<td>59°</td>
<td>106°</td>
<td>195.6</td>
</tr>
<tr>
<td>207-81</td>
<td>Stainless Steel</td>
<td>2000 N</td>
<td>0.30 kg</td>
<td>57°</td>
<td>99°</td>
<td>141.5</td>
</tr>
<tr>
<td>210-203</td>
<td>Carbon</td>
<td>2670 N</td>
<td>0.58 kg</td>
<td>59°</td>
<td>106°</td>
<td>203.7</td>
</tr>
<tr>
<td>210-204</td>
<td>Stainless Steel</td>
<td>3340 N</td>
<td>0.58 kg</td>
<td>59°</td>
<td>106°</td>
<td>195.6</td>
</tr>
<tr>
<td>247-200</td>
<td>Carbon</td>
<td>4450 N</td>
<td>1.07 kg</td>
<td>67°</td>
<td>122°</td>
<td>218.9</td>
</tr>
</tbody>
</table>

Dimensions and technical information are subject to change without notice.
DE-STA-CO clamp Series 301 and 311 are the most widely used clamps in the molding industry. You will find these clamps being used to clamp mold halves together once the mold is closed. A fixed stop automatically limits handle travel at various clamping positions once the clamp is installed, removing the need to adjust a manual stop. Series 301 and 311 have either a flanged base or a straight base allowing for more mounting flexibility. These clamps are available in cold-rolled steel or stainless steel. Due to the high temperatures of the molding process these clamps are not supplied with grips.
**Straight Line Action Clamps 602-204, 604-203, 624-204**

With fully retractable locators, these models are ideal for locating or holding in place small mold components where traditional hold-down clamps will not work. These clamps are mounted directly through a member by a jam nut on the work side, or flush by drilling and tapping the member. Models 602, 604, and 624 all lock in both the extended and retracted positions. Clamps are manufactured without grips.

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Material</th>
<th>Holding Capacity</th>
<th>Weight</th>
<th>Plunger Travel</th>
<th>Plunger Thread</th>
<th>Dimensions</th>
</tr>
</thead>
<tbody>
<tr>
<td>602-204</td>
<td>Carbon</td>
<td>900 N</td>
<td>0.11 kg</td>
<td>19</td>
<td>1/4-20</td>
<td>75.7 62.0 12.7 26.2 9.7 20.6 5/8-18 6.4 22.4</td>
</tr>
<tr>
<td></td>
<td></td>
<td>200 lbs</td>
<td>.25 lbs</td>
<td>.75&quot;</td>
<td></td>
<td>2.98 2.44 0.5 1.03 0.38 0.81 0.25 0.88</td>
</tr>
<tr>
<td>604-203</td>
<td>Carbon</td>
<td>1330 N</td>
<td>0.20 kg</td>
<td>38</td>
<td>5/16-18</td>
<td>101.6 116.1 16.0 33.0 11.2 39.6 3/4-16 6.4 25.4</td>
</tr>
<tr>
<td></td>
<td></td>
<td>300 lbs</td>
<td>.44 lbs</td>
<td>1.50&quot;</td>
<td></td>
<td>4 4.57 0.63 1.3 0.44 1.56 0.25 1</td>
</tr>
<tr>
<td>624-204</td>
<td>Carbon</td>
<td>3110 N</td>
<td>0.74 kg</td>
<td>66</td>
<td>3/8-16</td>
<td>139.2 169.9 22.4 46.0 16.0 69.9 1.00-14 6.4 38.1</td>
</tr>
<tr>
<td></td>
<td></td>
<td>700 lbs</td>
<td>1.63 lbs</td>
<td>2.63&quot;</td>
<td></td>
<td>5.48 6.69 0.88 1.81 0.63 2.75 0.25 1.5</td>
</tr>
</tbody>
</table>

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**Optional Mounting Plate**

Dimensions and technical information are subject to change without notice.
Model 385-29, the largest latch clamp in DE-STA-CO’s product line, offers a holding capacity up to 3.3kN [7500lb.]. These clamps are manufactured with a stainless steel hook pin to prevent any binding caused by the harsh environments of rotational molding. The stop on the base is machined an extra 0.13mm [0.005in.] to allow for more of an over-center toggle lock, guaranteeing that the clamp will not open during the rotation cycles of a rotomolding application. A thumbcontrol release lever is supplied with the clamp – allowing the operator to remove the U-hook from the mold with the same hand being used to operate the clamp. The optional latch plate 375509 eliminates the need for fabricating a latching mechanism on the other half of the mold or frame.
Parting Line Clamps Models 353-35, 353-65

These robust, heavy-duty cast clamps are designed to withstand the harshest environments of the rotational mold industry. They are ideal clamps for clamping directly on the parting lines of CNC machined molds. The cast clamps are available in carbon or stainless steel materials. The clamps utilize two stainless steel pivot pins to help eliminate binding at the pivot points. The curved radius on the mounting flange and keeper plate allows the clamp to fit snugly along the radius of the parting line. The ergonomic handle provides greater operator comfort by reducing the stress on the operator’s hands. Models 353-35 and 353-65 are black oxidized to help reduce corrosion. The clamps are supplied with a tapered M10X1.5 hex head bolt assembly and keeper plate.

<table>
<thead>
<tr>
<th>Model No</th>
<th>Max. Mechanical Advantage (M.A.)</th>
<th>Holding Capacity</th>
<th>Weight</th>
<th>Dimensions</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>A</td>
<td>B</td>
</tr>
<tr>
<td>353-35</td>
<td>23:1</td>
<td>12460 N</td>
<td>0.95 kg</td>
<td>232.4</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2800 lbs</td>
<td>2.1 lbs</td>
<td>9.15</td>
</tr>
<tr>
<td>353-65</td>
<td>27:1</td>
<td>9350 N</td>
<td>1.04 kg</td>
<td>262.4</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2100 lbs</td>
<td>2.3 lbs</td>
<td>10.33</td>
</tr>
</tbody>
</table>

Dimensions and technical information are subject to change without notice.
Automation power clamps for high temperatures, enclosed design Model 991-MRM

**Application:**
Clamping, holding, gripping and positioning of components and tools.

**Key areas of application:**
The power clamp is designed for applications at permanent ambient temperatures of 260 °C and briefly (up to 10 minutes) at ambient temperatures of 370 °C.

**Features:**
- dirt-resistant
- compact, enclosed design in a steel body
- 2 lateral mounting areas
- toggle action mechanism
- cylinder with temperature-resistant polymer seals
- integrated lubricating nipples for greasing the mechanical parts from the outside
- use of temperature-resistant grease

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Clamping position</th>
<th>Standard opening angle</th>
<th>Driven shaft for clamping arm variants</th>
<th>Max. holding torque [Nm]</th>
<th>Clamping torque at 6 bar [Nm]</th>
<th>Cylinder Ø [mm]</th>
<th>Weight ~ [kg]</th>
</tr>
</thead>
<tbody>
<tr>
<td>991-MRM</td>
<td>horizontal</td>
<td>118°</td>
<td>lateral and U-central</td>
<td>1250</td>
<td>390</td>
<td>63</td>
<td>8,3</td>
</tr>
</tbody>
</table>

**Spare parts**
- Cylinder: 893132M-ET
- Seal kit: 8930100-ET

**Zubehörteile für 991-MRM**
<table>
<thead>
<tr>
<th>Clamping arm</th>
<th>Clamping position</th>
<th>Order no. for set 991-MRM</th>
</tr>
</thead>
<tbody>
<tr>
<td>Clamping arm variant</td>
<td>Clamping position</td>
<td>8JG-069-1-01</td>
</tr>
<tr>
<td>U-central</td>
<td>horizontal</td>
<td>8JG-069-1-01</td>
</tr>
<tr>
<td>lateral</td>
<td>horizontal</td>
<td>8JG-070-1-01</td>
</tr>
<tr>
<td>Fett</td>
<td>auf Anfrage</td>
<td></td>
</tr>
</tbody>
</table>
The power clamp is designed for applications at permanent ambient temperatures of 260 °C and briefly (up to 10 minutes) at ambient temperatures of 370 °C.

If the power clamp is used in high-temperature environments, apply temperature-resistant grease once every month. Use the lubricating nipples that belong to the standard scope of delivery.

Technical data: **991-MRM**

<table>
<thead>
<tr>
<th>Model No.</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>D1</th>
<th>E</th>
<th>F</th>
<th>G</th>
<th>H</th>
<th>I</th>
<th>J</th>
<th>J1</th>
<th>K</th>
<th>L</th>
<th>M</th>
<th>N</th>
<th>O</th>
<th>P</th>
<th>U</th>
<th>V</th>
<th>W</th>
<th>Y</th>
<th>Y1</th>
</tr>
</thead>
<tbody>
<tr>
<td>991-MRM</td>
<td>G3/8</td>
<td>86</td>
<td>376</td>
<td>35</td>
<td>17,5</td>
<td>123</td>
<td>76,2</td>
<td>–</td>
<td>76</td>
<td>–</td>
<td>9,5</td>
<td>10,3</td>
<td>19</td>
<td>10</td>
<td>71</td>
<td>43</td>
<td>183</td>
<td>104</td>
<td>65</td>
<td>70</td>
<td>–</td>
<td>–</td>
<td>–</td>
</tr>
</tbody>
</table>
Workholding

• Widest variety of workholding products
• High durability and reliability
• Flexible solutions for all applications
• Custom products for unique requirements

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GLOBAL LOCATIONS

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Germany
Phone: +49-6171-705-0
Customer Service: europe@destaco.com

France
Phone: +33-1-3996-5000
Customer Service: france@destaco.com

UK
Phone: +44-1902-797980
Customer Service: uk@destaco.com

Spain
Phone: +34-936361680
Customer Service: spain@destaco.com

Benelux
Phone: +31-297285332
Customer Service: benelux@destaco.com

ASIA

Thailand
Phone: +66-2-326-0812
Customer Service: info@destaco.com

China
Phone: +86-21-2411 2600
Customer Service: china@destaco.com

India
Phone: +91-80-41123421-426
Customer Service: india@destaco.com

NORTH AMERICA

DE-STA-CO Headquarters
Auburn Hills, Michigan
Phone: 1.248.836.6700
Toll Free: 1.888.DESTACO
Marketing: marketing@destaco.com
Customer Service: customerservice@destaco.com

Charlevoix, Michigan
Phone: 1.888.DESTACO
Customer Service: customerservice@destaco.com

Wheeling, Illinois
Phone: 1.800.645.5207
Customer Service: camco@destaco.com

Red Wing, MN (Central Research Laboratories)
Phone: 651.385.2142
Customer Service: sales@centres.com

SOUTH AMERICA

Brazil
Phone: 0800-124070
Customer Service: samerica@destaco.com

DE-STA-CO Europe GmbH
Hiroshimastraße 2
61440 Oberursel
Germany
Phone: +49 6171 705-0
Fax: +49 6171 705-120
Email: europe@destaco.com
www.destaco.com