

PRODUCTS FOR ROTATIONAL MOLDERS

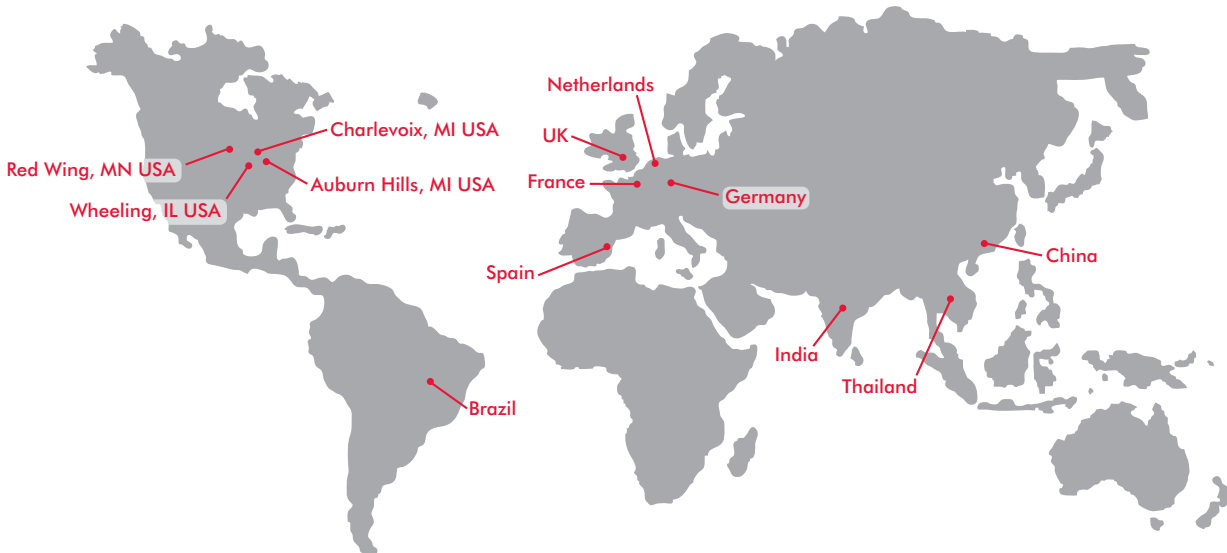


Product Catalog

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A DOVER COMPANY



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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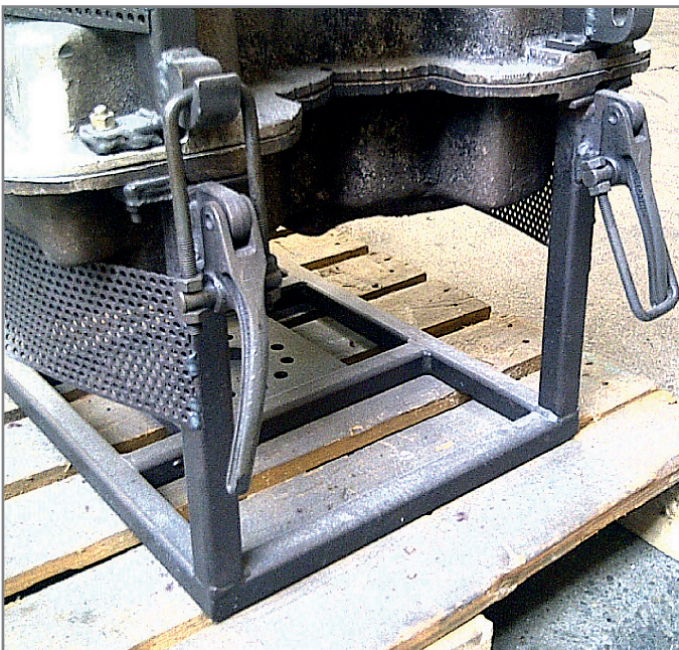
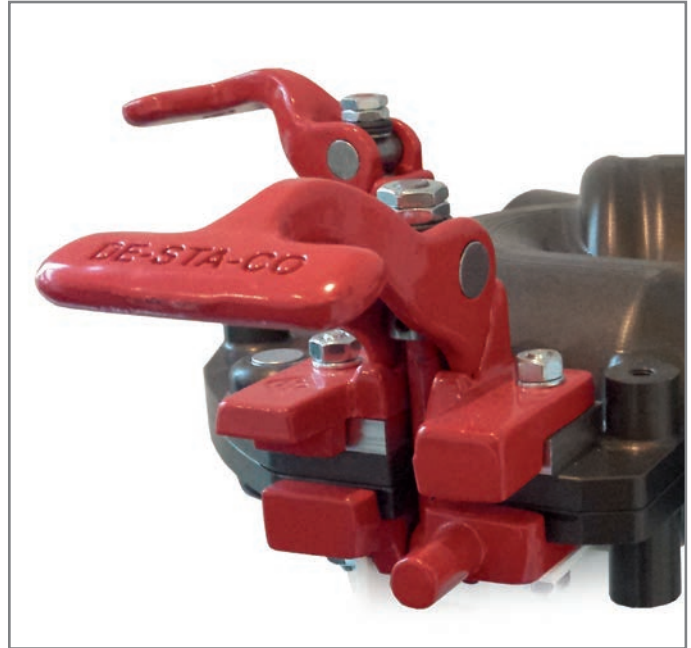
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DE-STA-CO's HMC-100 Rotomold Clamp

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



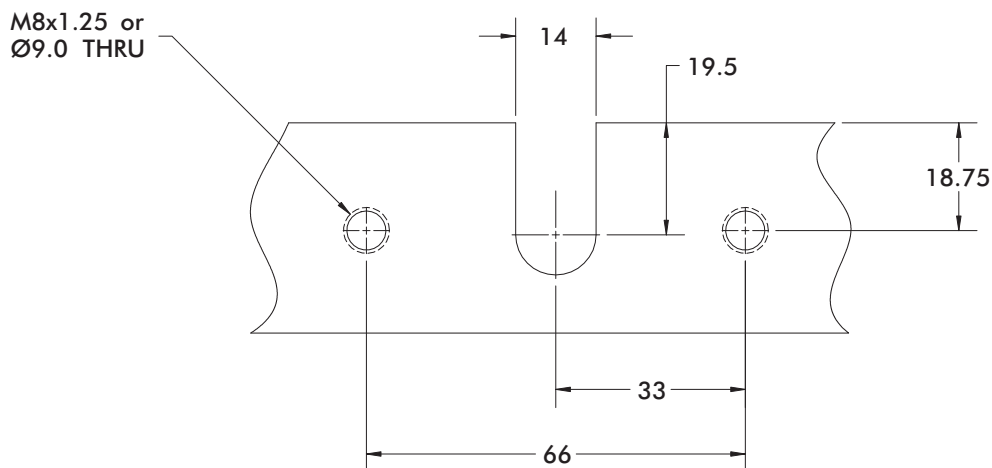
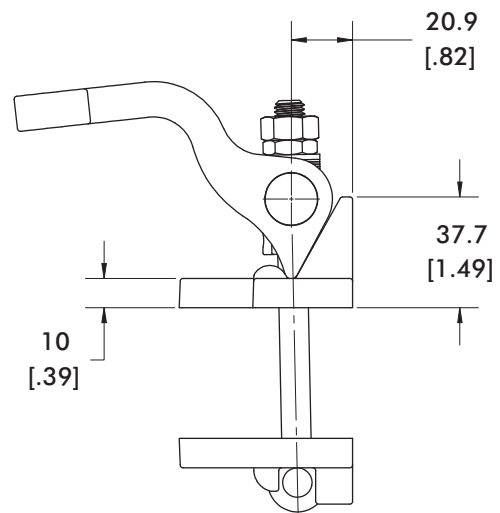
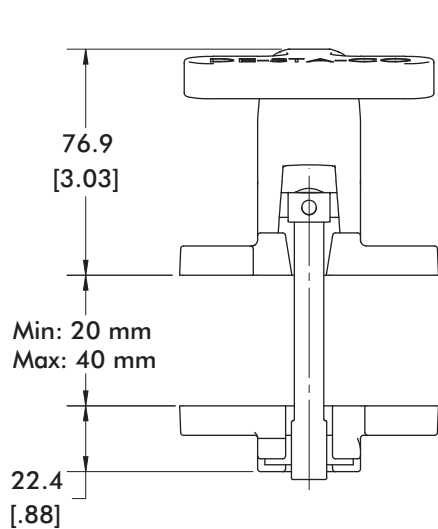
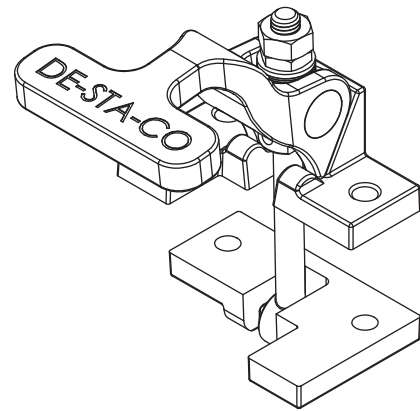
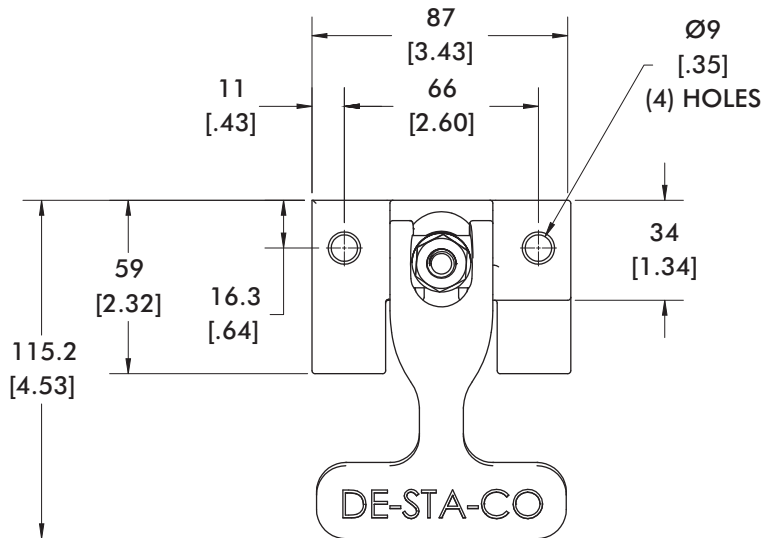
Old clamping method



Clamping method with DE-STA-CO Rotomolding clamps

Series HMC-100 Standard Dimensions

Weight: 1.27kg [2.8lb.]



NEW

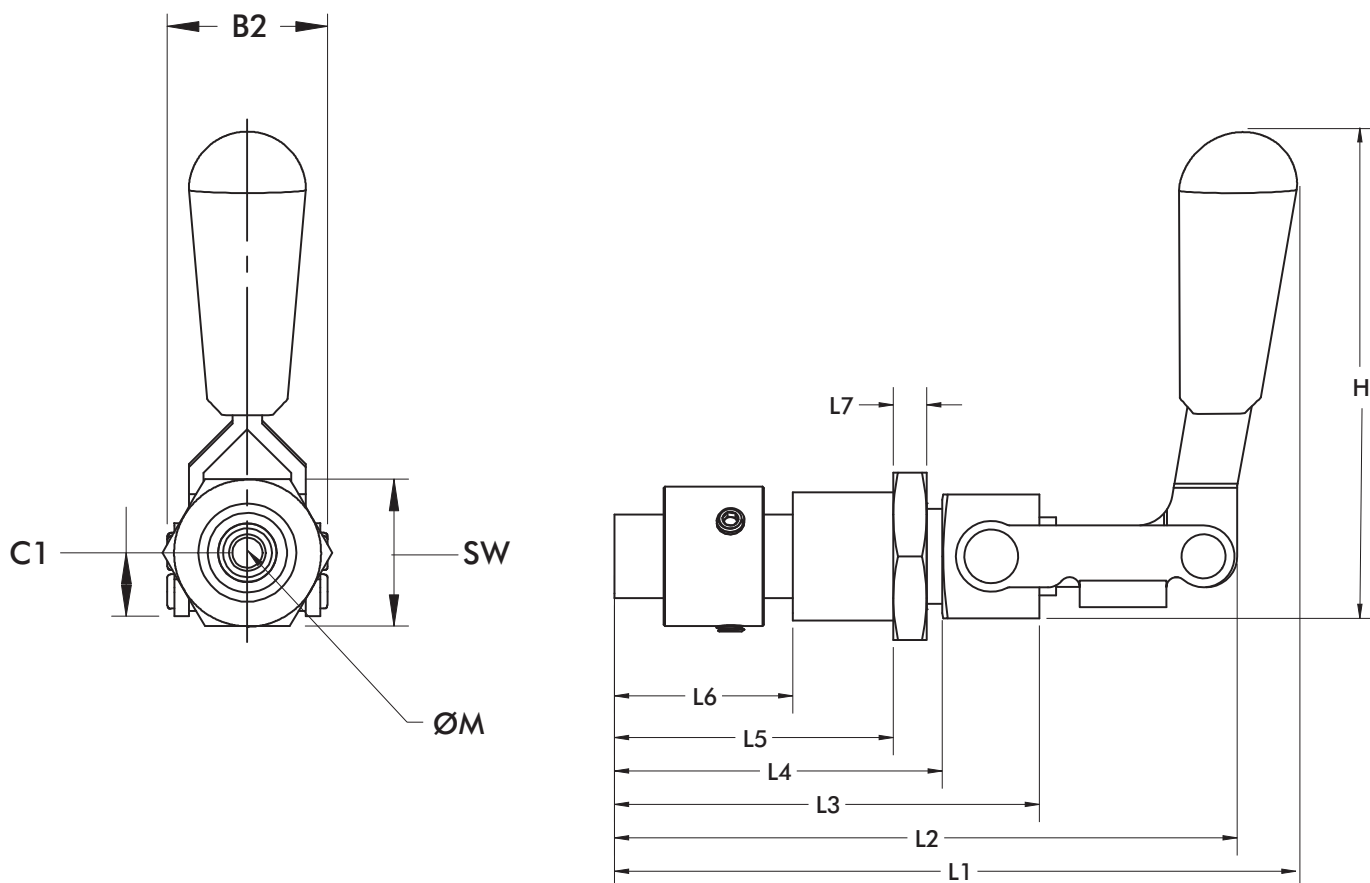


DE-STA-CO's newest addition to the rotomolding family of products. The 604 series of retractable insert holders are designed to **save molders time and money** when loading and unloading inserts into their molds. The inserts is placed directly on the retaining pin and is **precisely** and **securely** 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**



Insert in finish product



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

On request:



Horizontal Hold-Down Action Clamps
Models 217-201, 227-201, 237-201, 245-200



217-201



227-201



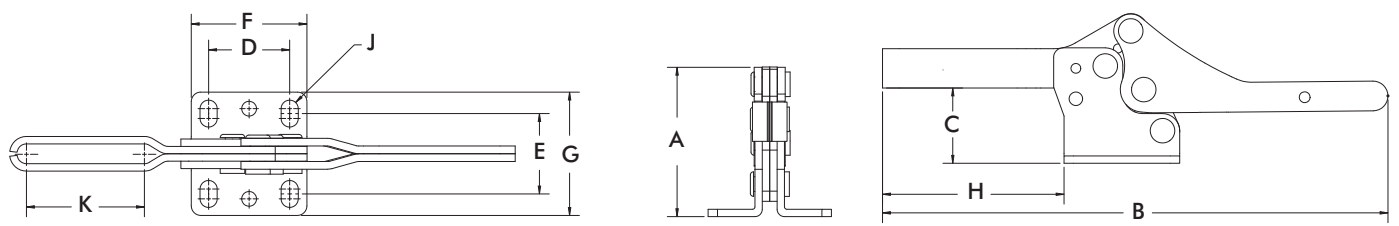
237-201



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.

Model No.	Material	Holding Capacity	Weight	Handle Moves	Bar Opens	Dimensions									
						A	B	C	D	E	F	G	H	J	K
217-201	Carbon	890 N	0.18 kg	76°	92°	50,0	160,0	24,6	26,2	29,2	37,3	39,9	58,9	5,6	38,1
		200 lbs.	.40 lbs.			1,97	6,3	0,97	1,03	1,15	1,47	1,57	2,32	0,22	1,50
227-201	Carbon	2224 N	0.31 kg	62°	92°	60,7	183,9	33,3	26,2		39,6	43,7	68,1	6,9	38,1
		500 lbs.	.68 lbs.			2,39	7,24	1,31	1,03	1,23	1,56	1,72	2,68	0,27	1,50
237-201	Carbon	3336 N	0.73 kg	63°	92°	79,0	268,5	45,0	41,4	42,9	57,2	57,2	103,4	8,6	69,9
		750 lbs.	1.6 lbs.			3,11	10,57	1,77	1,63	1,69	2,25	2,25	4,07	0,34	2,75
245-200	Carbon	4448 N	1.31 kg	67°	105°	110,5	311,2	58,7	41,4	41,4	66,8	66,8	124,0	8,4	77,0
		1000 lbs.	2.9 lbs.			4,35	12,25	2,31	1,63	1,63	2,63	2,63	4,88	0,33	3,03



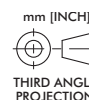
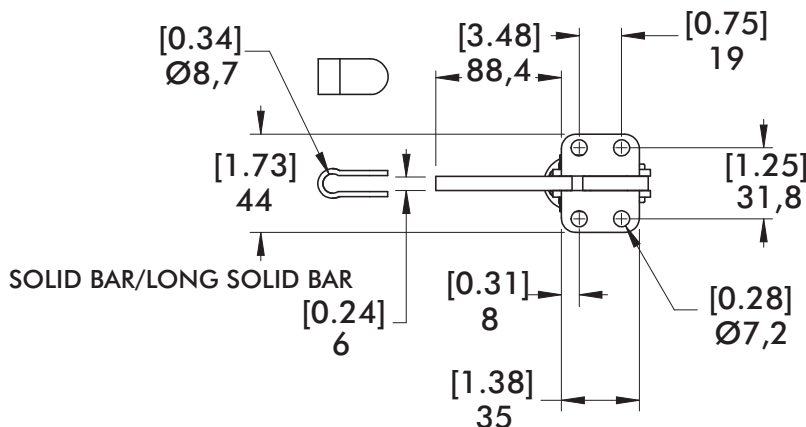
Vertical Hold-Down Clamps Series 207-LR

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



207-LR
Flanged Base
Long Solid Bar
with DE-STA-CO®
Toggle Lock Plus



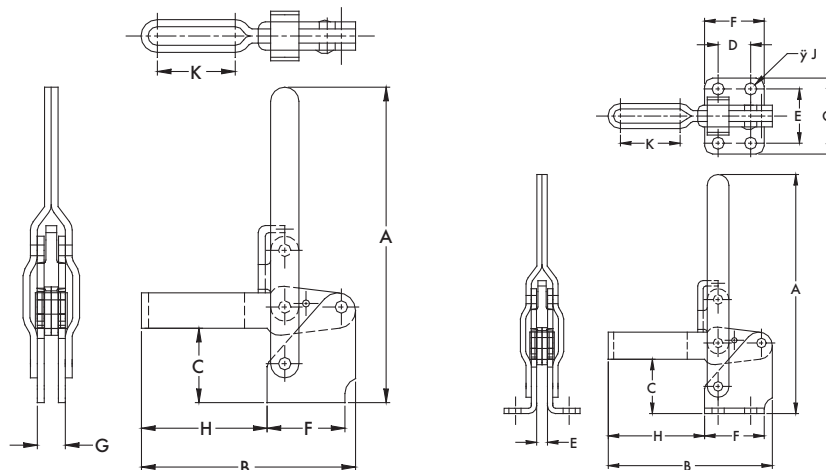
Model	Max. Holding Capacity	Clamp Bar Opening (+10°)	Handle Opening (+10°)	Weight	Accessories (Supplied)		
					Bolt Retainer	Spindle Assembly	Flanged Washers
207-LR	1670 N [375 lbf]	99°	57°	0,45kg [1.00lb]	207105	---	---

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.

Model No.	Material	Holding Capacity	Weight	Handle Moves	Bar Opens	Dimensions									
						A	B	C	D	E	F	G	H	J	K
207-201	Carbon	1670 N	0.30 kg	57°	99°	169,9	93,5	31,8	19,1	31,8	35,1	44,5	50,8	7,1	33,0
		375 lbs.	.67 lbs.			6,69	3,68	1,25	0,75	1,25	1,38	1,75	2	0,28	1,30
207-202	Carbon	1670 N	0.30 kg	57°	99°	171,5	93,5	33,3	-	-	35,1	12,7	50,8	-	33,0
		375 lbs.	.67 lbs.			6,75	3,68	1,31	-	-	1,38	0,5	2	-	1,30
207-203	Stainless Steel	2000 N	0.30 kg	57°	99°	139,7	112,0	31,8	19,1	31,8	35,1	44,5	72,4	7,1	52,6
		450 lbs.	.67 lbs.			5,5	4,41	1,25	0,75	1,25	1,38	1,75	2,85	0,28	2,07
207-81	Stainless Steel	2000 N	0.30 kg	57°	99°	141,5	112,0	33,3	-	-	35,1	12,7	72,4	-	52,6
		450 lbs.	.67 lbs.			5,57	4,41	1,31	-	-	1,38	0,5	2,85	-	2,07
210-203	Carbon	2670 N	0.58 kg	59°	106°	203,7	140,5	42,9	31,8	45,2	48,5	64,3	91,9	8,4	59,4
		600 lbs.	1.29 lbs.			8,02	5,53	1,69	1,25	1,78	1,91	2,53	3,62	0,33	2,34
210-204	Stainless Steel	3340 N	0.58 kg	59°	106°	195,6	140,5	42,9	31,8	45,2	48,5	64,3	91,9	8,4	65,5
		750 lbs.	1.29 lbs.			7,70	5,53	1,69	1,25	1,78	1,91	2,53	3,62	0,33	2,58
247-200	Carbon	4450 N	1,07 kg	67°	122°	218,9	174,0	50,8	31,8	45,2	50,8	64,3	124,0	8,6	79,2
		1000 lbs.	2.36 lbs.			8,62	6,85	2,00	1,25	1,78	2,00	2,53	4,88	0,34	3,12



Pull-Action Latch Clamps Series 301, 311



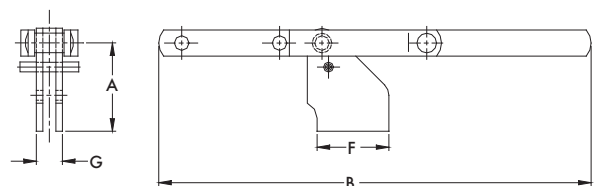
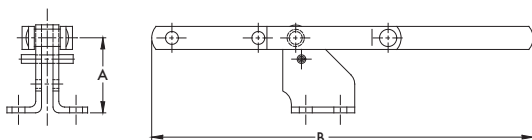
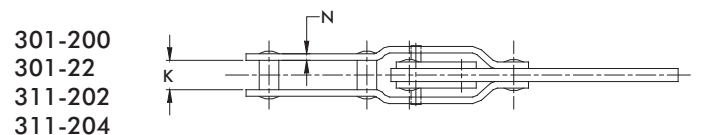
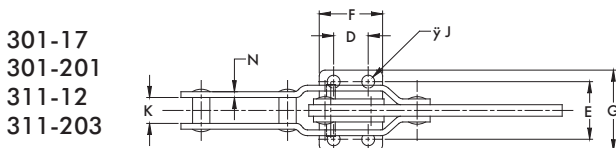
301-17
301-201
311-12
311-203



301-200
301-22
311-202
311-204

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.

Model No.	Material	Holding Capacity	Weight	Drawing Movement	Dimensions								
					A	B	D	E	F	G	J	K	N
301-17	Carbon	1670 N	0.32 kg	101,6	41,4	211,3	19,1	31,8	35,1	44,5	7,1	14,2	3,3
		375 lbs.	0.7 lbs.	4.00"	1,63	8,32	0,75	1,25	1,38	1,75	0,28	0,56	0,13
301-200	Carbon	1670 N	0.32 kg	101,6	42,9	211,3	-	-	35,1	12,7	-	14,2	3,3
		375 lbs.	0.7 lbs.	4.00"	1,69	8,32	-	-	1,38	0,50	-	0,56	0,13
301-201	Stainless Steel	2000 N	0.32 kg	101,6	41,4	211,3	19,1	31,8	35,1	44,5	7,1	14,2	3,3
		450 lbs.	0.7 lbs.	4.00"	1,63	8,32	0,75	1,25	1,38	1,75	0,28	0,56	0,13
301-22	Stainless Steel	2000 N	0.32 kg	101,6	42,9	211,3	-	-	35,1	12,7	-	14,2	3,3
		450 lbs.	0.7 lbs.	4.00"	1,69	8,32	-	-	1,38	0,50	-	0,56	0,13
311-12	Carbon	5340 N	0.53 kg	85,8	52,3	240,3	31,8	45,2	48,5	64,3	8,4	14,2	3,3
		1200 lbs.	1.16 lbs.	3.38"	2,06	9,46	1,25	1,78	1,91	2,53	0,33	0,56	0,13
311-202	Carbon	5240 N	0.53 kg	85,8	53,8	240,3	-	-	48,5	14,2	-	14,2	3,3
		1200 lbs.	1.16 lbs.	3.38"	2,12	9,46	-	-	1,91	0,56	-	0,56	0,13
311-203	Stainless Steel	6230 N	0.53 lbs.	85,8	52,3	240,3	31,8	45,2	48,5	64,3	8,4	14,2	3,3
		1400 lbs.	1.16 lbs.	3.38"	2,06	9,46	1,25	1,78	1,91	2,53	0,33	0,56	0,13
311-204	Stainless Steel	6230 N	0.53 lbs.	85,8	53,8	240,3	-	-	48,5	14,2	-	14,2	3,3
		1400 lbs.	1.16 lbs.	3.38"	2,12	9,46	-	-	1,91	0,56	-	0,56	0,13



Straight-Line Action Clamps Models **602-204, 604-203, 624-204**



604106
Mounting Plate

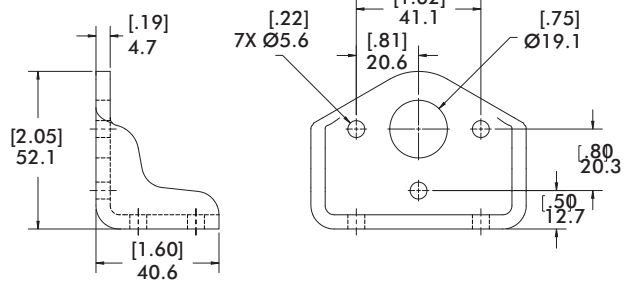
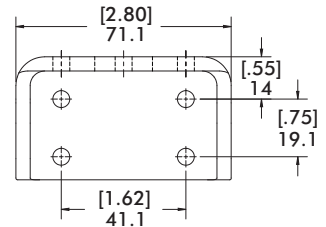


624108
Mounting Plate

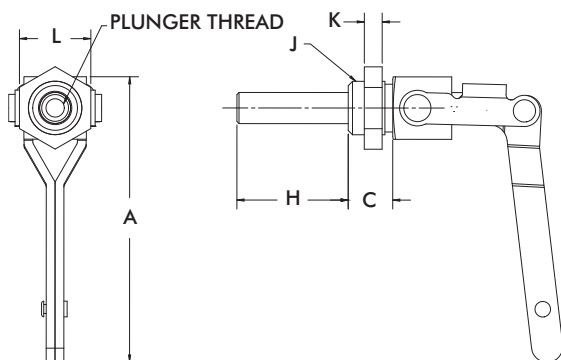
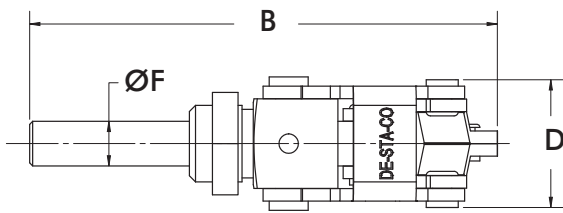
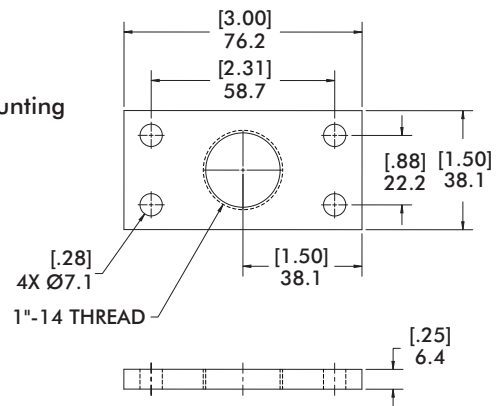
With fully retractable locators, these models are ideal for locating or holding in place small mold components where traditional hold-down clamps will not work. These clamps are mounted directly through a member by a jam nut on the work side, or flush by drilling and tapping the member. Models 602, 604,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

Model No.	Material	Holding Capacity	Weight	Plunger Travel	Plunger Thread	Dimensions								
						A	B	C	D	F	H	J	K	L
602-204	Carbon	900 N	0.11 kg	19	1/4-20	75,7	62,0	12,7	26,2	9,7	20,6	5/8-18	6,4	22,4
		200 lbs	.25 lbs	.75"		2,98	2,44	0,5	1,03	0,38	0,81		0,25	0,88
604-203	Carbon	1330 N	0.20 kg	38	5/16-18	101,6	116,1	16,0	33,0	11,2	39,6	3/4-16	6,4	25,4
		300 lbs	.44 lbs	1.50"		4	4,57	0,63	1,3	0,44	1,56		0,25	1
624-204	Carbon	3110 N	0.74 kg	66	3/8-16	139,2	169,9	22,4	46,0	16,0	69,9	1.00-14	6,4	38,1
		700 lbs	1.63 lbs	2.63"		5,48	6,69	0,88	1,81	0,63	2,75		0,25	1,5

604106
Optional Mounting Plate



624108
Optional Mounting Plate



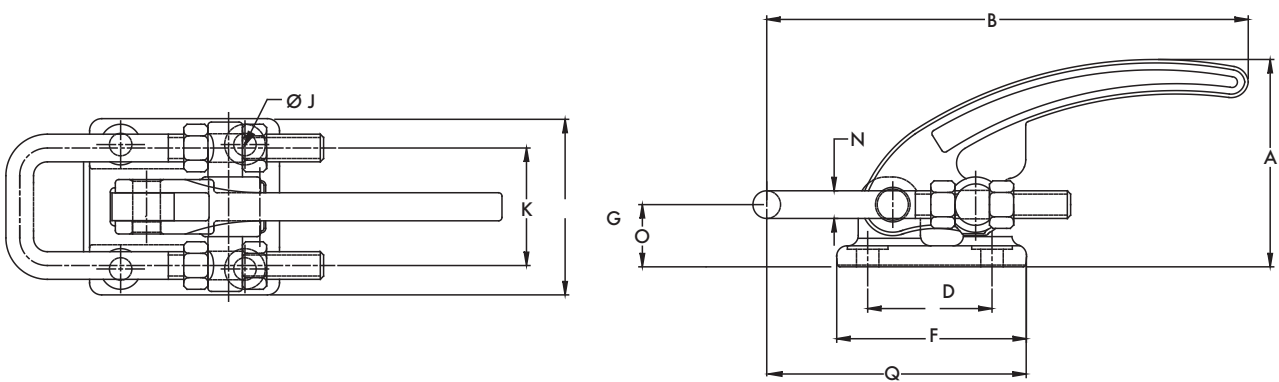
Pull-Action Latch Clamps Model **385-29**



375509
Optional Latch Plate

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.

Model No.	Holding Capacity	Weight	Drawing Movement	Dimensions										
				A	B*	D	F	G	J	K	N	O	Q Min	Q Max
385-29	33360 N	1,64	55,6	90,7	222,3	57,2	85,9	79,5	10,4	54,1	11,9	27,4	116,1	143,3
	7500 lbs.	3.62 lbs	2.19"	3,57	8,75	2,25	3,38	3,13	0,41	2,13	0,47	1,08	4,57	5,64



Parting Line Clamps Models **353-35, 353-65**



Sold as Complete Assembly



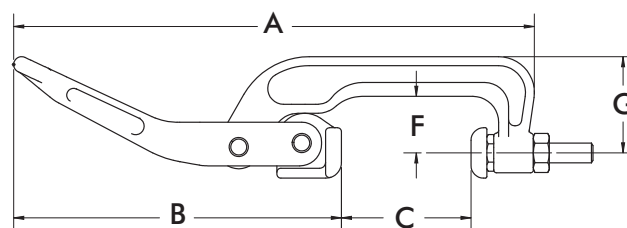
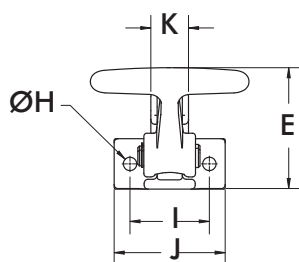
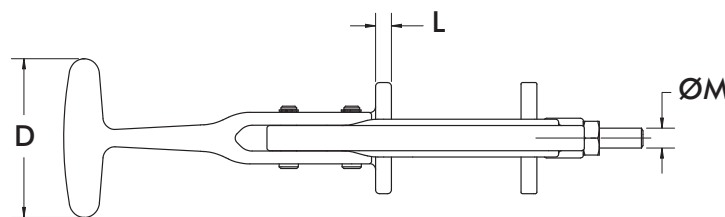
353004
Carbon Version
Keeper Plate



353904
Tapered Bolt
Assembly

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.

Model No.	Max. Mechanical Advantage (M.A.)	Holding Capacity	Weight	Dimensions												
				A	B	C Max	D	E	F	G	H	I	J	K	L	M
353-35	23:1	12460 N	0.95 kg	232,4	165,1	35,3	80,0	61,2	28,4	48,5	6,9	39,9	55,9	19,1	7,9	M10x1.5
		2800 lbs	2.1 lbs	9,15	6,5	1,39	3,15	2,41	1,12	1,91	0,27	1,57	2,2	0,75	0,31	
353-65	27:1	9350 N	1.04 kg	262,4	165,1	65,3	80,0	61,2	28,4	48,5	6,9	39,9	55,9	19,1	7,9	M10x1.5
		2100 lbs	2.3 lbs	10,33	6,5	2,57	3,15	2,41	1,12	1,91	0,27	1,57	2,2	0,75	0,31	



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.

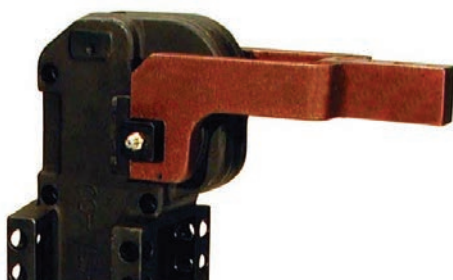
Features:

- 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

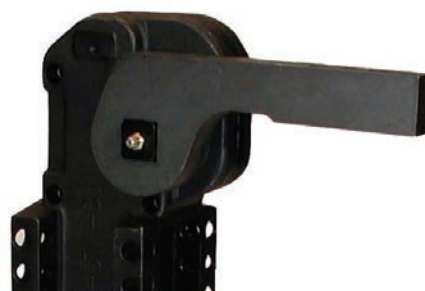


991-MRM
base model (without clamping arm)

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



991-MRM with U-type central clamping arm

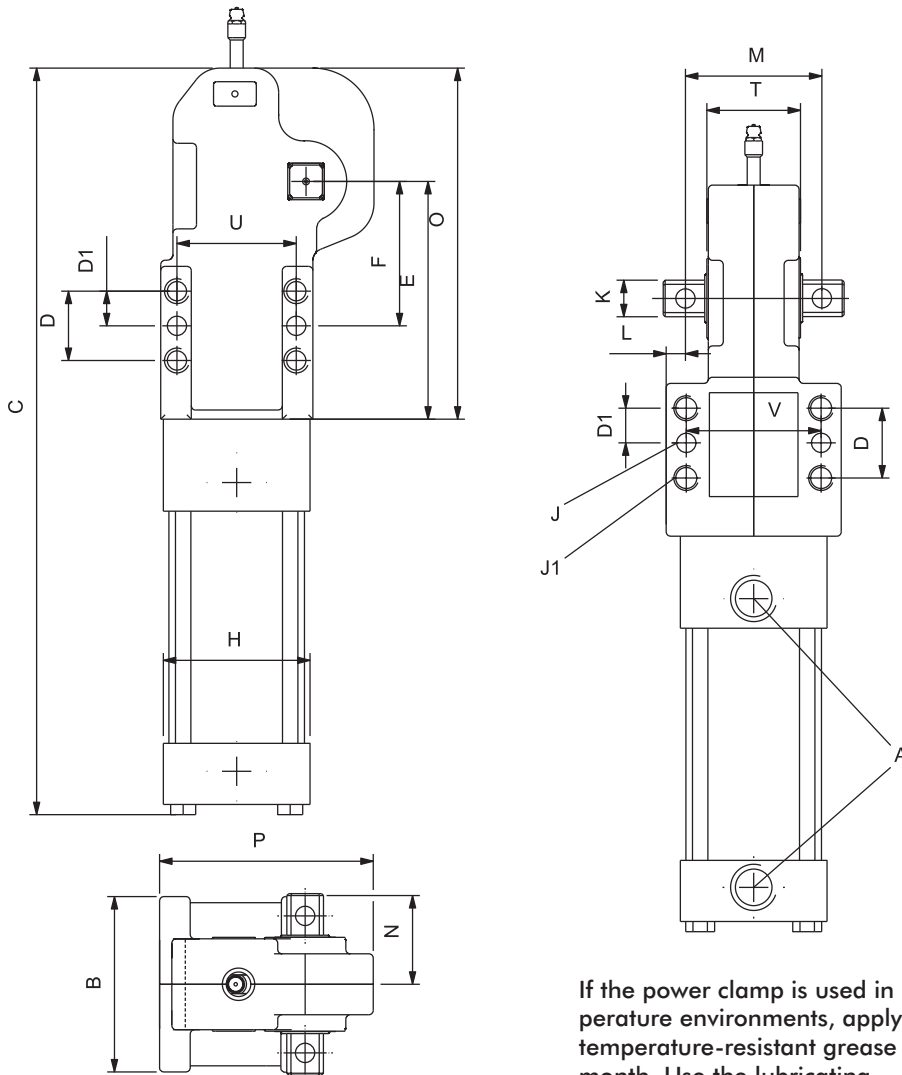


991-MRM with lateral clamping arm (right)

Spare parts	
Specification	Order no. for structural component 991-MRM
Cylinder	893132M-ET
Seal kit	8930100-ET

Zubehörteile für 991-MRM		
Clamping arm		structural component Order no. for set 991-MRM
Clamping arm variant	Clamping position	
U-central	horizontal	8JG-069-1-01
lateral	horizontal	8JG-070-1-01
Fett		auf Anfrage

991-MRM



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.

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.

Technical data: 991-MRM

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









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