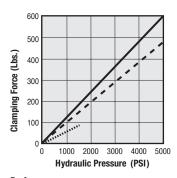
Hydraulic Power Clamps | Hydraulic Swing Clamps – 475 lb.

The DESTACO Threaded Body Swing Clamps are available in both single-acting and double-acting versions. They incorporate the latest hydraulic swing clamp technology. The top port design allows easy access for plumbing connections.

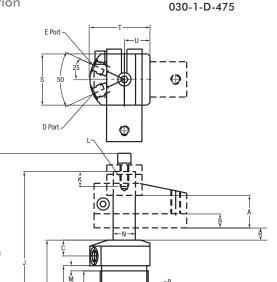
They are available with 90° left or right hand rotation. The breather port on single-acting models may be replaced with tubing for remote venting. The optional arms clamp securely to the piston rod to reduce fatigue and deflection. Arms may be easily modified or custom arms may be substituted.

Features:

- · Advanced seals and wipers utilize a special, highly wear-resistant construction for long cycle life and 5,000 PSI operation
- Triple track piston rod design for field adjustable swing direction
- Hardened and hard chrome plated piston rod for increased strength and wear resistance
- Advanced metal treated body for superior wear and corrosion resistance
- MRO interchange design



For 475 lb. Swing Clamp Arms see Page MC-HYD-11



030-1-S-475

Performance

- With 031-L-475 Arm (3.25" long)
- - With 0-31-S-475 Arm (1.22" long)
- Straight Pull

			Specific	ations				Max
Cat. no.	Oper.	Swing Direction	*Force (lbs.)		a (sq. In.) Unclamp		o. (cu. In.) Unclamp	Oil Flow in ³ /m in
030-1-S-475 (-X)	Single- Acting	Left Hand	475	0.12	_	0.00	-	12
030-1-D-475 (-X)	Double- acting	(Counter Clockwise) Right Hand (Clockwise)	475	0.12	0.24	0.08	0.15	12

Ordering Notes:

- Left hand swing (ccw) is standard no suffix
- Add –R suffix for right hand swing

								Spe	cificati	ons									
Cat. no.	Α	В		D	. E														
	Total Stroke	Clamping Stroke	С	Clamp	Unclamp Port	F	G	н	J	K	L	М	Ν	Р	Q	R	S	Т	U
030-1-S-475 (i)	0.65	0.210	0.59	SAE-2	SAE-2	1 020	2.086	2.07	4.429	0.8	AA41	0.157	0.393	1-1/8-	4.04	0.495	1.3	1.55	0.61
030-1-D-475	0.65	0.32	0.59	SAE-Z	JAE-Z	1.729	2.000	3.07	4.429	0.8	MOXI	0.157	0.393	16UN	4.90	0.493	1.3	1.55	0.01

i This item is available upon request

*With 1.22" long arm at 5,000 PSI maximum operating pressure.

^aDo not pressurize – single-acting only † See page MC-HYD-11 for arms, accessories and custom arm mounting



030-1-S-1100

Hydraulic Power Clamps | Hydraulic Swing Clamps - 1,100lb.

 $\frac{1}{2}$

E Port

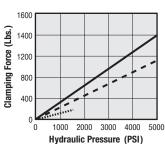
030-1-D-1100

The DESTACO Threaded Body Swing Clamps are available in both single-acting and double-acting versions. They incorporate the latest hydraulic swing clamp technology. The top port design allows easy access for plumbing connections.

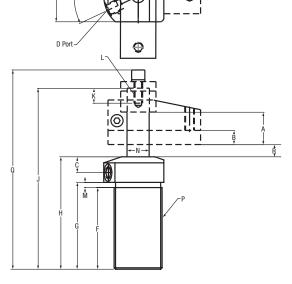
They are available with 90° left or right hand rotation. The breather port on single-acting models may be replaced with tubing for remote venting. The optional arms clamp securely to the piston rod to reduce fatigue and deflection. Arms may be easily modified or custom arms may be substituted.

Features:

- Advanced seals and wipers utilize a special, highly wear-resistant construction for long cycle life and 5,000 PSI operation
- Triple track piston rod design for field adjustable swing direction
- Hardened and hard chrome plated piston rod for increased strength and wear resistance
- Advanced metal treated body for superior wear and corrosion resistance
- MRO interchange design



For 1,100 lb. Swing Clamp Arms see Page MC-HYD-12



	ilyuraulic i ressure (i Si)
Performa	ance
	With 031-L-1100 Arm (5.31" long)
	With 031-S-1100 Arm (1.89" long)
	Straight Pull

			Specific	ations				Max Oil Flow
Cat. no.		Swing	*Force	Eff. Are	a (sq. In.)	Oil Cap	o. (cu. ln.)	in ³ /m
	Oper.	Direction	(lbs.)	Clamp	Unclamp	Clamp	Unclamp	in
030-1-S-1000 (-X)	Single- Acting	Left Hand	1100	0.28	-	0.25	-	25
030-1-D-1000 (-X) 🚺	Double- acting	(Counter Clockwise) Right Hand (Clockwise)	1100	0.28	0.59	0.25	0.52	25

0	:	Mada
Ord	lering	Notes

- Left hand swing (ccw) is standardno suffix
- Add –R suffix for right hand swing

								Spe	cificat	ions									
Cat. no.	Α	В		D	Е														
	Total	Clamping	_		Unclamp	-	_			V			N.		^		c		
	Stroke	Stroke	<u> </u>	Port	Port		G_	<u> H</u>		K		<u> M</u>	<u>N</u>	r	Q	K	<u> </u>		U
030-1-S-1100 (i)	0.89	0.39	0.6	SAE-4	SAE-4	2.4	2.6	2 50	5.305	0.04	M8 x	0 104	0 620	1-3/8- 18UN	5 045	0.400	1.5	1.87	0.75
030-1-D-1100(i)	0.09	0.39	0.0	JAE-4	JAE-4	2.4	2.0	3.36	3.303	0.94	1.25	0.170	0.029	18UN	3.703	0.400	1.3	1.07	0.75

¹ This item is available upon request

[∆]Do not pressurize – single-acting only

MC-HYD



^{*}With 1.89" long arm at 5,000 PSI maximum operating pressure.

[†] See page MC-HYD-12 for arms, accessories and custom arm mounting

Hydraulic Power Clamps | Hydraulic Swing Clamps - 2,400 lb.

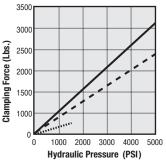
The DESTACO Threaded Body Swing Clamps are available in both single-acting and double-acting versions. They incorporate the latest hydraulic swing clamp technology. The top port design allows easy access for plumbing connections.

They are available with 90° left or right hand rotation. The breather port on single-acting models may be replaced with tubing for remote venting. The optional arms clamp securely to the piston rod to reduce fatigue and deflection. Arms may be easily modified or custom arms may be substituted.

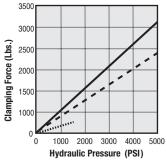
Features:

- · Advanced seals and wipers utilize a special, highly wear-resistant construction for long cycle life and 5,000 PSI operation
- Triple track piston rod design for field adjustable swing direction
- Hardened and hard chrome plated piston rod for increased strength and wear resistance
- Advanced metal treated body for superior wear and corrosion resistance
- MRO interchange design

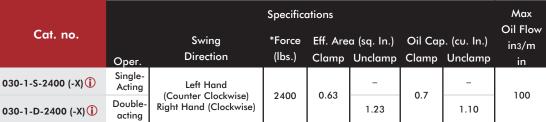
Performance

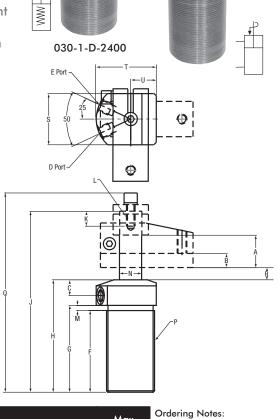


For 2,400 lb. Swing Clamp Arms see Page MC-HYD-11



...... With 031-L-2400 Arm (6.36" long) - - With 031-S-2400 Arm (2.43" long) Straight Pull





Ordering	Notes
امسما الماما	ai.a. 1

030-1-S-2400

- Left hand swing (ccw) is standardno suffix
- Add –R suffix for right hand swing

								Spe	cificati	ions									
Cat. no.	A Total	B Clamping			E Unclamp														
	Stroke	Stroke	C	Port	Port	F	G	<u> </u>	J	K		M_	<u>N</u>	P	Q	R	<u> S </u>	T	U
030-1-S-2400 (i)	1.12	0.5	0.62	SAE-4	SAE-4		2 38	4.38	6.8	1.28	M10x	n 106	0.87	1-7/8- 16UN	7 543	0.517	2.0	2.38	1.0
030-1-D-2400 (i)	1.12	0.5	0.02	JAL-4	3AL-4 8	'	3.36	4.30	0.8	1.20	1.5	0.170	0.07	16UN	, .545	0.517	2.0	2.30	'.0

i This item is available upon request



^{*}With 2.43" long arm at 5,000 PSI maximum operating pressure.

^ADo not pressurize – single-acting only

[†] See page MC-HYD-11 for arms, accessories and custom arm mounting

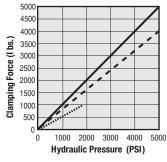
Hydraulic Power Clamps | Hydraulic Swing Clamps - 4,000 lb.

The DESTACO Threaded Body Swing Clamps are available in both single-acting and double-acting versions. They incorporate the latest hydraulic swing clamp technology. The top port design allows easy access for plumbing connections.

They are available with 90° left or right hand rotation. The breather port on single-acting models may be replaced with tubing for remote venting. The optional arms clamp securely to the piston rod to reduce fatigue and deflection. Arms may be easily modified or custom arms may be substituted.

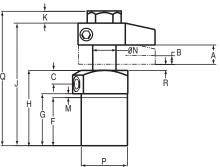
Features:

- Advanced seals and wipers utilize a special, highly wear-resistant construction for long cycle life and 5,000 PSI operation
- Triple track piston rod design for field adjustable swing direction
- Hardened and hard chrome plated piston rod for increased strength and wear resistance
- Advanced metal treated body for superior wear and corrosion resistance
- MRO interchange design



For 4,000 lb. Swing Clamp Arms see Page MC-HYD-11





Performance	,
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- ······ With 031-L-4000 Arm (X.XX" long)
- - With 031-S-4000 Arm (X.XX" long)
 - Straight Pull

			Specific	ations				Max
Cat. no.	Oper.	Swing Direction	*Force (lbs.)		a (sq. In.) Unclamp		o. (cu. In.) Unclamp	Oil Flow in ³ /m in
030-1-S-4000 (-X)	Single- Acting	Left Hand	4000	1.10	-	1.22	-	140
030-1-D-4000 (-X)	Double- acting	(Counter Clockwise) Right Hand (Clockwise)	4000	1.10	2.35	1.22	2.60	140
▼I.1. 11								

i This item is available upon request

								Spec	ificatio	ons									
Cat. no.	A Total Stroke	B Clamping Stroke	С	D Clamp Port	E Unclamp Port	F	G	н	J	K	L	М	N	P	Q	R	S	Т	U
030-1-S-4000 (i)	1.07	0.45	0.75	CAE#4	CAE#4	0.70	0.00	4.00		0 / 4	1 /1	0.14	1.0/	2-	7 20	0.22	0.54	0.00	1.00
030-1-D-4000 (i)	1.07	0.45	0.75	SAE#4	SAE#4	2.70	2.83	4.09	6.67	0.64	1.61	0.14	1.26	1/2-16 UN	7.30	0.33	2.56	2.99	1.28

(i) This item is available upon request

NOTE: *With 2.75" long arm at 5,000 PSI maximum operating pressure.

^Do not pressurize – single-acting only

† See page MC-HYD-11 for arms, accessories and custom arm mounting



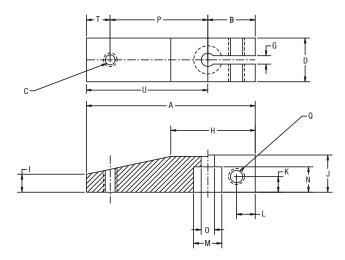
Ordering Notes:

 Left hand swing (ccw) is standardno suffix
 Add –R suffix for right hand swing

Hydraulic Power Clamps | Hydraulic Swing Clamps 475-2,400 lb. Arms

Custom built arms of any length must clamp to the swing clamp's piston rod in a manner similar to the DESTACO arms or some derating of the clamp will be necessary.

The design feature "K," in the chart and drawing at the bottom of this page, is recommended for all applications of custom, single arms. See the accompanying chart for design details. In applications where there is no bending stress being transferred into the piston rod (like push/pull linkages and equalizing double arms), this design detail may be eliminated. In these applications, the clamp's full capacity (referred to as "straight pull" capacity) is available.



									Specif	ications	;							
Cat. no.	A	В	С	D	G	н	1	J	K	L	М	N	0	Р	Q	т	U	Weight (lbs.)
031-S-475	1.929	0.709	M6	0.63		1.139	0.394	0.630			0.394	0.394	0.256	0.984	M6	0.236	1.220	0.159
031-L-475	3.959	0.709	-	0.63		1.166	0.394	0.630			0.394	0.394	0.256	-	M6	-	3.250	0.348
031-S-1100	2.598	0.709	M8	0.748		1.294	0.433	0.748			0.630	0.472	0.33	1.575	M6	0.315	1.889	0.286
031-L-1100	6.019	0.709	-	0.748	0.126	1.412	0.433	0.748	0.236	0.217	0.630	0.472	0.335	-	M6	-	5.310	0.721
031-S-2400	3.268	0.866	M10	1.125		1.459	0.633	1.00			0.866	0.709	0.413	1.969	M8	0.433	2.402	0.634
031-L-2400	7.226	0.866	-	1.125		1.696	0.633	1.00			0.866	0.709	0.413	-	M8	-	6.360	1.564

IMPORTANT: Any clamp using a modified or custom arm that is longer or heavier than DESTACO's

standard arms must be derated to prevent internal damage.

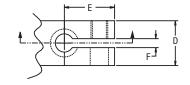
Do not exceed the maximum speed and pressure ratings for DESTACO's standard arms.

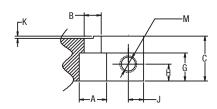
For maximum hydraulic pressure and speed ratings, see the accompanying charts Do not use meter-out circuitry for controlling double-acting clamp speeds

Do not use meter-out circuitry for controlling double-acting clamp speed Contact DESTACO if further design assistance is required

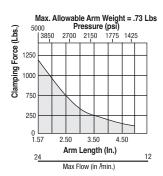
Custom Arm Mounting Dimensions for Swing Clamps

Shaft		Specifications											
Dia.	Α	В	С	D	Е	F	G	н	J	K	М		
10 MM	0.394	0.256	0.63	0.63	0.709	1.26	0.394	0.236	0.217	0.30	M6 x 1.0		
16MM	0.630	0.335	0.748	0.748	0.709		0.472	0.236	0.217		M6 x 1.0		
22 MM	0.866	0.413	1.00	1.00	0.866		0.709	0.236	0.217		M8 x 1.25		









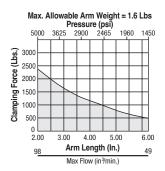


Chart Legend

Maximum Length / Pressure
Operating Range

Clamps must operate at or below maximum arm length/pressure curve:

To approximate clamping force with any arm at less than maximum pressure:

FORCE = $P \times A \times [1-(P/M \times .23)]$

P = Hyd. system operating pressure (PSI)

A = Clamp effective area (sq. in.)

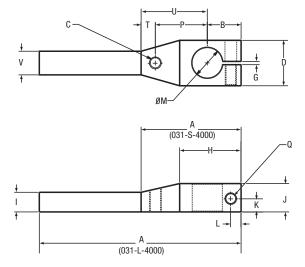
M = Max. rated pressure of chosen arm length (PSI)



Hydraulic Power Clamps | Hydraulic Swing Clamps - 4,000 lb. Arms

Custom built arms of any length must clamp to the swing clamp's piston rod in a manner similar to the DESTACO arms or some derating of the clamp will be necessary.

The design feature "K," in the chart and drawing at the bottom of this page, is recommended for all applications of custom, single arms. See the accompanying chart for design details. In applications where there is no bending stress being transferred into the piston rod (like push/pull linkages and equalizing double arms), this design detail may be eliminated. In these applications, the clamp's full capacity (referred to as "straight pull" capacity) is available.



	Specifications																
Cat no.	Α	В	С	D	G	н	1	J	Κ	L	М	P	Q	T	U	٧	Weight (lbs.)
031-S-4000	4.17	1.42	1/2-13	1.89	0.138	2.56	0.83	1.18	0.55	0.43	1.26	2.17	M12	0.58	2.75	0.98	1.80
031-L-4000	8.43	1.42	1/2-13	1.89	0.138	2.56	0.83	1.18	0.55	0.43	1.26	-	M12	-	7.01	0.98	2.80

IMPORTANT: Any clamp using a modified or custom arm that is longer or heavier than DESTACO's standard arms must be derated to prevent internal damage.

Do not exceed the maximum speed and pressure ratings for DESTACO's standard arms.

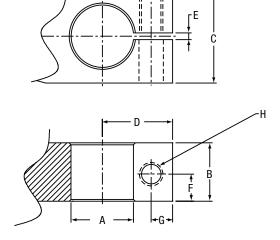
For maximum hydraulic pressure and speed ratings, see the accompanying charts

Do not use meter-out circuitry for controlling double-acting clamp speeds

Contact DESTACO if further design assistance is required

Custom Arm Mounting Dimensions for 4,000 lb. Swing Clamps

Cat no.	Specifications											
	A	В	С	D	E	F	G	н				
32MM	1.26	1.18	1.89	1.42	0.138	0.55	0.43	M12 x 1.75				



031-S-4000 • 031-L-4000

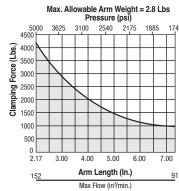


Chart Legend

Maximum Length / Pressure
Operating Range

Clamps must operate at or below maximum arm length/pressure curve:

To approximate clamping force with any arm at less than maximum pressure:

FORCE = $P \times A \times [1-(P/M \times .23)]$

P = Hyd. system operating pressure (PSI)

A = Clamp effective area (sq. in.)

M = Max. rated pressure of chosen arm length (PSI)

