

# Pneumatic Swing Clamps

01/28/2025



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# Pneumatic Swing Clamps

01/28/2025

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## Table of Contents

Pneumatic Swing Clamps

MC-PSC-1

# Pneumatic Swing Clamps

01/28/2025

## Table of Contents (continued)

# 9500 SERIES

## Pneumatic Swing Clamps | Product Overview

### Features:

- Ideal for tight spaces with an arm motion that rotates at the top of the stroke
- Includes a rod weld cover to protect the rod throughout the entire stroke
- Can be mounted on any face with optional side flange mounting kit
- Switch ready for Ø4mm or 6.5mm x 5mm sensors

### Applications:

- Assembly
- Welding
- Light machining

### Also Available:

- See page MC-PSC-6 for mounting options
- See page MC-PSC-7 for clamping arms
- See page MC-PSC-40 for sensing options

Covered under one or more U.S./International Patents

9522-2



9530-2



9540-2



9550-2



Shown with optional clamping arm.

## Technical Information

| Model    | Swing Direction | Total Stroke<br>[in] mm | Vertical Clamping Stroke*<br>[in] mm | Ports  | Clamping Force @<br>[lbf] N† | Bore Size<br>[in] mm | Air Consumption‡<br>dm³ [in³] | Weight<br>[lb] kg | Replacement Seal Kit |
|----------|-----------------|-------------------------|--------------------------------------|--------|------------------------------|----------------------|-------------------------------|-------------------|----------------------|
| 9522-2L  | LH              | [0.50]                  | [0.50]                               | M5     | [34]                         | [0.86]               | [0.004]                       | [0.68]            | 952292               |
| 9522-2R  | RH              | 13                      | 13                                   |        | 150                          | 22                   | 0,10                          | 0,31              |                      |
| 9530-2L  | LH              | [0.79]                  | [0.79]                               | 1/8NPT | [76]                         | [1.26]               | [0.010]                       | [1.25]            | 953092               |
| 9530-2GL |                 |                         |                                      | G-1/8  |                              |                      |                               |                   |                      |
| 9530-2R  | RH              |                         |                                      | 1/8NPT | [123]                        | [1.57]               | [0.016]                       | [1.98]            |                      |
| 9530-2GR |                 |                         |                                      | G-1/8  |                              |                      |                               |                   |                      |
| 9540-2L  | LH              | [0.79]                  | [0.79]                               | 1/8NPT | [196]                        | [1.97]               | [0.026]                       | [3.33]            | 955092               |
| 9540-2GL |                 |                         |                                      | G-1/8  |                              |                      |                               |                   |                      |
| 9540-2R  | RH              |                         |                                      | 1/8NPT | [123]                        | [1.57]               | [0.016]                       | [1.98]            |                      |
| 9540-2GR |                 |                         |                                      | G-1/8  |                              |                      |                               |                   |                      |
| 9550-2L  | LH              | [0.79]                  | [0.79]                               | 1/8NPT | [196]                        | [1.97]               | [0.026]                       | [3.33]            | 955092               |
| 9550-2GL |                 |                         |                                      | G-1/8  |                              |                      |                               |                   |                      |
| 9550-2R  | RH              |                         |                                      | 1/8NPT | [123]                        | [1.57]               | [0.016]                       | [1.98]            |                      |
| 9550-2GR |                 |                         |                                      | G-1/8  |                              |                      |                               |                   |                      |

\*No stroke travel during clamp arm rotation.

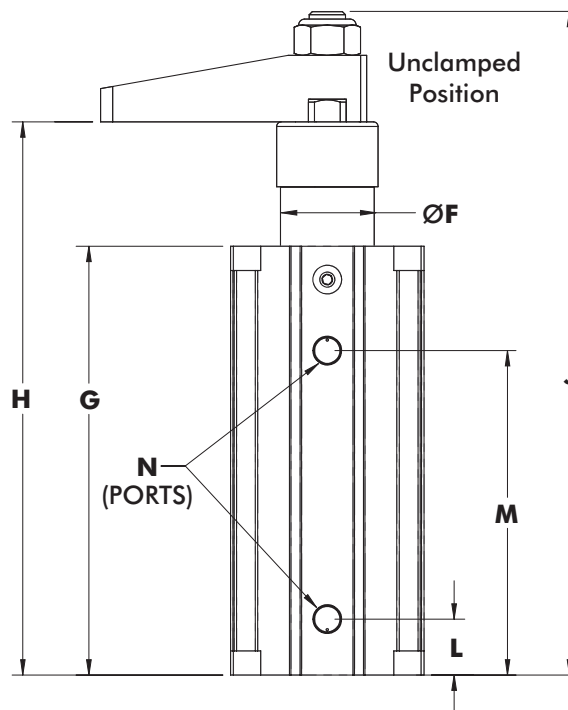
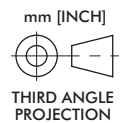
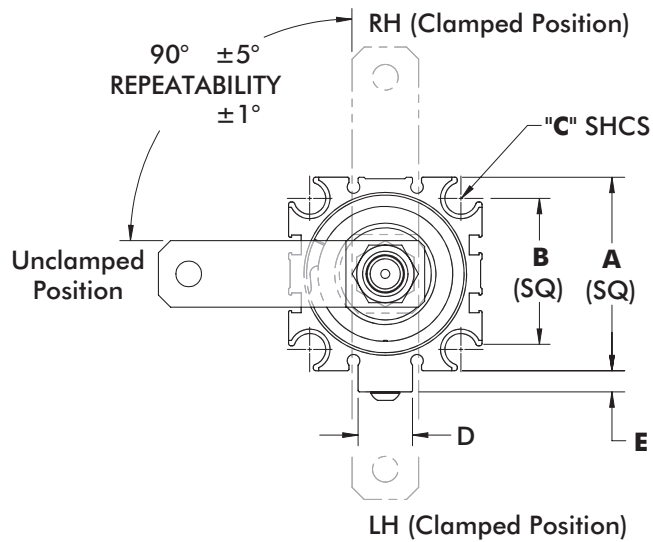
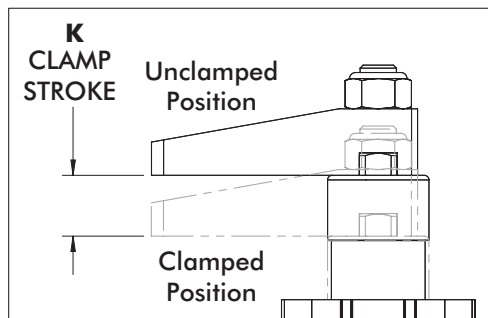
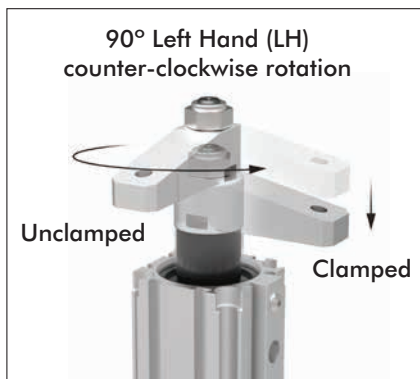
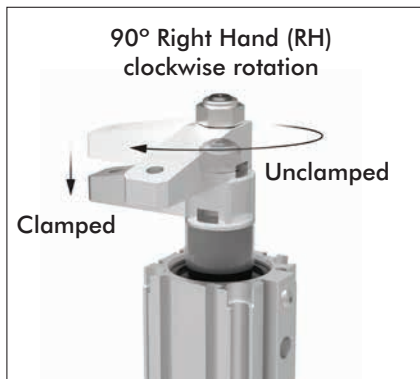
† with standard clamping arm at 5 bar [72psi]. ‡ Per double stroke at 5 bar [72psi]

Operating Pressure Range: 3 bar [45 psig] to 8 bar [120 psig]

Maximum Operating Temperature: 60°C [140°F]

# 9500 SERIES

## Pneumatic Swing Clamps | Dimensions



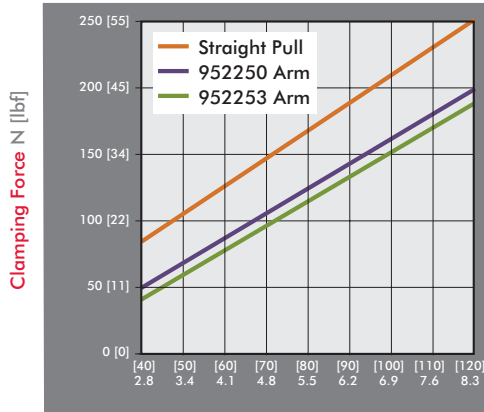
Shown with optional clamping arm.

| Model   | A            | B              | C             | D            | E           | F              | G               | H               | J               | K            | L              | M              | N      |
|---------|--------------|----------------|---------------|--------------|-------------|----------------|-----------------|-----------------|-----------------|--------------|----------------|----------------|--------|
| 9522-2  | [1.42]<br>36 | [1.00]<br>25,4 | M5<br>(#10)   | --           | --          | [0.82]<br>21   | [3.77]<br>95,8  | [4.79]<br>121,8 | [5.72]<br>145,7 | [0.50]<br>13 | [0.43]<br>11   | [2.90]<br>73,8 | M5     |
| 9530-2  | [1.81]<br>46 | [1.34]<br>34   | M6<br>(1/4")  | [0.55]<br>14 | [0.16]<br>4 | [0.96]<br>24,4 | [4.48]<br>113,7 | [6.09]<br>154,8 | [7.33]<br>186   | [0.79]<br>20 | [0.65]<br>16,5 | [3.43]<br>87,1 | 1/8NPT |
| 9530-2G |              |                |               |              |             |                |                 |                 |                 |              |                |                |        |
| 9540-2  | [2.05]<br>52 | [1.57]<br>40   |               |              | [0.20]<br>5 | [1.13]<br>28,7 | [4.63]<br>117,6 | [6.29]<br>159,7 | [7.52]<br>190,9 |              |                |                | 1/8NPT |
| 9540-2G |              |                |               |              |             |                |                 |                 |                 |              |                |                | G-1/8  |
| 9550-2  | [2.52]<br>64 | [1.97]<br>50   | M8<br>(5/16") | [0.71]<br>18 | [0.28]<br>7 | [1.32]<br>33,5 | [5.58]<br>141,8 | [7.20]<br>182,9 | [8.64]<br>219,3 |              |                |                | 1/8NPT |
| 9550-2G |              |                |               |              |             |                |                 |                 |                 |              |                |                | G-1/8  |

# 9500 SERIES

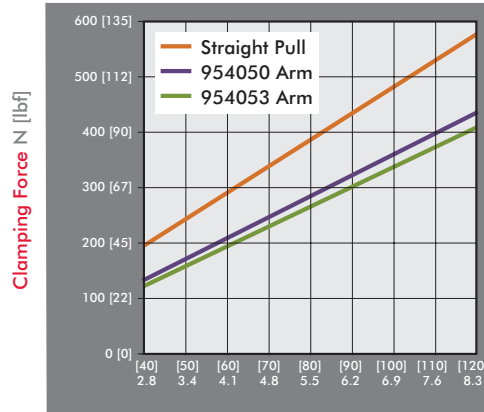
## Pneumatic Swing Clamps | Clamping Forces

Series 9522-2 Clamping Force



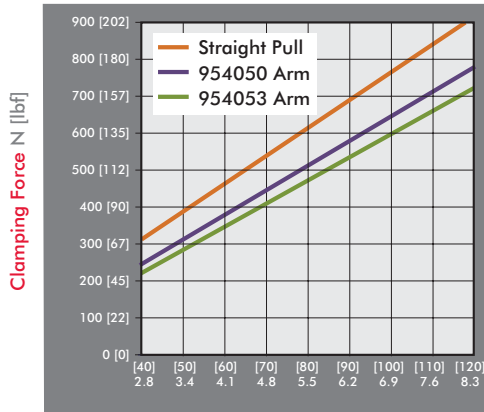
Inlet Pressure bar [PSI]

Series 9530-2 Clamping Force



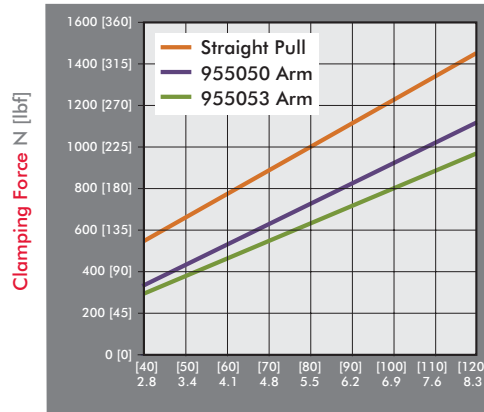
Inlet Pressure bar [PSI]

Series 9540-2 Clamping Force



Inlet Pressure bar [PSI]

Series 9550-2 Clamping Force



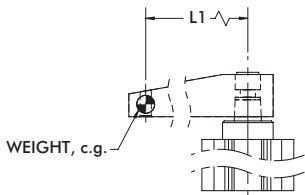
Inlet Pressure bar [PSI]

## Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

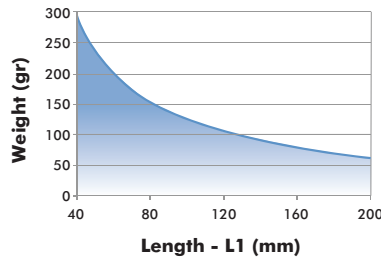
### Example: 9522-2

At a weight of 80 gr, the maximum length of the arm is approximately 120mm.

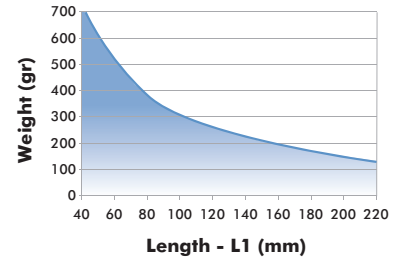


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

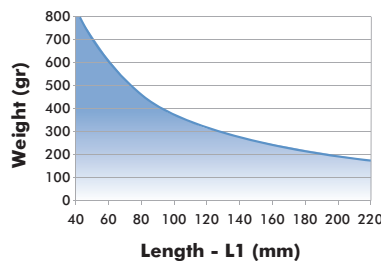
9522-2 Clamp Arm Weight



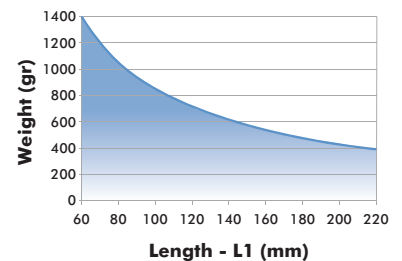
9530-2 Clamp Arm Weight



9540-2 Clamp Arm Weight

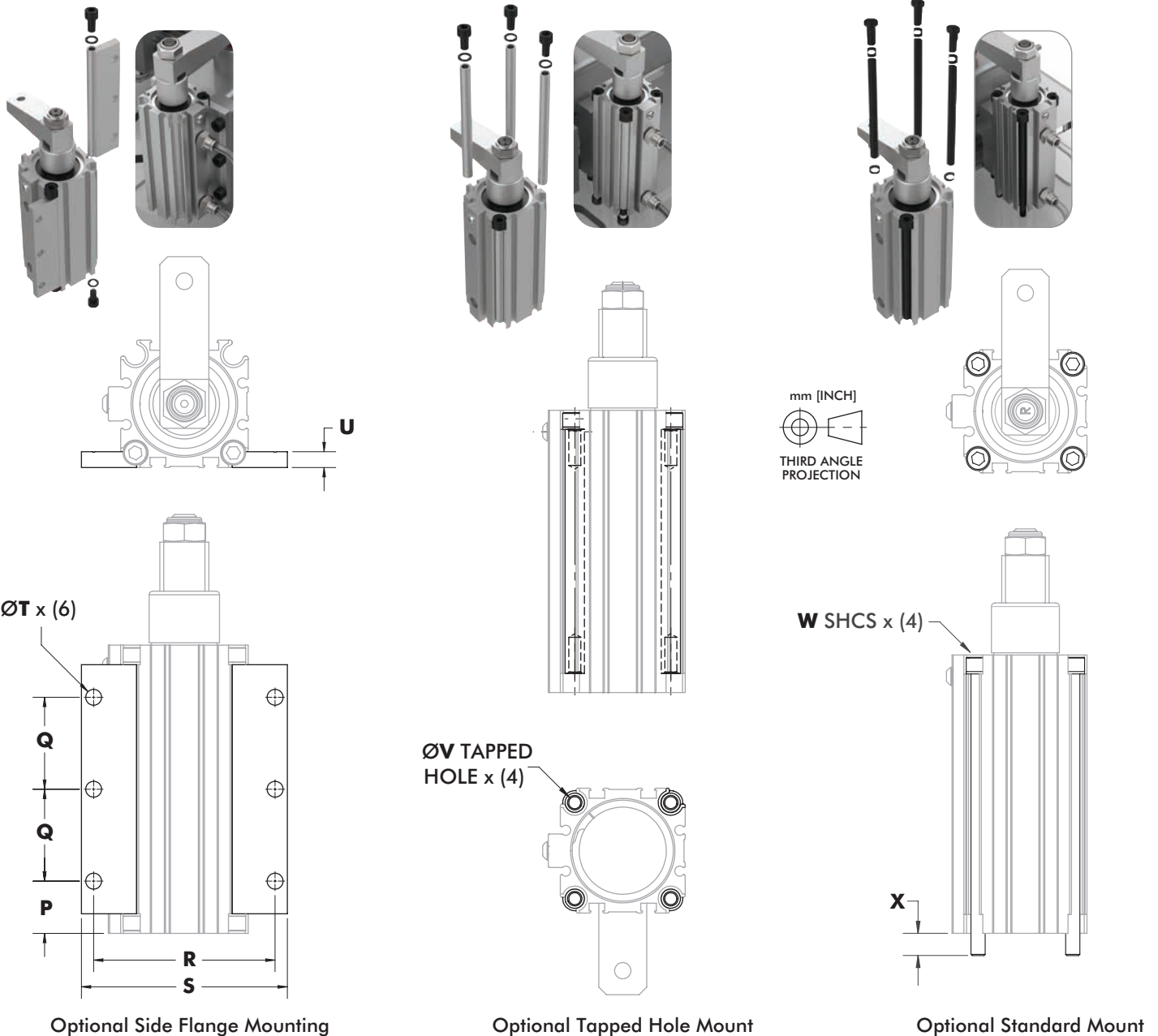


9550-2 Clamp Arm Weight



# 9500 SERIES

## Pneumatic Swing Clamps | Mounting Accessories



| Model   | P              | Q              | R              | S              | T             | U             | V  | W      | X              | Side Flange Kit | Tapped Hole Kit | Standard Mount Kit |
|---------|----------------|----------------|----------------|----------------|---------------|---------------|----|--------|----------------|-----------------|-----------------|--------------------|
| 9522-2  | [0.41]<br>10,4 |                | [1.91]<br>48,5 | [2.26]<br>57,5 | [0.22]<br>5,5 | [0.22]<br>5,5 | M5 | M5x100 | [0.36]<br>9,2  | 952260          | 952261          | 952262             |
| 9530-2  | [0.76]<br>19,4 | [1.48]<br>37,5 | [2.68]<br>68   | [3.07]<br>78   |               |               |    |        | [0.52]<br>13,3 | 953060          | 953061          |                    |
| 9530-2G |                |                |                |                | [0.26]<br>6,5 | [0.26]<br>6,5 | M6 | M6x120 |                |                 |                 | 953062             |
| 9540-2  | [0.84]<br>21,3 |                | [2.91]<br>74   | [3.31]<br>84   |               |               |    |        | [0.37]<br>9,4  | 954060          | 954061          |                    |
| 9540-2G |                |                |                |                |               |               |    |        |                |                 |                 |                    |
| 9550-2  | [0.82]<br>20,9 | [1.97]<br>50   | [3.66]<br>93   | [4.17]<br>106  | [0.33]<br>8,5 | [0.31]<br>8   | M8 | M8x150 | [0.59]<br>15   | 955060          | 955061          | 955062             |
| 9550-2G |                |                |                |                |               |               |    |        |                |                 |                 |                    |

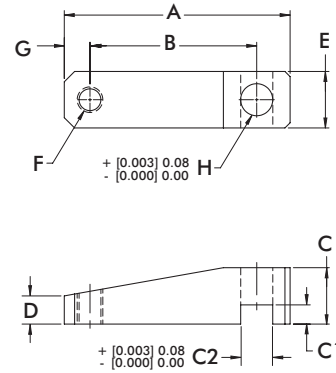
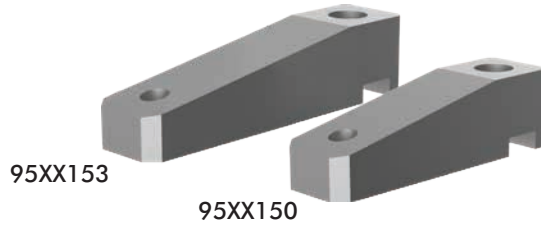
Refer to NPN-9500-2 for mounting instructions

# 9500 SERIES

## Pneumatic Swing Clamps | Clamping Arms

### Features:

- Lightweight aluminum construction
- Designed for use with 9500-2 series clamps



| Part Number | Used with Model | A             | B            | C      | C1     | C2      | D      | E      | F   | G            | H                | Weight [lbs] kg |
|-------------|-----------------|---------------|--------------|--------|--------|---------|--------|--------|-----|--------------|------------------|-----------------|
| 9522150     | 9522-2          | [2.28]<br>58  | [1.77]<br>45 | [0.59] | [0.16] | [0.315] | [0.30] | [0.59] | M6  | [0.20]<br>5  | [0.315]<br>8,00  | [0.06]<br>0,025 |
| 9522153     |                 | [3.07]<br>78  | [2.56]<br>65 | 15     | 4      | 8,01    | 7,50   | 15     |     |              |                  | [0.08]<br>0,034 |
| 9540150     | 9530-2, 9540-2  | [2.76]<br>70  | [1.97]<br>50 | [0.79] | [0.18] | [0.394] | [0.39] | [0.79] | M8  | [0.39]<br>10 | [0.394]<br>10,00 | [0.12]<br>0,054 |
| 9540153     |                 | [3.94]<br>100 | [3.15]<br>80 | 20     | 4,6    | 10,01   | 10     | 20     |     |              |                  | [0.17]<br>0,079 |
| 9550150     | 9550-2          | [3.46]<br>88  | [2.56]<br>65 | [0.87] | [0.30] | [0.493] | [0.43] | [0.87] | M10 | 10           | [0.492]<br>12,50 | [0.18]<br>0,081 |
| 9550153     |                 | [4.45]<br>113 | [3.54]<br>90 | 22     | 7,5    | 12,51   | 11     | 22     |     |              |                  | [0.23]<br>0,11  |



### Features:

- Swing direction is field adjustable between left, right, or straight. (20mm not linear adjustable)
- Switch ready for Ø4mm or 6.5mm x 5mm sensors
- Lightweight and robust, designed for several million cycles
- Clamp arm sold separately

### Applications:

- Assembly
- Welding
- Light machining

### Also Available:

See page MC-PSC-11 thru 13 for clamping arms and mounting accessories

See page MC-PSC-40 for sensing options

89R



## Technical Information

| Model       | Swing Direction* | Total Stroke<br>[in] mm | Stroke During Rotation<br>[in] mm | Vertical Clamp Stroke<br>[in] mm | Clamping Force†<br>[lbf] N | Bore Size<br>[in] mm | Air Consumption‡<br>[ft³] dm³ | Weight<br>[lbs] kg | Replacement Seal Kit |
|-------------|------------------|-------------------------|-----------------------------------|----------------------------------|----------------------------|----------------------|-------------------------------|--------------------|----------------------|
| 89R20-010-2 | LH, RH           | [0.83]<br>21            | [0.43]<br>11                      | [0.39]<br>10                     | [18]<br>80                 | [0.79]<br>20         | [0.002]<br>0,07               | [0.66]<br>0,3      | 89R20-00             |
| 89R32-010-2 | LH, RH,<br>STRT  | [1.10]<br>28            | [0.61]<br>18                      |                                  | [55]<br>245                | [1.26]<br>32         | [0.009]<br>0,25               | [1.32]<br>0,6      | 89R32-00             |
| 89R40-010-2 |                  | [1.24]<br>31,5          | [0.85]<br>21,5                    |                                  | [85]<br>380                | [1.57]<br>40         | [0.015]<br>0,43               | [2.09]<br>0,95     | 89R40-00             |
| 89R40-025-2 |                  | [1.83]<br>46,5          | [0.98]<br>25                      | [138]<br>614                     | [1.97]<br>50               | [0.022]<br>0,63      | [2.43]<br>1,1                 |                    |                      |
| 89R50-025-2 |                  | [2.05]<br>52            |                                   | [1.06]<br>27                     | [218]<br>970               | [2.48]<br>63         | [0.040]<br>1,13               | [3.97]<br>1,8      | 89R50-00             |
| 89R63-025-2 |                  | [2.30]<br>58,5          | [1.32]<br>33,5                    | [0.072]<br>2,04                  | [6.17]<br>2,8              | 89R63-00             |                               |                    |                      |

\*Swing direction is field adjustable. †with standard clamping arm 5 bar [72psi]. ‡per double stroke at 5 bar [72psi]

**Operating Pressure Range:** 3 bar [45 psig] to 8 bar [120 psig]

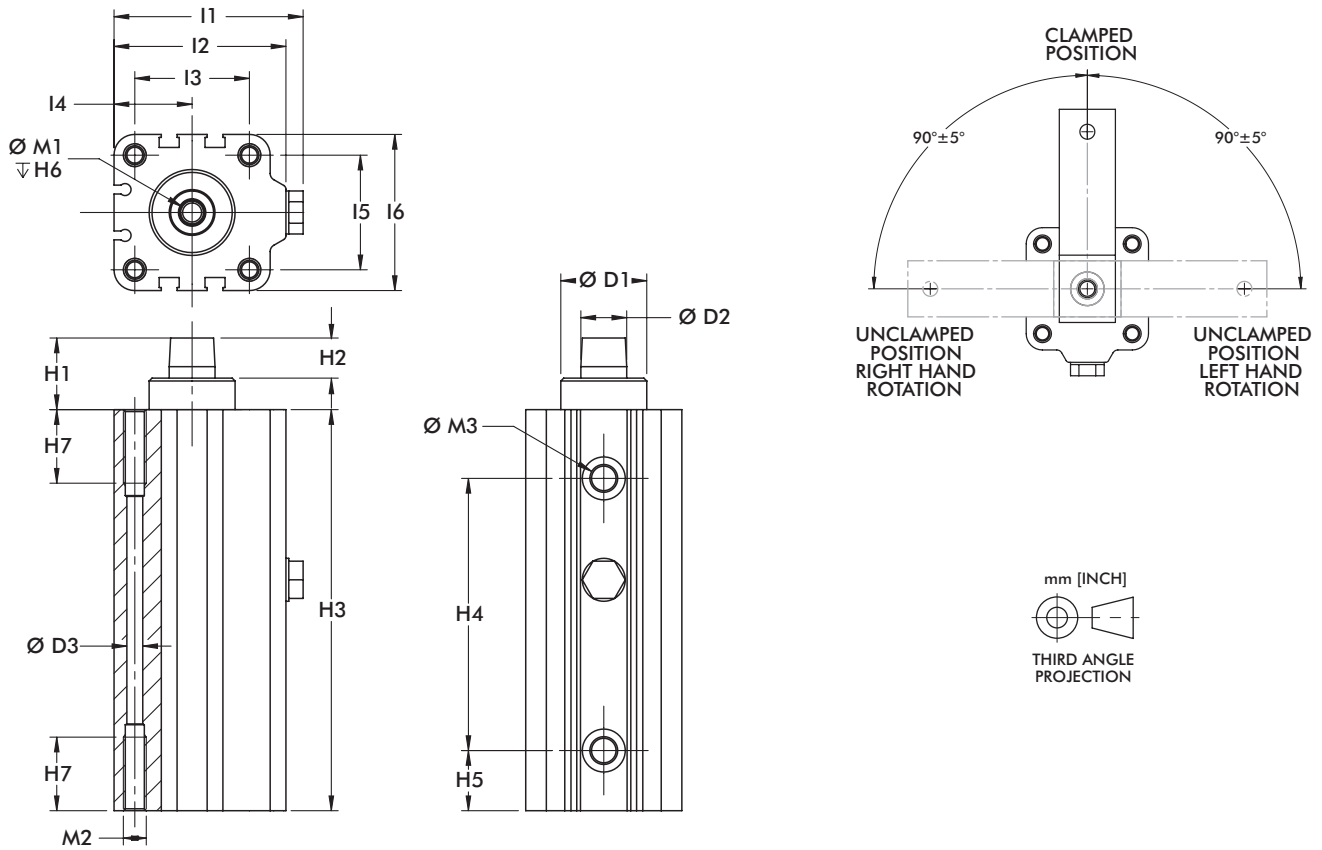
**Maximum Operating Temperature:** 60°C [140°F]

### Note:

Switches are optional. To order with (2) 8EA-109-1 switches, add **A** to the end of the model. Ex. 89R32-010-2**A**

# 89R SERIES

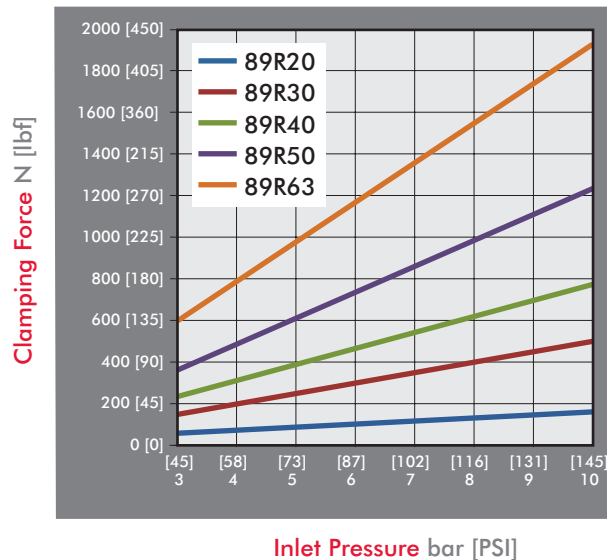
## Pneumatic Swing Clamps | Dimensions



| Model       | ØD1<br>H9    | ØD2<br>F7    | ØD3           | H1             | H2             | H3              | H4              | H5             | H6           | H7           | L1             | L2             |
|-------------|--------------|--------------|---------------|----------------|----------------|-----------------|-----------------|----------------|--------------|--------------|----------------|----------------|
| 89R20-010-2 | [0.71]<br>18 | [0.39]<br>10 | [0.18]<br>4,6 | [0.78]<br>19,8 | [0.47]<br>11,9 | [4.15]<br>105,5 | [2.60]<br>66    | [0.52]<br>13,2 | [0.59]<br>15 | [0.55]<br>14 | [1.56]<br>39,5 | [1.38]<br>35   |
| 89R32-010-2 | [0.87]<br>22 | [0.47]<br>12 |               | [0.93]<br>23,7 |                | [4.92]<br>125   | [3.27]<br>83    | [0.69]<br>17,5 |              | [0.63]<br>16 | [2.36]<br>60   | [2.13]<br>54   |
| 89R40-010-2 | [1.18]<br>30 | [0.63]<br>16 | [0.22]<br>5,5 | [0.98]<br>25   | [0.43]<br>11   | [5.51]<br>140   | [3.74]<br>95    | [0.83]<br>21   | [0.67]<br>17 |              | [2.60]<br>66   | [2.36]<br>60   |
| 89R40-025-2 |              |              |               |                |                | [6.69]<br>170   | [4.92]<br>125   |                |              | [0.98]<br>25 |                |                |
| 89R50-025-2 | [1.57]<br>40 | [0.71]<br>18 | [0.29]<br>7,4 | [1.24]<br>31,4 |                | [7.70]<br>195,5 | [5.39]<br>137   | [1.05]<br>26,7 | [0.98]<br>25 |              | [3.09]<br>78,5 | [2.85]<br>72,5 |
| 89R63-025-2 | [1.77]<br>45 | [0.78]<br>20 | [0.37]<br>9,3 | [1.30]<br>33   | [0.59]<br>15   | [8.33]<br>211,5 | [6.08]<br>154,5 | [1.04]<br>26,5 |              |              | [3.74]<br>95   | [3.46]<br>88   |

| Model       | L3           | L4             | L5           | L6             | M1  | M2  | M3    |
|-------------|--------------|----------------|--------------|----------------|-----|-----|-------|
| 89R20-010-2 | [0.87]<br>22 | [0.63]<br>16   | [0.87]<br>22 | [1.26]<br>32   | M5  | M6  | M5    |
| 89R32-010-2 | [1.42]<br>36 | [0.94]<br>24   | [1.26]<br>32 | [1.77]<br>45   | M6  |     |       |
| 89R40-010-2 | [1.57]<br>40 | [1.07]<br>27,3 | [1.57]<br>40 | [2.15]<br>54,5 | M8  | M8  | G-1/8 |
| 89R40-025-2 |              |                |              |                |     |     |       |
| 89R50-025-2 | [1.97]<br>50 | [1.28]<br>32,5 | [1.97]<br>50 | [2.56]<br>65   | M10 | M10 |       |
| 89R63-025-2 | [2.44]<br>62 | [1.57]<br>40   | [2.44]<br>62 | [3.15]<br>80   | M10 | M12 | G-1/4 |

Series 89R Clamping Force  
(w/ standard clamping arm)

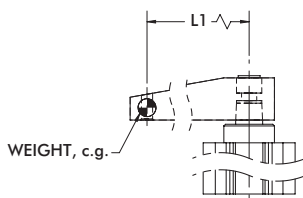


### Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

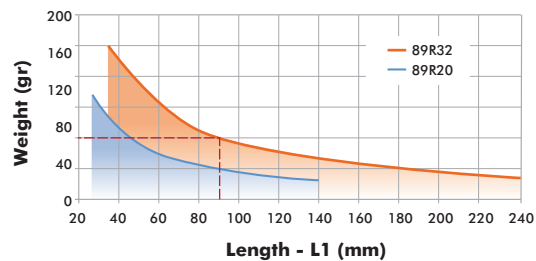
**Example: 89R32**

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

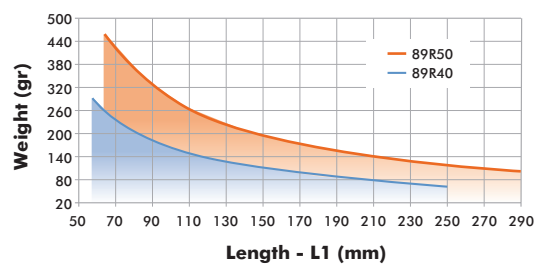


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

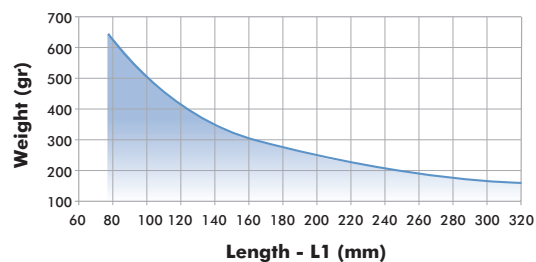
89R20 & 89R32 Clamp Arm Weight



89R40 & 89R50 Clamp Arm Weight



89R63 Clamp Arm Weight

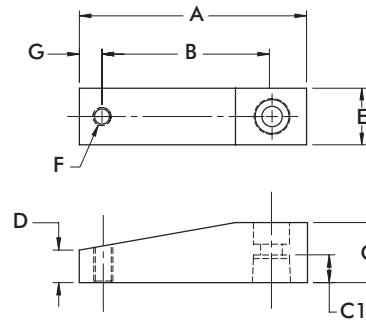
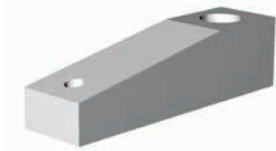


# 89R SERIES

## Pneumatic Swing Clamps | Clamping Arms

### Features:

- Lightweight aluminum construction
- Locking tapered connection for 360 deg. arm positioning

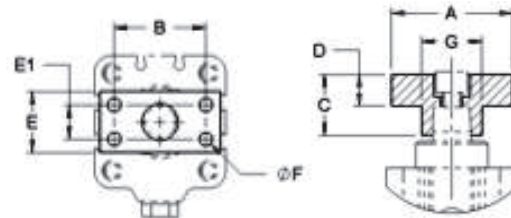
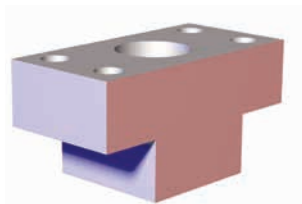


| Part Number | Used with Model             | A             | B            | C            | C1             | D              | E            | F   | G            | Weight [lbs] kg |
|-------------|-----------------------------|---------------|--------------|--------------|----------------|----------------|--------------|-----|--------------|-----------------|
| 8JG-215-1   | 89R20-010-2                 | [2.64]<br>67  | [2.05]<br>52 | [0.59]<br>15 | [0.33]<br>8,5  | [0.33]<br>8,5  | [0.59]<br>15 | M6  | [0.28]<br>7  | [0.08]<br>0,04  |
| 8JG-217-1   | 89R32-010-2                 | [3.15]<br>80  | [2.36]<br>60 | [0.79]<br>20 | [0.37]<br>9,5  |                | [0.79]<br>20 | M8  | [0.39]<br>10 | [0.14]<br>0,06  |
| 8JG-218-1   | 89R40-010-2,<br>89R40-025-2 | [3.74]<br>95  | [2.76]<br>70 | [0.98]<br>25 | [0.45]<br>11,5 | [0.55]<br>14   | [0.98]<br>25 |     |              | [0.28]<br>0,13  |
| 8JG-219-1   | 89R50-025-2                 | [4.17]<br>106 | [3.15]<br>80 | [1.18]<br>30 | [0.59]<br>15   | [0.57]<br>14,5 | [1.18]<br>30 | M10 | [0.47]<br>12 | [0.42]<br>0,19  |
| 8JG-220-1   | 89R63-025-2                 | [4.72]<br>120 | [3.54]<br>90 | [1.38]<br>35 | [0.67]<br>17   | [0.67]<br>17   | [1.38]<br>35 |     |              | [0.66]<br>0,30  |

## Clamping Arm Adapters

### Features:

- For attaching custom made clamp arms
- 360° rotatable arm
- Aluminum construction



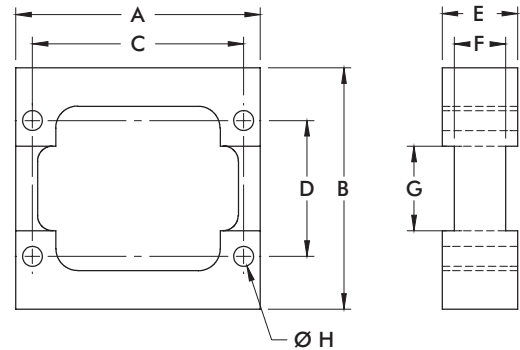
| Part Number | Used with Model             | A            | B            | C            | D            | E            | E1           | F                  | Weight [lbs] kg |
|-------------|-----------------------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------------|-----------------|
| 8MA-084-1   | 89R20-010-2                 | [1.57]<br>40 | [1.10]<br>28 | [0.59]<br>15 | [0.32]<br>8  | [0.59]<br>15 | --           | [0.22]<br>5,5 (2x) | [0.03]<br>0,014 |
| 8MA-086-1   | 89R32-010-2                 | [1.97]<br>50 | [1.38]<br>35 | [0.79]<br>20 | [0.43]<br>11 | [0.79]<br>20 |              |                    | [0.08]<br>0,035 |
| 8MA-087-1   | 89R40-010-2,<br>89R40-025-2 |              | [1.50]<br>38 | [0.98]<br>25 | [0.51]<br>13 | [0.98]<br>25 | [0.55]<br>14 | [0.22]<br>5,5 (4x) | [0.11]<br>0,050 |
| 8MA-088-1   | 89R50-025-2                 | [2.36]<br>60 | [1.77]<br>45 | [1.18]<br>30 | [0.59]<br>15 | [1.18]<br>30 | [0.59]<br>15 | [0.28]<br>7 (4x)   | [0.19]<br>0,085 |
| 8MA-089-1   | 89R63-025-2                 | [2.56]<br>65 | [1.89]<br>48 | [1.38]<br>35 | [0.67]<br>17 | [1.38]<br>35 | [0.71]<br>18 | [0.35]<br>9 (4x)   | [0.28]<br>0,125 |

# 89R SERIES

## Pneumatic Swing Clamps | Body Mount Flanges

### Features:

- For recessed mounting
- Variable height adjustment
- Can be used with switches
- For use with the **89R** Series Pneumatic Swing Clamps

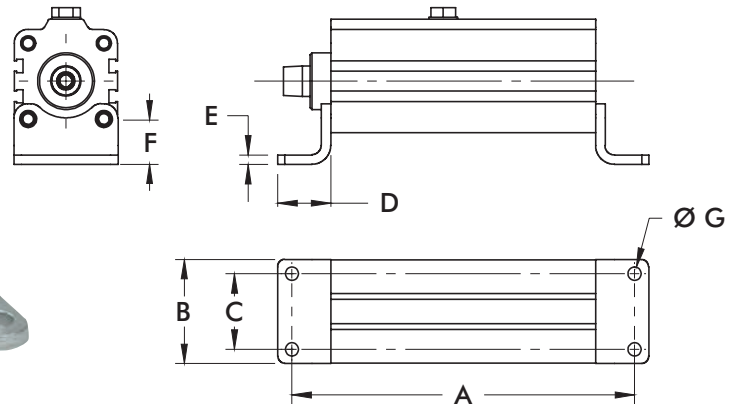


| Part Number | Used with Model | A               | B             | C              | D            | E            | F            | G            | H             | Weight [lbs] kg |
|-------------|-----------------|-----------------|---------------|----------------|--------------|--------------|--------------|--------------|---------------|-----------------|
| 8MA-092-1   | 89R20-010-2     | [2.24]<br>57    | [2.17]<br>55  | [1.85]<br>47   | [0.94]<br>24 | [0.59]<br>15 | --           | --           | [0.28]<br>5,5 | [0.22]<br>0,10  |
| 8MA-094-1   | 89R32-010-2     |                 | [2.95]<br>75  |                | [1.57]<br>40 | [0.79]<br>20 | [0.47]<br>12 | [0.98]<br>25 |               | [0.44]<br>0,20  |
| 8MA-095-1   | 89R40-010-2     | [3.19]<br>81    | [3.15]<br>80  | [2.55]<br>70   | [1.77]<br>45 | [0.98]<br>25 | [0.67]<br>17 | [1.10]<br>28 | [0.26]<br>6,6 | [0.55]<br>0,25  |
|             | 89R40-025-2     |                 |               |                |              |              |              | [1.46]<br>37 | [0.35]<br>9   | [0.88]<br>0,40  |
| 8MA-096-1   | 89R50-025-2     | [4.00]<br>101,5 | [3.94]<br>100 | [3.37]<br>85,5 | [1.97]<br>50 |              |              |              |               |                 |

## Mounting Feet

### Features:

- Can be mounted on bottom side or front side
- Can be mounted on 4 sides of the cylinder
- For use with **89R** Series Pneumatic Swing Clamps



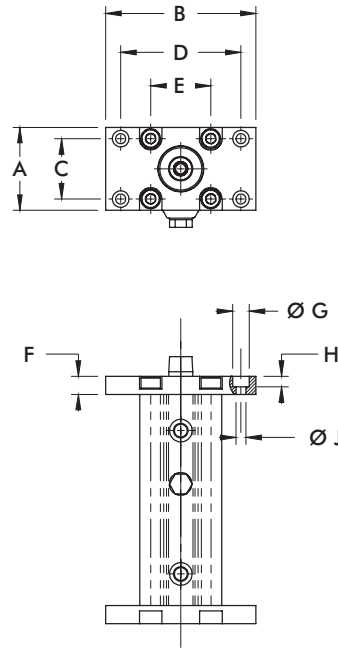
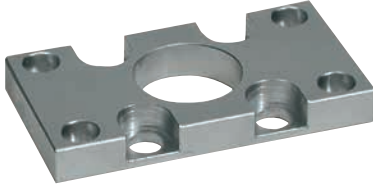
| Part Number | Used with Model | A                | B            | C            | D            | E           | F            | G            | Weight [lbs] kg |
|-------------|-----------------|------------------|--------------|--------------|--------------|-------------|--------------|--------------|-----------------|
| 8MW-018-1   | 89R20-010-2     | [5.41]<br>137,5  | [1.38]<br>35 | [0.87]<br>22 | [0.87]<br>22 | [0.16]<br>4 | [0.63]<br>16 |              | [0.08]<br>0,04  |
| 8MW-020-1   | 89R32-010-2     | [6.54]<br>166    | [1.97]<br>50 | [1.38]<br>35 |              |             | [0.71]<br>18 | [0.28]<br>7  | [0.15]<br>0,07  |
| 8MW-021-1   | 89R40-010-2     | [7.13]<br>181    | [2.17]<br>55 | [1.57]<br>40 | [1.10]<br>28 | [0.20]<br>5 | [0.94]<br>24 |              | [0.22]<br>0,10  |
|             | 89R40-025-2     | [8.31]<br>211    |              |              |              |             |              |              | [0.35]<br>9     |
| 8MW-022-1   | 89R50-025-2     | [9.39]<br>238,5  | [2.64]<br>67 | [1.97]<br>50 | [1.26]<br>32 | [0.24]<br>6 | [1.06]<br>27 | [0.43]<br>11 | [0.52]<br>0,24  |
| 8MW-023-1   | 89R63-025-2     | [10.37]<br>263,5 | [3.35]<br>85 | [2.44]<br>62 | [1.57]<br>40 |             |              |              |                 |

# 89R SERIES

## Pneumatic Swing Clamps | End Mount Flanges

### Features:

- Can be mounted on bottom side or top side
- For use with **89R** Pneumatic Swing Clamps



| Part Number | Used with Model             | A            | B             | C<br>[±0.008]<br>±0,2 | D<br>[±0.008]<br>±0,2 | E            | F            | G            | H           | J             | Weight<br>[lbs]kg |
|-------------|-----------------------------|--------------|---------------|-----------------------|-----------------------|--------------|--------------|--------------|-------------|---------------|-------------------|
| 8MA-061-1   | 89R20-010-2                 | [1.26]<br>32 | [2.56]<br>65  | [0.71]<br>18          | [1.97]<br>50          | [0.87]<br>22 | [0.39]<br>10 |              |             |               | [0.07]<br>0,03    |
| 8MA-063-1   | 89R32-010-2                 | [1.97]<br>50 | [3.15]<br>80  | [1.26]<br>32          | [2.52]<br>64          | [1.26]<br>32 | [0.47]<br>12 | [0.43]<br>11 | [0.28]<br>7 | [0.26]<br>6,6 | [0.20]<br>0,09    |
| 8MA-064-1   | 89R40-010-2,<br>89R40-025-2 | [2.17]<br>55 | [3.94]<br>100 | [1.57]<br>40          | [3.15]<br>80          | [1.57]<br>40 |              |              |             |               | [0.29]<br>0,13    |
| 8MA-065-1   | 89R50-025-2                 | [2.56]<br>65 | [4.72]<br>120 | [1.77]<br>45          | [3.94]<br>100         | [1.97]<br>50 | [0.59]<br>15 | [0.59]<br>15 | [0.35]<br>9 | [0.33]<br>8,5 | [0.46]<br>0,21    |
| 8MA-066-1   | 89R63-025-2                 | [3.15]<br>80 | [5.12]<br>130 | [2.36]<br>60          | [4.33]<br>110         | [2.44]<br>62 |              |              |             | [0.35]<br>8,8 | [0.66]<br>0,30    |

### Features:

- Lightweight and robust, designed for several millions cycles
- Can be mounted from the side or the top
- Sensor ready for T-slot style sensors
- Metric design
- Clamp arm sold separately

### Applications:

- Assembly
- Welding
- Light machining

### Also Available:

See page MC-PSC-17 for clamping arms  
See page MC-PSC-40 for sensing options

### Series 89B



### Technical Information

| Model        | Swing Direction | Total Stroke [in] mm<br>S | Stroke During Rotation [in] mm<br>S1 | Vertical Clamp Stroke [in] mm<br>S2 | Clamping Force [lbf.]<br>N† | Bore Size mm[in] | Air Consumption‡ [ft³] dm³ | Weight [lbs] kg | Replacement Seal Kit |
|--------------|-----------------|---------------------------|--------------------------------------|-------------------------------------|-----------------------------|------------------|----------------------------|-----------------|----------------------|
| 89B20-010-2R | RH              | [0.79]                    | [0.39]                               |                                     | [29]                        | [0.79]           | [0.003]                    | [1.46]          | 89B/E20-2-00         |
| 89B20-010-2L | LH              | 20                        | 10                                   |                                     | 130                         | 20               | 0,08                       | 0,66            |                      |
| 89B32-010-2R | RH              | [0.83]                    | [0.43]                               | [0.39]                              | [79]                        | [1.25]           | [0.008]                    | [2.25]          | 89B/E32-2-00         |
| 89B32-010-2L | LH              | 21                        | 11                                   | 10                                  | 350                         | 32               | 0,22                       | 1,02            |                      |
| 89B40-010-2R | RH              | [0.94]                    | [0.55]                               |                                     | [130]                       | [1.57]           | [0.014]                    | [3.17]          | 89B/E40-2-00         |
| 89B40-010-2L | LH              | 24                        | 14                                   |                                     | 580                         | 40               | 0,39                       | 1,44            |                      |
| 89B50-025-2R | RH              | [1.57]                    | [0.59]                               | [0.98]                              | [225]                       | [1.97]           | [0.036]                    | [5.95]          | 89B/E50-2-00         |
| 89B50-025-2L | LH              | 40                        | 15                                   | 25                                  | 1000                        | 50               | 1,03                       | 2,70            |                      |
| 89B63-008-2R | RH              | [1.02]                    | [0.71]                               | [0.32]                              | [321]                       | [2.48]           | [0.038]                    | [6.39]          | 89B/E63-2-00         |
| 89B63-008-2L | LH              | 26                        | 18                                   | 8                                   | 1430                        | 63               | 1,08                       | 2,90            |                      |

† with standard clamping arm at 6 bar [87psi]. ‡ per double stroke at 6 bar [87psi]

**Operating Pressure Range:** 3 bar [45 psig] to 6 bar [87 psig]

**Maximum Operating Temperature:** 80°C [176°F]

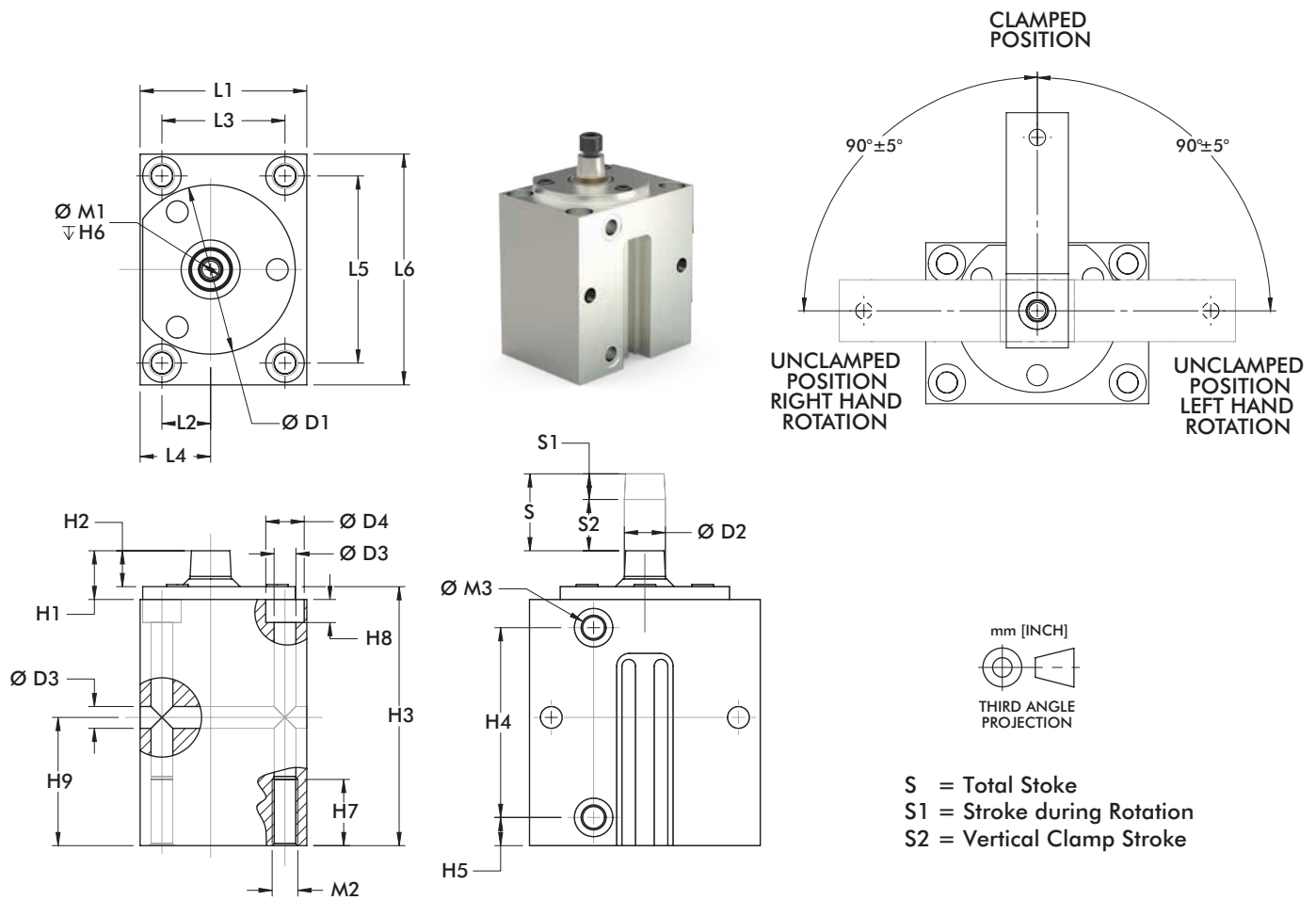
### Note:

Switches are optional. To order clamp with (2) 8EA-109-1 switches, add **A** to the end of the model.

EX. 89B30-010-2**RA**. See page MC-PSC-40 for additional switch options.

# 89B SERIES

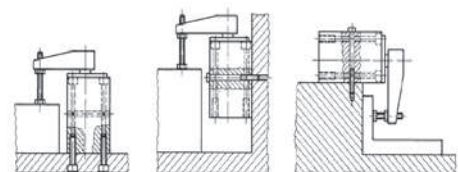
## Pneumatic Swing Clamps | Dimensions



| Model | ØD1          | ØD2          | ØD3           | D4           | H1             | H2           | H3             | H4            | H5           | H6           | H7           | H8           | H9           | L1           |
|-------|--------------|--------------|---------------|--------------|----------------|--------------|----------------|---------------|--------------|--------------|--------------|--------------|--------------|--------------|
| 89B20 | [1.89]<br>48 | [0.39]<br>10 | [0.26]<br>6,6 | [0.43]<br>11 | [0.69]<br>17,5 | [0.35]<br>9  | [3.48]<br>88,5 | [2.28]<br>58  | [0.35]<br>9  | [0.59]<br>15 | [0.79]<br>20 | [0.28]<br>7  | [1.57]<br>40 | [1.77]<br>45 |
| 89B32 | [2.20]<br>56 | [0.47]<br>12 | [0.33]        | [0.59]       | [0.63]<br>16   | [0.43]<br>11 | [3.70]<br>94   | [2.72]<br>69  | [0.39]<br>10 | [0.67]<br>17 | [0.98]<br>25 | [0.35]<br>9  | [1.77]<br>45 | [2.17]<br>55 |
| 89B40 | [2.60]<br>66 | [0.63]<br>16 | 8,5           | 15           | [0.75]<br>19   | [0.55]<br>14 | [3.98]<br>101  | [2.91]<br>74  |              |              |              |              | [1.97]<br>50 | [2.56]<br>65 |
| 89B50 | [3.07]<br>78 | [0.71]<br>18 | [0.41]        | [0.71]       | [0.98]<br>25   | [0.67]<br>17 | [5.51]<br>140  | [4.29]<br>109 | [0.43]<br>11 | [0.98]<br>25 | [1.18]<br>30 | [0.43]<br>11 | [2.76]<br>70 | [2.95]<br>75 |
| 89B63 | [3.70]<br>94 | [0.79]<br>20 | 10,5          | 18           | [1.06]<br>27   | [0.75]<br>19 | [4.53]<br>115  | [3.35]<br>85  |              |              |              |              | [2.16]<br>55 | [3.54]<br>90 |

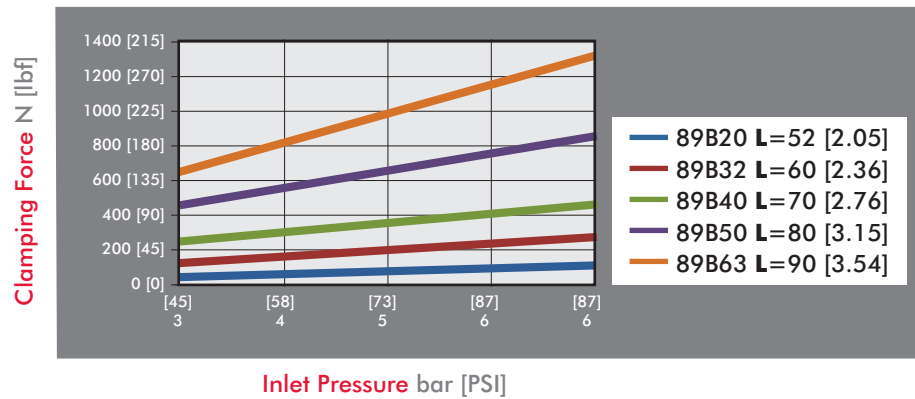
| Model | L2             | L3           | L4             | L5            | L6            | M1  | M2  | M3    |
|-------|----------------|--------------|----------------|---------------|---------------|-----|-----|-------|
| 89B20 | [0.45]<br>11,5 | [1.18]<br>30 | [0.75]<br>19   | [2.36]<br>60  | [2.95]<br>75  | M5  | M8  | M5    |
| 89B32 | [0.55]<br>14   | [1.50]<br>38 | [0.89]<br>22,5 | [2.68]<br>68  | [3.35]<br>85  | M6  | M10 |       |
| 89B40 | [0.75]<br>19   | [1.89]<br>48 | [1.08]<br>27,5 | [2.87]<br>73  | [3.54]<br>90  | M8  |     | G-1/8 |
| 89B50 | [0.94]<br>24   | [2.17]<br>55 | [1.34]<br>34   | [3.54]<br>90  | [4.33]<br>110 |     | M12 |       |
| 89B63 | [1.18]<br>30   | [2.76]<br>70 | [1.57]<br>40   | [3.94]<br>100 | [4.72]<br>120 | M10 |     | G-1/4 |

### Mounting Options





Series 89B Clamping Force  
(w/ standard clamping arm)

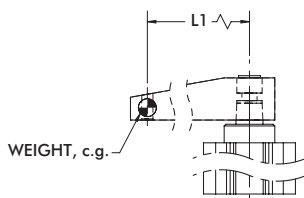


### Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

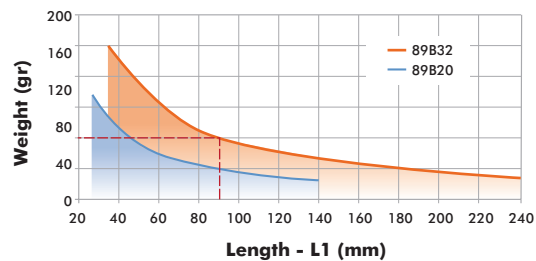
**Example: 89B32**

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

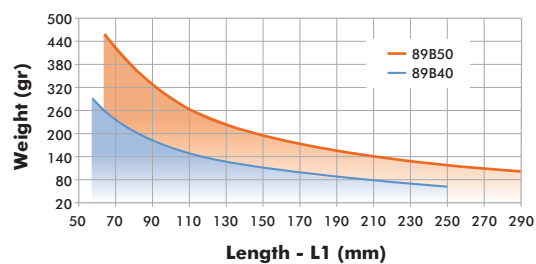


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

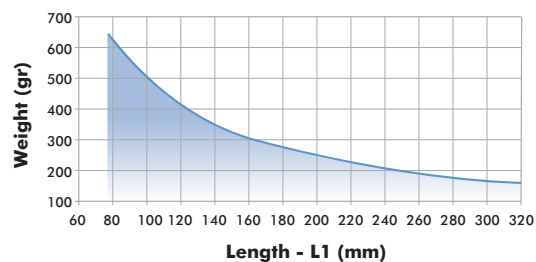
89B20 & 89B32 Clamp Arm Weight



89B40 & 89B50 Clamp Arm Weight



89B63 Clamp Arm Weight

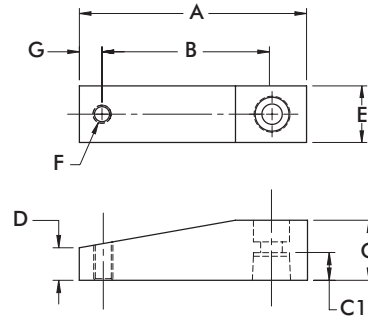
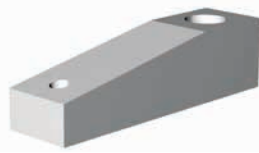


# 89B SERIES

## Pneumatic Swing Clamps | Clamping Arm

### Features:

- Lightweight aluminum construction
- Locking tapered connection for 360 deg. arm positioning

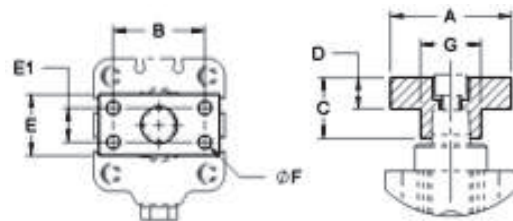
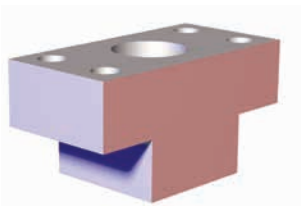


| Part Number | Used with Model | A             | B            | C            | C1             | D              | E            | F   | G            | Weight [lbs] kg |
|-------------|-----------------|---------------|--------------|--------------|----------------|----------------|--------------|-----|--------------|-----------------|
| 8JG-215-1   | 89B20-010-2     | [2.64]<br>67  | [2.05]<br>52 | [0.59]<br>15 | [0.33]<br>8,5  | [0.33]<br>8,5  | [0.59]<br>15 | M6  | [0.28]<br>7  | [0.08]<br>0,04  |
| 8JG-217-1   | 89B32-010-2     | [3.15]<br>80  | [2.36]<br>60 | [0.79]<br>20 | [0.37]<br>9,5  |                | [0.79]<br>20 | M8  | [0.39]<br>10 | [0.14]<br>0,06  |
| 8JG-218-1   | 89B40-010-2     | [3.74]<br>95  | [2.76]<br>70 | [0.98]<br>25 | [0.45]<br>11,5 | [0.55]<br>14   | [0.98]<br>25 |     |              | [0.28]<br>0,13  |
| 8JG-219-1   | 89B50-025-2     | [4.17]<br>106 | [3.15]<br>80 | [1.18]<br>30 | [0.59]<br>15   | [0.57]<br>14,5 | [1.18]<br>30 |     |              | [0.42]<br>0,19  |
| 8JG-220-1   | 89B63-008-2     | [4.72]<br>120 | [3.54]<br>90 | [1.38]<br>35 | [0.67]<br>17   | [0.67]<br>17   | [1.38]<br>35 | M10 | [0.47]<br>12 | [0.66]<br>0,30  |

## Clamping Arm Adapters

### Features:

- For attaching custom made clamp arms
- 360° rotatable arm
- Aluminum construction



| Part Number | Used with Model | A            | B            | C            | D            | E            | E1           | F                  | Weight [lbs] kg |
|-------------|-----------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------------|-----------------|
| 8MA-084-1   | 89B20-010-2     | [1.57]<br>40 | [1.10]<br>28 | [0.59]<br>15 | [0.32]<br>8  | [0.59]<br>15 | --           | [0.22]             | [0.03]<br>0,014 |
| 8MA-086-1   | 89B32-010-2     | [1.97]<br>50 | [1.38]<br>35 | [0.79]<br>20 | [0.43]<br>11 | [0.79]<br>20 | --           | 5,5 (2x)           | [0.08]<br>0,035 |
| 8MA-087-1   | 89B40-010-2     |              | [1.50]<br>38 | [0.98]<br>25 | [0.51]<br>13 | [0.98]<br>25 | [0.55]<br>14 | [0.22]<br>5,5 (4x) | [0.11]<br>0,050 |
| 8MA-088-1   | 89B50-025-2     | [2.36]<br>60 | [1.77]<br>45 | [1.18]<br>30 | [0.59]<br>15 | [1.18]<br>30 | [0.59]<br>15 | [0.28]<br>7 (4x)   | [0.19]<br>0,085 |
| 8MA-089-1   | 89B63-008-2     | [2.56]<br>65 | [1.89]<br>48 | [1.38]<br>35 | [0.67]<br>17 | [1.38]<br>35 | [0.71]<br>18 | [0.35]<br>9 (4x)   | [0.28]<br>0,125 |



# 8100, 8300 SERIES

## Pneumatic Swing Clamps | Product Overview

### Features:

- Lightweight and robust, designed for several millions cycles
- Block style body may be mounted from the side or the top.
- Sensor ready for use with round style sensors
- Clamp arm and spindle included

### Applications:

- Assembly
- Welding
- Light machining

### Also Available:

See page MC-PSC-22 for clamping arms  
See page MC-PSC-40 for sensing options

8115  
Right-hand  
Swing



8116  
Left-hand  
Swing



8315  
Right-hand  
Swing



8316  
Left-hand  
Swing



## Technical Information

| Model | Swing Direction | Total Stroke [in] mm | Stroke During Rotation [in] mm | Vertical Clamp Stroke [in] mm | Clamping Force [lbf.] N† | Bore Size mm[in] | Air Consumption‡ [ft³] dm³ | Weight [lbs] kg | Replacement Seal Kit |
|-------|-----------------|----------------------|--------------------------------|-------------------------------|--------------------------|------------------|----------------------------|-----------------|----------------------|
| 8115  | RH              | [0.85]               | [0.47]                         | [0.38]                        | [25]                     | [0.75]           | [0.002]                    | [0.68]          | 801560               |
| 8116  | LH              | 21,5                 | 11,8                           | 9,7                           | 110                      | 19,1             | 0,06                       | 0,31            |                      |
| 8315  | RH              | [1.25]               | [0.75]                         | [0.50]                        | [89]                     | [1.50]           | [0.014]                    | [2.00]          | 821560               |
| 8316  | LH              | 31,8                 | 19,1                           | 12,7                          | 400                      | 38,1             | 0,40                       | 0,91            |                      |

† with standard clamping arm at 5 bar [72psi]. ‡ per double stroke at 5 bar [72psi]

**Operating Pressure Range:** 3 bar [45 psig] to 9 bar [130 psig]  
**Maximum Operating Temperature:** -18°C to 60°C [0°F to 140°F]

### Note:

To order without clamping arm add **-LA** to the end of the model. Ex. 8315-**LA**



# 8100, 8300 SERIES

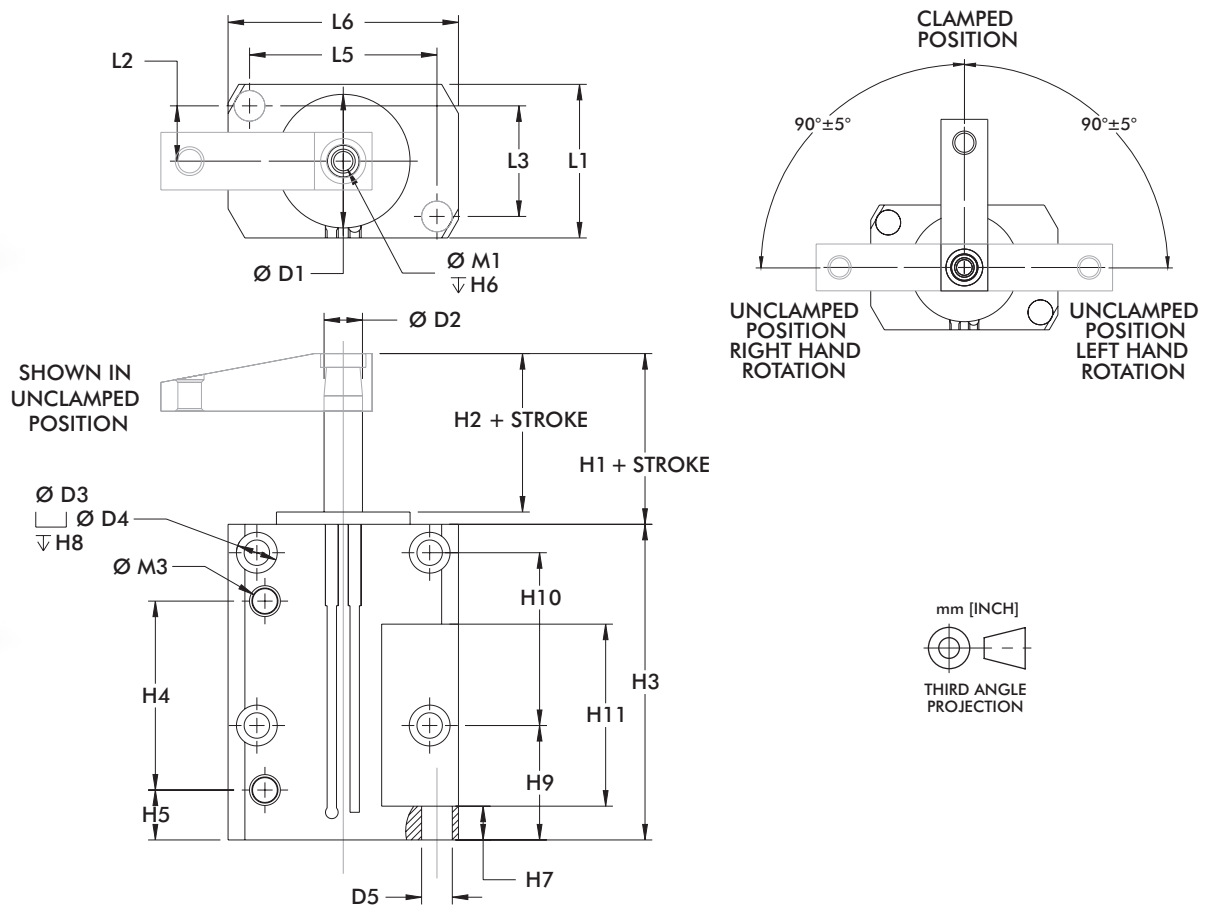
## Pneumatic Swing Clamps | Dimensions



Unclamped



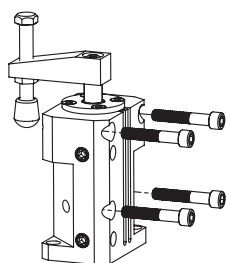
Clamped



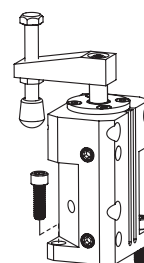
| Model | ØD1    | ØD2    | ØD3    | ØD4    | ØD5    | Stroke | H1     | H2     | H3     | H4     | H5     | H6     |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 8115  | [1.23] | [0.44] | [0.20] | --     | --     | [0.85] | [0.53] | [0.41] | [3.37] | [1.45] | [0.35] | [0.75] |
| 8116  | 31,2   | 11,2   | 5,1    | --     | --     | 21,5   | 13,5   | 10,4   | 85,6   | 36,8   | 8,9    | 19,1   |
| 8315  | [1.74] | [0.50] | [0.33] | [0.53] | [0.40] | [1.25] | [0.97] | [0.81] | [4.11] | [2.46] | [0.65] | [0.67] |
| 8316  | 44,2   | 12,7   | 8,4    | 13,5   | 10,2   | 31,8   | 24,6   | 20,6   | 104,4  | 62,5   | 16,5   | 17     |

| Model | H7     | H8     | H9     | H10    | H11    | L1     | L2     | L3     | L5     | L6     | M1      | M3      |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|---------|---------|
| 8115  | [0.25] | --     | [1.37] | [1.00] | [1.00] | [1.25] | [0.47] | [0.94] | [0.94] | [1.25] | ¼-20    | #10-32  |
| 8116  | 6,4    | --     | 34,8   | 25,4   | 25,4   | 31,8   | 11,9   | 23,9   | 23,9   | 31,8   |         |         |
| 8315  | [0.44] | [1.00] | [1.49] | [2.25] | [2.37] | [2.00] | [0.72] | [1.44] | [2.44] | [3.00] | 5/16/18 | 1/8 NPT |
| 8316  | 11,2   | 25,4   | 37,9   | 57,2   | 60,2   | 50,8   | 18,3   | 36,6   | 62     | 76,2   |         |         |

### Mounting Options



Can be mounted to the side or front of the fixture, or mounted back to back for multiple clamping operations.

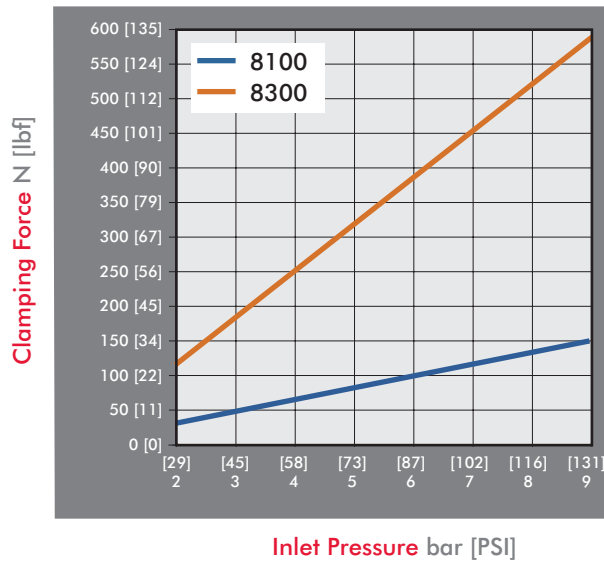


Mounted to the top of the work surface through the two mounting holes in the bottom of unit.

# 8100, 8300 SERIES

## Pneumatic Swing Clamps | Clamping Forces

Series 8100, 8300 Clamping Force  
(w/ standard clamping arm)

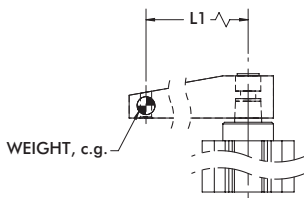


### Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

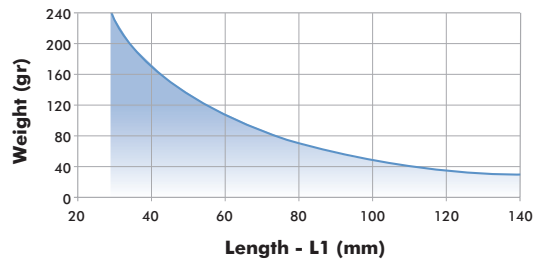
#### Example: 8315

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

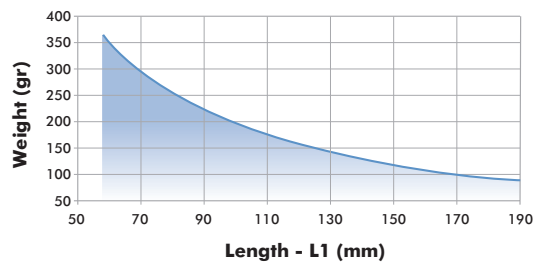


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

8115/8116 Clamp Arm Weight



8315/8316 Clamp Arm Weight

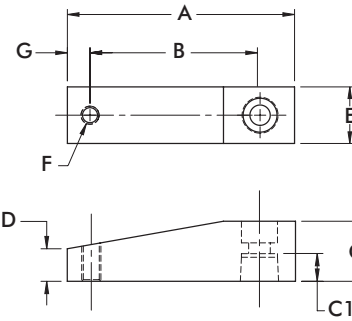
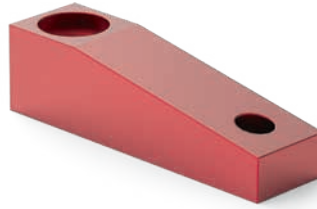


# 8100, 8300 SERIES

## Pneumatic Swing Clamps | Clamping Arms

### Features:

- Lightweight aluminum construction
- Locking tapered connection for 360 deg. arm positioning

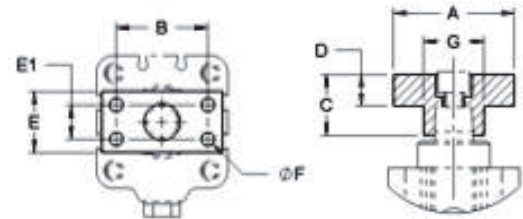
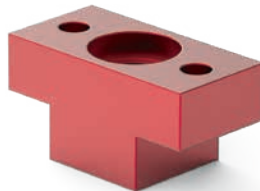


| Part Number | Used with Model | A              | B              | C              | C1             | D             | E              | F      | G             | Weight [lbs] kg |
|-------------|-----------------|----------------|----------------|----------------|----------------|---------------|----------------|--------|---------------|-----------------|
| 801528      | 8115, 8116      | [1.74]<br>44,2 | [1.11]<br>28,2 | [0.37]<br>9,4  | [0.33]<br>8,3  | [0.25]<br>6,4 | [0.62]<br>15,7 | #10-32 | [0.32]<br>8,1 | [0.03]<br>0,01  |
| 801529      |                 | [2.87]<br>72,9 | [2.24]<br>56,9 |                |                |               |                |        |               |                 |
| 821512      | 8315, 8316      | [2.75]<br>69,9 | [2.00]<br>50,8 | [0.75]<br>19,1 | [0.57]<br>14,5 | [0.38]<br>9,5 | [0.75]<br>19,1 | 3/8-16 | [0.38]<br>9,5 | [0.05]<br>0,02  |
| 821513      |                 | [3.75]<br>95,3 | [3.00]<br>76,2 |                |                |               |                |        |               |                 |

## Clamping Arm Adapters

### Features:

- For attaching custom made clamp arms
- 360° rotatable arm
- Aluminum construction



| Part Number | Used with Model | A              | B              | C             | D             | E              | E1 | F              | Weight [lbs] kg |
|-------------|-----------------|----------------|----------------|---------------|---------------|----------------|----|----------------|-----------------|
| 801532      | 8115, 8116      | [1.37]<br>34,8 | [1.00]<br>25,4 | [0.39]<br>9,1 | [0.25]<br>6,4 | [0.62]<br>15,7 | -- | #10-32<br>(2x) | [0.03]<br>0,014 |
| 821556      | 8315, 8316      | [1.50]<br>38,1 | [1.06]<br>26,9 | [0.75]<br>19  | [0.37]<br>9,4 | [0.75]<br>19   | -- | 1/4-20<br>(2x) | [0.05]<br>0,020 |

# 89E SERIES

## Pneumatic Swing Clamps | Product Overview

### Features:

- Lightweight and robust, designed for several millions cycles
- Threaded body may be mounted in a tapped hole or a clearance hole with optional mounting flange
- Metric design
- Clamp arm sold separately

### Applications:

- Assembly
- Welding
- Light machining

### Also Available:

See page MC-PSC-26 for clamping arms

See page MC-PSC-27 for mounting flanges

### Series 89E



## Technical Information

| Model        | Swing Direction | Total Stroke<br>[in] mm<br>S | Stroke During Rotation<br>[in] mm<br>S1 | Vertical Clamp Stroke<br>[in] mm<br>S2 | Clamping Force [lbf.]<br>N† | Bore Size<br>mm[in] | Air Consumption‡<br>[ft³] dm³ | Weight<br>[lbs] kg | Replacement Seal Kit |
|--------------|-----------------|------------------------------|---|--|-----------------------------|---------------------|-------------------------------|--------------------|----------------------|
| 89E20-010-2R | RH              | [0.79]                       | [0.39]                                  |  | [29]                        | [0.79]              | [0.003]                       | [0.64]             | 89B/E20-2-00         |
| 89E20-010-2L | LH              | 20                           | 10                                      |  | 130                         | 20                  | 0,08                          | 0,29               |                      |
| 89E32-010-2R | RH              | [0.83]                       | [0.43]                                  | [0.39]                                 | [79]                        | [1.25]              | [0.008]                       | [0.93]             | 89B/E32-2-00         |
| 89E32-010-2L | LH              | 21                           | 11                                      | 10                                     | 350                         | 32                  | 0,22                          | 0,42               |                      |
| 89E40-010-2R | RH              | [0.94]                       | [0.55]                                  |  | [130]                       | [1.57]              | [0.014]                       | [1.76]             | 89B/E40-2-00         |
| 89E40-010-2L | LH              | 24                           | 14                                      |  | 580                         | 40                  | 0,39                          | 0,80               |                      |
| 89E50-025-2R | RH              | [1.57]                       | [0.59]                                  | [0.98]                                 | [225]                       | [1.97]              | [0.036]                       | [3.22]             | 89B/E50-2-00         |
| 89E50-025-2L | LH              | 40                           | 15                                      | 25                                     | 1000                        | 50                  | 1,03                          | 1,46               |                      |
| 89E63-008-2R | RH              | [1.02]                       | [0.71]                                  | [0.32]                                 | [321]                       | [2.48]              | [0.038]                       | [3.68]             | 89B/E63-2-00         |
| 89E63-008-2L | LH              | 26                           | 18                                      | 8                                      | 1430                        | 63                  | 1,08                          | 1,67               |                      |

† with standard clamping arm at 6 bar [87psi]. ‡ per double stroke at 6 bar [87psi]

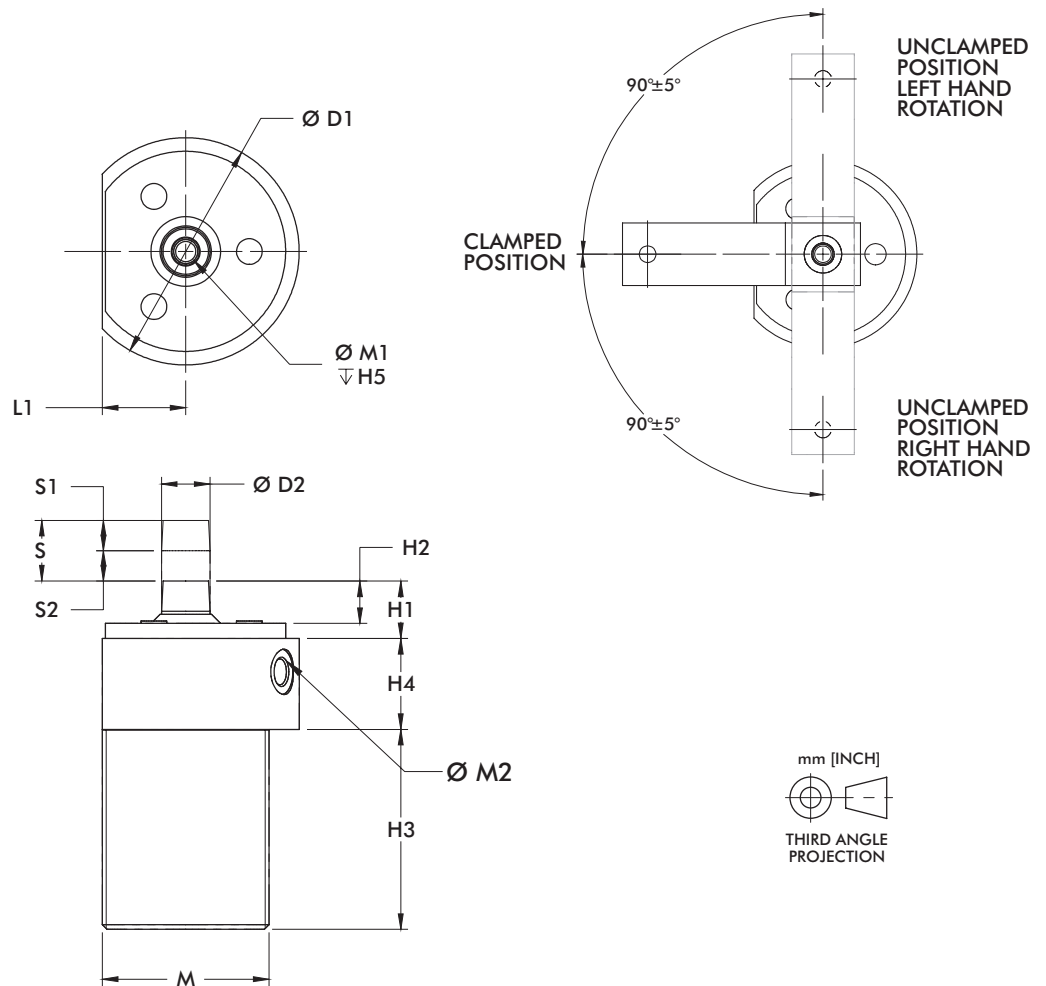
**Operating Pressure Range:** 3 bar [45 psig] to 10 bar [145 psig] (89E20 8 bar [116 psig] max.)

**Maximum Operating Temperature:** 80°C [176°F]



# 89E SERIES

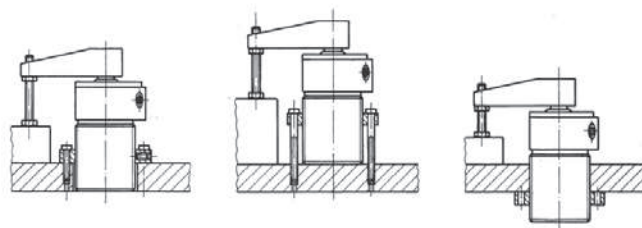
## Pneumatic Swing Clamps | Dimensions



S = Total Stroke  
 S1 = Stroke during Rotation  
 S2 = Vertical Clamp Stroke

| Model | ØD1           | ØD2          | H1             | H2           | H3            | H4           | H5             | L1             | M       | M1    | M2    |
|-------|---------------|--------------|----------------|--------------|---------------|--------------|----------------|----------------|---------|-------|-------|
| 89E20 | [1.89]<br>48  | [0.39]<br>10 | [0.69]<br>17,5 | [0.35]<br>9  | [2.36]<br>60  | [0.79]<br>20 | [0.59]<br>15   | [0.75]<br>19   | M36X1,5 | M5    | M5    |
| 89E32 | [2.52]<br>64  | [0.47]<br>12 | [0.63]<br>16   | [0.43]<br>11 | [2.72]<br>69  |              | [0.67]<br>17   | [0.89]<br>22,5 | M42X1,5 | M6    |       |
| 89E40 | [2.95]<br>75  | [0.63]<br>16 | [0.75]<br>19   | [0.55]<br>14 | [2.60]<br>66  | [1.18]<br>30 | [0.98]<br>25   | [1.08]<br>27,5 | M55X2   | M8    | G-1/8 |
| 89E50 | [3.54]<br>90  | [0.71]<br>18 | [0.98]<br>25   | [0.67]<br>17 | [4.09]<br>104 |              | [1.36]<br>34,5 | M68X2          | M10     |       |       |
| 89E63 | [4.13]<br>105 | [0.79]<br>20 | [1.06]<br>27   | [0.75]<br>19 | [3.03]<br>77  |              | [1.57]<br>40   | M80X2          | M10     | G-1/4 |       |

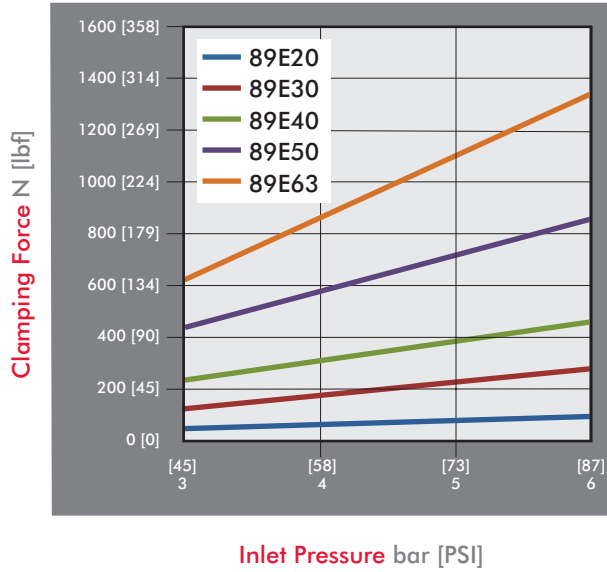
### Mounting Options



# 89E SERIES

## Pneumatic Swing Clamps | Clamping Forces

Series 89E Clamping Force  
(w/ standard clamping arm)

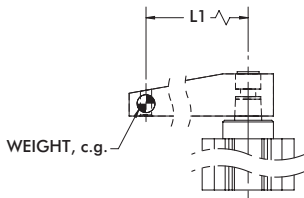


### Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

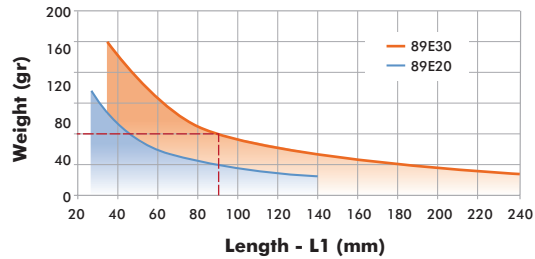
#### Example: 89E32

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

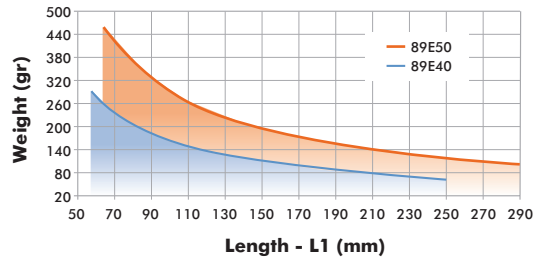


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

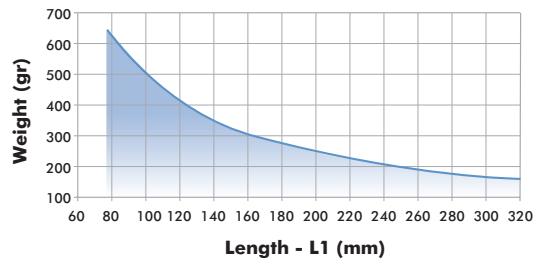
89E20 & 89E32 Clamp Arm Weight



89E40 & 89E50 Clamp Arm Weight



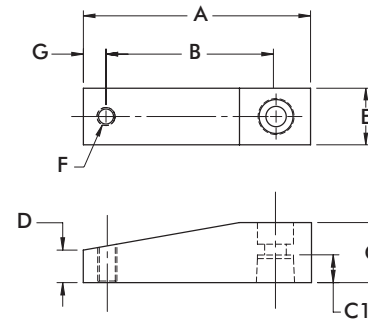
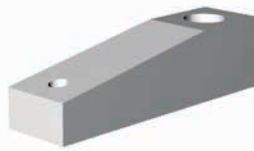
89E63 Clamp Arm Weight



## Pneumatic Swing Clamps | Clamping Arms

### Features:

- Lightweight aluminum construction
- Locking tapered connection for 360 deg. arm positioning

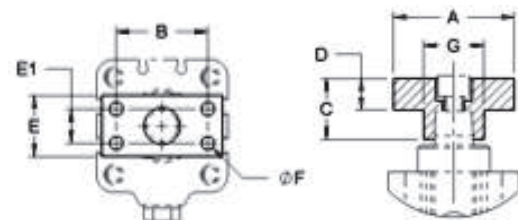
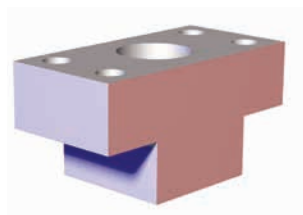


| Part Number | Used with Model | A             | B            | C            | C1             | D              | E            | F   | G            | Weight [lbs] kg |
|-------------|-----------------|---------------|--------------|--------------|----------------|----------------|--------------|-----|--------------|-----------------|
| 8JG-215-1   | 89E20-010-2     | [2.64]<br>67  | [2.05]<br>52 | [0.59]<br>15 | [0.33]<br>8,5  | [0.33]<br>8,5  | [0.59]<br>15 | M6  | [0.28]<br>7  | [0.08]<br>0,04  |
| 8JG-217-1   | 89E32-010-2     | [3.15]<br>80  | [2.36]<br>60 | [0.79]<br>20 | [0.37]<br>9,5  |                | [0.79]<br>20 | M8  | [0.39]<br>10 | [0.14]<br>0,06  |
| 8JG-218-1   | 89E40-010-2     | [3.74]<br>95  | [2.76]<br>70 | [0.98]<br>25 | [0.45]<br>11,5 | [0.55]<br>14   | [0.98]<br>25 |     |              | [0.28]<br>0,13  |
| 8JG-219-1   | 89E50-025-2     | [4.17]<br>106 | [3.15]<br>80 | [1.18]<br>30 | [0.59]<br>15   | [0.57]<br>14,5 | [1.18]<br>30 | M10 | [0.47]<br>12 | [0.42]<br>0,19  |
| 8JG-220-1   | 89E63-008-2     | [4.72]<br>120 | [3.54]<br>90 | [1.38]<br>35 | [0.67]<br>17   | [0.67]<br>17   | [1.38]<br>35 |     |              | [0.66]<br>0,30  |

## Clamping Arm Adapters

### Features:

- For attaching custom made clamp arms
- 360° rotatable arm
- Aluminum construction



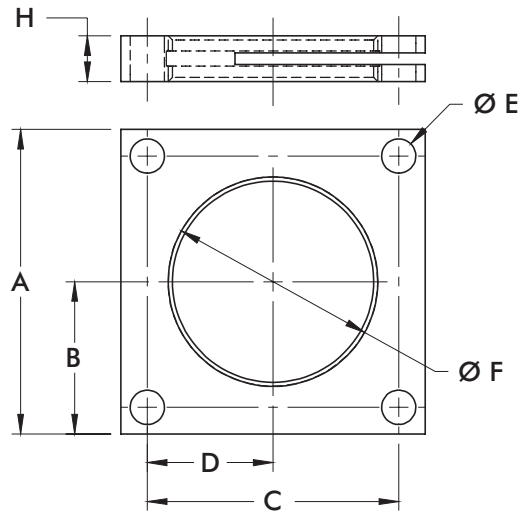
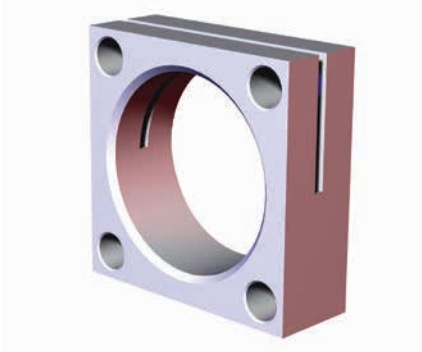
| Part Number | Used with Model | A            | B            | C            | D            | E            | E1           | F                  | Weight [lbs] kg |
|-------------|-----------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------------|-----------------|
| 8MA-084-1   | 89E20-010-2     | [1.57]<br>40 | [1.10]<br>28 | [0.59]<br>15 | [0.32]<br>8  | [0.59]<br>15 | --           | [0.22]             | [0.03]<br>0,014 |
| 8MA-086-1   | 89E32-010-2     | [1.97]<br>50 | [1.38]<br>35 | [0.79]<br>20 | [0.43]<br>11 | [0.79]<br>20 | --           | 5,5 (2x)           | [0.08]<br>0,035 |
| 8MA-087-1   | 89E40-010-2     |              | [1.50]<br>38 | [0.98]<br>25 | [0.51]<br>13 | [0.98]<br>25 | [0.55]<br>14 | [0.22]<br>5,5 (4x) | [0.11]<br>0,050 |
| 8MA-088-1   | 89E50-025-2     | [2.36]<br>60 | [1.77]<br>45 | [1.18]<br>30 | [0.59]<br>15 | [1.18]<br>30 | [0.59]<br>15 | [0.28]<br>7 (4x)   | [0.19]<br>0,085 |
| 8MA-089-1   | 89E63-008-2     | [2.56]<br>65 | [1.89]<br>48 | [1.38]<br>35 | [0.67]<br>17 | [1.38]<br>35 | [0.71]<br>18 | [0.35]<br>9 (4x)   | [0.28]<br>0,125 |

# 89E SERIES

## Pneumatic Swing Clamps | Mounting Flanges

### Features:

- For use with Threaded Body Pneumatic Swing Clamps
- Variable height adjustment
- For recessed mounting



| Part Number | Used with Model | A             | B              | C            | D            | E             | F       | H            |
|-------------|-----------------|---------------|----------------|--------------|--------------|---------------|---------|--------------|
| 8MA-219-1   | 89E20-010-2     | [2.17]<br>55  | [4.33]<br>27,5 | [1.65]<br>42 | [0.83]<br>21 | [0.26]<br>6,6 | M36X1,5 | [0.31]<br>8  |
| 8MA-220-1   | 89E32-010-2     | [2.76]<br>70  | [1.38]<br>35   | [2.13]<br>54 | [1.06]<br>27 | [0.35]<br>9   | M42X1,5 | [0.39]<br>10 |
| 8MA-221-1   | 89E40-010-2     | [3.15]<br>80  | [1.57]<br>40   | [2.60]<br>66 | [1.30]<br>33 |               | M55X2   | [0.47]<br>12 |
| 8MA-222-1   | 89E50-025-2     | [3.54]<br>90  | [1.77]<br>45   | [2.99]<br>76 | [1.50]<br>38 | [0.43]<br>11  | M68X2   | [0.59]<br>15 |
| 8MA-223-1   | 89E63-008-2     | [4.33]<br>110 | [2.17]<br>55   | [3.54]<br>90 | [1.77]<br>45 |               | M80X2   |              |

# 8000, 8200, 8400 SERIES

## Pneumatic Swing Clamps | Product Overview

### Features:

- Threaded body may be mounted in a tapped hole or a clearance hole with optional mounting flange. 8215/8216 may be mounted with the upper flange.
- Sensor ready for use with round style sensors
- Clamp arm and spindle included

### Applications:

- Assembly
- Welding
- Light machining

### Also Available:

- See page MC-PSC-31 for clamping arms
- See page MC-PSC-31 for mounting flanges
- See page MC-PSC-40 for sensing options



## Technical Information

| Model | Swing Direction | Total Stroke [in] mm | Stroke During Rotation [in] mm | Vertical Clamp Stroke [in] mm | Clamping Force [lbf.] N† | Bore Size [in] mm | Air Consumption‡ [ft³] dm³ | Weight [lbs] kg | Replacement Seal Kit |
|-------|-----------------|----------------------|--------------------------------|-------------------------------|--------------------------|-------------------|----------------------------|-----------------|----------------------|
| 8015  | RH              | [0.85] 21,5          | [0.47] 11,8                    | [0.38] 9,7                    | [18] 80                  | [0.75] 19,1       | [0.002] 0,06               | [1.0] 0,45      | 801560               |
| 8016  | LH              |                      |                                |                               |                          |                   |                            |                 |                      |
| 8215  | RH              | [1.25] 31,8          | [0.75] 19,1                    | [0.50] 12,7                   | [67] 300                 | [1.50] 38,1       | [0.015] 0,41               | [2.2] 1         | 821560               |
| 8216  | LH              |                      |                                |                               |                          |                   |                            |                 |                      |
| 8415  | RH              |                      |                                |                               | [55] 245                 | [1.19] 30,2       | [0.009] 0,25               | [1.5] 0,68      | 841560               |
| 8416  | LH              |                      |                                |                               |                          |                   |                            |                 |                      |

† with standard clamping arm at 5 bar [72psi]. ‡ per double stroke at 5 bar [72psi]

**Operating Pressure Range:** 3 bar [45 psig] to 9 bar [130 psig]

**Maximum Operating Temperature:** 60°C [140°F]

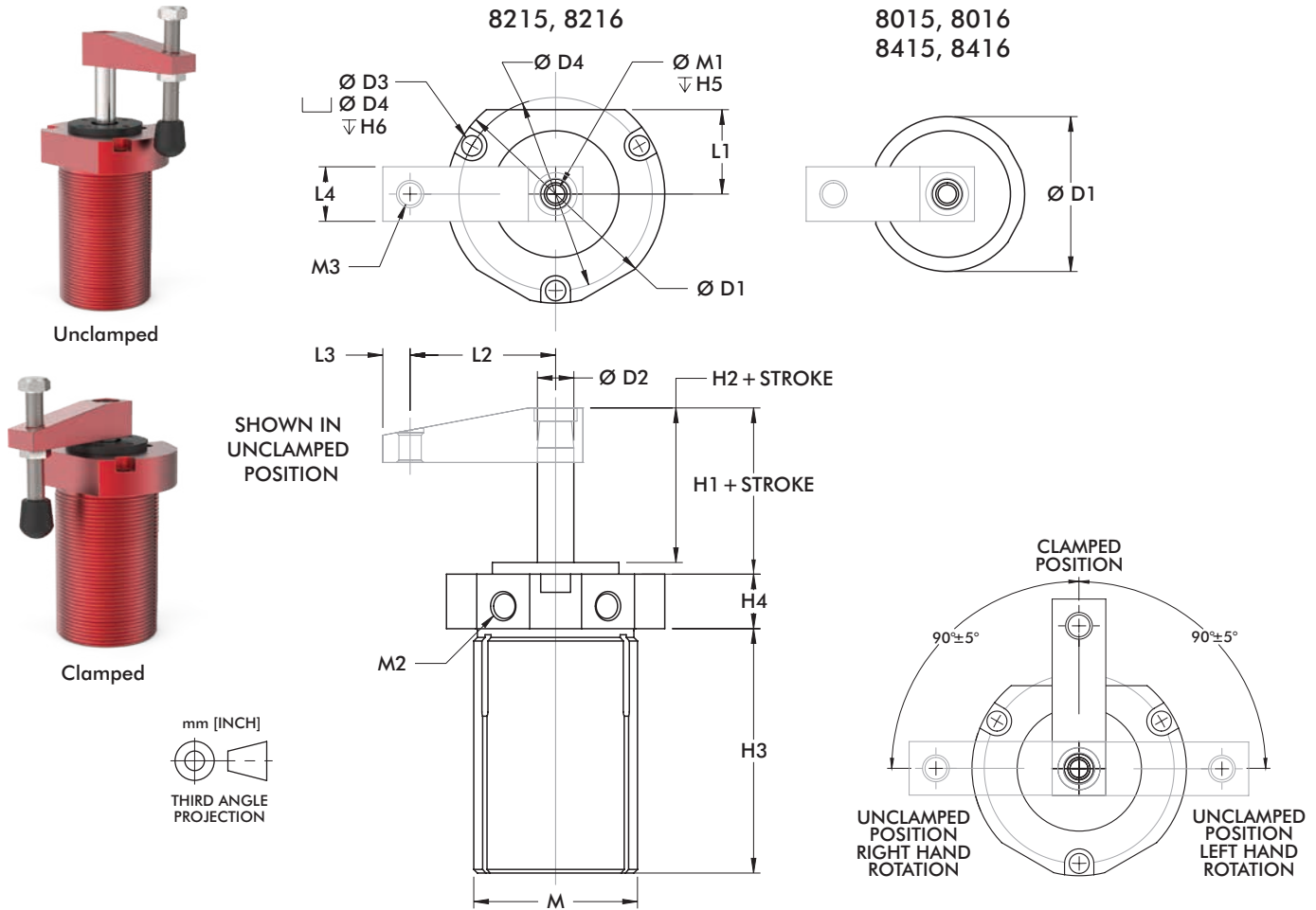
### Note:

To order without clamping arm add **-LA** to the end of the model. Ex. 8215-**LA**



# 8000, 8200, 8400 SERIES

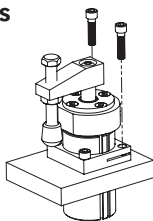
## Pneumatic Swing Clamps | Dimensions



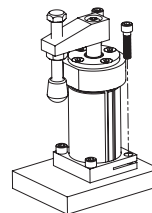
| Model | ØD1    | ØD2    | ØD3    | ØD4    | Stroke | H1     | H2     | H3     | H4     | H5     | H6     | L1     |
|-------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 8015  | [1.25] | [0.44] | --     | --     | [0.85] | [0.53] | [0.41] | [2.87] | [0.50] | [0.75] | --     | --     |
| 8016  | 31,8   | 11,1   | --     | --     | 21,5   | 13,5   | 10,4   | 72,9   | 12,7   | 19,1   | --     | --     |
| 8215  | [3.00] | [0.50] | [0.28] | [2.66] | [1.25] | [0.97] | [0.81] | [3.36] | [0.75] | [0.67] | [0.25] | [1.16] |
| 8216  | 76,2   | [0.50] | 7,1    | 67,6   | 31,8   | 24,6   | 20,6   | 85,3   | [0.75] | [0.67] | 6,4    | 29,5   |
| 8415  | [2.13] | 12,7   | --     | --     | [0.94] | [0.94] | [0.78] | [3.17] | 19,1   | 17     | --     | --     |
| 8416  | 54,1   | 12,7   | --     | --     | 31,8   | 23,9   | 19,8   | 80,5   | 19,1   | 17     | --     | --     |

| Model | L2     | L3     | L4     | M        | M1      | M2      | M3     |
|-------|--------|--------|--------|----------|---------|---------|--------|
| 8015  | [1.12] | [0.31] | [0.62] | 1-1/8-16 | 1/4-20  | #10-32  | #10-32 |
| 8016  | 28,4   | 7,9    | 15,7   | 1-1/8-16 | 1/4-20  | #10-32  | #10-32 |
| 8215  | [2.00] | [0.38] | [0.75] | 2-1/4-12 | 5/16-18 | 1/8 NPT | 3/8-16 |
| 8216  | 50,8   | [0.38] | [0.75] | 2-1/4-12 | 5/16-18 | 1/8 NPT | 3/8-16 |
| 8415  | [1.56] | 9,6    | 19,1   | 1-3/4-12 | 5/16-18 | 1/8 NPT | 3/8-16 |
| 8416  | 39,6   | 9,6    | 19,1   | 1-3/4-12 | 5/16-18 | 1/8 NPT | 3/8-16 |

### Mounting Options



**8000, 8200, 8400**  
Mounted into a tapped hole or a through a clearance hole with the optional mounting flange. Jam nuts are available for 8000.

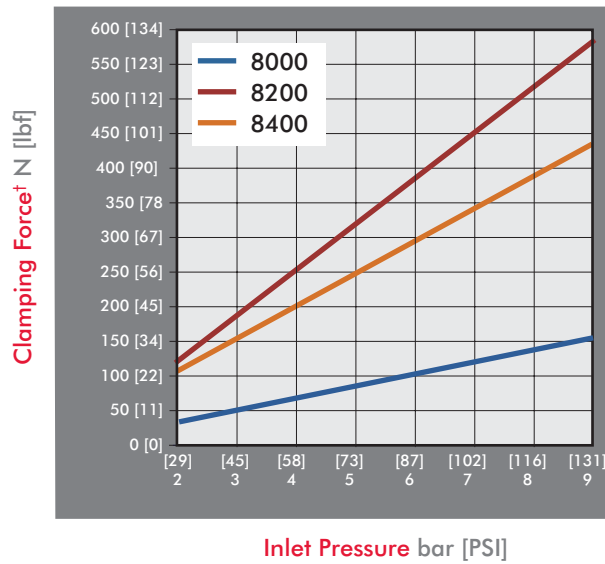


**8200 only**  
Mounted through a clearance hole using mounting screws in the top flange.

# 8000, 8200, 8400 SERIES

## Pneumatic Swing Clamps | Clamping Forces

Series 8000, 8200, 8400 Clamping Force  
(w/ standard clamping arm)

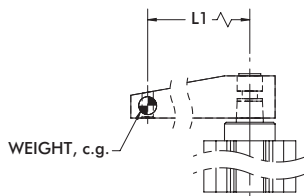


### Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

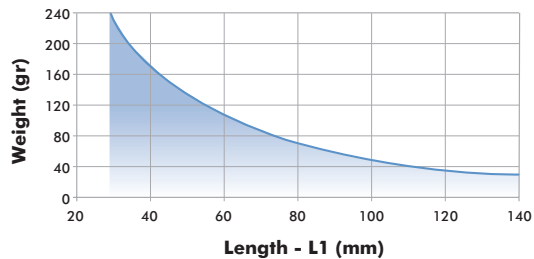
**Example: 8215**

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

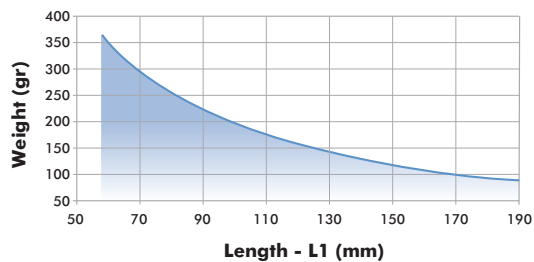


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

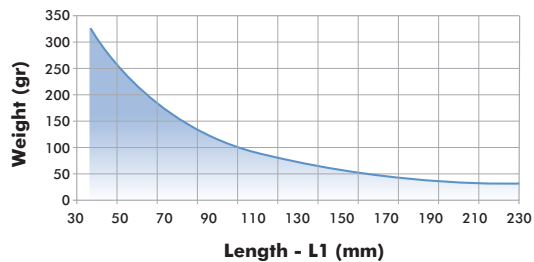
**8015/8016 Clamp Arm Weight**



**8215/8216 Clamp Arm Weight**



**8415/8416 Clamp Arm Weight**

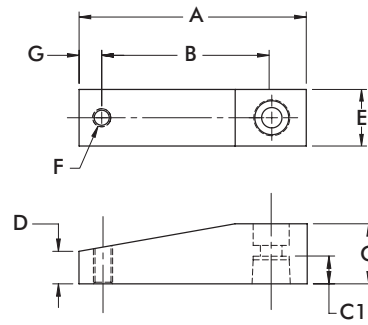
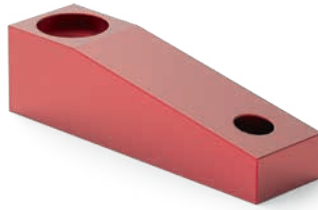


# 8000, 8200, 8400 SERIES

## Pneumatic Swing Clamps | Clamping Arms

### Features:

- Lightweight aluminum construction
- Locking tapered connection for 360 deg. arm positioning

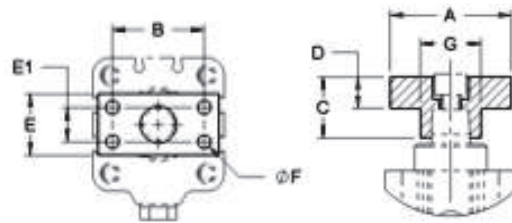
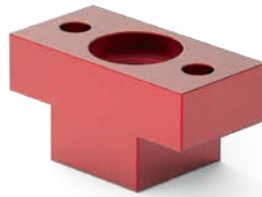


| Part Number | Used with Model           | A              | B              | C              | C1             | D             | E              | F      | G             | Weight [lbs] kg |
|-------------|---------------------------|----------------|----------------|----------------|----------------|---------------|----------------|--------|---------------|-----------------|
| 801528      | 8015, 8016                | [1.74]<br>44,2 | [1.11]<br>28,2 | [0.37]<br>9,4  | [0.33]<br>8,3  | [0.25]<br>6,4 | [0.62]<br>15,7 | #10-32 | [0.32]<br>8,1 | [0.03]<br>0,01  |
| 801529      |                           | [2.87]<br>72,9 | [2.24]<br>56,9 |                |                |               |                |        |               |                 |
| 821512      | 8215, 8216,<br>8415, 8416 | [2.75]<br>69,9 | [2.00]<br>50,8 | [0.75]<br>19,1 | [0.57]<br>14,5 | [0.38]<br>9,5 | [0.75]<br>19,1 | 3/8-16 | [0.38]<br>9,5 | [0.04]<br>0,02  |
| 821513      |                           | [3.75]<br>95,3 | [3.00]<br>76,2 |                |                |               |                |        |               |                 |

## Clamping Arm Adapters

### Features:

- For attaching custom made clamp arms
- 360° rotatable arm
- Aluminum construction

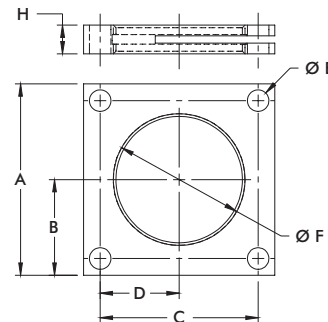
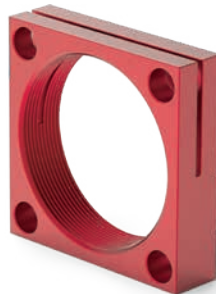


| Part Number | Used with Model | A              | B              | C      | D      | E      | E1 | F              | Weight [lbs] kg |
|-------------|-----------------|----------------|----------------|--------|--------|--------|----|----------------|-----------------|
| 801532      | 8015, 8016      | [1.37]<br>34,8 | [1.00]<br>25,4 | [0.39] | [0.25] | [0.62] | -- | #10-32<br>(2x) | [0.03]<br>0,014 |
| 821556      | 8215, 8216      | [1.50]<br>38,1 | [1.06]<br>26,9 | [0.75] | [0.37] | [0.75] | -- | 1/4-20<br>(2x) | [0.05]<br>0,020 |

## Mounting Flanges

### Features:

- For use with Threaded Body Pneumatic Swing Clamps
- Variable height adjustment
- For recessed mounting



| Part Number | Used with Model | A              | B              | C              | D              | E             | F        | H              |
|-------------|-----------------|----------------|----------------|----------------|----------------|---------------|----------|----------------|
| 801553      | 8015, 8016      | [1.38]<br>35   | [0.69]<br>17,5 | [1.08]<br>27,4 | [0.54]<br>13,7 | [0.20]<br>5,1 | 1 1/8-16 | [0.50]<br>12,7 |
| 821553      | 8215, 8216      | [2.50]<br>63,5 | [1.25]<br>31,8 | [2.12]<br>53,8 | [1.06]<br>26,9 | [0.28]<br>7,1 | 2 1/4-12 |                |
| 841550      | 8415, 8416      | [2.00]<br>50,8 | [1.00]<br>25,4 | [1.60]<br>40,6 | [0.80]<br>20,3 |               | 1 3/4-12 |                |



# 035 SERIES

## Pneumatic Swing Clamps | Product Overview

### Features:

- Available with threaded body, or lower flange mounting
- Low profile for confined spaces
- Double locked arm attachment is bolted to piston rod and clamped around shaft diameter

### Applications:

- Assembly
- Welding
- Light machining

### Also Available:

See page MC-PSC-35 for clamping arms  
See page MC-PSC-36 for jam nuts

### Series 035-1



Threaded body design for mounting through fixture plates.

### Series 035-2



Flanged body design for quick and easy mounting

## Technical Information

| Model       | Swing Direction | Total Stroke [in] mm<br>S | Stroke During Rotation [in] mm<br>S1 | Vertical Clamp Stroke [in] mm<br>S2 | Clamping Force [lbf.]<br>N† | Bore Size [in] mm | Air Consumption‡ [ft³] dm³ | Weight [lbs] kg | Replacement Seal Kit |
|-------------|-----------------|---------------------------|--------------------------------------|-------------------------------------|-----------------------------|-------------------|----------------------------|-----------------|----------------------|
| 035-125-190 | RH              | [1.04]                    | [0.51]                               | [0.53]                              | [20]                        | [0.98]            | [0.005]                    | [0.56]          | 905516               |
| 035-125-290 | LH              | 26,3                      | 12,8                                 | 13,5                                | 89                          | 25                | 0,13                       | 0,25            |                      |
| 035-132-190 | RH              | [1.13]                    | [0.56]                               | [0.57]                              | [30]                        | [1.26]            | [0.008]                    | [0.94]          | 905517               |
| 035-132-290 | LH              | 28,8                      | 14,3                                 | 14,5                                | 133                         | 32                | 0,24                       | 0,43            |                      |
| 035-140-190 | RH              | [1.20]                    | [0.57]                               | [0.63]                              | [60]                        | [1.57]            | [0.015]                    | [1.31]          | 905518               |
| 035-140-290 | LH              | 30,4                      | 14,4                                 | 16                                  | 267                         | 40                | 0,41                       | 0,59            |                      |
| 035-150-190 | RH              | [1.18]                    | [0.63]                               | [0.55]                              | [69]                        | [1.97]            | [0.023]                    | [1.81]          | 905519               |
| 035-150-290 | LH              | 30                        | 16                                   | 14                                  | 307                         | 50                | 0,64                       | 0,82            |                      |
| 035-225-190 | RH              | [1.05]                    | [0.54]                               | [0.51]                              | [20]                        | [0.98]            | [0.005]                    | [0.56]          | 905516               |
| 035-225-290 | LH              | 26,7                      | 13,7                                 | 13                                  | 89                          | 25                | 0,13                       | 0,25            |                      |
| 035-232-190 | RH              | [1.06]                    | [0.57]                               | [0.49]                              | [30]                        | [1.26]            | [0.008]                    | [1.13]          | 905517               |
| 035-232-290 | LH              | 26,8                      | 14,4                                 | 12,4                                | 133                         | 32                | 0,24                       | 0,51            |                      |
| 035-240-190 | RH              | [1.09]                    | [0.57]                               | [0.52]                              | [60]                        | [1.57]            | [0.015]                    | [1.40]          | 905518               |
| 035-240-290 | LH              | 27,7                      | 14,4                                 | 13,3                                | 267                         | 40                | 0,41                       | 0,64            |                      |
| 035-250-190 | RH              | [1.13]                    | [0.63]                               | [0.51]                              | [69]                        | [1.97]            | [0.023]                    | [1.90]          | 905519               |
| 035-250-290 | LH              | 28,8                      | 16                                   | 12,8                                | 307                         | 50                | 0,64                       | 0,86            |                      |

† with standard clamping arm at 5 bar [72psi]. ‡ per double stroke at 5 bar [72psi]

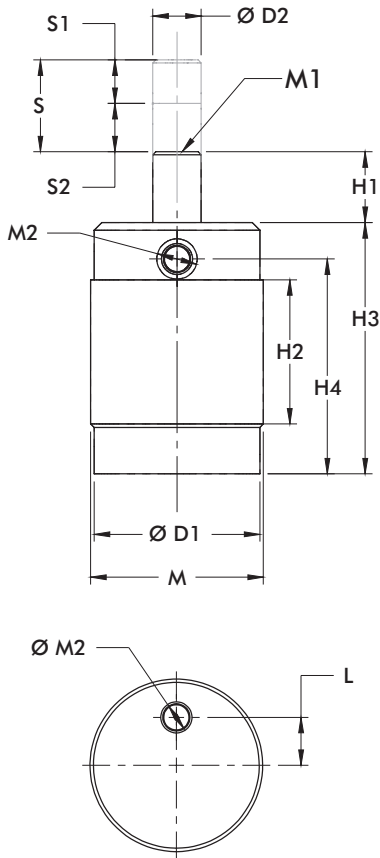
**Operating Pressure Range:** 3 bar [45 psig] to 7 bar [100 psig]  
**Maximum Operating Temperature:** 80°C [176°F]

# 035 SERIES

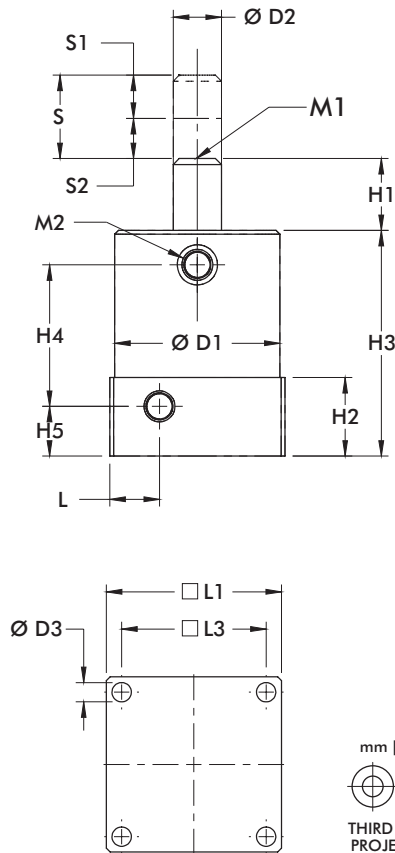
## Pneumatic Swing Clamps | Dimensions



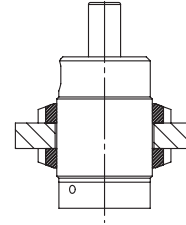
Series 035-1



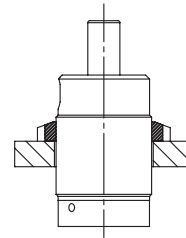
Series 035-2



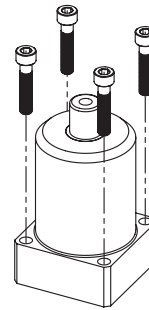
## Mounting Options



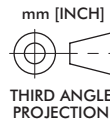
**035-1**  
Threaded body mounts through a clearance hole and locked in place using two optional jam nuts



**035-1**  
Threaded body mounts into a threaded hole and is locked in place using one optional jam nuts

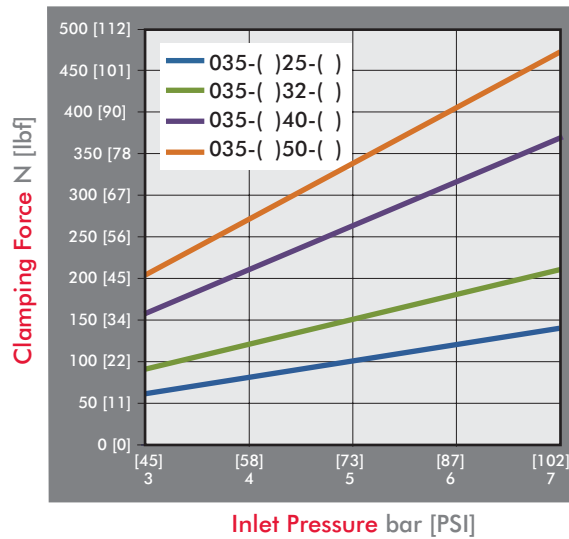


**035-2**  
Mount using four mounting holes in the base flange



| Model       | ØD1            | ØD2          | D3           | H1             | H2             | H3             | H4             | H5             | L              | L1             | L3           | M        | M1      | M2      |
|-------------|----------------|--------------|--------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|--------------|----------|---------|---------|
| 035-125-( ) | [1.42]<br>36   | [.55]<br>14  | --           | [0.57]<br>14,4 | [1.50]<br>38,1 | [2.76]<br>70   | [2.25]<br>57,2 | --             | [0.35]<br>9    | --             | --           | 1-½ -16  | 1/4-20  | #10-32  |
| 035-132-( ) | [1.79]<br>45,4 | [0.63]<br>16 | --           | [0.75]<br>19,1 | [1.72]<br>43,7 | [3.87]<br>98,2 | [2.63]<br>66,7 | --             | [0.45]<br>11,4 | --             | --           | 1-7/8-16 | 5/16-18 | 1/8 NPT |
| 035-140-( ) | [2.16]<br>54,8 | [0.63]<br>16 | --           | [0.76]<br>19,4 | [1.88]<br>47,7 | [3.28]<br>83,2 | [2.80]<br>71   | --             | [0.70]<br>17,8 | --             | --           | 2-1/4-16 |         |         |
| 035-150-( ) | [2.36]<br>60   | [0.79]<br>20 | --           | [0.70]<br>17,8 | [2.00]<br>50,8 | [3.48]<br>88,3 | [2.95]<br>75   | --             | [0.50]<br>12,7 | --             | --           | 2-1/2-16 | 3/8-16  |         |
| 035-225-( ) | [1.38]<br>35   | [.55]<br>14  | [.18]<br>4,5 | [0.60]<br>15,2 | [.91]<br>23    | [2.62]<br>66,5 | [1.60]<br>40,6 | [0.50]<br>12,7 | [0.57]<br>14,5 | [1.57]<br>40   | [1.22]<br>31 | --       | 1/4-20  | #10-32  |
| 035-232-( ) | [1.97]<br>50   | [0.63]<br>16 | [.26]<br>6,5 | [0.85]<br>21,6 | [.91]<br>23    | [2.79]<br>71   | [1.76]<br>44,6 | [0.57]<br>14,5 | [0.65]<br>16,5 | [2.13]<br>54   | [1.73]<br>44 | --       | 5/16-18 | 1/8 NPT |
| 035-240-( ) | [2.16]<br>54,8 | [0.63]<br>16 | [.26]<br>6,5 | [0.94]<br>23,9 | [1.03]<br>26,1 | [2.95]<br>75   | [1.85]<br>47   | [0.65]<br>16,5 | [0.65]<br>16,5 | [2.29]<br>58,2 | [1.89]<br>48 | --       |         |         |
| 035-250-( ) | [2.36]<br>60   | [0.79]<br>20 | [.33]<br>8,5 | [0.78]<br>19,7 | [1.03]<br>26   | [3.15]<br>80   | [2.05]<br>52   | [0.65]<br>16,5 | [0.65]<br>16,5 | [2.68]<br>68   | [2.17]<br>55 | --       | 3/8-16  |         |

Series 035 Clamping Force  
(w/ standard clamping arm)

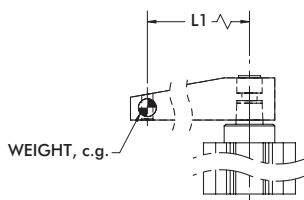


### Guidelines

DESTACO Pneumatic Swing Clamps are designed for long life when using standard clamping arms and spindles. In the event that a longer arm or additional weight is needed, please consult these charts for the allowable weight and length.

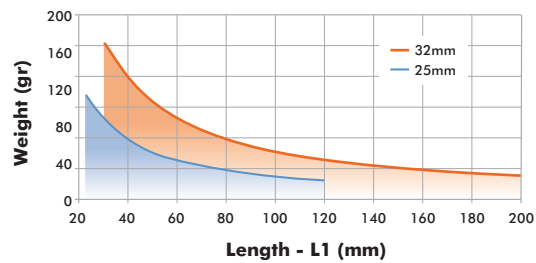
**Example: 035-132-190**

At a weight of 80 gr, the maximum length of the arm is approximately 90mm.

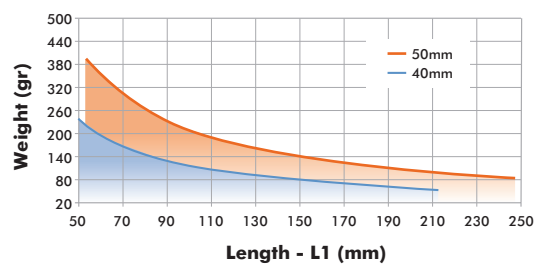


All data refers to an operating pressure of 5 bar [72psi] and an opening and closing time of 1 second.

25mm, 32mm Clamp Arm Weight



40mm, 50mm Clamp Arm Weight

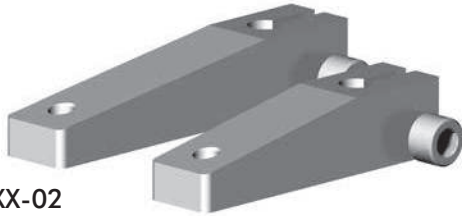


# 035 SERIES

## Pneumatic Swing Clamps | Clamping Arms

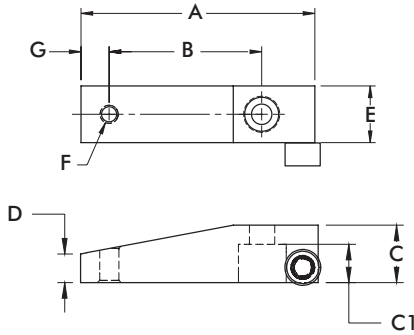
### Features:

- For standard use
- Aluminum construction
- Clamp on style connection for 360 deg. arm positioning



036-XXX-02

036-XXX-01



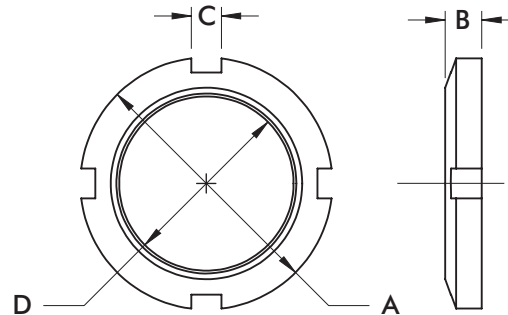
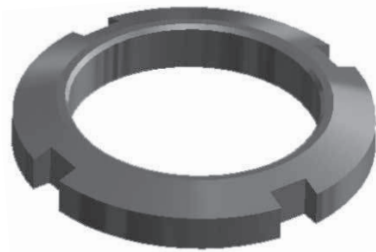
| Part Number | Used with Model/series                               | A               | B              | C              | C1             | D              | E              | F       | G             | Weight [lbs] kg |
|-------------|--|-----------------|----------------|----------------|----------------|----------------|----------------|---------|---------------|-----------------|
| 036-551-01  | 035-12....<br>035-22....                             | [2.38]<br>60,5  | [1.36]<br>34,5 | [0.63]<br>15,9 | [0.40]<br>10,2 | [0.31]<br>8    | [0.75]<br>19,1 | 1/4-20  | [0.32]<br>8   | [0.10]<br>0,05  |
| 036-551-02  |  | [3.38]<br>85,9  | [2.36]<br>60   |                |                |                |                |         |               | [0.13]<br>0,06  |
| 036-630-01  | 035-13....<br>035-23....<br>035-14....<br>035-24.... | [3.10]<br>78,7  | [2.00]<br>50,8 | [0.75]<br>19,1 | [0.50]<br>12,7 | [0.38]<br>9,5  | [0.75]<br>19,1 | 5/16-18 | [0.38]<br>9,5 | [0.15]<br>0,07  |
| 036-630-02  |  | [4.73]<br>120   | [3.63]<br>92,1 |                |                |                |                |         |               | [0.21]<br>0,10  |
| 036-787-01  | 035-15....<br>035-25....                             | [4.00]<br>101,6 | [2.75]<br>69,9 | [1.00]<br>25,4 | [0.70]<br>17,8 | [0.50]<br>12,7 | [1.00]<br>25,4 | 3/8-16  | [0.38]<br>9,5 | [0.33]<br>0,15  |
| 036-787-02  |  | [6.36]<br>161,5 | [5.00]<br>127  |                |                |                |                |         |               | [0.49]<br>0,22  |

# 035 SERIES

## Pneumatic Swing Clamps | Jam Nuts

### Features:

- For use with Threaded Body Pneumatic Swing Clamps
- Variable height adjustment
- For recessed mounting
- Steel construction



| Part Number | Used with Model/series      | A              | B              | C              | D           | Weight [lbs] kg |
|-------------|-----------------------------|----------------|----------------|----------------|-------------|-----------------|
| 051-150-160 | 035-125-190,<br>035-125-290 | [2.00]<br>50,8 | [0.38]<br>9,7  | [0.275]<br>7   | 1 1/2-16 UN | [0.13]<br>0,06  |
| 051-187-160 | 035-132-190,<br>035-132-290 | [2.63]<br>66,7 |                | [0.312]<br>7,9 |             | [0.25]<br>0,11  |
| 051-225-160 | 035-140-190,<br>035-140-290 | [3.00]<br>76,2 | [0.50]<br>12,7 | [0.312]<br>7,9 | 2 1/4-16 UN | [0.40]<br>0,18  |
| 051-250-160 | 035-150-190,<br>035-150-290 | [3.25]<br>82,6 |                |                |             | [0.44]<br>0,20  |

# 8700 SERIES

## Pneumatic Lever Clamps | Product Overview

### Features:

- Alternative solution to swing clamps when space is limited
- The clamping lever may be positioned left, forward, or right (relative to ports) within the same clamp body
- Threaded body with upper flange mount
- Non-toggle locking linkage
- Clamping arm and spindle included

### Applications:

- Assembly & welding fixtures
- Light machining

### Also Available:

See page MC-PSC-39 for jam nuts

8725



8732  
8732G



8740  
8740G



8750  
8750G



## Technical Information

| Model | Vertical Clamping Stroke*<br>[in.] mm | Clamping Force†<br>[lb.f.] N | Bore Size<br>[in.] mm | Air Consumption‡<br>[in. <sup>3</sup> ] cm <sup>3</sup> | Weight<br>[lb.] kg | Seal Kit |
|-------|---------------------------------------|------------------------------|-----------------------|---|--------------------|----------|
| 8725  | [0.10]<br>2,5                         | [43]<br>195                  | [0.98]<br>25          | [0.004]<br>0,11   | [1.3]<br>0,6       | 872500   |
| 8732  | [0.12]<br>3,2                         | [64]<br>285                  | [1.26]<br>32          | [0.008]<br>0,23   | [2.2]<br>1         | 873200   |
| 8732G |                                       |                              |                       |   |                    |          |
| 8740  |                                       |                              |                       |   |                    |          |
| 8740G |                                       | [106]<br>470                 | [1.57]<br>40          | [0.014]<br>0,41   | [2.6]<br>1,2       | 874000   |
| 8750  | [0.15]<br>3,8                         | [167]<br>745                 | [1.97]<br>50          | [0.023]<br>0,64   | [4,4]<br>2         | 875000   |
| 8750G |                                       |                              |                       |   |                    |          |

\* Equal to approx. 6° above horizontal with standard clamping arm. † at 5 bar [72psi].  
‡ per double stroke at 5 bar [72psi].

### Operating Pressure Range:

3 bar [45 psig] to 7 bar [100 psig]

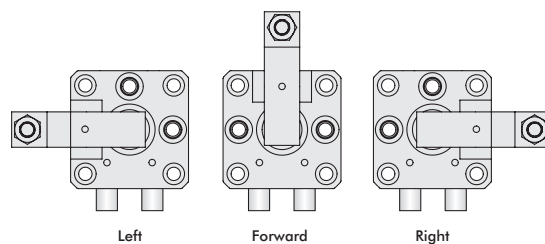
### Max. Operating Temperature:

-10°C to 80°C [14°F to 175°F]

### Application Note:

If using clamping arms other than standard, the length must not exceed 1.5X the overall length of the standard arm.

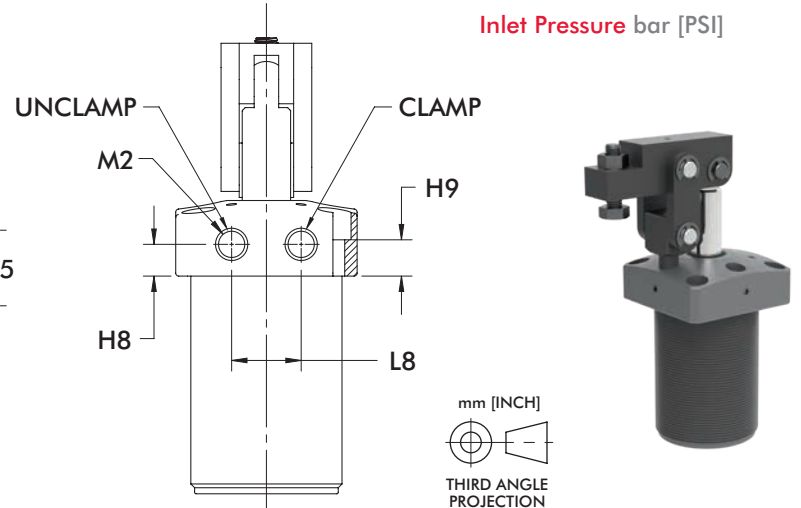
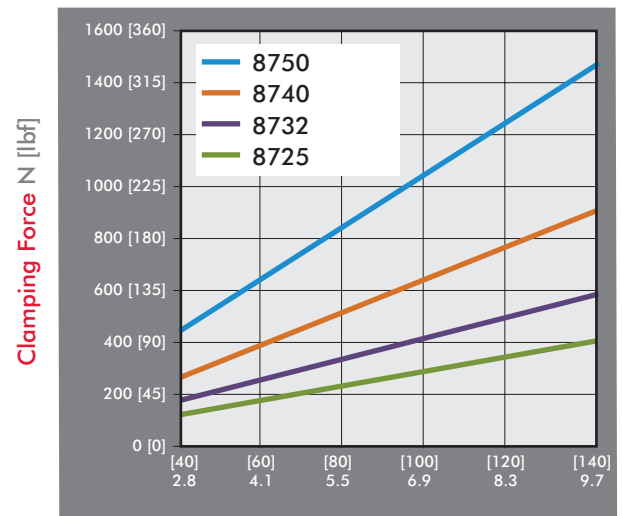
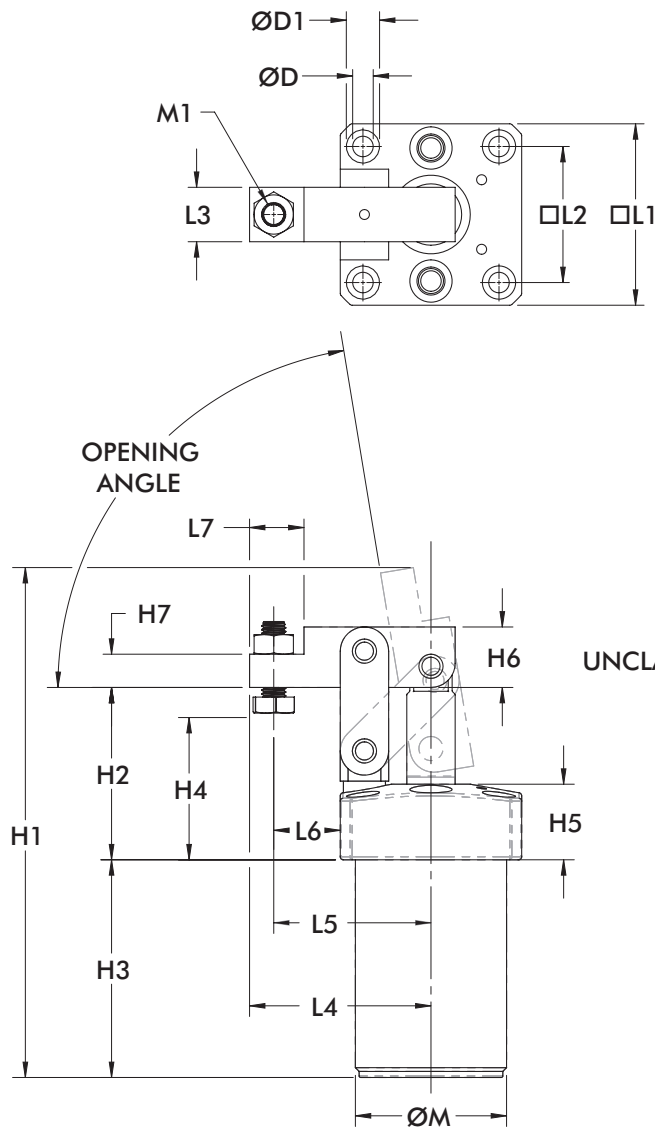
The inlet air flow rate should be adjusted to position the arm in no less than 1/2 second for standard arms and no less than 1 second in the case of an extended arm.



Levers can be positioned in one of three positions in relation to the air ports.

# 8700 SERIES

## Pneumatic Lever Clamps | Dimensions, Clamping Forces



| Model          | Opening Angle | ØD            | ØD1          | H1            | H2           | H3             | H4 (min/max)         | H5           | H6           | H7           | H8             | H9             |
|----------------|---------------|---------------|--------------|---------------|--------------|----------------|----------------------|--------------|--------------|--------------|----------------|----------------|
| 8725           | 80°           | [0.22]<br>5,5 | [0.35]<br>9  | [5.67]<br>144 | [1.97]<br>50 | [2.42]<br>61,5 | [0.59-0.98]<br>15-25 | [0.98]<br>25 | [0.67]<br>17 | [0.39]<br>10 | [0.47]<br>12   | [0.59]<br>15   |
| 8732/<br>8732G | 81°           | [0.27]<br>6,8 | [0.43]<br>11 | [6.65]<br>169 | [2.25]<br>57 | [2.83]<br>72   | [0.63-1.18]<br>16-30 |              | [0.79]<br>20 | [0.43]<br>11 | [0.41]<br>10,5 | [0.51]<br>13   |
| 8740/<br>8740G | 82°           | [0.27]<br>6,8 | [0.43]<br>11 | [6.93]<br>176 | [2.40]<br>61 | [2.85]<br>72,5 | [0.75-1.14]<br>19-29 |              | [0.98]<br>25 | [0.55]<br>14 |                | [0.41]<br>10,5 |
| 8750/<br>8750G | 75°           | [0.33]<br>8,5 | [0.55]<br>14 | [7.87]<br>200 | [2.60]<br>66 | [3.11]<br>79   | [0.86-1.30]<br>22-33 |              | [1.18]<br>30 | [0.59]<br>15 | [0.41]<br>10,5 | [0.43]<br>11   |

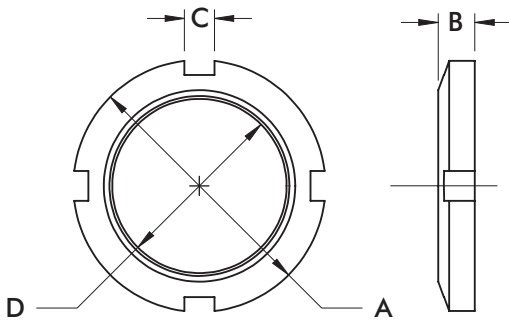
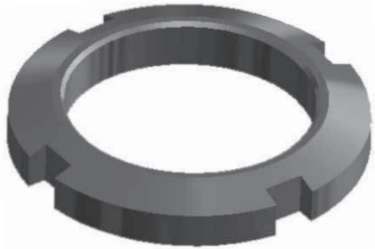
| Model         | L1           | L2           | L3           | L4             | L5             | L6             | L7           | L8           | ØM         | M1         | M2                |
|---------------|--------------|--------------|--------------|----------------|----------------|----------------|--------------|--------------|------------|------------|-------------------|
| 8725          | [1.97]<br>50 | [1.46]<br>37 | [0.63]<br>16 | [1.89]<br>48   | [1.61]<br>41   | [0.63]<br>16   | [0.55]<br>14 | [0.91]<br>23 | M40 x 1,50 | M6 x 1,0   | M5 x 0,8          |
| 8732<br>8732G | [2.36]<br>60 | [1.77]<br>45 | [0.71]<br>18 | [2.36]<br>60   | [2.05]<br>52   | [0.87]<br>22   | [0.71]<br>18 |              | M50 x 1,50 | M8 x 1,25  | [1/8NPT]<br>G-1/8 |
| 8740<br>8740G | [2.56]<br>65 | [1.97]<br>50 | [0.79]<br>20 | [2.60]<br>66   | [2.20]<br>56   | [0.93]<br>23,5 | [0.79]<br>20 | [1.02]<br>26 | M55 x 1,50 |            | [1/8NPT]<br>G-1/8 |
| 8750<br>8750G | [2.95]<br>75 | [2.28]<br>58 | [0.87]<br>22 | [3.05]<br>77,5 | [2.50]<br>63,5 | [1.02]<br>26   | [1.10]<br>28 | [1.26]<br>32 | M65 x 1,50 | M12 x 1,75 | [1/8NPT]<br>G-1/8 |

# 8700 SERIES

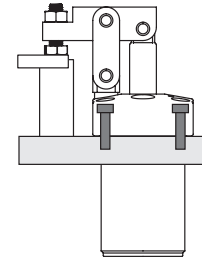
## Pneumatic Lever Clamps | Jam Nuts

### Features:

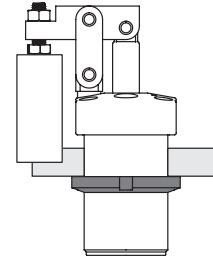
- For use with 8700 Series Pneumatic Lever Clamps
- Variable height adjustment
- For recessed mounting



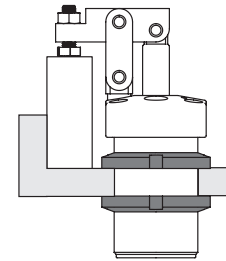
Mounting from above using 4 socket cap screws through the flange.



Mounting by screwing body into a tapped hole and locking with one jam nut.



Mounting by inserting body into a plain hole and locking with two jam nuts.



| Part Number | Used with Model | A            | B            | C           | D          | Weight [lbs] kg |
|-------------|-----------------|--------------|--------------|-------------|------------|-----------------|
| 872550      | 8725            | [2.28]<br>58 | [0.35]<br>9  | [0.28]<br>7 | M40 x 1,50 | [0.13]<br>0,06  |
| 873250      | 8732            | [2.76]<br>70 | [0.43]<br>11 |             | M50 x 1,50 | [0.35]<br>0,16  |
| 874050      | 8740            | [2.95]<br>75 |              | [0.31]<br>8 | M55 x 1,50 | [0.37]<br>0,17  |
| 875050      | 8750            | [3.35]<br>85 | [0.47]<br>12 |             | M65 x 1,50 | [0.33]<br>0,15  |



### Features:

- Alternative solution to swing clamps
- The clamp arm may be positioned in any 45° radial position
- Magnetic piston for sensing option
- Sensing option tracks, 4X Ø4mm, 4X 3x6mm
- Built-in flow controls
- Clamp arm and spindle included
- Patented body design allows for multiple mounting options
- Non toggle-locking linkage

### Applications:

- Assembly & welding fixture
- Light machining

### Also Available:

See page MC-PSC-40 for mounting kits

8822



8832/  
8832G



8840/  
8840G



8850/  
8850G



## Technical Information | Holding Capacities

| Model          | Clamping Force at 5.5 bar [80 psi] | Bore Diameter [in] mm | Air Consumption at 5.5bar [80psi] | Weight              | Seal Kit |
|----------------|------------------------------------|-----------------------|-----------------------------------|---------------------|----------|
| 8822           | [27 lbs]<br>120 N                  | [0.87]<br>22          | [0.033 CFM]<br>0,93 lpm           | [0.7 lbs]<br>0,3 kg | 882200   |
| 8832/<br>8832G | [52 lbs]<br>231 N                  | [1.26]<br>32          | [0.042 CFM]<br>1,19 lpm           | [1.3 lbs]<br>0,6 kg | 883200   |
| 8840/<br>8840G | [102 lbs]<br>454 N                 | [1.57]<br>40          | [0.074 CFM]<br>2,10 lpm           | [1.9 lbs]<br>0,9 kg | 884000   |
| 8850/<br>8850G | [138 lbs]<br>614 N                 | [1.97]<br>50          | [0.125 CFM]<br>3,54 lpm           | [3.4 lbs]<br>1,5 kg | 885000   |

Operating Pressure Range: 2.8 bar [40psig] to 8.3 bar [120psig]

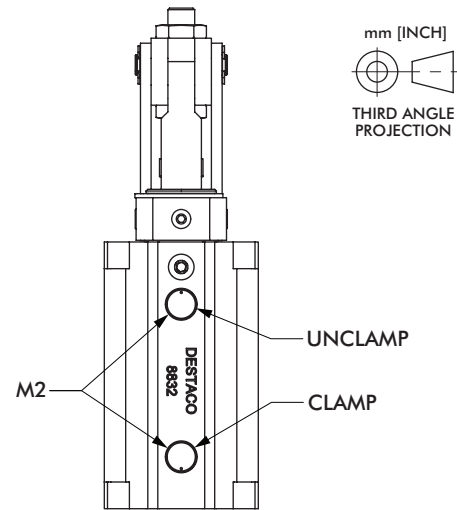
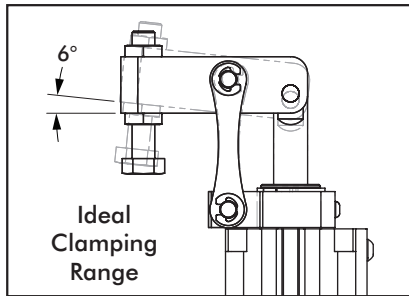
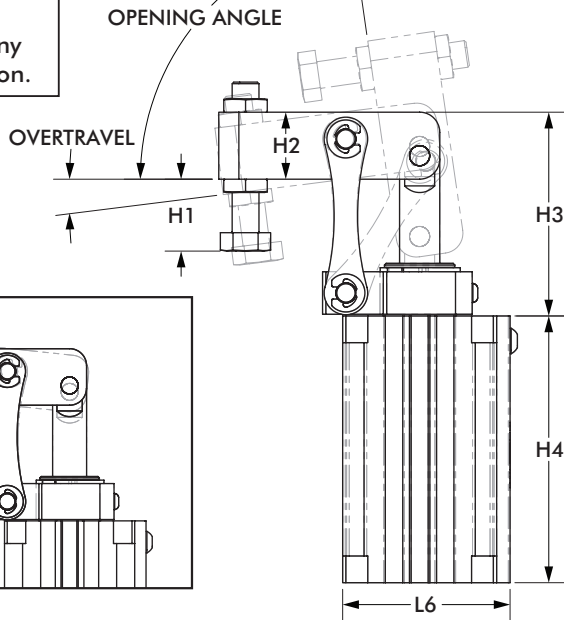
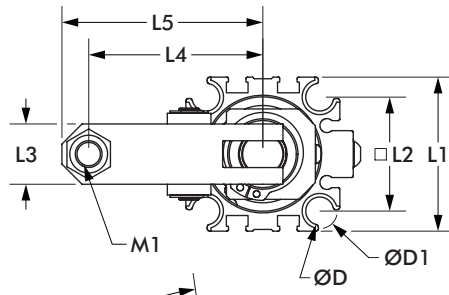
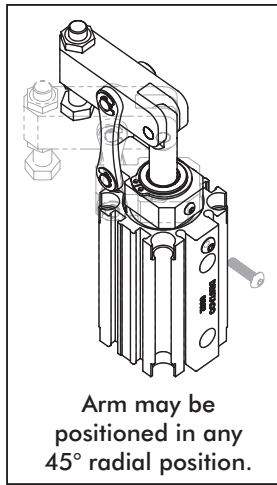
Temperature Operating Range: -10°C to 80°C [14°F to 175°F]

## Exerting Force

| Model | Input Pressure      |                     |                     |                      |                      | Exerting Force |
|-------|---------------------|---------------------|---------------------|----------------------|----------------------|----------------|
|       | [40 psi]<br>2,8 bar | [60 psi]<br>4,1 bar | [80 psi]<br>5,5 bar | [100 psi]<br>6,9 bar | [120 psi]<br>8,3 bar |                |
| 8822  | [12 lbs]<br>53 N    | [21 lbs]<br>93 N    | [27 lbs]<br>120 N   | [35 lbs]<br>156 N    | [44 lbs]<br>196 N    |                |
| 8832  | [26 lbs]<br>116 N   | [39 lbs]<br>173 N   | [52 lbs]<br>231 N   | [64 lbs]<br>285 N    | [78 lbs]<br>347 N    |                |
| 8840  | [50 lbs]<br>222 N   | [75 lbs]<br>334 N   | [102 lbs]<br>454 N  | [123 lbs]<br>547 N   | [147 lbs]<br>654 N   |                |
| 8850  | [63 lbs]<br>280 N   | [102 lbs]<br>454 N  | [138 lbs]<br>614 N  | [172 lbs]<br>765 N   | [208 lbs]<br>925 N   |                |

# 8800 SERIES

## Pneumatic Link Clamps | Dimensions

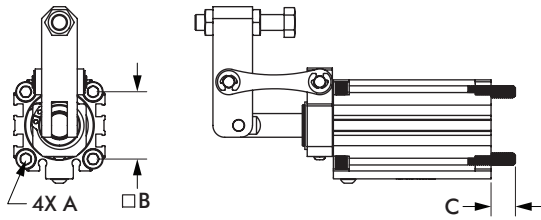


| Model          | Opening Angle | Over-Travel | ØD             | ØD1            | H1 (MIN/MAX)                | H2           | H3             | H4              |
|----------------|---------------|-------------|----------------|----------------|-----------------------------|--------------|----------------|-----------------|
| 8822           | 85°           | 6°          | [0.28]<br>7    | [0.35]<br>9    | [0.30 - 1.12]<br>7,5 - 28,5 | [0.67]<br>17 | [2.11]<br>53,5 | [2.73]<br>69,4  |
| 8832/<br>8832G |               |             | [0.33]<br>8,3  | [0.41]<br>10,5 | [0.37 - 1.04]<br>9,5 - 26,5 | [0.79]<br>20 | [2.40]<br>61   | [3.14]<br>79,7  |
| 8840/<br>8840G |               |             | [0.79]<br>20   | [2.64]<br>67   | [3.50]<br>88,8              |              |                |                 |
| 8850/<br>8850G |               |             | [0.42]<br>10,6 | [0.53]<br>13,5 | [0.47 - 1.81]<br>12 - 46    | [1.02]<br>26 | [2.99]<br>76   | [4.13]<br>104,8 |

| Model          | L1           | L2             | L3           | L4             | L5             | L6           | M1      | M2      |
|----------------|--------------|----------------|--------------|----------------|----------------|--------------|---------|---------|
| 8822           | [1.42]<br>36 | [1.00]<br>25,4 | [0.59]<br>15 | [1.61]<br>41   | [1.89]<br>48   | [1.42]<br>36 | M6-1    | M5      |
| 8832/<br>8832G | [1.81]<br>46 | [1.34]<br>34   | [0.71]<br>18 | [2.05]<br>52   | [2.36]<br>60   | [1.97]<br>50 | M8-1,25 | 1/8 NPT |
| 8840/<br>8840G | [2.05]<br>52 | [1.57]<br>40   | [0.79]<br>20 | [2.20]<br>56   | [2.60]<br>66   | [2.24]<br>57 |         | 1/8 NPT |
| 8850/<br>8850G | [2.52]<br>64 | [1.97]<br>50   | [0.87]<br>22 | [2.50]<br>63,5 | [3.05]<br>77,5 | [2.80]<br>71 | M10-1,5 | 1/8 NPT |
|                |              |                |              |                |                |              |         | G1/8    |

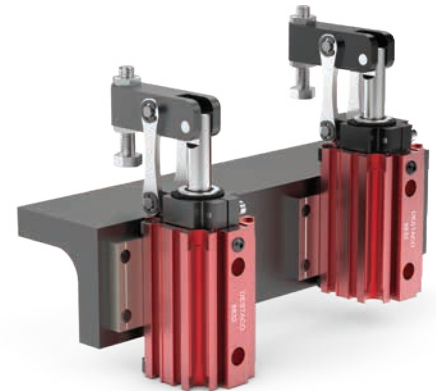
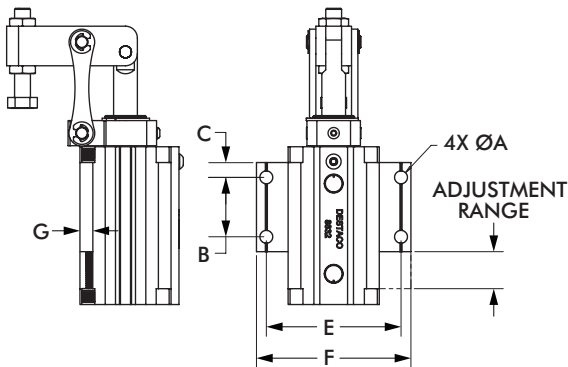
**Application Note:**  
If using clamping arms other than standard, the length and mass must not exceed 1.5X the overall length and mass of the standard arm.

### Standard Mount Kits



| Mount Kit Number | For Model | A   | B              | C              |
|------------------|-----------|-----|----------------|----------------|
| 882262           | 8822      | M6  | [1.00]<br>25,4 | [0.43]<br>11   |
| 883262           | 8832      | M8  | [1.34]<br>34   | [0.51]<br>13   |
| 884062           | 8840      |     | [1.57]<br>40   | [0.53]<br>13,5 |
| 885062           | 8850      | M10 | [1.97]<br>50   | [0.93]<br>23,5 |

### Side Mount Kits



| Mount Kit Number | For Model | ØA            | B            | C             | D            | E              | F              | G             | ADJUSTMENT RANGE |
|------------------|-----------|---------------|--------------|---------------|--------------|----------------|----------------|---------------|------------------|
| 882260           | 8822      | [0.22]<br>5,5 | [1.18]<br>30 | [0.20]<br>5   | [1.57]<br>40 | [1.91]<br>48,5 | [2.26]<br>57,5 | [0.23]<br>5,8 | [0.67]<br>17     |
| 883260           | 8832      | [0.26]<br>6,5 | [1.18]<br>30 | [0.30]<br>7,5 | [1.77]<br>45 | [2.68]<br>68   | [3.07]<br>78   | [0.26]<br>6,5 | [0.71]<br>18     |
| 884060           | 8840      |               | [1.38]<br>35 |               | [1.97]<br>50 | [2.91]<br>74   | [3.31]<br>84   |               | [0.87]<br>22     |
| 885060           | 8850      | [0.33]<br>8,5 | [1.57]<br>40 | [0.39]<br>10  | [2.36]<br>60 | [3.66]<br>93   | [4.17]<br>106  | [0.31]<br>8   | [1.02]<br>26     |

# PNEUMATIC SWING CLAMPS ACCESSORIES

## Pneumatic Swing Clamps | Sensors

### Features:

- Sensors are activated by a magnetic ring installed on the cylinder piston
- All sensors feature an LED for easy set-up
- IP67 rated
- Temperature Range: -10°C to 60°C [14°F to 140°F]

810169,  
810173,  
810174



8EA-109-1,  
8EA-120-1,  
810170,  
810171



810151,  
810153,  
810155,  
810157



Tie rod clip 810151-1 included.

810156,  
810158



810153



## Technical Information

| Item Number | Mount Style | Connector              | Length          | Function | Voltage       | Max. Switching Current | Voltage Drop |
|-------------|-------------|------------------------|-----------------|----------|---------------|------------------------|--------------|
| 810169      | Round       | M8 male quick connect  | 165mm [6.5in.]  | Reed     | 5-120V AC/DC  | 50mA                   | 3.0V         |
| 810173      |             |                        |                 | PNP      | 4.5-28V DC    | 100mA                  | 0.5V         |
| 810174      |             |                        |                 | NPN      | 4.5-28V DC    | 100mA                  | 0.5V         |
| 8EA-109-1   | T-slot      | M8 male quick connect  | 300mm [11.8in.] | Reed     | 10-30V DC     | 100mA                  | 3.0V         |
| 8EA-120-1   |             | M12 male quick connect | 300mm [11.8in.] | Reed     | 15-30 V AC/DC | 500mA                  | 1.5V         |
| 810170      |             | M8 male quick connect  | 165mm [6.5in.]  | PNP      | 10-30V DC     | 100mA                  | 2.0V         |
| 810171      |             |                        |                 | NPN      | 10-30V DC     | 100mA                  | 2.0V         |
| 810151      | Tie Rod     | No connector cord      | 2,7m [9ft.]     | Reed     | 5-120V AC/DC  | 500mA                  | 3.5V         |
| 810153      |             |                        |                 | Reed     | 24-240V AC    | 4A                     | 1.0V         |
| 810155      |             |                        |                 | PNP      | 6-24V DC      | 500mA                  | 1.0V         |
| 810157      |             |                        |                 | NPN      | 6-24V DC      | 500mA                  | 1.0V         |
| 810156      | Band Clamp  | No connector cord      | 2,7m [9ft.]     | Reed     | 5-120V AC/DC  | 500mA                  | 3.5V         |
| 810158      | PNP         |                        |                 | 6-24V DC | 500mA         | 1.0V                   |              |

# PNEUMATIC SWING CLAMPS ACCESSORIES

Pneumatic Swing Clamps | Extension Cordsets

## Features:

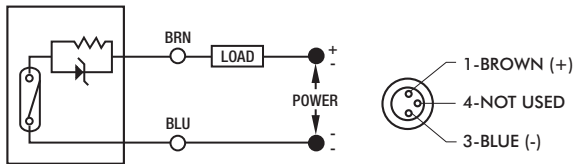
- For use with M8 quick connect sensors
- Threaded coupling nuts provide IP67 protection
- Robotic grade, oil and abrasion resistant polyurethane (PUR) cable



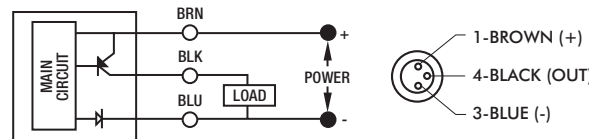
| Item Number | Length            | Rating              | Temperature Rating             |
|-------------|-------------------|---------------------|--------------------------------|
| CABL-010    | 2 Meter [78in.]   | 120V AC/DC, 3A max. | -20°C to 80°C [-40°F to 176°F] |
| CABL-013    | 5 Meter [16.4ft.] |                     |                                |

## Wiring Schematics

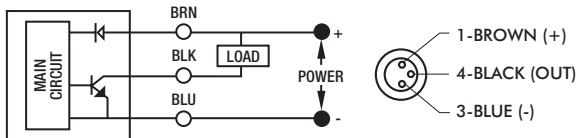
810169



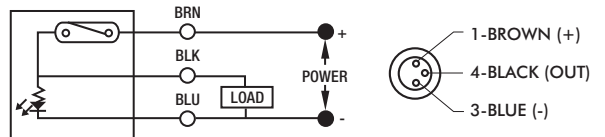
810170, 810173



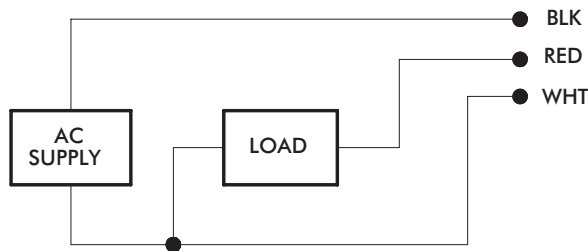
810171, 810174



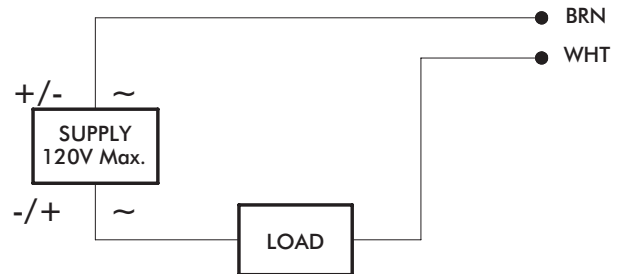
8EA-109-1, 8EA-120-1



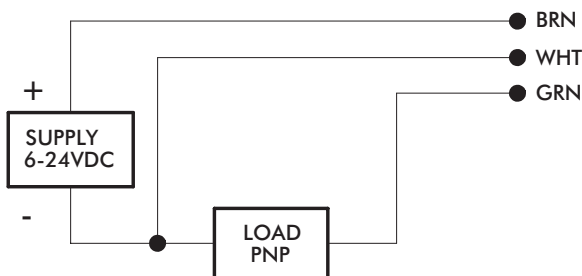
810153



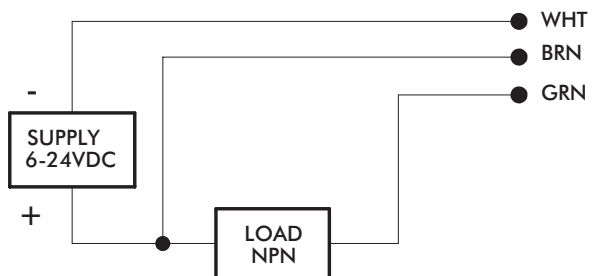
810151, 810156



810155, 810158



810157, 810158



# 6000-SW SERIES

## Manual Swing Clamps | Product Overview and Dimensions

### Features:

- Left or right swing motion available
- 90° Swing clamp arm motion
- Higher clamping force than pneumatic version
- Through-hole mounting
- Clamp arm can be radially positioned 360°
- Handle can be radially positioned up to 180°

### Applications:

- Assembly
- Checking fixtures
- Welding fixtures
- Tensioning devices

**6002-SWL**  
Clamp Arm  
Swing Left



**6002-SWR**  
Clamp Arm  
Swing Right



**6004-SWL**  
Clamp Arm  
Swing Left



**6004-SWR**  
Clamp Arm  
Swing Right



Shown in open (un-clamp) position.

## Technical Information | Holding Capacities | Dimensions

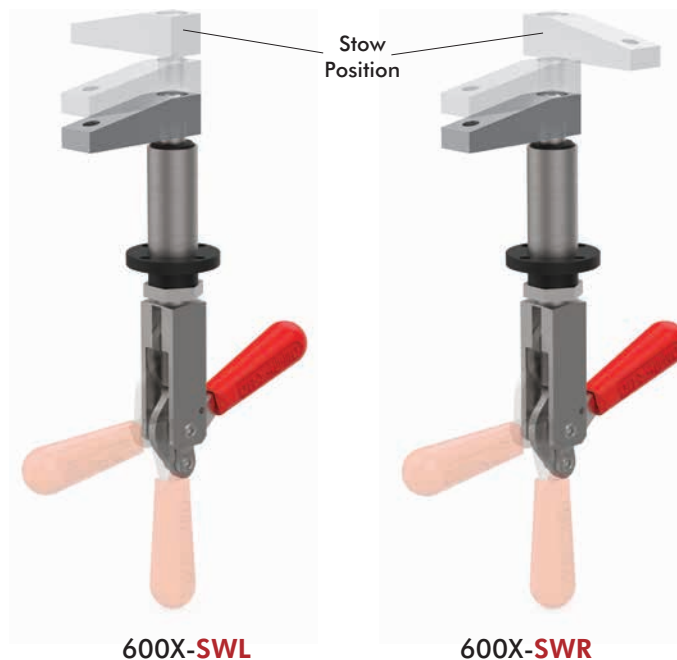
### Color Handles

Available on models in this series. Add -Y, -G, -B, -K to end of model number.



| Model    | Swing Direction | Max. Holding Capacity* | Total Stroke [in] mm | Stroke During Rotation [in] mm | Stroke Straight Pull [in] mm | Weight [lb] Kg |
|----------|-----------------|------------------------|----------------------|--------------------------------|------------------------------|----------------|
| 6002-SWL | LH              | [400 lbf]<br>1780 N    | [0.75]<br>19,1       | [0.53]<br>13,5                 | [0.22]<br>5,6                | [0.95]<br>0,43 |
| 6002-SWR | RH              |                        |                      |                                |                              |                |
| 6004-SWL | LH              | [600 lbf]<br>2670 N    | [1.50]<br>38         | [0.87]<br>22                   | [0.63]<br>16                 | [1.32]<br>0,6  |
| 6004-SWR | RH              |                        |                      |                                |                              |                |

\*Straight pull. Does not account for clamp arm.



# 6000-SW SERIES

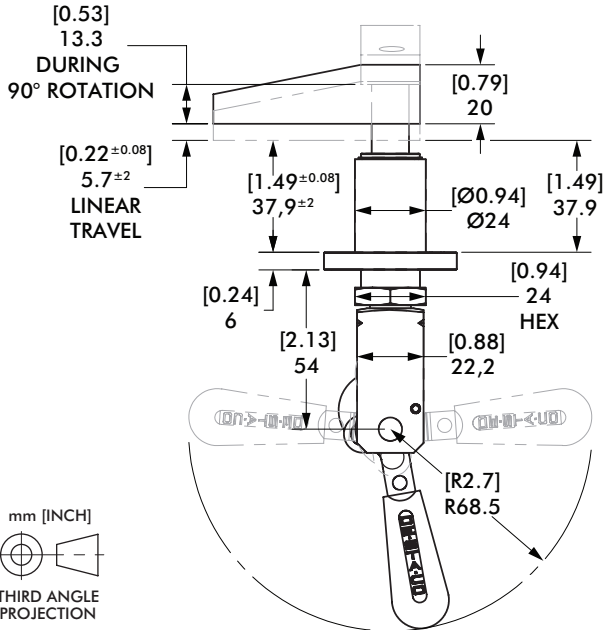
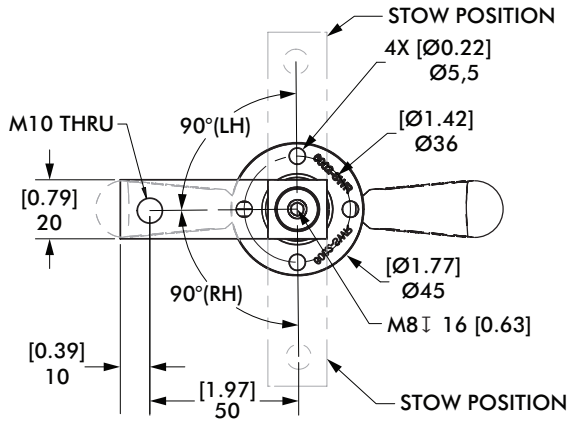
## Manual Swing Clamps | Product Overview and Dimensions

### 6002-SWL/SWR



6002-SWL

6002-SWR

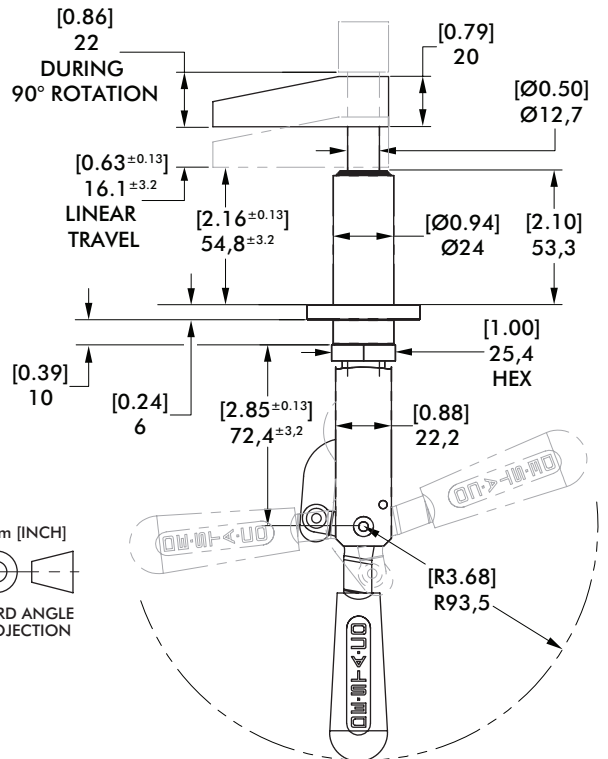
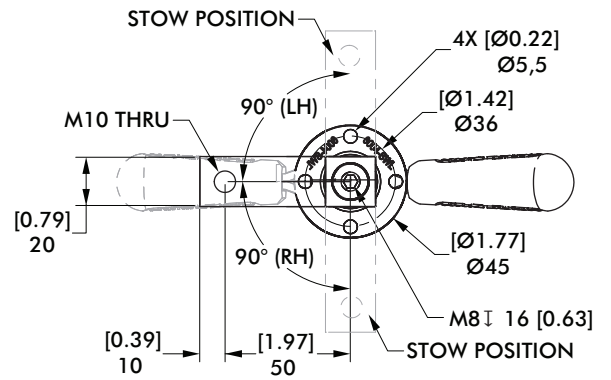


### 6004-SWL/SWR



6004-SWL

6004-SWR

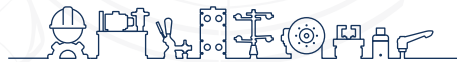


| Applied Force (on handle)          | [lbs] N | [25] 111   | [20] 89    | [15] 67   | [10] 44   |
|------------------------------------|---------|------------|------------|-----------|-----------|
| Plunger Pull Force (straight pull) |         | [360] 1601 | [288] 1281 | [216] 961 | [144] 641 |
| Clamp Force (with arm shown below) |         | [229] 1019 | [189] 841  | [149] 663 | [108] 480 |

| Applied Force (on handle)          | [lbs] N | [40] 178   | [30] 133   | [20] 89    | [10] 44   |
|------------------------------------|---------|------------|------------|------------|-----------|
| Plunger Pull Force (straight pull) |         | [576] 2562 | [432] 1922 | [288] 1281 | [144] 641 |
| Clamp Force (with arm shown below) |         | [323] 1437 | [269] 1197 | [189] 841  | [108] 480 |

Higher clamping forces than pneumatic version





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