

DE-STA-CO pallet clamps are designed with a view to the requirements of the automotive and sheet processing industries. They are the perfect choice when it comes to clamping, holding and positioning metal sheets and other components on and in jigs. These clamps are used whenever normal automation power clamps cannot be used for accessibility reasons.

Locating clamps do two jobs in parallel: positioning and clamping. Their encapsulated mechanism is particularly well suited for long usage in welding systems. Sensors check if a clamping arm is actuated or released. This optional feature is a distinct advantage in automatic production systems.

All clamps share one common feature:

The clamps are designed to last for millions of cycles if the relevant application complies with the concept guideline.



Pallet clamps sorted by clamping force

Model	Clamping force [N]
82U50-2	4000
82P35-3	3500
82P30-3	2000

Series 82U50-2

■ Pallet power clamps, enclosed model

Models: 82U50-2....

Application:

Clamping, holding, gripping and positioning of metal sheets and other parts, mainly in jigs and handling systems, particularly in situations where local accessibility does not allow the use of standard clamps.



82U50-200....
Pallet power clamp

Key areas of application:

Automotive manufacturing, sheet processing industry, jig and general mechanical engineering.

Features:

- compact, enclosed aluminium body
- high holding torques
- long life cycle
- hard alloy rest at the clamping hook
- toggle action mechanism
- inductive sensing module with LED display

Optional:

- adapter plate for lateral connection
- sensing system integrated or attached to the cylinder

Model no.			Max. holding force [N]	Clamping force at 5 bar [N]	Max. operating pressure [bar]	Cylinder Ø mm	Weight ~ [kg]
with inductive sensing							
Connector M12x1, fixed	Connector M12x1, w/ lead	Connector M8x1, fixed					
82U50-200B700	82U50-200B800	82U50-200C800	4000	4000	6	50	3,2

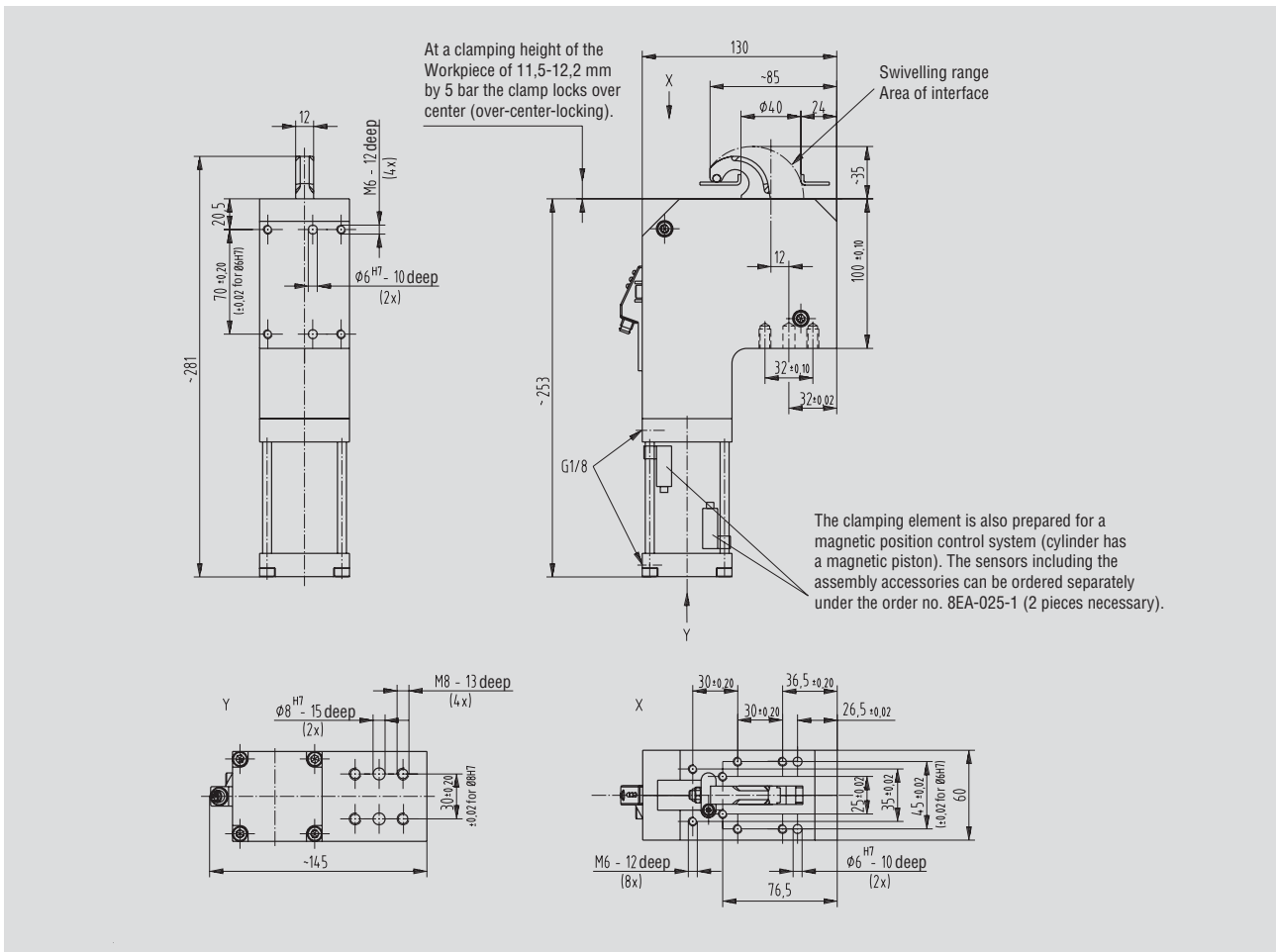
Accessories

Specification	Order no. for structure component 82U50-200....	Comment
Connector cable (1 connector socket & 5 m cable)		
B7 / B8 sensing system		
Connector socket M12x1, straight, 5-pin	8EL-002-1	
Connector socket M12x1, angular, 4-pin	8EL-003-1	
C8 sensing system		
Connector socket M8x1, straight, 4-pin	8EL-009-1	
Connector socket M8x1, angular, 4-pin	8EL-007-1	
Plug adapter M8 to M12	8EL-008-1	
Sensing system attached to cylinder		
Magnetic sensors plus installation material	8EA-025-1	2 pcs required
Adapter plate plus screws and washers	82ZB-002-1	

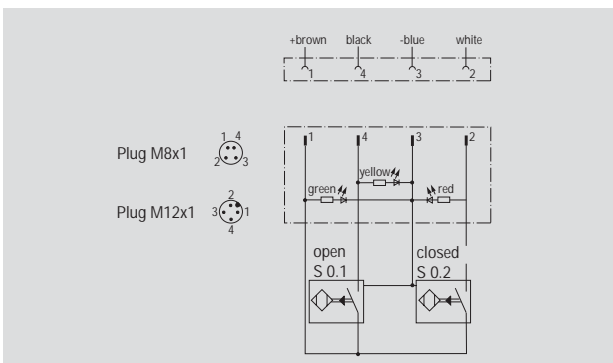
Major spare parts

Specification	Order no. for structural component 82U50-200....
Pneumatic cylinder	8PW-007-1
Seal kit	8PW-007-1-00
Sensor box "B7" , connector plug M12x1, fixed	8EA-060-1
Sensor box "B8" , connector plug M12x1 with lead	8EA-031-1
Sensor box "C8" , connector plug M8x1, fixed	8EA-023-2

82U50-200....



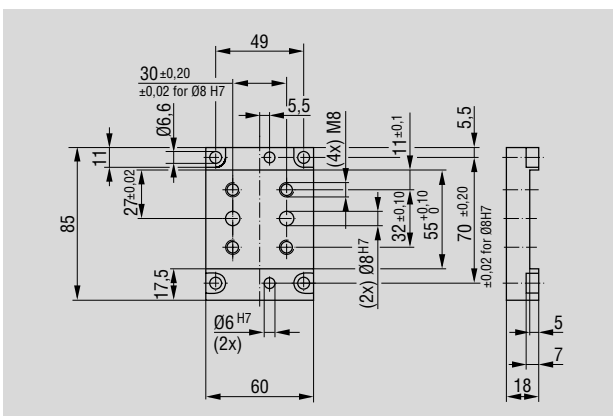
Power clamp to be operated with external pneumatic one-way flow control valve only



Wiring diagram of electrical sensing systems B7, C8, B8

Sensing system immune to interference from d.c. arc welding and a.c. arc welding

- B7: inductive, sensor box, connector plug M12x1, fixed
- B8: inductive, sensor box, connector plug M12x1 with lead
- C8: inductive, sensor box, connector plug M8x1, fixed



Series 82P30-3/82P35-3

- Pneumatic locating clamps, enclosed and narrow design, with single-sided or double-sided clamping hook

Models: 82P30-3..... 82P35-3.....

Application:

Clamping, holding, gripping and accurately positioning of metal sheets and other parts in jigs and handling systems.

Key areas of application:

Automotive manufacturing, sheet processing industry, jig and general mechanical engineering.

Features:

- compact design
- low weight (aluminium body)
- single-sided or double-sided clamping hook
- lateral attachment
- centring pin diameters between 20 mm and 45 mm
- 2 body variants, cylinder diameters 30 mm or 35 mm
- toggle action mechanism
- inductive sensing module with LED display



Locating clamp 82P30-3..C000

Single-sided clamping hook without centring pin



Locating clamp 82P30-3..C0D0

Double-sided clamping hook without centring pin

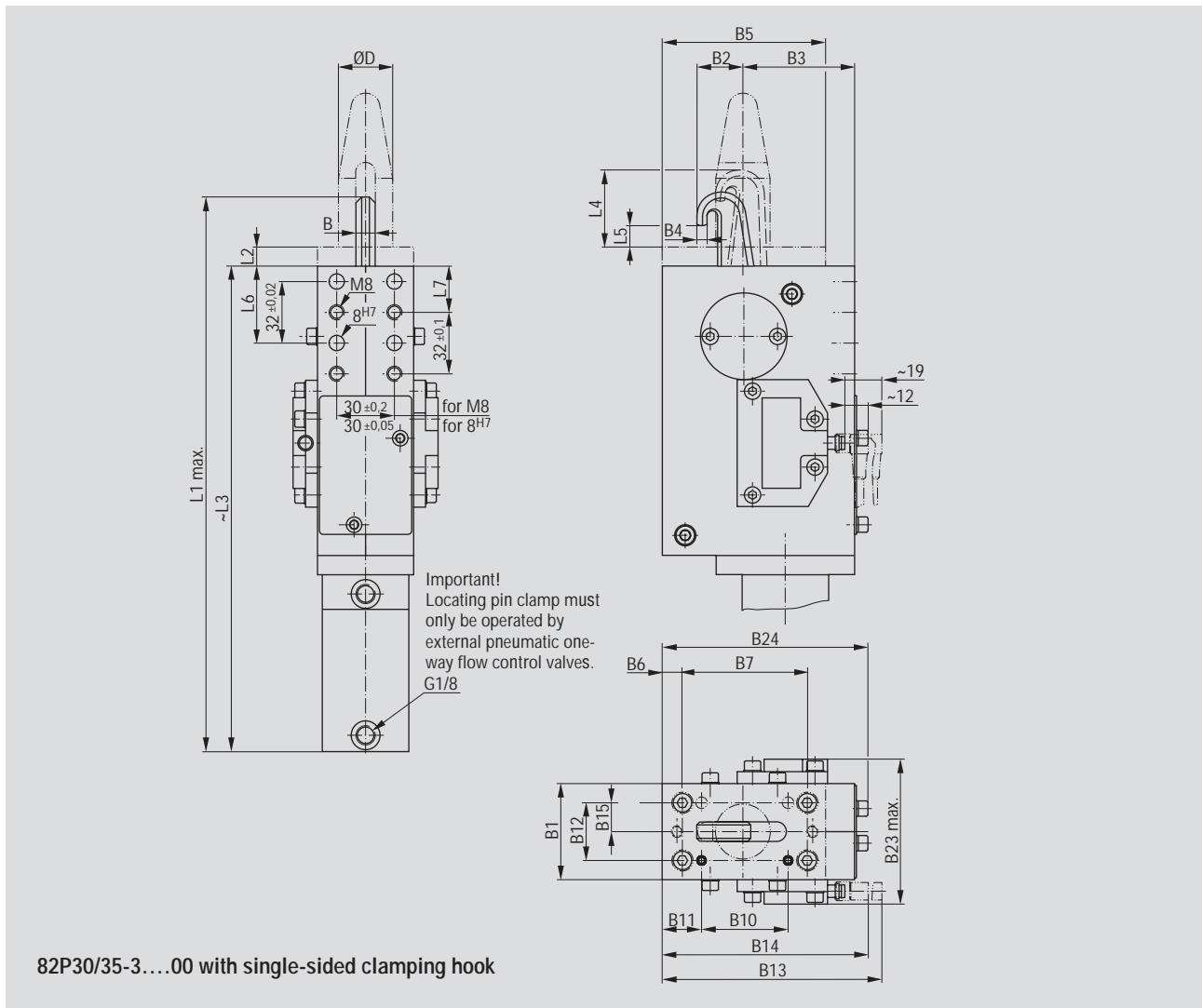
Locating clamps with single-side clamping hook (Centring pin has to be ordered separately)

Model no. with inductive sensing without centring pin		Max. clamping force at 6 bar [N]	Max. operating pressure [bar]	Cylinder Ø [mm]	For centring pin Ø D [mm]	Weight ~ [kg]	Air consumption per double stroke at 6 bar [dm ³]
Connector M12x1	Connector M8x1						
82P30-320B800	82P30-320C000	2000	6	30	20,0-23,0	3	0,8
82P30-325B800	82P30-325C000	2000	6	30	23,1-28,0	3	0,8
82P30-330B800	82P30-330C000	2000	6	30	28,1-33,0	3	0,8
82P35-340B800	82P35-340C000	3500	6	35	33,1-45,0	3,4	1,0

Locating clamps with double-side clamping hook (Centring pin has to be ordered separately)

Model no. with inductive sensing without centring pin		Max. clamping force at 6 bar [N]	Max. operating pressure [bar]	Cylinder Ø [mm]	For centring pin Ø D [mm]	Weight ~ [kg]	Air consumption per double stroke at 6 bar [dm ³]
Connector M12x1	Connector M8x1						
82P30-320B8D0	82P30-320C0D0	2000	6	30	20,0-23,0	3	0,8
82P30-325B8D0	82P30-325C0D0	2000	6	30	23,1-28,0	3	0,8
82P30-330B8D0	82P30-330C0D0	2000	6	30	28,1-33,0	3	0,8
82P35-340B8D0	82P35-340C0D0	3500	6	35	33,1-45,0	3,4	1,0

■ Locating clamp with single-sided clamping hook



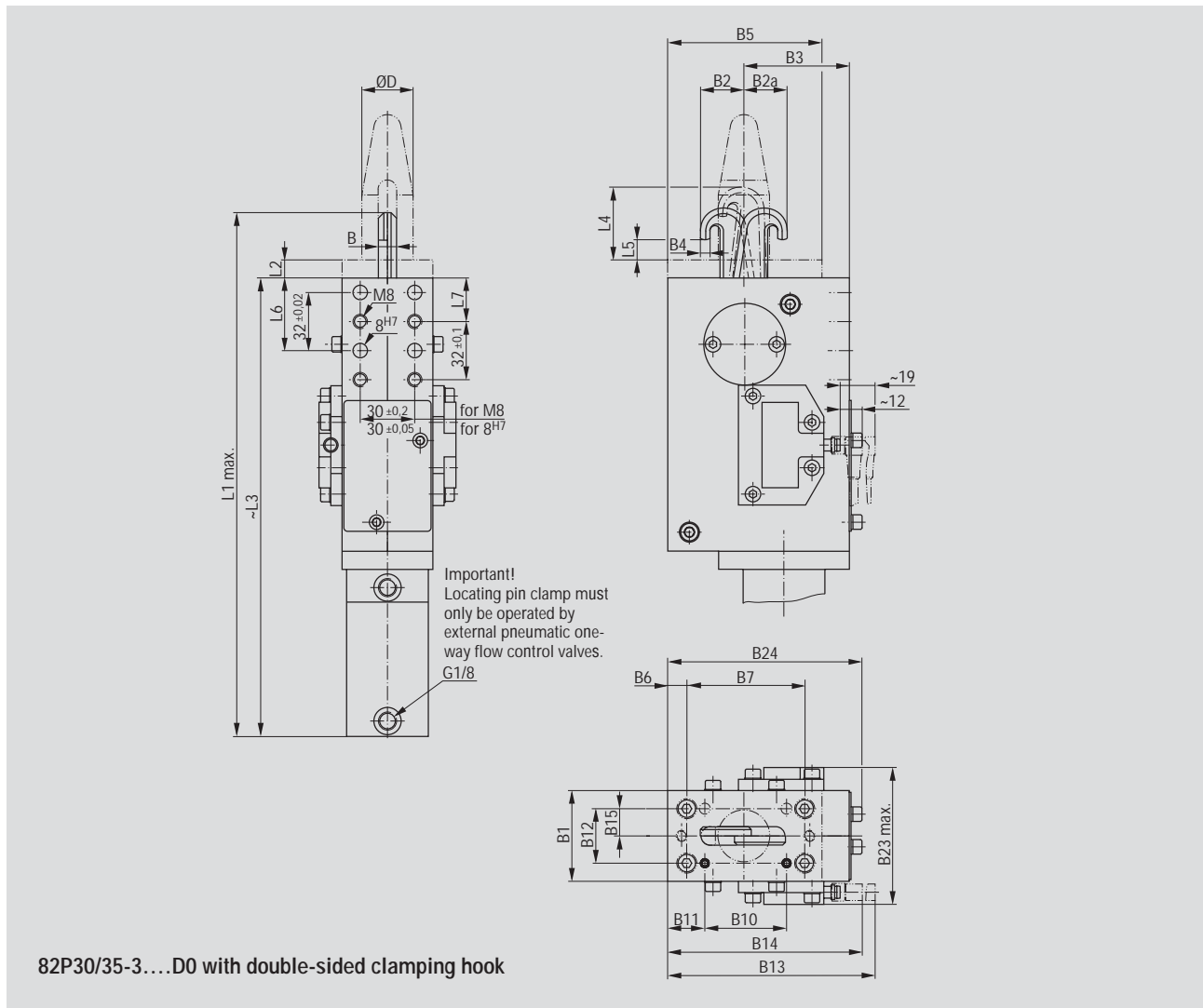
Technical data

Model no.		Piston Ø	For centring pin Ø											
with inductive sensing			D	B	B1	B2	B3	B4	B5	B6	B7	B10	B11	B12*
Connector M12x1	Connector M8x1		-0,05	-0,1						±0,1	±0,2	±0,1	±0,1	±0,05
82P30-320B800	82P30-320C000	30	20,0-23,0	10	50	18,5	58	5	85	10,5	65	35	25,5	30
82P30-325B800	82P30-325C000	30	23,1-28,0	10	50	20,5	58	5,25	85	10,5	65	35	25,5	30
82P30-330B800	82P30-330C000	30	28,1-33,0	10	50	22,5	58	5,25	85	10,5	65	35	25,5	30
82P35-340B800	82P35-340C000	35	33,1-45,0	12	60	34	53	7	90	19	61	37	31	40

Model no.		B13	B14	B15*	B23	B24	L1	L2	L3	L4	L5	L6	L7		
with inductive sensing		max	max	±0,025	max		max	+0,1	~	~		±0,05	±0,1		
Connector M12x1	Connector M8x1														
82P30-320B800	82P30-320C000	114	107	15	75,4	107	304	10	265	40	11,5	40	24		
82P30-325B800	82P30-325C000	114	107	15	75,4	107	306	10	265	44	11,5	40	24		
82P30-330B800	82P30-330C000	114	107	15	75,4	107	306	10	265	45	11,5	40	24		
82P35-340B800	82P35-340C000	114	107	20	85,4	107	330	12	265	56	14	38	22		

*Tolerances for dowel holes only

Locating clamp with double-sided clamping hook



Technical data







Model no. with inductive sensing without centring pin		Piston Ø	For centring pin Ø	D	B	B1	B2	B2a	B3	B4	B5	B6	B7	B10	B11
Connector M12x1	Connector M8x1		D	-0,05	-0,05							±0,1	±0,2	±0,1	±0,1
82P30-320B8D0	82P30-320C0D0	30	20,0-23,0	5	50	18,5	19,5	58	5	85	10,5	65	35	25,5	
82P30-325B8D0	82P30-325C0D0	30	23,1-28,0	5	50	20,5	21,5	58	5,25	85	10,5	65	35	25,5	
82P30-330B8D0	82P30-330C0D0	30	28,1-33,0	5	50	22,5	23,5	58	5,25	85	10,5	65	35	25,5	
82P35-340B8D0	82P35-340C0D0	35	33,1-45,0	6	60	34	34	53	7	90	19	61	37	31	

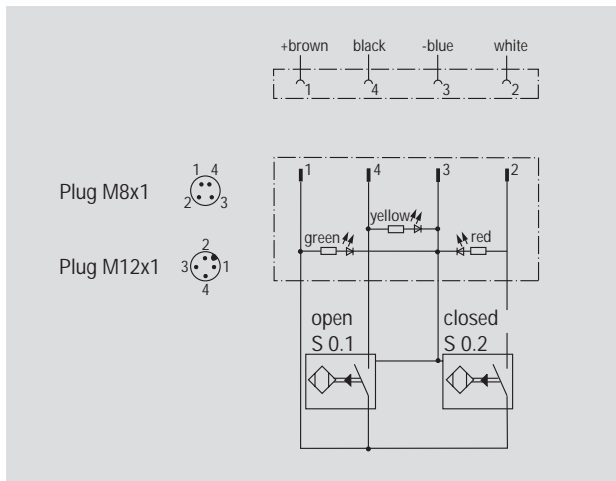
Model no. with inductive sensing without centring pin		B12*	B13	B14	B15*	B23	B24	L1	L2	L3	L4	L5	L6	L7		
Connector M12x1	Connector M8x1	±0,05	max	max	±0,025	max		max	+0,1	~	~		±0,05	±0,1		
82P30-320B8D0	82P30-320C0D0	30	114	107	15	75,4	107	304	10	265	40	11,5	40	24		
82P30-325B8D0	82P30-325C0D0	30	114	107	15	75,4	107	306	10	265	44	11,5	40	24		
82P30-330B8D0	82P30-330C0D0	30	114	107	15	75,4	107	306	10	265	45	11,5	40	24		
82P35-340B8D0	82P35-340C0D0	40	114	107	20	85,4	107	330	12	265	56	14	38	22		

*Tolerances for dowel holes only

Numbering code for locating clamps 82P30-3... / 82P35-3...

Example Model no.: **82P30 - 3 30 B8 00**

<p>Location clamp</p>  <p>82P30-3.../82P35-3...</p> <p>Basic model</p>	<p>Adapter for standard centring pin</p> <p>20 for pin-Ø 20,0 - 23,0 mm 25 for pin-Ø 23,1 - 28,0 mm 30 for pin-Ø 28,1 - 33,0 mm 40 for pin-Ø 33,1 - 45,0 mm</p>  <p>Standard locating pin order separately</p> <p>Standard locating pin</p>	<p>C0 = Sensor 8EA-012-2 Connector (M8x1)</p>  <p>B8 = Sensor 8EA-030-1 Connector (M12x1)</p>  <p>Sensors</p>	<p>00 = Standard clamping hook</p>  <p>DO = Double clamping hook</p>  <p>Clamping hook</p>
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Wiring diagram of electrical sensing system

Sensing system immune to interference from d.c. arc welding and a.c. arc welding

Inductive models:

- B8 inductive, with LEDs, connector plug M12x1
- C0 inductive, with LEDs, connector plug M8x1

Pin assignment

Accessories for 82P30/35-3...

Specification	Order no. for structural component	
	82P30-3...	82P35-3...
Centring pins (put diameter in model number)	82P30-3-__-__ ¹⁾	82P35-3-__-__ ¹⁾
Connector cable (1 connector socket & 5 m cable)		
B8 sensing system		
Connector socket M12x1, straight, 5-pin	8EL-002-1	8EL-002-1
Connector socket M12x1, angular, 4-pin	8EL-003-1	8EL-003-1
C0 sensing system		
Connector socket M8x1, straight, 4-pin	8EL-009-1	8EL-009-1
Connector socket M8x1, angular, 4-pin	8EL-007-1	8EL-007-1

¹⁾ __-__ = centring pin diameter "D" as illustrated on page 17.8

Ordering example: To order the centring pin for locating clamp 82P30-325C000 with pin diameter "D" = 26.5 mm: "82P30-3-26.5"

Series 82P30-3/82P35-3

■ Centring pin (has to be ordered separately)

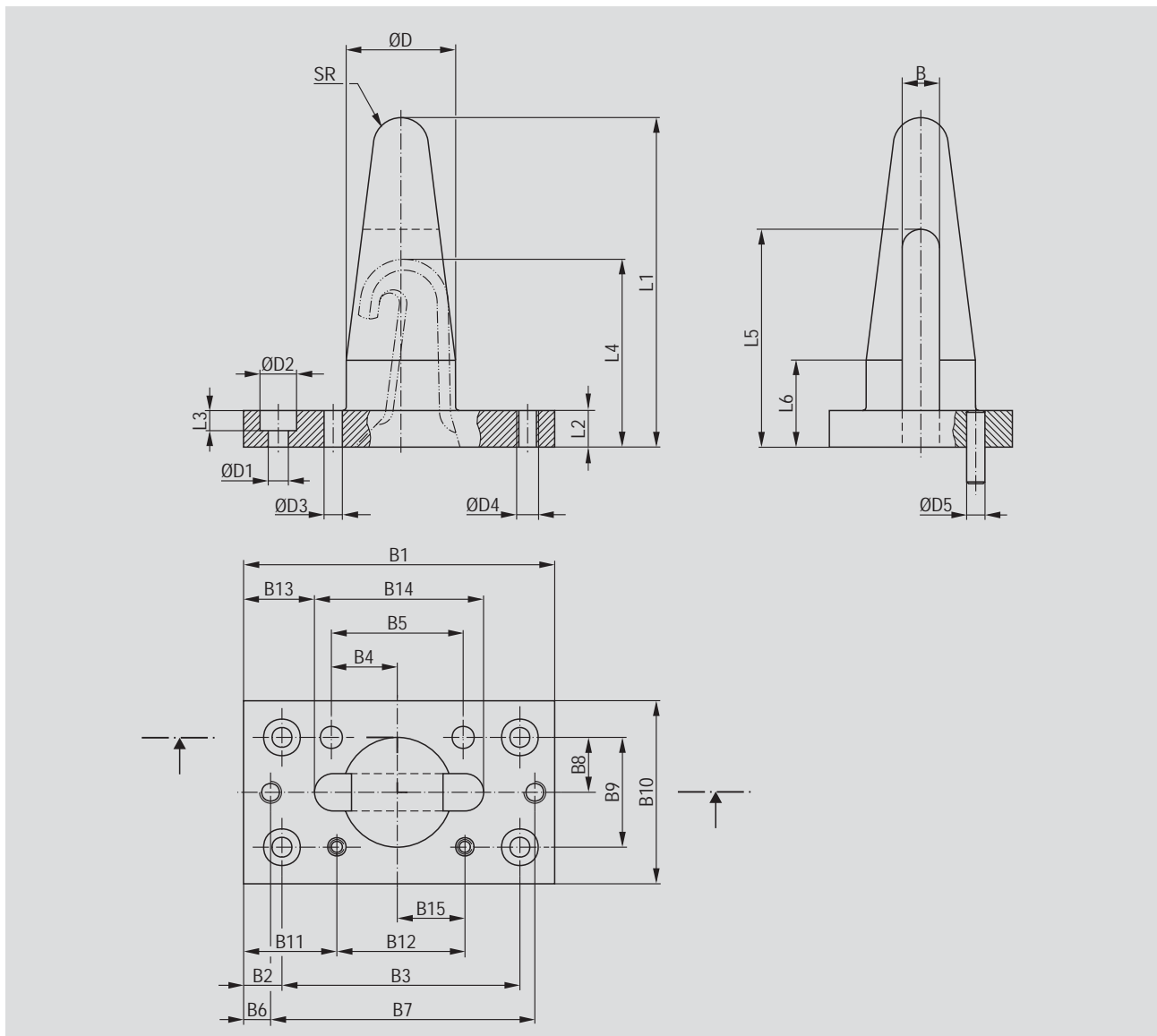


Locating clamp with single-sided clamping hook and centring pin



Centring pin (accessory part)

Centring pin for 82P30-3... and 82P35-3...



Technical data of centring pins

Base locating clamp model	Order no. for centring pin	ØD -0,05	ØD1	ØD2	ØD3 H7	ØD4	ØD5 H11	SR	L1	L2 +0,1	L3	L4	L5	L6	B	B1	B2 ±0,1
82P30-320....	82P30-3-__ __ ¹⁾	20,0-23,0	5,5	10	6	M6	5	5	80	10	6	52	59,5	25	10,2	85	10,5
82P30-325....	82P30-3-__ __ ¹⁾	23,1-28,0	5,5	10	6	M6	5	7,5	90	10	6	54	59,5	25	10,2	85	10,5
82P30-330....	82P30-3-__ __ ¹⁾	28,1-33,0	5,5	10	6	M6	5	7,5	90	10	6	55	59,5	25	10,2	85	10,5
82P35-340....	82P35-3-__ __ ¹⁾	33,1-45,0	5,5	10	6	M6	5	8	102	12	6	68	73,5	30	12,2	90	19

Base locating clamp model	Order no. for centring pin	B3 ±0,2	B4 ±0,02	B5 ±0,02	B6	B7 ±0,2	B8* ±0,025	B9* ±0,05	B10	B11 ±0,1	B12 ±0,1	B13	B14	B15 ±0,05
82P30-320....	82P30-3-__ __ ¹⁾	65	18	36	10,5	65	15	30	50	25,5	35	19,4	46,2	18,5
82P30-325....	82P30-3-__ __ ¹⁾	65	18	36	10,5	65	15	30	50	25,5	35	19,4	46,2	18,5
82P30-330....	82P30-3-__ __ ¹⁾	65	18	36	10,5	65	15	30	50	25,5	35	19,4	46,2	18,5
82P35-340....	82P35-3-__ __ ¹⁾	61	18	36	7	76	20	40	60	31	37	16	62	21

* Tolerance for dowel hole

¹⁾ __ __ = centring pin diameter "D"

Ordering example: To order the centring pin for locating clamp 82P30-325C000 with pin diameter "D" = 26.5 mm: "82P30-3-26.5"

Major spare parts for 82P30-3/82P35-3

Specification	Order no. for structural component	
	82P30-3...	82P35-3...
End position sensing		
B8 plug connector M12x1	8EA-030-1	8EA-030-1
C0 plug connector M8x1	8EA-012-2	8EA-012-2
Cylinder	8PW-019-1	8PW-006-1
Seal kit	8PW-019-1-00	8PW-006-1-00

Series 52H30-3/52H35-3

- Locating clamps, manual actuation, enclosed and narrow design, with single-sided clamping hook

Application:

Clamping, holding, gripping and accurately positioning of metal sheets and other parts in jigs and handling systems.

Key areas of application:

Automotive manufacturing, sheet processing industry, jig and general mechanical engineering.

Features:

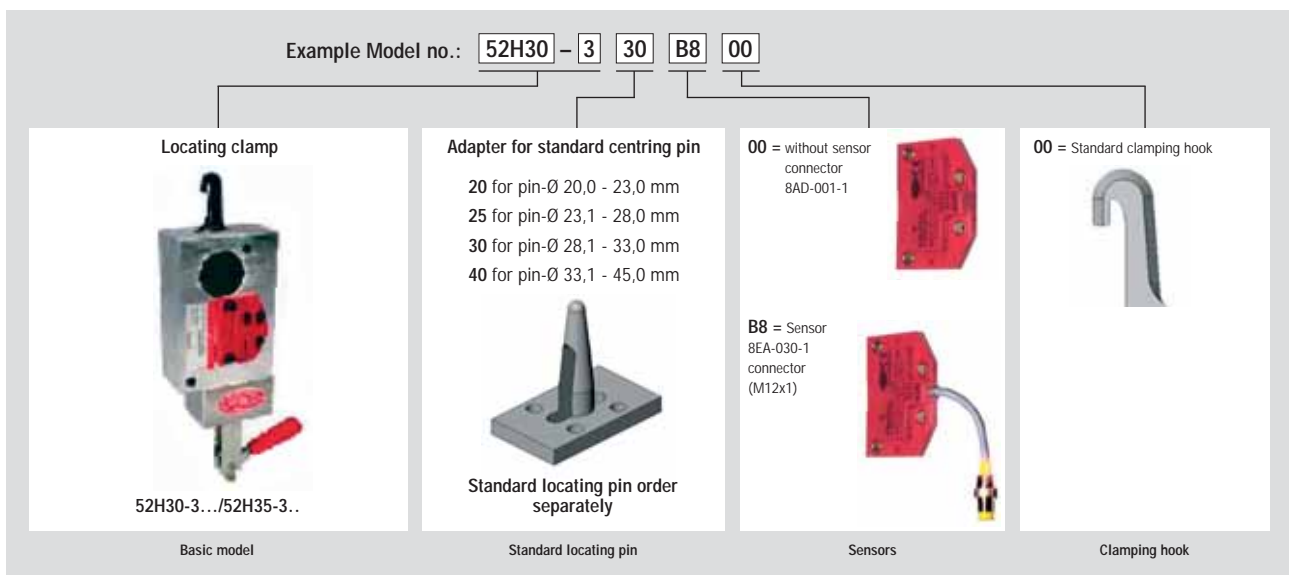
- compact design
- low weight (aluminium body)
- manual actuation and single-sided clamping hook
- lateral attachment
- centring pin diameters between 20 mm and 45 mm
- toggle action mechanism
- inductive sensing module with LED display



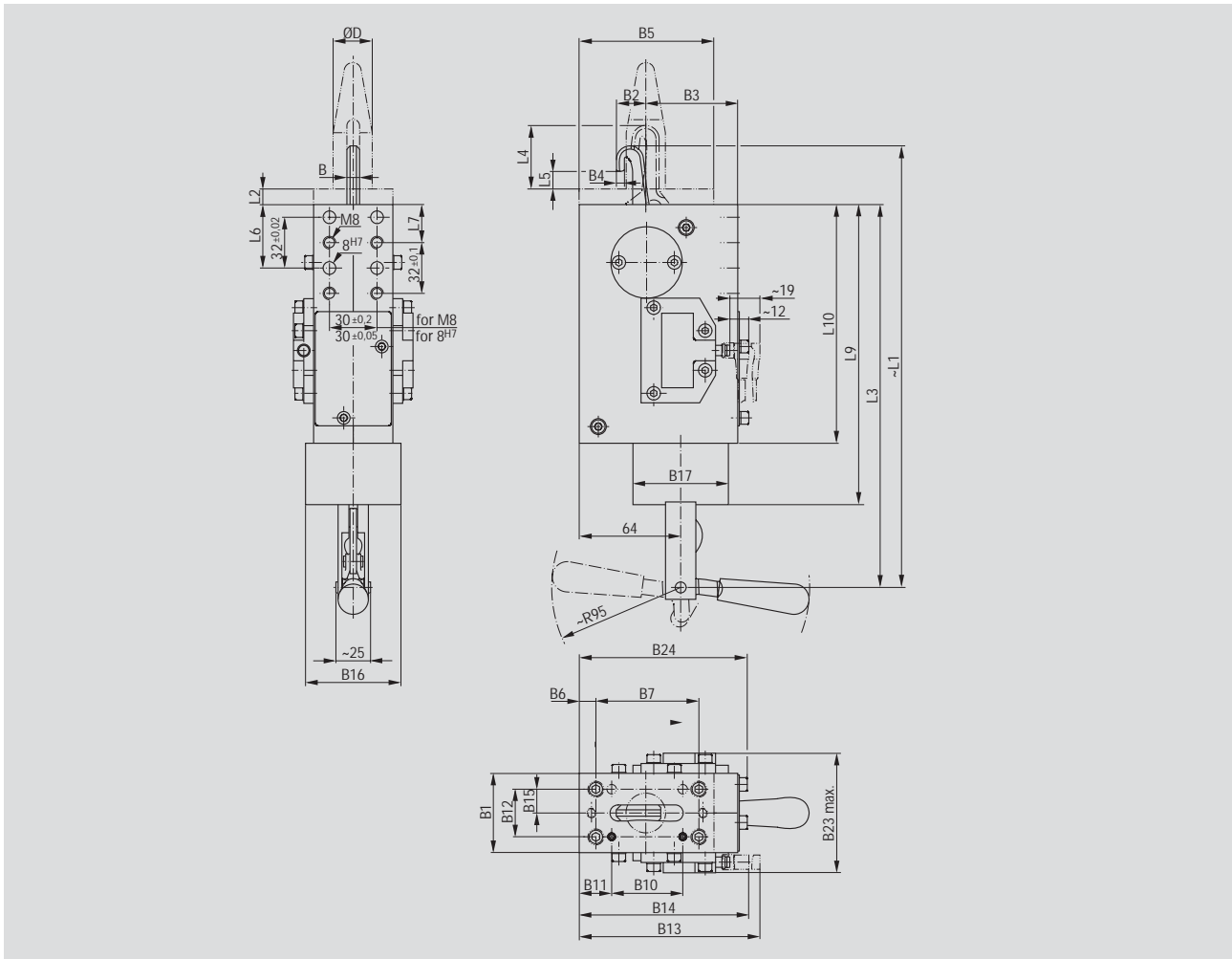
52H30/35-3...B800

Model no. without centring pin		For centring pin Ø D ^{-0.05} [mm]	Weight ~ [kg]
w/o sensing	w/ inductive sensing connector M12x1		
52H30-3200000	52H30-320B800	20,0-23,0	3,1
52H30-3250000	52H30-325B800	23,1-28,0	3,1
52H30-3300000	52H30-330B800	28,1-33,0	3,1
52H35-3400000	52H35-340B800	33,1-45,0	3,1

Model numbering code for 52H30/35-3...00



52H30-3, 52H35-3



Technical data

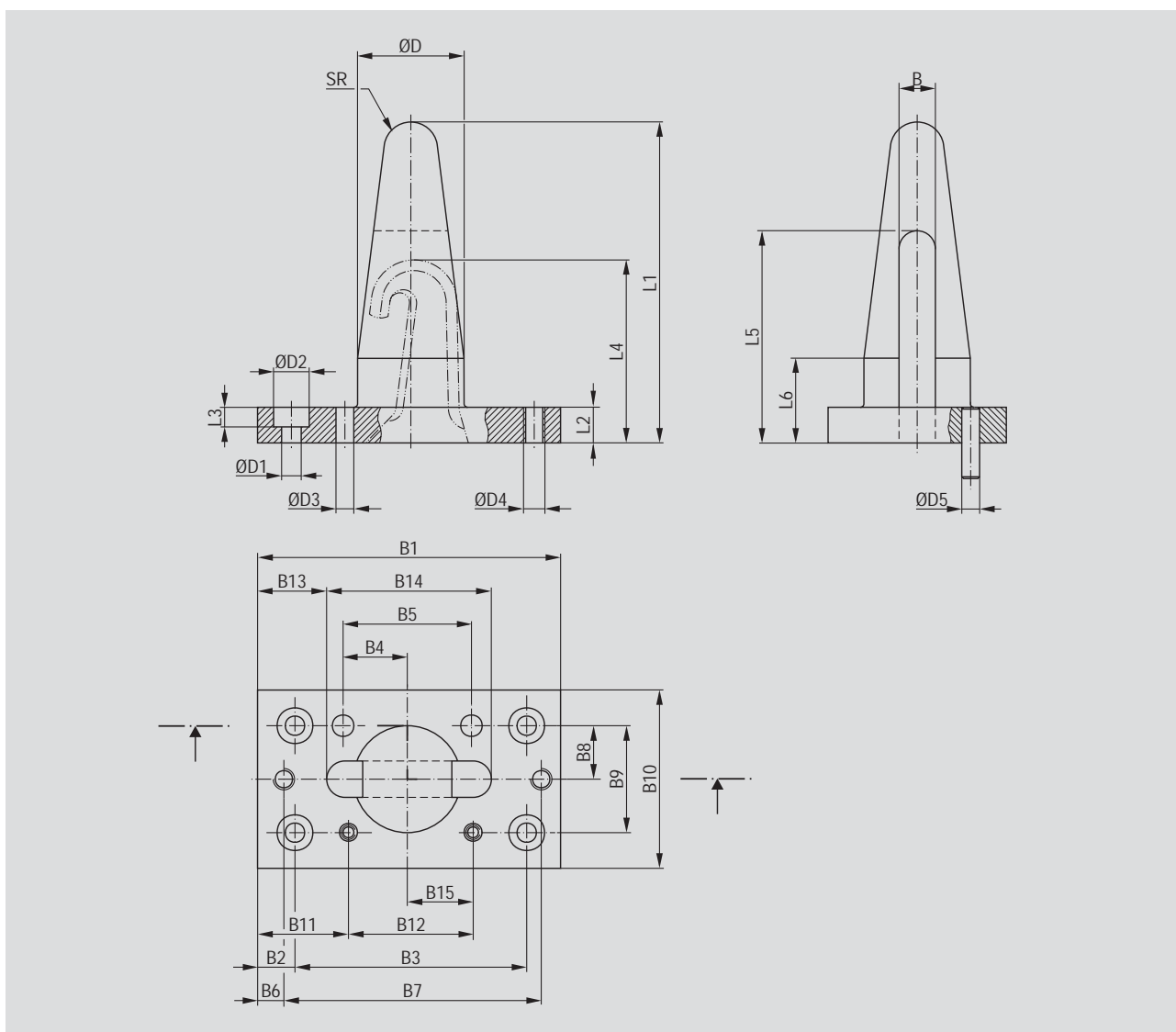
Model no.		For centring pin Ø													
without sensing	with ind. sensing connector M12x1	D	B	B1	B2	B3	B4	B5	B6	B7	B10	B11	B12*	B13	B14
		-0,05	-0,1						±0,1	±0,2	±0,1	±0,1	±0,05	max	max
52H30-3200000	52H30-320B800	20,0-23,0	10	50	18,5	58	5	85	10,5	65	35	25,5	30	114	107
52H30-3250000	52H30-325B800	23,1-28,0	10	50	20,5	58	5,25	85	10,5	65	35	25,5	30	114	107
52H30-3300000	52H30-330B800	28,1-33,0	10	50	22,5	58	5,25	85	10,5	65	35	25,5	30	114	107
52H35-3400000	52H30-340B800	33,1-45,0	12	60	34	53	7	90	19	61	37	31	40	114	107

Model no.		B15*	B23	B24	L1	L2	L3	L4	L9	L10	L5	L6	L7	B16	B17
without sensing	with ind. sensing connector M12x1	±0,025	max			+0,1	~			~		±0,05	±0,1		
52H30-3200000	52H30-320B800	15	75,4	107	295	10	256	40	195,5	150,5	11,5	40	24	50	78
52H30-3250000	52H30-325B800	15	75,4	107	295	10	256	44	195,5	150,5	11,5	40	24	50	78
52H30-3300000	52H30-330B800	15	75,4	107	295	10	256	45	195,5	150,5	11,5	40	24	50	78
52H35-3400000	52H30-340B800	20	85,4	107	320	12	279	56	218,5	173,5	14	38	22	70	70

*Tolerances for dowel holes only

Series 52H30-3/52H35-3

Centring pin for 52H30-3... and 52H35-3... (hasto be ordered separately)



Technical data

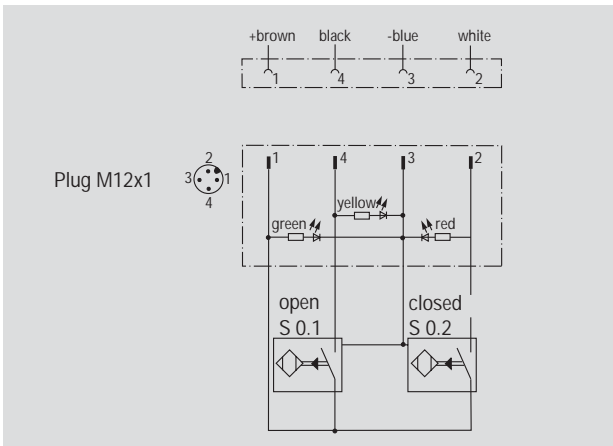
Base locating clamp model	Order no. for centring pin	ØD -0,05	ØD1	ØD2	ØD3 H7	ØD4	ØD5 H11	SR	L1	L2 +0,1	L3	L4	L5	L6	B	B1	B2 ±0,1
52H30-320....	82P30-3-__-__ ¹⁾	20,0-23,0	5,5	10	6	M6	5	5	80	10	6	52	59,5	25	10,2	85	10,5
52H30-325....	82P30-3-__-__ ¹⁾	23,1-28,0	5,5	10	6	M6	5	7,5	90	10	6	54	59,5	25	10,2	85	10,5
52H30-330....	82P30-3-__-__ ¹⁾	28,1-33,0	5,5	10	6	M6	5	7,5	90	10	6	55	59,5	25	10,2	85	10,5
52H35-340....	82P35-3-__-__ ¹⁾	33,1-45,0	5,5	10	6	M6	5	8	102	12	6	68	73,5	30	12,2	90	19

Base locating clamp model	Order no. for centring pin	B3 ±0,2	B4 ±0,02	B5 ±0,02	B6	B7 ±0,2	B8* ±0,025	B9* ±0,05	B10	B11 ±0,1	B12 ±0,1	B13	B14	B15 ±0,05
52H30-320....	82P30-3-__-__ ¹⁾	65	18	36	10,5	65	15	30	50	25,5	35	19,4	46,2	18,5
52H30-325....	82P30-3-__-__ ¹⁾	65	18	36	10,5	65	15	30	50	25,5	35	19,4	46,2	18,5
52H30-330....	82P30-3-__-__ ¹⁾	65	18	36	10,5	65	15	30	50	25,5	35	19,4	46,2	18,5
52H35-340....	82P35-3-__-__ ¹⁾	61	18	36	7	76	20	40	60	31	37	16	62	21

* Tolerance for dowel hole

¹⁾ __-__ = centring pin diameter "D"

Ordering example: To order the centring pin for locating clamp 52H30-325B800 with pin diameter "D" = 26.5 mm: "52H30-3-26.5"



Wiring diagram of electrical sensing system

Sensing system immune to interference from d.c. arc welding and a.c. arc welding

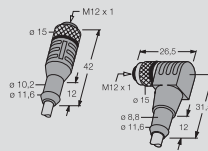
Inductive model:

- B8 inductive, with LEDs, connector plug M12x1

Pin assignment

Accessories for 52H30/35-3...00

Specification	Order no. for structural component	
	52H30-3...	52H35-3...
Centring pins	52H30-3-__/_ ¹⁾	52H35-3-__/_ ¹⁾
Connector cable (1 connector socket & 5 m cable)		
B8 sensing system		
Connector socket M12x1, straight, 5-pin	8EL-002-1	8EL-002-1
Connector socket M12x1, angular, 4-pin	8EL-003-1	8EL-003-1



¹⁾ __/_ = centring pin diameter "D" as illustrated on page 17.12

Ordering example: To order the centring pin for locating clamp 52H30-325B800 with pin diameter "D" = 26.5 mm: "52H30-3-26.5"

Major spare parts for 52H30/35-3...00

Specification	Order no. for structural component
	52H30/35-3...
End position sensing	
B8 plug connector M12x1	8EA-030-1

Centring pin (accessory part)

