

The Chain Clamp was born here. Today, Mathey Dearman manufactures the broadest range of Chain Clamps to handle any size job, from 1-inch pipe all the way up to 20 feet. Our clamps can align Schedule 80 and reform Schedule 40 pipes, elbows, tees and other fittings within their range while providing the maximum degree of welder safety. Whether aligning and/or reforming small tubes or large vessels, Mathey Dearman has the right Chain Clamp for the job.



## ALIGNING AND REFORMING CLAMPS

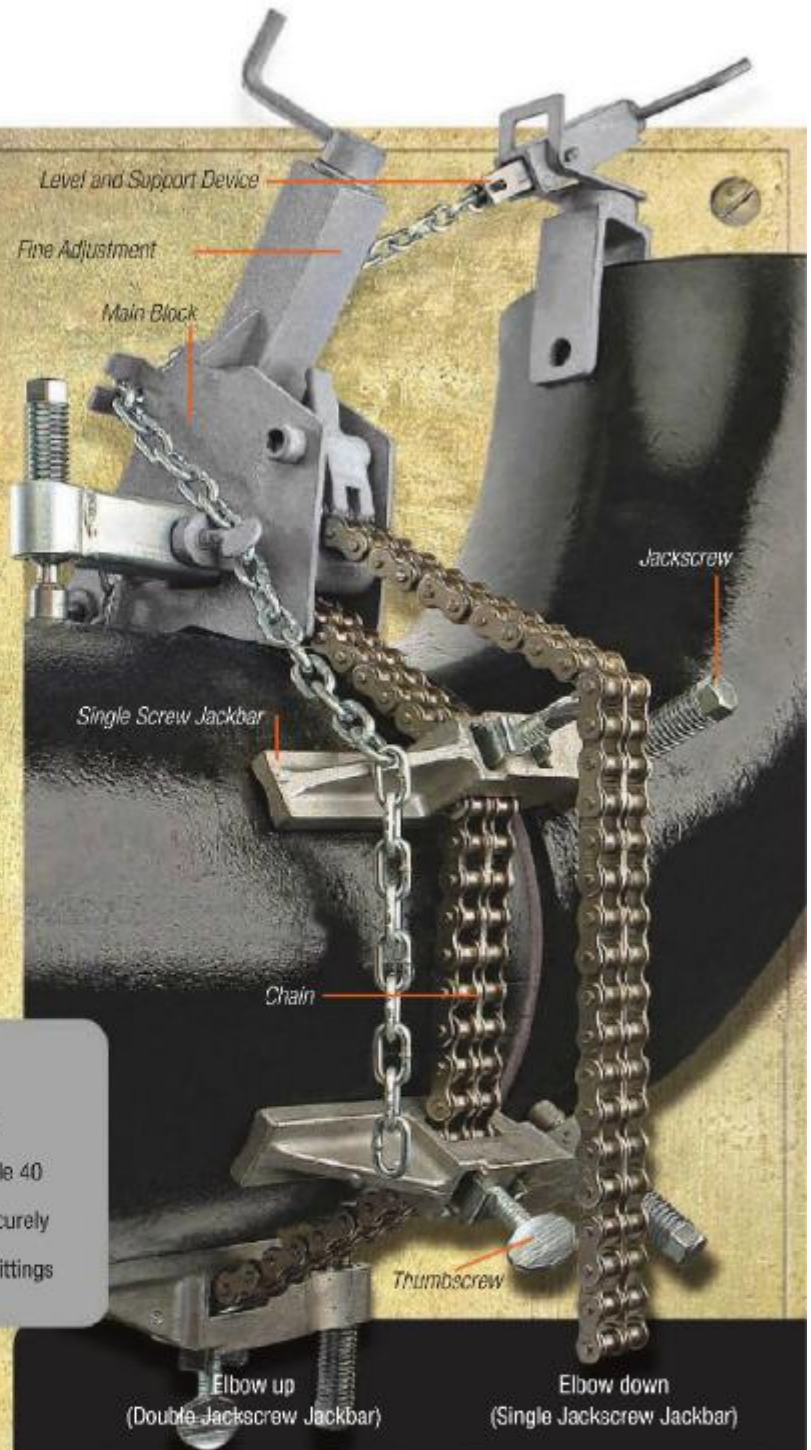


## ALIGNING & REFORMING CLAMPS

### SINGLE JACKSCREW CHAIN CLAMP

The Single Jackscrew Chain Clamp reforms the mating side of the weld gap and is capable of reforming up to Schedule 40 pipe.\* Each jackbar is equipped with its own jackscrew to exert pressure on the high points of the mating pipe, eliminating "Hi-Lo" as pipe and fittings are aligned. Pipe with wall thickness to Schedule 80 can be aligned with the Single Jackscrew Chain Clamp.\* The Level and Support Device of the Chain Clamp allows elbows, tees, flanges and other fittings to be held safely and securely for alignment and welding. The Single Jackscrew Chain Clamp is available in nickel plated carbon steel chain and stainless steel chain versions to fit pipe from 1" to 54" (25 mm to 1372 mm) in diameter. Although all Mathey Dearman Chain Clamps feature stainless steel Jackscrews, Jackbars and Main Blocks, stainless steel chain should always be used for stainless steel and specialty alloy applications to avoid potential contamination.

- ACCURATE** | Aligns within 1/64" (.4 mm) of an inch
- HEAVY DUTY** | Aligns pipe with wall thickness to Schedule 80
- STRONG** | Reforms mating pipe with wall thickness to Schedule 40
- SAFER** | Level and Support Device holds fittings safely and securely
- VERSATILE** | Aligns and reforms pipe, elbows, tees and other fittings



#### Single Jackscrew Jackbar

THE SINGLE JACKSCREW CHAIN CLAMP SHOULD NEVER BE USED AS THE SOLE SUPPORT FOR THE PIPE OR TO LIFT THE PIPE. DO NOT EXCEED PIPE SIZE RANGE LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP BY MATHEY DEARMAN WILL VOID THE CLAMP WARRANTY.





### Single Jackscrew Chain Clamp Includes:

- Nickel plated carbon steel or stainless steel duplex roller chain
- Stainless steel Single Jackscrew Jackbars, quantity as indicated in specifications
- Stainless steel Main Block
- Stainless steel Level and Support Device
- Jackscrew Wrench
- Heavy-duty Storage Box
- Parts and Operating Manual

### Single Jackscrew Chain Clamp Benefits:

- One Chain Clamp covers the range of 8 cage clamps
- Pipe and fittings can be fully welded with clamp in place
- Jackscrew contact points swivel to protect against marring the pipe
- Optional Spacing Screws available to assist in setting weld gap
- An add-on Jackbar can be added when additional reforming pressure is need.

The Single Chain Clamp reduces fatigue as elbows, tees and other fittings can be held easily in place while being accurately aligned with the Level and Support Device.

## SINGLE JACKSCREW CHAIN CLAMP | Specifications

Model	Number of Jackbars	Nominal Pipe Size Range in (mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Est. Shipping Weight
D231	3	1-8 (25-203)	40	80	21 lbs / 9 kg
D231SS	3	1-8 (25-203)	40	80	21 lbs / 9 kg
D232	7	4-16 (102-406)	40	80	68 lbs / 31 kg
D232SS	7	4-16 (102-406)	40	80	68 lbs / 31 kg
D233	8	10-36 (254-914)	40	80	144 lbs / 67 kg
D233SS	8	10-36 (254-914)	40	80	144 lbs / 67 kg
D234	13	10-54 (254-1372)	40	80	170 lbs / 79 kg
D234SS	13	10-54 (254-1372)	40	80	170 lbs / 79 kg

\*Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch / 3,164 kg per square centimeter

SS - Indicates clamp includes stainless steel chain. All clamps equipped with stainless steel Jackbars, Jackscrews, and Main Blocks.

\* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch

**NOTE: MATHEY DEARMAN CHAIN CLAMPS CAN BE RECONFIGURED FOR STAINLESS STEEL AND OTHER SPECIALTY ALLOY APPLICATIONS. REPLACE THE CARBON STEEL ROLLER CHAIN WITH STAINLESS STEEL CHAIN. (ALL OTHER COMPONENTS OF CHAIN CLAMPS ARE MADE OF STAINLESS STEEL)**

Cross-tee horizontal  
(Single Jackscrew Jackbar)



Cross-tee vertical  
(Single Jackscrew Jackbar)



Tee in-line  
(Single Jackscrew Jackbar)



Pipe to pipe horizontal  
(Single Jackscrew Jackbar)





**DOUBLE JACKSCREW CHAIN CLAMP**

Mathey Dearman's Double Jackscrew Chain Clamp reforms Schedule 40 pipe on either side of the joint to be welded. It is also able to exert pressure on the high points of both sides to eliminate "Hi-Lo." The Chain Clamp's Level and Support Device allows the pipe, elbow, tee, flange and other fittings to be held securely in place during alignment and welding. Pipe with wall thicknesses up to Schedule 80 can be aligned with the Double Jackscrew Chain Clamp. Mathey Dearman Double Jackscrew Chain Clamps are available in carbon steel chain and stainless steel chain versions to fit pipe from 1" to 54" (25 mm to 1372 mm) in diameter. Although all Mathey Dearman Chain Clamps feature stainless steel Jackscrews, Jackbars and Main Blocks, stainless steel chain should be used on stainless steel or specialty alloy applications to avoid potential contamination.

**EXTRA WELDING CLEARANCE** | Jackbar design provides additional clearance, so the weld can be easily completed with clamp in place

**PRECISE ALIGNMENT** | Double Jackbars, spaced around the diameter of the pipe allow reforming on both sides of joint to within 1/64" (.4mm)

**HEAVY DUTY** | Aligns pipe with wall thickness up to Schedule 80

**STRONG** | Reforms pipe with wall thickness to Schedule 40

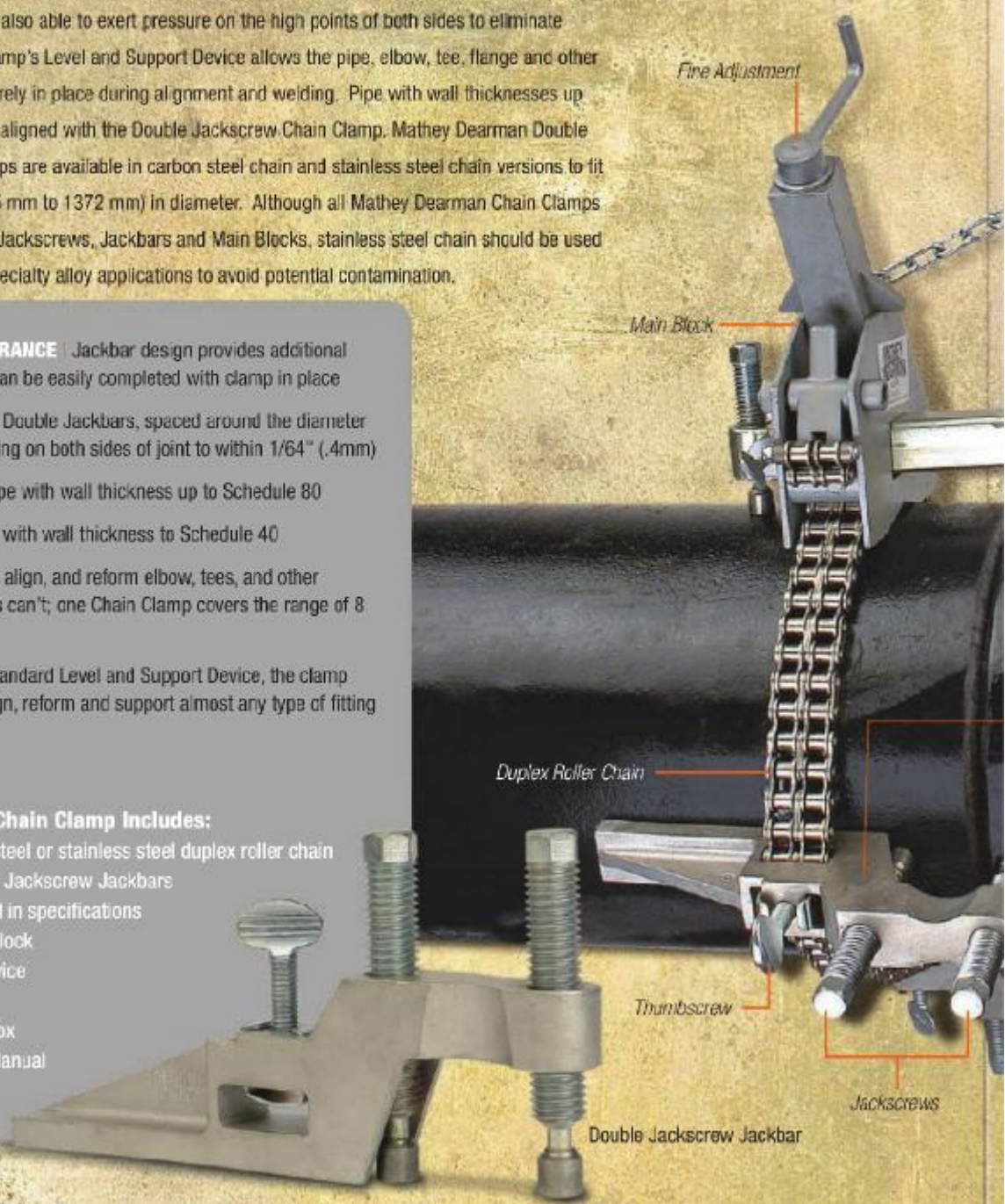
**WIDE RANGE** | Support, align, and reform elbow, tees, and other fittings that cage clamps can't; one Chain Clamp covers the range of 8 cage clamps

**VERSATILE** | With the standard Level and Support Device, the clamp can be configured to align, reform and support almost any type of fitting for welding

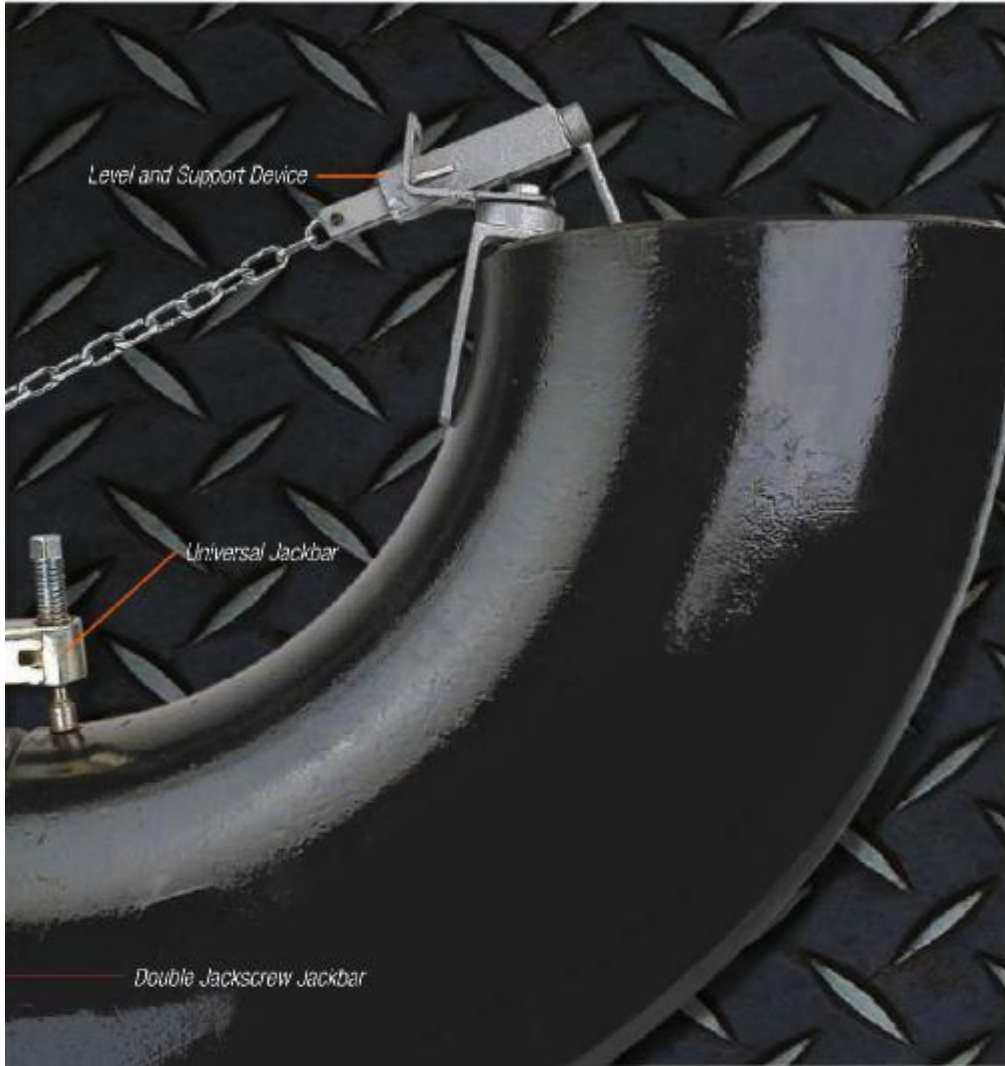
**Double Jackscrew Chain Clamp Includes:**

- | Nickel plated carbon steel or stainless steel duplex roller chain
- | Stainless steel Double Jackscrew Jackbars - quantity as indicated in specifications
- | Stainless steel Main Block
- | Level and Support Device
- | Jackscrew Wrench
- | Heavy-duty Storage Box
- | Parts and Operating Manual

**WARNING:** THE DOUBLE JACKSCREW CHAIN CLAMP IS TO BE USED AS THE SOLE SUPPORT FOR THE PIPE OR TO LIFT THE PIPE. DO NOT EXCEED PIPE SIZE RANGE LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP BY MATHEY DEARMAN WILL VOID THE CLAMP WARRANTY.







### DOUBLE JACKSCREW CHAIN CLAMP | Specifications

Model	Number of Jackbars	Nominal Pipe Size Range in (mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Est. Shipping Weight
D250	3	1-8 (25-203)	40	80	27 lbs / 12 kg
D250SS	3	1-8 (25-203)	40	80	27 lbs / 12 kg
D249	7	4-16 (102-406)	40	80	72 lbs / 33 kg
D249SS	7	4-16 (102-406)	40	80	72 lbs / 33 kg
D235	8	10-36 (254-914)	40	80	144 lbs / 67 kg
D235SS	8	10-36 (254-914)	40	80	144 lbs / 67 kg
D236	13	10-54 (254-1372)	40	80	180 lbs / 72 kg
D236SS	13	10-54 (254-1372)	40	80	180 lbs / 72 kg

\* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3,164 kg per square centimeter)  
 SS - Indicates clamp includes stainless steel chain. All clamps are equipped with stainless steel Jackbars, Jackscrews, and Main Blocks.



### DEARMAN LIGHT CHAIN CLAMP

Our versatile and easy-to-handle Dearman Light clamps are ideal for lighter-wall pipe alignment and reforming, yet sturdy enough to align up to Schedule 40 pipe. Lighter weight than the original Mathey Dearman Chain Clamps, Dearman Light Chain Clamps are quick and easy to set up while still providing the ability to get excellent fit-ups on pipe from 1" to 36" (25 mm to 914 mm) in diameter. Dearman Light Chain Clamps are available in carbon steel chain or stainless steel chain versions. Although all Mathey Dearman Chain Clamps feature stainless steel Jackscrews, Jackbars and Main Blocks, stainless steel chain should be used on stainless steel or specialty alloy applications to avoid potential contamination. Larger Dearman Light clamp models come standard with our Level and Support Device to hold and accurately position pipe and fittings.

**ACCURATE** | Aligns within 1/64 of an inch (.4 mm)

**LIGHTWEIGHT** | The 1" to 12" (25 mm to 305 mm) Dearman Light Chain Clamp weighs 50% less than an 8" (203 mm) hand-lever cage clamp

**WIDE RANGE** | Covers the same pipe range as 11 cage clamps

**VERSATILE** | Aligns pipe with wall thickness to Schedule 40, reforms pipe to Schedule 20

**SAFER** | Elbows, tees, flanges and other fittings are well-secured during alignment with the Level and Support Device

#### Dearman Light Chain Clamp Includes:

- | Nickel plated carbon steel or stainless steel duplex roller chain
- | Stainless steel Single or Double Jackscrew Jackbars - quantity as indicated in specifications
- | Stainless steel Main Block
- | Level and Support Device\*
- | Jackscrew Wrench
- | Parts and Operating Manual
- | Heavy-duty Storage Box\*

**\*NOTE:** D231-LT AND D231-LTSS CLAMPS DO NOT INCLUDE LEVEL AND SUPPORT DEVICE OR HEAVY-DUTY STORAGE BOX.

**WARNINGS:** DEARMAN LIGHT CHAIN CLAMPS SHOULD NEVER BE USED AS THE SOLE SUPPORT DEVICE FOR CRITICAL PIPEWORK. DO NOT EXCEED THE SPECIFIED LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP MAY VOID THE DEARMAN WARRANTY.

Fine Adjustment

Main Block

Duplex roller chain

Single Screw Jackbar

Thumbscrew





Level and Support Device



### DEARMAN LIGHT SINGLE JACKSCREW CHAIN CLAMP

Model	Number of Jackbars	Pipe Size Range in (mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Est. Shipping Weight
D231-LT**	5	1-12 (25-305)	20	40	13 lbs / 6 kg
D231-LTSS**	5	1-12 (25-305)	20	40	13 lbs / 6 kg
D232-LT	7	4-20 (102-506)	20	40	31 lbs / 14 kg
D232LTSS	7	4-20 (102-506)	20	40	31 lbs / 14 kg
D233-LT	10	6-36 (152-914)	20	40	84 lbs / 38 kg
D233LTSS	10	6-36 (152-914)	20	40	84 lbs / 38 kg

\*Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3,168 kg per square centimeter)

SS INDICATES CLAMP IS FOR STAINLESS STEEL APPLICATION \*\* DOES NOT INCLUDE LEVEL AND SUPPORT DEVICE OR STORAGE BOX.

### DEARMAN LIGHT DOUBLE JACKSCREW CHAIN CLAMP

Model	Number of Jackbars	Pipe Size Range in (mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Est. Shipping Weight
D249-LT	7	4-20 (102-506)	20	40	36 lbs / 17 kg
D249-LTSS	7	4-20 (102-506)	20	40	36 lbs / 17 kg
D235-LT	10	6-36 (152-914)	20	40	90 lbs / 41 kg
D235LTSS	10	6-36 (152-914)	20	40	90 lbs / 41 kg

\* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3,168 kg per square centimeter)

\*\* DOES NOT INCLUDE LEVEL AND SUPPORT DEVICE OR STORAGE BOX.

**NOTE:** COMPLETE WELDING OF THE JOINT CAN BE ACCOMPLISHED WITHOUT REMOVING THE CLAMP. AN ADDITIONAL JACKBAR CAN BE INSTALLED IF PRESSURE NEEDS TO BE APPLIED BETWEEN THE CLAMP JACKBARS. OPTIONAL SPACING SCREWS CAN BE ADDED FOR PRECISE WELD GAP ADJUSTMENT.

**UNIVERSAL CHAIN CLAMP**

Universal Chain Clamps reform pipe to Schedule 20 and align pipe to Schedule 40. Available in carbon steel chain and stainless steel chain versions to fit pipe from 1" to 36" (25 mm to 914 mm). The versatile design provides the ability to accurately fit-up, weld and grind joints without removing the clamp. The Level and Support Device of the Universal Chain Clamp allows pipe, elbow, tee, flange and other fittings to be safely secured during the alignment and welding process. Although all Mathey Dearman Chain Clamps feature stainless steel Jackscrews, Jackbars and Main Blocks, stainless steel chain should be used on stainless steel or specialty alloy applications to avoid potential contamination.

**VERSATILE** | Reforms pipe to Schedule 20 and aligns pipe to Schedule 40

**PRECISE** | Swivel-foot Jackscrews help ensure precise alignment by securely holding on uneven pipe surfaces

**SAFER** | Jackbars can be adjusted to relocate the contact point of Jackscrews for extra support of mating pipe or fittings

**WIDE RANGE** | A single Universal Chain Clamp covers the same range as 8 cage clamps

**Universal Chain Clamp Includes:**

- | Nickel plated carbon steel or stainless steel duplex roller chain
- | Universal stainless steel Jackbars  
- quantity as indicated in specifications
- | Stainless steel Main Block
- | Level and Support Device
- | Jackscrew Wrench
- | Heavy-duty Storage Box
- | Parts and Operating Manual



Universal Jackbar equipped with (2) Jackscrews

Fine Adjustment

Main Block

Universal Jackbar

Jackscrews

**WARNING:** UNIVERSAL CHAIN CLAMPS SHOULD NEVER BE USED AS THE SOLE SUPPORT FOR THE PIPE OR TO LIFT THE PIPE. DO NOT EXCEED PIPE SIZE RANGE LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP BY MATHEY DEARMAN WILL VOID THE CLAMP WARRANTY.





Level and Support Device

Universal Jackbar



**NOTE:** MATHEY DEARMAN CHAIN CLAMPS CAN BE RECONFIGURED FOR STAINLESS STEEL AND OTHER SPECIALTY ALLOY APPLICATIONS. REPLACE THE CARBON STEEL ROLLER CHAIN WITH STAINLESS STEEL CHAIN. (ALL OTHER COMPONENTS OF CHAIN CLAMPS ARE MADE OF STAINLESS STEEL.)

### UNIVERSAL CHAIN CLAMP | Specifications

Model	Number of Jackbars	Pipe Size Range in (mm)	Reforms Pipe to Schedule*	Aligns Pipe to Schedule	Est. Shipping Weight
D2250	3	1-8 (25-203)	20	40	25 lbs / 11 kg
D2250SS	3	1-8 (25-203)	20	40	25 lbs / 11 kg
D2249	7	4-16 (102-406)	20	40	70 lbs / 32 kg
D2249SS	7	4-16 (102-406)	20	40	70 lbs / 32 kg
D2235	8	10-36 (254-914)	20	40	145 lbs / 65 kg
D2235SS	8	10-36 (254-914)	20	40	145 lbs / 65 kg

\* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3,164 kg per square centimeter).  
SS - Indicates clamp is for stainless steel application.

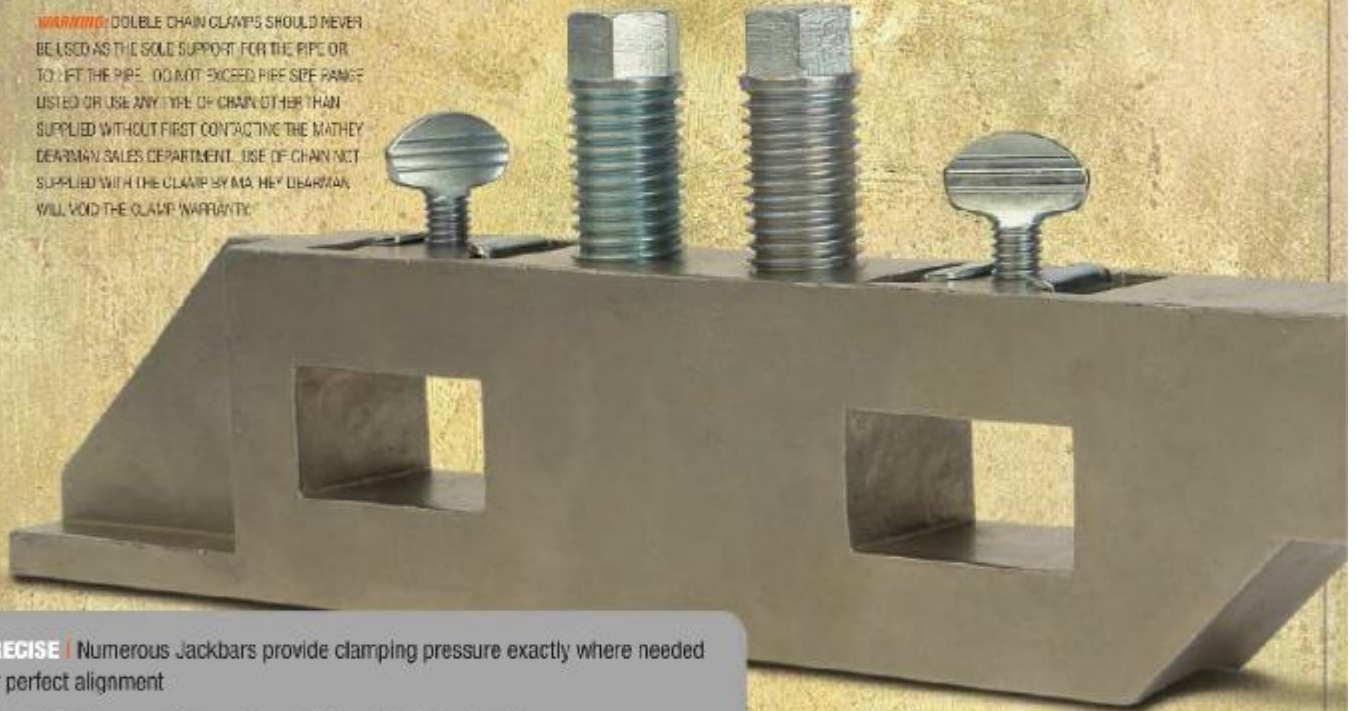
COMPLETE YIELDING OF THE JOINT CAN BE ACCOMPLISHED WITH REMOVING THE CLAMP. ADD-ON JACKBAR CAN BE ADDED IF PRESSURE NEEDS TO BE APPLIED BETWEEN THE CLAMP JACKBARS. JACKSCREW PADS PIVOT INDEPENDENTLY TO HANDLE UNEVEN SURFACES. OPTIONAL SPACING SCREWS CAN BE ADDED FOR PRECISE WELD GAP ADJUSTMENT.



### DOUBLE CHAIN CLAMP | D251 SERIES

The Mathey Dearman Double Chain Clamp is a heavy-duty vessel clamp designed for alignment and reforming of pipes and vessels up to 20' (6 m) in diameter with Schedule 80 wall thickness. Our Double Chain Clamps also align Schedule 80 pipe and heavier when no reforming is required. The extra heavy-duty Jackbars and Main Block provide the brute strength necessary to accomplish even the toughest reforming jobs. Models 10" to 36" through 10" to 54" come with a Level and Support Device. All other models come with a cable hoist. The Double Chain Clamp is available in steel and stainless steel versions and is shipped in a wooden crate.

**WARNING:** DOUBLE CHAIN CLAMPS SHOULD NEVER BE USED AS THE SOLE SUPPORT FOR THE PIPE OR TO LIFT THE PIPE. DO NOT EXCEED PIPE SIZE RANGE LISTED OR USE ANY TYPE OF CHAIN OTHER THAN SUPPLIED WITHOUT FIRST CONTACTING THE MATHEY DEARMAN SALES DEPARTMENT. USE OF CHAIN NOT SUPPLIED WITH THE CLAMP BY MATHEY DEARMAN WILL VOID THE CLAMP WARRANTY.



Double Chain Jackbar

**PRECISE** | Numerous Jackbars provide clamping pressure exactly where needed for perfect alignment

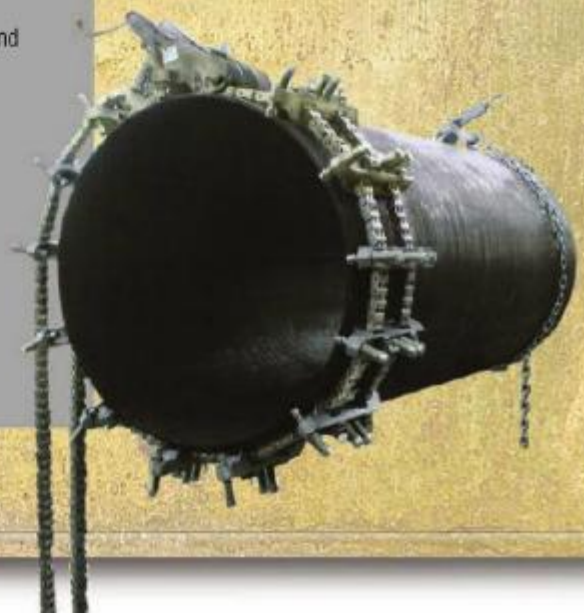
**TOUGH** | Reforms and aligns pipe with Schedule 80 wall thickness

**ADAPTABLE** | Fits extremely large range of pipe diameters

**CONFORMING** | Jackbar pads pivot independently to handle uneven pipe and fitting surfaces

**Double Chain Clamp Includes:**

- | (2) Nickel plated or stainless steel high-strength leaf chains
- | Extra heavy-duty stainless steel Jackbars-quantity as listed in specifications
- | Double chain Main block with (2) Fine Adjustments
- | Level and Support Device (D251-1060 model and larger supplied with cable hoist)
- | Jackscrew Wrench
- | Parts and Operating Manual







Joints on large pipe or tube shells up to 20' (6096 mm) in diameter can be aligned, reformed and welded without removing the clamp, saving time and improving weld quality.

## DOUBLE CHAIN CLAMP | Specifications

Number	Number of Main Blocks	Number of Jackbars	Pipe Size Range in (mm)	Est. Shipping Weight
D251-1036	1	9	10-36 (254-914)	220 lbs / 100 kg
D251-1036SS	1	9	10-48 (254-914)	220 lbs / 100 kg
D251-1048	1	12	10-48 (254-1219)	278 lbs / 126 kg
D251-1048SS	1	12	10-48 (254-1219)	278 lbs / 126 kg
D251-1054	1	14	10-54 (254-1372)	300 lbs / 136 kg
D251-1054SS	1	14	10-54 (254-1372)	300 lbs / 136 kg
D251-1060	1	16	10-60 (254-1524)	328 lbs / 149 kg
D251-1060SS	1	16	10-60 (254-1524)	328 lbs / 149 kg
D251-1072	1	20	10-72 (254-1829)	387 lbs / 176 kg
D251-1072SS	1	20	10-72 (254-1829)	387 lbs / 176 kg
D251-1084	1	24	10-84 (254-2134)	442 lbs / 200 kg
D251-1084SS	1	24	10-84 (254-2134)	442 lbs / 200 kg
D251-1096	2	28	10-96 (254-2438)	498 lbs / 226 kg
D251-1096SS	2	28	10-96 (254-2438)	498 lbs / 226 kg
D251-10108	2	32	10-108 (254-2743)	554 lbs / 251 kg
D251-10108SS	2	32	10-108 (254-2743)	554 lbs / 251 kg
D251-10120	2	36	10-120 (254-3048)	610 lbs / 277 kg
D251-10120SS	2	36	10-120 (254-3048)	610 lbs / 277 kg
D251-1011F	2	39	10-132 (254-3353)	660 lbs / 299 kg
D251-1011FSS	2	39	10-132 (254-3353)	660 lbs / 299 kg
D251-1012F	2	42	10-144 (254-3656)	710 lbs / 322 kg
D251-1012FSS	2	42	10-144 (254-3656)	710 lbs / 322 kg
D251-1014F	2	48	10-168 (254-4267)	810 lbs / 367 kg
D251-1014FSS	2	48	10-168 (254-4267)	810 lbs / 367 kg
D251-1016F	3	54	10-192 (254-4877)	910 lbs / 410 kg
D251-1016FSS	3	54	10-192 (254-4877)	910 lbs / 410 kg
D251-1018F	3	60	10-216 (254-5486)	1010 lbs / 455 kg
D251-1018FSS	3	60	10-216 (254-5486)	1010 lbs / 455 kg
D251-1020F	3	66	10-240 (254-6096)	1110 lbs / 500 kg
D251-1020FSS	3	66	10-240 (254-6096)	1110 lbs / 500 kg

\* Calculations are based on pipe with a tensile strength of 45,000 lbs per square inch (3,164 kg per square centimeter).  
SS - indicates clamp is for stainless steel application.

**NOTE:** ALL DOUBLE CHAIN CLAMPS WITH 16 OR MORE JACKBARS INCLUDE CABLE HOIST. SMALLER CLAMPS INCLUDE LEVEL AND SUPPORT DEVICE.



**HYDRAULIC CLOSURE MECHANISM**

Perfect for clamping larger diameters and applying extra clamp load, Mathey Dearman's Hydraulic Chain Clamp Closure Mechanism uses a 5" (127 mm) stroke to apply up to 10,000 pounds (4535kg) of tension to the standard Double Chain Clamp. Hydraulic pressure is supplied to the closure mechanism's hydraulic cylinder by a hand pump with reservoir. Tension can be applied to close the clamp on the pipe. Using the Hydraulic Closure Mechanism, our Double Chain Clamp is able to align pipe up Schedule 120 and reform pipe to Schedule 80.



**D251 SERIES HYDRAULIC CLOSURE MECHANISM**

Model	Description	Est. Shipping Weight
DD-580	Hydraulic closure mechanism for D251 Double Chain Clamp	43 lbs / 20 kg
D104-KIT	Hydraulic kit Includes manual hydraulic pump, reservoir and hoses needed for operation	12 lbs / 5 kg

The Hydraulic Closure Mechanism can be added to a previously purchased Double Chain Clamp.



**MANUAL HYDRAULIC PUMP KIT**

ITEM NO. D104-KIT



**DD-580 HYDRAULIC CLOSURE MECHANISM**

**CHAIN CLAMP ACCESSORIES & REPLACEMENT PARTS**

**JACKBARS** | All Single and Double Jackbars are investment cast stainless steel.



Item Number	Original Chain Clamp	Original Chain Clamp Range	Dearman Light Chain Clamp	Dearman Light Chain Clamp Range	Est. Shipping Weight
Mini-Fit Jackbar		in (mm)		in (mm)	
DXL-523	D230, D230-A	1-8 (25-203) (Carbon Steel)	D231-LT	1-12 (25-305) (Carbon Steel)	1 lbs / .5 kg
DXL-523S	D230SS, D230-ASS	1-8 (25-203) (Carbon or Stainless Steel)	D231-LTSS	1-12 (25-305) (Carbon or Stainless Steel)	1 lbs / .5 kg



Single Screw Jackbar		in (mm)		in (mm)	
DA-500S	D231, D231SS	1-8 (25-203) (Carbon or Stainless Steel)	D231-LT, D231-LTSS	4-20 (102-508) (Carbon or Stainless Steel)	3 lbs / 1.4 kg
DB-500S	D232, D232SS	4-16 (102-406) (Carbon or Stainless Steel)	D232-LT, D232-LTSS D233-LT, D233-LTSS	6-36 (152-914) (Carbon or Stainless Steel)	4 lbs / 1.8 kg
DC-500S	D233, D233SS, D234, D234SS	10-36 (254-914) 10-54 (254-1372) (Carbon or Stainless Steel)			5 lbs / 2.3 kg





Item Number	Original Chain Clamp	Original Chain Clamp Range	Dearman Light Chain Clamp	Dearman Light Chain Clamp Range	Est. Shipping Weight
<b>Double Screw Jackbar</b>		<b>in (mm)</b>		<b>in (mm)</b>	
DA-600S	D250, D250SS	1-8 (25-203) Carbon or Stainless Steel	D249-LT, D249-LTSS	4-20 (102-508) (Carbon or Stainless Steel)	3 lbs / 1.4 kg
DB-600S	D249, D249SS	4-16 (102-406) Carbon or Stainless Steel	D235-LT, D235-LTSS	6-36 (152-914) (Carbon or Stainless Steel)	4 lbs / 1.8 kg
DC-600S	D235, D235SS D236, D236SS	10-36 (254-914) 10-54 (254-1372) Carbon or Stainless Steel			5 lbs / 2.3 kg



<b>Universal Jackbar</b>		<b>in (mm)</b>			
DA-800	D2250	1-8 (25-203) Carbon Steel			1 lbs / .5 kg
DB-800	D2249	4-16 (102-406) Carbon Steel			3 lbs / 1.4 kg
DC-800	D2235	10-36 (254-914) Carbon Steel			4 lbs / 1.8 kg



<b>Double Chain Jackbar</b>		<b>in (mm)</b>			
DD-500S	D251 Series	10"-20" (254-9144)			8 lbs / 3.6 kg



<b>Add-on Jackbar</b>		<b>in (mm)</b>			
DA-900	D231, D231SS D250, D250SS	1-8 (25-204) Carbon or Stainless Steel			3 lbs / 1 kg
DB-900	D232, D232SS D249, D249SS	4-16 (102-406) Carbon or Stainless Steel			3 lbs / 1 kg
DC-900	D233, D233SS D234, D234SS D235, D235SS D236, D236SS	10-54 (254-1372) Carbon or Stainless Steel			5 lbs / 2 kg



<b>Jackscrews</b>		<b>in (mm)</b>		<b>in (mm)</b>		
DA-501	DA-500S, DB-500S	1-8 (25-204)	5/8" - 11 NC X 3 1/4"			.2 lbs / .1 kg
DA-701	DA-600S, DA-800, DA-900 DB-600S, DB-800, DB-900	4-16 (102-406)	5/8" - 11 NC x 4"			.25 lbs / .11 kg
DC-501	DC-500S, DC-600S, DC-800, DC-900, DD-500	10 - 54 (254-1372)	7/8" - 9 NC x 4 1/2"			.6 lbs / .2 kg
DXL-525	DXL-523		1/2" - 13	1-12 (25-305) Carbon Steel		.2 lbs / .1 kg
DXL-525S	DXL-523S		1/2" - 13	1-12 (25-305) Stainless Steel		.2 lbs / .1 kg



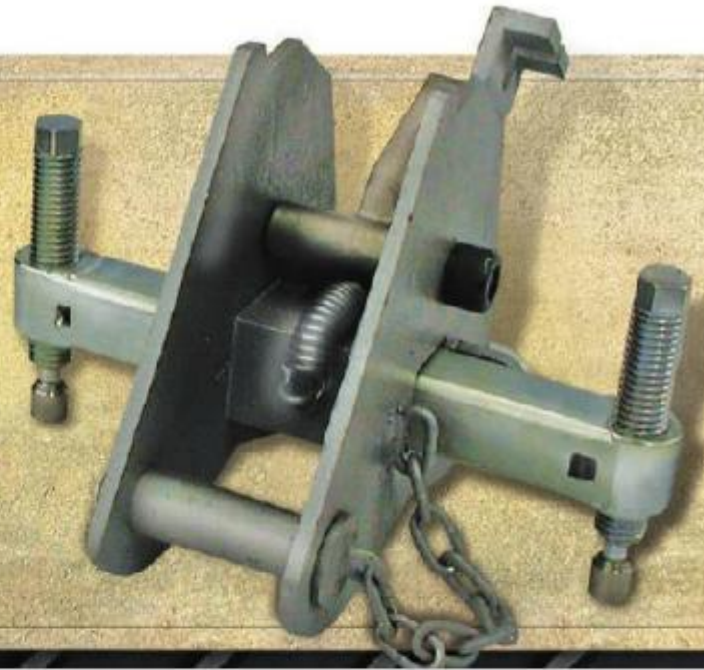


## CHAIN CLAMP REPLACEMENT PARTS AND ACCESSORIES

### MAIN BLOCK | FINE ADJUSTMENT | LEVEL AND SUPPORT DEVICE

#### MAIN BLOCK

The frame of the Main Block that contacts the pipe is made of stainless steel. The chain dog, located in the Main Block, contacts the chain rollers and positively engages the chain.



#### MAIN BLOCK

Item Number	Single, Double, Universal or D251 Series Chain Clamp	Pipe Size Range in (mm)	Est. Shipping Weight
<b>Main Block</b>			
DXL-524	D230	1-8 (25 -203)	3 lbs / 1.4 kg
DXL-524S	D230SS	4-16 (102-406)	3 lbs / 1.4 kg
DXL-524LT	D231-LT	10-36 (254-91)	7 lbs / 3 kg
DXL-524LTSS	D231-LTSS	4-16 (102-406)	7 lbs / 3 kg
DA-100	D231, D231SS, D250, D250SS, D2250, D2250SS	1-8 (25 -203)	3 lbs / 1.4 kg
DA-100LT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4-20 (102-508)	3 lbs / 1.4 kg
DB-100	D249, D249SS, D2249, D2249SS, D232, D232SS	4-16 (102-406)	13 lbs / 6 kg
DB-100LT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	4-16 (102-406)	25 lbs / 11 kg
DC-100	D236SS, D2235, D2235SS	4-16 / (102-406)	25 lbs / 11 kg
DD-100	D251 SERIES (carbon steel)		
DD-100S	D251 SERIES (stainless steel)		

#### FINE ADJUSTMENT

Item Number	Single, Double, and Universal Chain Clamp	Pipe Size Range in (mm)	Est. Shipping Weight
<b>Fine Adjustment</b>			
DA-200	D231, D231SS, D250, D250SS, D2250, D2250SS	1 - 8 (25-203)	.1 lbs / .045 kg
DA-200LT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 20 (102-508)	.1 lbs / .045 kg
DB-200	D232, D232SS, D249, D249SS, D2249, D2249SS	4 - 16 (102-406)	3 lbs / 1.4 kg
DB-200LT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6 - 36 (152-914)	3 lbs / 1.4 kg
DC-200	D233, D233SS, D234, D234SS, D235, D235SS, D236, D236SS, D2235, D2235SS, D251 Series	10 - 36 (254- 914)	4 lbs / 1.8 kg
DXL-200	D230, D230SS	10 - 240 (254- 6096)	1.6 lbs / 0.7 kg
DXL-200LT	D231-LT, D231-LTSS	10 - 240 (254- 6096)	1.6 lbs / 0.7 kg

The Fine Adjustment engages in the Main Block and is used to tension the clamp on the pipe.







**ELBOW WRENCH** The Elbow Wrench is furnished with clamps for Jackscrew adjustment and attachment of the Level and Support Device.



**LEVEL AND SUPPORT DEVICE**

Our Level and Support Device allows accurate positioning of all types of fittings while freeing the user's hands.

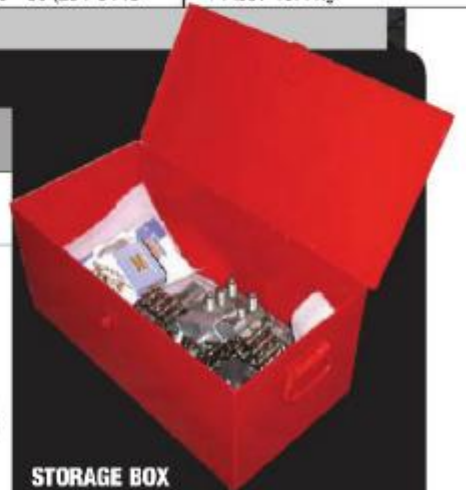
**D900-01**  
 D2249, D2249SS, D2250, D2250SS, D231, D231SS, D232, D232SS, D232-LT, D232-LTSS, D233-LT, D233-LTSS, D249, D249-LT, D249-LTSS, D250, D250SS  
**D900-002**  
 D233, D233SS, D234, D234SS, D235, D235SS, D236, D236SS, D251 Series, D711-0406, D711-0406M, D711-0608, D711-0608M, D711-0810, D711-0810M, D711-1012, D711-1012M



Item Number	Single, Double and Universal Chain Clamp	Pipe Size Range in (mm)	Est. Shipping Weight
<b>Level and Support Device</b>			
DA-400S	D231, D231SS, D250, D250SS, D2250, D2250SS	1 - 8 (25-203)	2 lbs / 1 kg
DA-400SLT	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 20 (102-508)	2 lbs / 1 kg
DB-400S	D232, D232SS, D249, D249SS, D2249, D2249SS	4 - 16 (102-406)	5 lbs / 2.3 kg
DB-400SLT	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6 - 36 (152-914)	5 lbs / 2.3 kg
DC-400	D233, D234, D235, D236, D2235, D251 Series (carbon steel)	10 - 36 (254-914)	14 lbs / 16.4 kg
DC-400S	D233SS, D234SS, D235SS, D236SS, D2235SS, D251 Series (Stainless Steel)	10 - 36 (254-914)	14 lbs / 16.4 kg

**CHAIN CLAMP STORAGE BOXES**

Item Number	Boxes For Models	Clamp Size in (mm)	Dimensions in (mm)
D861	D231, D231S	1-8 (25-203) Single Jackscrew	16 x 7 x 7.5 (406 x 178 x 191)
	D232-LT, D232-LTSS	4-20 (102-508) Light Single Jackscrew	
D862	D232, D232SS, D249, D249SS,	4 - 16 (102-406) Single and Double Jackscrew	29 x 10 x 13 3/4 (737 x 2543 x 349)
	D232-LT, D232-LTSS, D249-LT, D249-LTSS	4 - 16 (102-406) and 10-36 (254-914) Universal Jackscrew	
	D2235, D2235SS, D2249, D2249SS	10-36 (254-914) and Single and Double Jackscrew	
	D233, D233S, D235, D235SS	10-54 (254-1372) Single and Double Jackscrew	
D863	D233-LT, D233-LTSS, D235-LT, D235-LTSS	6-36 / (152-914) Light Single and Double Jackscrew	20 x 8 1/2 x 8 3/4 (508 x 216 x 222)
	D250, D250S,	1-8 / (25-203) Double	
	D2250, D2250SS	1-8 / (25-203) Universal Jackscrew	
	D249-LT, D249-LTSS	4-16 / (104-406) Light Double	



**STORAGE BOX**

Durable Chain Clamp Steel Storage Boxes are available in three (3) sizes. Storage Boxes come standard with lifting handle(s), and lockable hasp with a powder coated finish.



**SPACING SCREWS**

Spacing Screws are used to obtain a precise weld gap between pipes or fittings. Spacing Screw assemblies are available for steel and stainless steel applications. When ordering Spacing Screws, one Spacing Screw should be ordered for each Jackbar and one should be ordered for the Main Block.

Item Number	Jackbar Spacing Screws	Chain Clamp Application
DA-570	Carbon Steel	D231, D249-LT, D232-LT, D250
DA-570S	Stainless Steel	D231SS, D249-LTSS, D232-LTSS, D250SS
DB-570	Carbon Steel	D232, D233-LT, D235-LT, D249
DB-570S	Stainless Steel	D232SS, D233-LTSS, D235-LT D249SS
DC-570	Carbon Steel	D233, D234, D235, D236
DC-570S	Stainless Steel	D233SS, D234SS, D235SS, D236SS

Spacing Screws, when mounted to the Jackbar and Main Block, provides a precise and simple way to hold a weld gap between pipes or pipe and fitting.



Jackbar Spacing Screw assembly

Main Block (Universal Jackbar) Spacing Screw assembly

Item Number	Type	Main Block and
DA-870	Carbon Steel	D231, D249-LT, D232-LT, D250
DA-870S	Stainless Steel	D231SS, D249-LTSS, D232-LTSS, D250SS
DB-870	Carbon Steel	D232, D233-LT, D235-LT, D249
DB-870S	Stainless Steel	D232SS, D233-LTSS, D235-LT D249SS
DC-870	Carbon Steel	D233, D234, D235, D236
DC-870S	Stainless Steel	D233SS, D234SS, D235SS, D236SS





## CHAIN CLAMP CHAIN

Three (3) different sizes of roller chain are used in the Mathey Dearman Single and Double Jackscrew, Universal and Dearman Light Chain Clamps to insure the maximum amount of safety is provided for the welder. The roller chain is available in stainless steel and nickel plated carbon steel.



## CHAIN AND CONNECTING LINKS

Item Number	Original Chain Clamp	Standard Chain Clamp Range in (mm)	Dearman Light Chain Clamp	Dearman Light Chain Clamp Range
<b>Chain</b>				
DA-300	D230, D230-A, D231, D250, D2250	1-8 (25-203) (Carbon Steel)	D-231LT, D249LT	4-20 / 102-508 (Carbon Steel)
DA-300S	D250SS, D2250SS, D230SS, D230-A, D231SS	1-8 (25-203) (Stainless Steel)	D231-LTSS, D249-LTSS	4-20 / 102-508 (Stainless Steel)
DB-300	D232, D249, D2249	4-16 (102-406) (Carbon Steel)	D232-LT, D235-LT	6-36 / 152-914 (Carbon Steel)
DB-300S	D2249SS, D232SS, D249SS	4-16 (102-406) (Stainless Steel)	D232-LTSS, D235-LTSS	6-36 / 152-914 (Stainless Steel)
DC-300	D233, D234, D235, D236, D2235, D251-Series (Carbon Steel)	10-36 (254-914) 10-54 (254-1372) (Carbon Steel)		
DC-300S	D233SS, D234SS, D235SS, D236SS, D2235SS, D251-Series (Stainless Steel)	10-36 / 254-914 10-54 / 254-1372 (Stainless Steel)		

**NOTE:** A CONNECTING LINK IS REQUIRED TO JOIN CHAIN ENDS TOGETHER. ONE ADDITIONAL JACKBAR SHOULD BE ADDED FOR EACH ADDITIONAL FOOT OF CHAIN.



## Connecting Link

Chain	Original Chain Clamp	Range in (mm)	Dearman Light	Range in (mm)
DA-301	D230, D230-A, D231, D250, D2250	1-8 (25-203) (Carbon Steel)	D-231LT, D232-LT, D232LTSS, D249-LT	4-20 (102-508) (Carbon Steel)
DA-301S	D250SS, D2250SS, D230SS, D230-A, D231SS	1-8 (25-203) (Stainless Steel)	D231-LTSS, D249-LTSS	4-20 (102-508) (Stainless Steel)
DB-301	D232, D249, D2249	4-16 (102-406) (Carbon Steel)	D232-LT, D233-LT, D235-LT	6-36 (152-914) (Carbon Steel)
DB-301S	D2249SS, D232SS, D249SS	4-16 (102-406) (Stainless Steel)	D235-LTSS	6-36 (152-914) (Stainless Steel)
DC-301	D233, D234, D235, D236, D2235, D251-Series (Carbon Steel)	10-36 (254-914) 10-54 (254-1372) (Carbon Steel)		
DC-301SS	D233SS, D234SS, D235SS, D236SS, D2235SS, D251-Series (Stainless Steel)	10-36 (254-914) 10-54 (254-1372) (Stainless Steel)		

**WARNINGS:** THE REFORMING CAPABILITY OF THE CHAIN CLAMP CAN BE SEVERELY AFFECTED IF THE LENGTH OF THE CHAIN IS EXTENDED BEYOND THE PUBLISHED WORKING RANGE. MATHEY DEARMAN WILL NOT WARRANTY ANY CLAMP THAT IS APPLIED BEYOND THE NORMAL OPERATING RANGE OF THE CLAMP. TO MAINTAIN WARRANTY USE ONLY CHAIN PURCHASED FROM MATHEY DEARMAN. CHAIN CAN NOT BE USED WITH THE MATHEY DEARMAN CHAIN CLAMP. USE OF CHAIN NOT SUPPLIED BY MATHEY DEARMAN WILL VOID THE WARRANTY OF THE CLAMP.

## HOW TO DETERMINE LENGTH OF CHAIN TO EXTEND THE RANGE OF A CHAIN CLAMP.

### Example:

**Step 1:** For a D249 [range: 4" - 16" (102 mm - 405 mm)] standard length of chain is:

60" / 1524 mm

**Step 2:** Multiply the diameter of the pipe that you wish to align by 3.1416 (i.e.: 20" (506 mm) pipe diameter x 3.1416) =

62.8" / 1595 mm

**Step 3:** Subtract the length of chain noted on the D249 clamp used in Step 2.

- 60" / 1524 mm

2.8" / .71 mm

**Step 4:** Round up to the next whole foot (305 mm) for additional chain required.

1' / 305 mm of

additional chain

**NOTE:** FORMULA FOR DETERMINING CHAIN LENGTH REQUIRED IS AVAILABLE AT [WWW.MATHEY.COM](http://WWW.MATHEY.COM)