



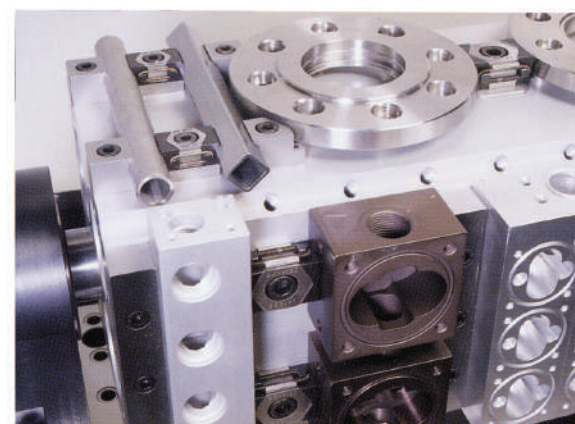
OK-VISE

OK-VISE BK2-VT-B DK2-VT-B ...

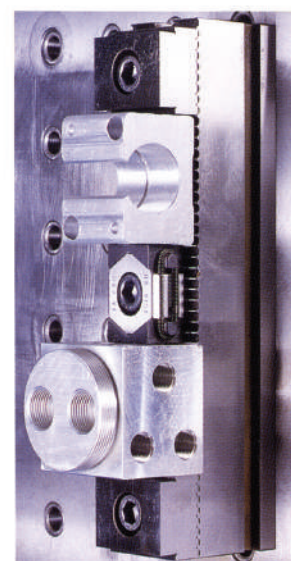


CLAMPING METHOD CLAMPING METHOD CLAMPING METHOD CLAMPING METHOD

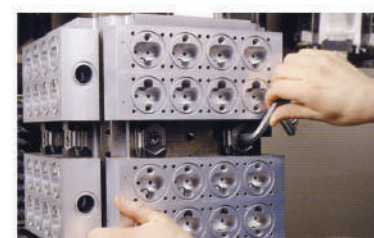
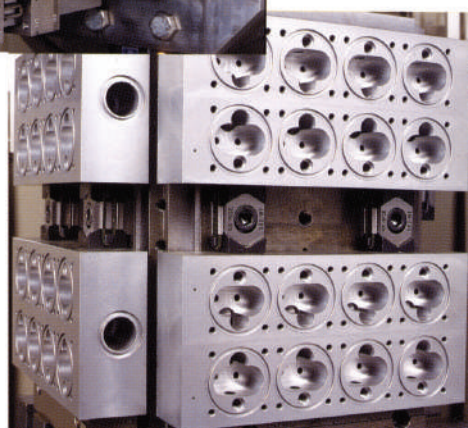
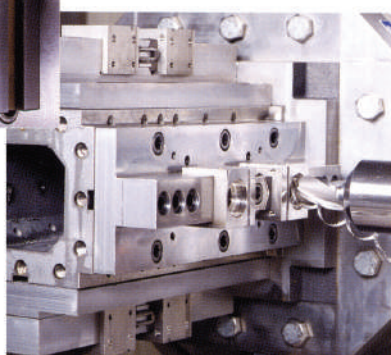
*Smart design
Ultimate efficiency*



Accurate machining needs a free operative clamping unit. OK-VISE is a good solution for reaching such target because it is locked firmly in every direction as it is tightened down and this cuts out all possibilities of measurement error due to sliding.



OK-VISE low-profile clamp is flexible to operate on different pallets.



OK-VISE low-profile clamp extends the capacity of each pallets to be utilized.

OK-VISE low-profile clamp cuts down the cost of changing other machining jig and fixtures, which means that the clamp is possible to achieve the highest level of this effectiveness.

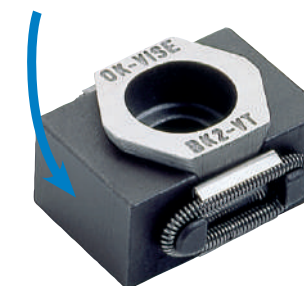
SERRATED JAWS

General-purpose clamp for your workshop. Serration creates high friction, which ensures reliable clamping in any circumstances.



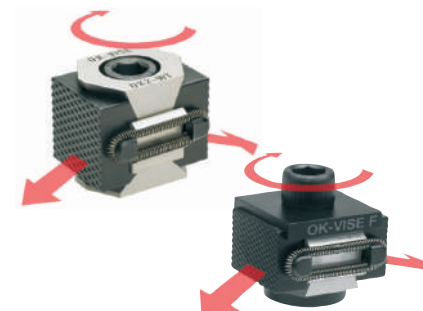
SMOOTH JAWS

When no marks on the workpieces are allowed, smooth jaws are used.



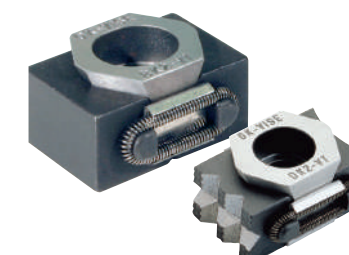
PULL-DOWN MODELS

In addition to holding the workpiece in place, pull-down clamps also generate pull-down action, pressing workpieces down onto the fixture base.



MACHINABLE JAWS

Single-wedge clamps are also available with extended jaws and can be machined to suit the geometry of the workpiece. The smallest model can be machined up to 3 mm and the larger ones up to 5 mm.



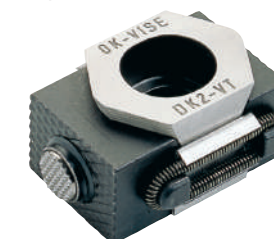
ADDITIONAL PIECE MODELS

Additional piece models have machined female threadings (M5) for socket head screws on the side of the jaw, making it quick and easy to use various additional pieces which can also be machined into different shapes.



SELF-ADJUSTABLE MODELS

These clamps have a self-adjustable ball pressure screw inserted into a clamp jaw. The ball bearing at the end is made of steel and equipped with torsion protection, allowing the ball to self-adjust up to 9 degrees. This makes clamping irregularshaped parts and castings more flexible.



STAINLESS STEEL MODEL

The stainless steel model is designed to meet the demands of wire EDM applications. This model only contains parts made of high quality stainless steel. Available only with smooth-ended jaws.



ECONOMY MODELS

These models meet the demands of workholding when ultra precision and high clamping force are not necessary. They are made of the same raw material as our other models. Only the bottom of the jaw is ground. Our smallest series is only available as the economy model (AK2-VT-SO).



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OK-VISE

CLAMPING UNIT

THE COST EFFICIENT CHOICE !

Accuracy of the fixture comes normally from the precision of the fixed stoppers, guideframes and location pins (so called 0-points) not from the clamp itself which job is to generate the clamping force to hold the

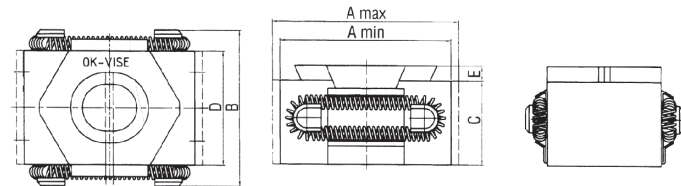
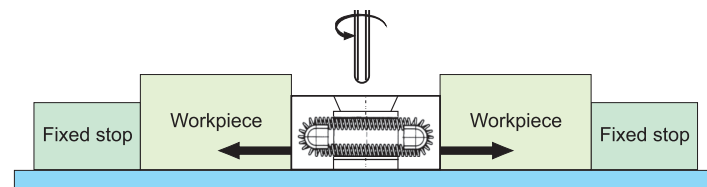
workpiece towards the 0-points.

We have designed three models on this page to meet the demands of

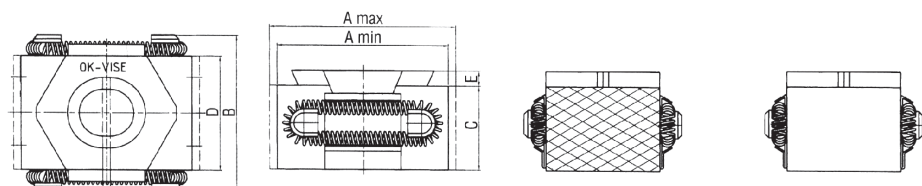
regular workholding when ultra precision is not a necessity.

Although not ground as precise as standard models these clamps are just as effective when it comes to clamping force. Same raw material is being used and bottom of the jaws are ground for precise locating on the fixture base.

AK2-VT-SO always comes with Viton o-rings but B-series clamps are also available with regular springs on request.



TYPE	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC
	min	optimum	max									
AK2-VT-SO	20	23	25	22	11	15	4.2	M5x025	10	10	0.022	48-52



BK2-VT-O

BK2-VT-SO

TYPE	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC
	min	optimum	max									
BK2-VT-O	27	29	31	29	15	21	2.5	M8x020	25	44	0.055	48-52

TYPE	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC
	min	optimum	max									
BK2-VT-SO	27	29	31	29	15	21	2.5	M8x020	25	44	0.055	48-52

AK2-VT-SO

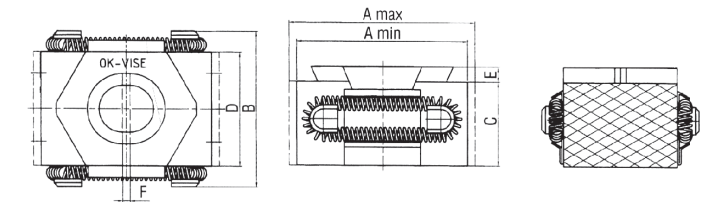
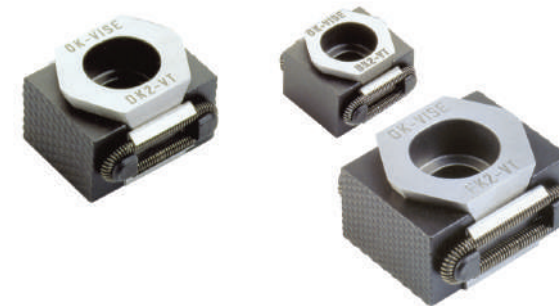
BK2-VT-O

BK2-VT-SO



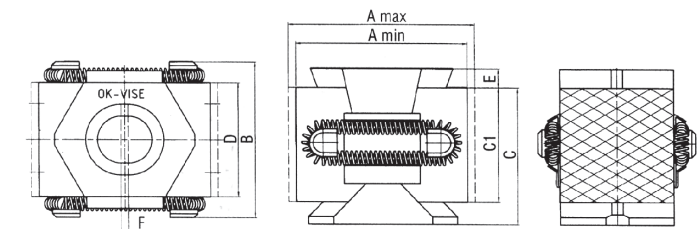
OK-VISE

CLAMPING UNIT



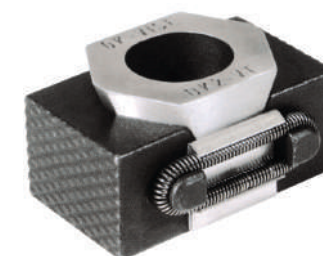
TYPE	A			B	C	D	E	F	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC
	min	optimum	max										
BK2-VT	27	29	31	29	15	21	2.5	1	M 8x020	25	44	0.055	48-52
DK2-VT	42	45	49	41	22	30	4.0	2	M12x030	65	145	0.180	48-52
FK2-VT	57	61	66	56	29	42	5.0	3	M16x040	110	360	0.465	48-52

Notice : Standard jaw is serrated (as drawing), if U need flat-jaw, please add "-s" after the model number. For example : BK2-VT-S



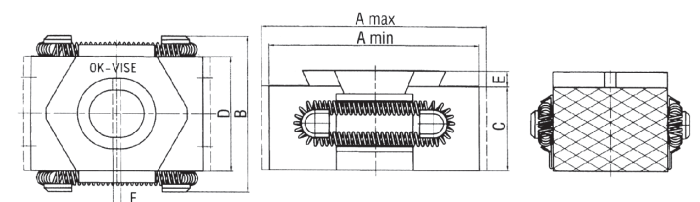
TYPE	A			B	C	C1	D	E	F	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC
	min	optimum	max											
DK2-WT	42	46	49	41	36	30	30	5	2	M12x040	90	145	0.275	48-52
FK2-WT	58	61	66	56	50	42	42	5	3	M16x060	150	360	0.730	48-52

Notice : Standard jaw is serrated (as drawing), if U need flat-jaw, please add "-s" after the model number. For example : BK2-WT-S



SPECIAL MODELS

Special models include machinable jaw models, additional piece models and models designed for castings. BK2-VT Stainless steel mode is specially designed for use on EDM machines.



TYPE	A			B	C	D	E	F	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC
	min	optimum	max										
BK2-VT+3	33	35	37	29	15	21	2.5	1	M 8x020	22	43	0.070	30-34
DK2-VT+5	52	55	59	41	22	30	4.0	2	M12x030	55	145	0.235	30-34
FK2-VT+5	67	70	75	56	29	42	5.0	3	M16x040	100	360	0.550	30-34

Notice : Except BK2-VT+3 only with flat-jaw, others have flat or serrated jaw.

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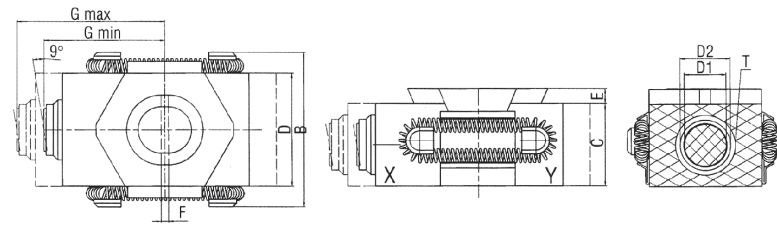
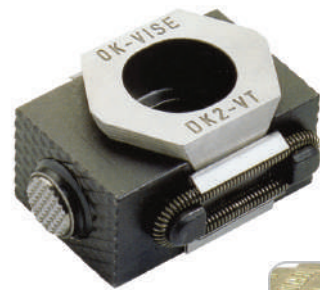
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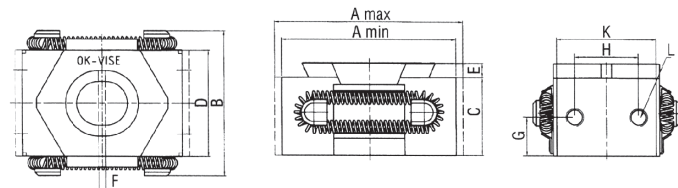
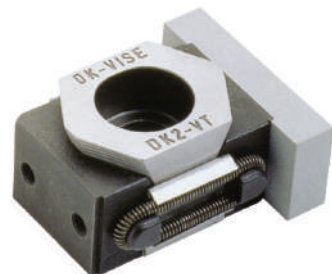
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OK-VISE CLAMPING UNIT



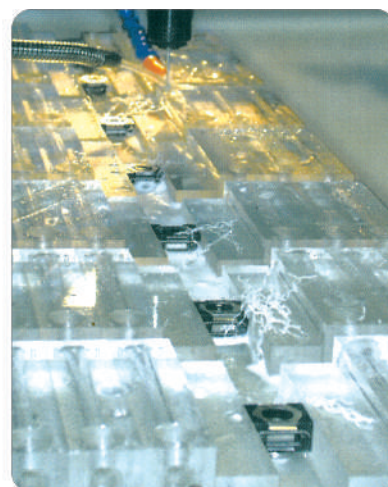
TYPE	Thread (T)	Diameter of ball (D2)	Diameter of serration (D1)	G min	G opt	G max
BK2-VT-B	M12	8.5	7.2	19.5	20.5	21.5
DK2-VT-B	M16	12.0	10.7	31.0	32.5	34.5

TYPE	A			B	C	D	E	F	G	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC X	Hardness of jaws HRC Y
	min	optimum	max												
BK2-VT-B	33	35	37	29	15	21	2.5	1	3	M 8x020	22	43	0.064	30-34	48-52
DK2-VT-B	52	55	59	41	22	30	4.0	2	5	M12x030	55	145	0.212	30-34	48-52



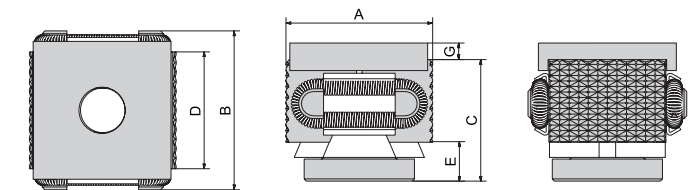
TYPE	A			B	C	D	E	F	G	H	K	L	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC
	min	optimum	max														
BK2-VT-T	33	35	37	29	15	21	2.5	1	7.5	12	-	4xM5	M 8x020	22	43	0.060	30-34
DK2-VT-T	46	49	53	41	22	30	4.0	2	11.0	18	28	4xM5	M12x030	55	145	0.200	30-34
FK2-VT-T	61	65	70	56	29	42	5.0	3	14.5	26	40	4xM5	M16x040	100	360	0.480	30-34

Notice : use the screw strength above 8.8

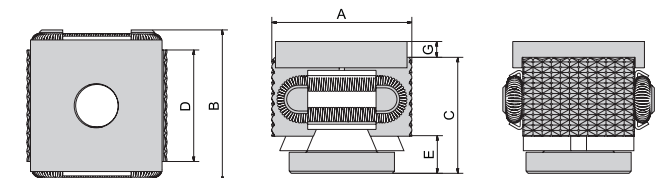


OK-VISE CLAMPING UNIT

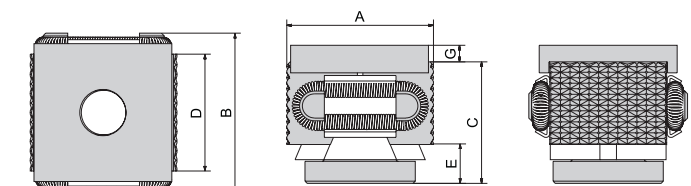
SMOOTH BASIC VERSION



TYPE	A			B	C	D	E	G	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC
	min	optimum	max										
BK2-VT-PD	27	29	31	29	22	21	7	3	M8x20	25	44	0.068	48-52



TYPE	A			B	C	D	E	G	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC
	min	optimum	max										
DK2-VT-PD	42	45	49	41	32	30	10	4	M12x60	65	145	0.270	48-52



TYPE	A			B	C	D	E	G	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in kg approx.	Hardness of jaws HRC
	min	optimum	max										
FK2-VT-PD	57	61	65	56	40.5	42	11.5	5	M16x60	110	360	0.620	48-52

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OK-VISE CLAMPING UNIT

OK-VISE LOW-PROFILE CLAMP TYPES

Size	A	B	D	D(inch)	F
Serrated basic version		BK2-VT	DK2-VT	DK2-VTI	FK2-VT
Smooth basic version		BK2-VT-S	DK2-VT-S	DK2-VTI-S	FK2-VT-S
Machinable jaws		BK2-VT+3	DK2-VT+5	DK2-VTI+5	FK2-VT+5
Machinable & smooth combo		BK2-VT+3S	DK2-VT+5S	DK2-VTI+5S	FK2-VT+5S
Additional piece model		BK2-VT-T	DK2-VT-T	DK2-VTI-T	FK2-VT-T
Additional piece model & smooth combo		BK2-VT-TS	DK2-VT-TS	DK2-VTI-TS	FK2-VT-TS
Self-adjustable model		BK2-VT-B	DK2-VT-B	DK2-VTI-B	
Two self-adjustable jaws		BK2-VT-E	DK2-VT-E	DK2-VTI-E	
Single-wedge pull-down, serrated		BK2-VT-PD	DK2-VT-PD	DK2-VTI-PD	FK2-VT-PD
Double-wedge pull-down, serrated			DK2-WT	DK2-WTI	FK2-WT
Double-wedge pull-down, smooth			DK2-WT-S	DK2-WTI-S	FK2-WT-S
Stainless steel model		BK2-VT-SS			
Economy-series, serrated		BK2-VT-O			
Economy-series, smooth	AK2-VT-SO	BK2-VT-SO			
Metric bolt	M5	M8	M12		M16
Imperial bolt	3/16"	5/16"		1/2"	5/8"
Force up to (kN)	10	25	90	90	150

OK-VISE CLAMPFORCES

Horizontal forces of OK-Vise low profile clampa

