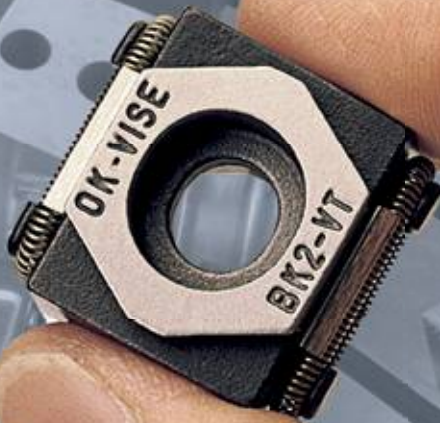


OK-VISE®

The Only Original Wedge-clamp

Small in size – Giant in performance



10 YEAR
WARRANTY

OK-VISE®

Clamping Method

COMPANY PROFILE

Founded in 1984, OK-VISE Oy is located in the beautiful lake district of Central Finland, in the Muurame Business Park, a center of the mechatronics industry in the northern European Union.

The OK-VISE low-profile clamp was originally designed to solve a specific workholding need in the flowmeter production process of our parent company. This clamping method attracted the interest of other companies due to the obvious benefits it offers, such as the possibility of three-directional machining, extreme clamping force, and ultimate efficiency.

Our products are available through a global distribution network and can reach even the most distant places within a few working days. A wide selection of information as well as the latest updates about our products are easily obtained from our website at: www.ok-vise.com

This unique workholding solution is designed to meet the demands of the modern metalworking, plastic, aerospace, and electronics industries. As a result of constant product development and dedicated customer service, our name stands for quality in every respect, and today OK-VISE is a well recognized trademark around the globe.

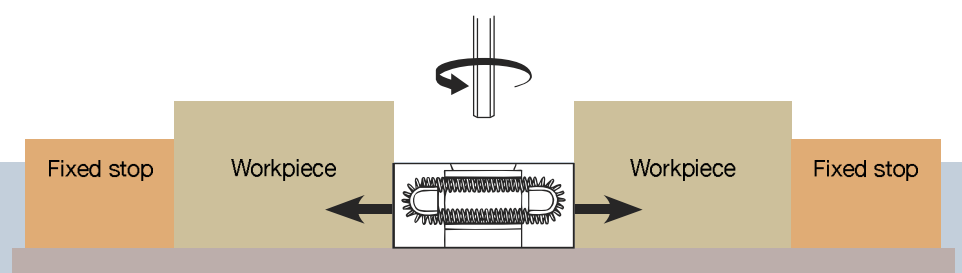
OPERATING PRINCIPLE

OK-VISE low-profile clamps function on the principle that when tightened down they expand, simultaneously pressing the workpieces against the guide and preventing any possibility of play. These clamps are designed to fit between the workpieces and take very little space on the fastening base. Small in size, yet possessing an excellent clamping force up to 150 kN, these clamps guarantee a holding capacity which clearly exceeds the load imposed by machining forces.

Our low-profile clamps can be used on single machines just as successfully as in large Flexible Manufacturing Systems. No additional investments other than fixed stoppers are required.

Standard models come with a hardness of 48-52 HRC and serrated jaws. Smooth jaws are also available on request. Both the wedge and the jaws are made of tool steel and are through hardened. A fastening operation involving one bolt (M5-M16) ensures quick set up times.

OK-VISE low-profile clamps come in two basic models, one with a single-wedge construction and the other with a double-wedge construction that creates a pull-down action. We also offer a line of machinable jaw models for workpieces of irregular shape and a special models for castings and wire EDM applications.



A CORE COMPONENT OF ANY MODERN WORKHOLDING SYSTEM

OK-VISE low-profile clamps adapt optimally to any system. They fit into grid pattern systems, T-slot tables, serrated rails, and many other platforms. Additionally, the most economical fixtures can be built by using OK-VISE low-profile clamps on machinable plates. OK-Vise clamps are suitable for three-directional machining, 5-axis machining, and many other modern machining methods. When you need fixtures for any modern machining application, OK-VISE clamps are your best choice.

ABSOLUTE STABILITY

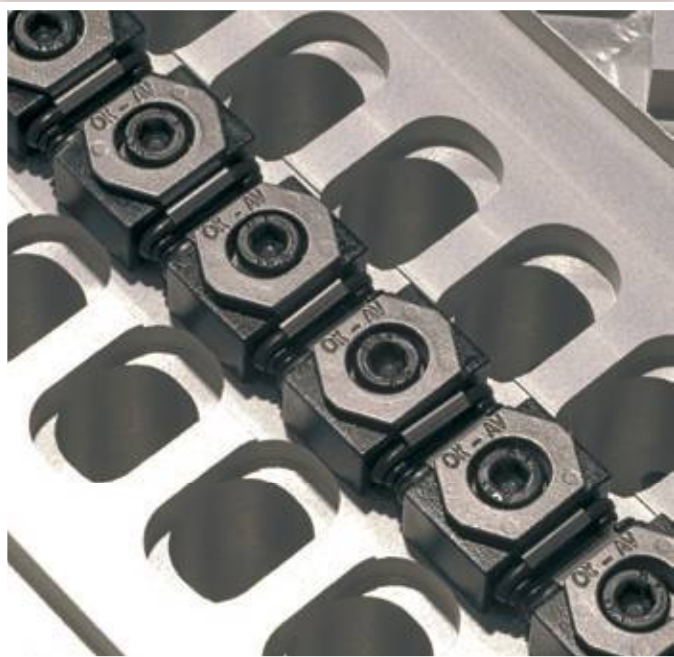
The key feature of the OK-VISE low-profile clamp is its cross-wedge structure in both the horizontal and vertical planes, which means that the clamp is locked firmly in every direction as it is tightened down. This eliminates all possibilities of measurement error due to sliding.

EXTREME CLAMPING FORCE

With extreme clamping force up to 150 kN, OK-VISE low-profile clamps guarantee a holding capacity that clearly exceeds the load imposed by machining forces.

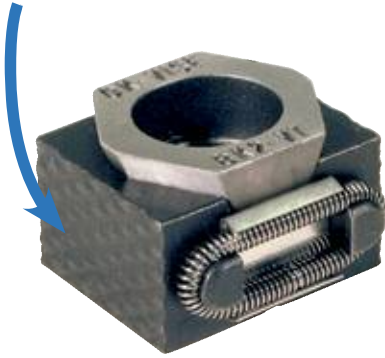
SMALL IN SIZE – GIANT IN PERFORMANCE

Low-profile clamps do not require as much space as traditional machine vises. This leads to efficient use of the machinable area, savings in tool changes, less operator interventions, and ultimately to extended cycle times while reducing machine downtime. Thanks to their small size, these light-weight clamps are easy to install. Moving them from one application or machine to another is virtually effortless. Their universal design makes easy use a reality in manual as well as CNC machines. With OK-VISE low-profile clamps, it is possible to achieve the highest level of effectiveness.



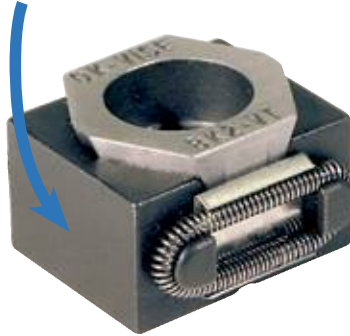
SERRATED JAWS

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 irregular-shaped 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).



INCH MODELS

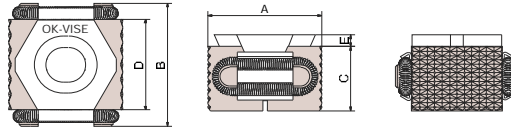
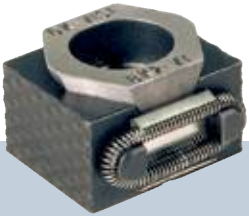
D-series clamps are also designed for the half-inch bolt. The center hole of the inch-series wedge is wider in order to fit the half-inch socket head screw. VTI and WTI in the code stand for inch models.



ACCESSORIES

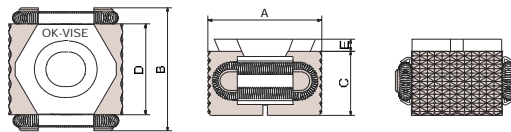
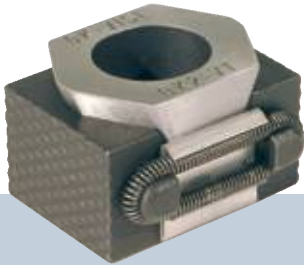
Several accessories can be utilized with OK-VISE clamps. Take a look at the expanding range of accessories at www.ok-vise.com/low-profile-clamps/accessories

SERRATED BASIC VERSION



Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
BK2-VT	27	29	31	29	15	21	2.5	M8x20	25	44	55	48-52

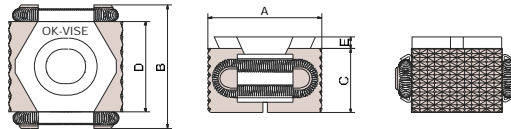
BK2-VT



DK2-VTI measures given in inches and ounces.

Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max									
DK2-VT	42	45	49	41	22	30	4	M12x30	65	145	180	48-52
DK2-VTI	1.65	1.77	1.92	1.61	0.86	1.18	0.15	1/2-1 1/4	65	145	6.34*	48-52

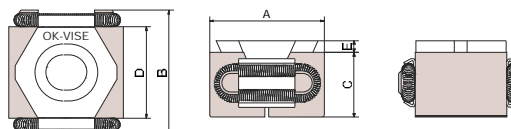
DK2-VT / DK2-VTI



Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
FK2-VT	57	61	65	56	29	42	5	M16x40	110	360	465	48-52

FK2-VT

STAINLESS STEEL MODEL



Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN	Tightening torque, Nm	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
BK2-VT-SS	27	29	31	29	15	21	2.5	M8x20	25	44	55	48-52

BK2-VT-SS

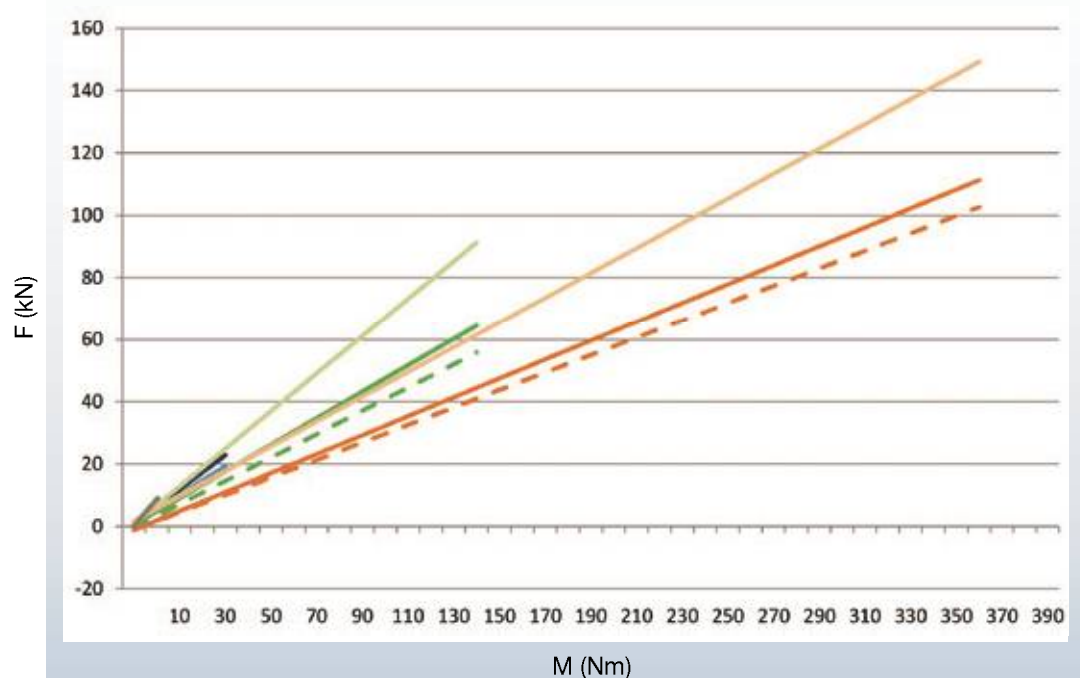
OK-VISE LOW-PROFILE CLAMP TYPES

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

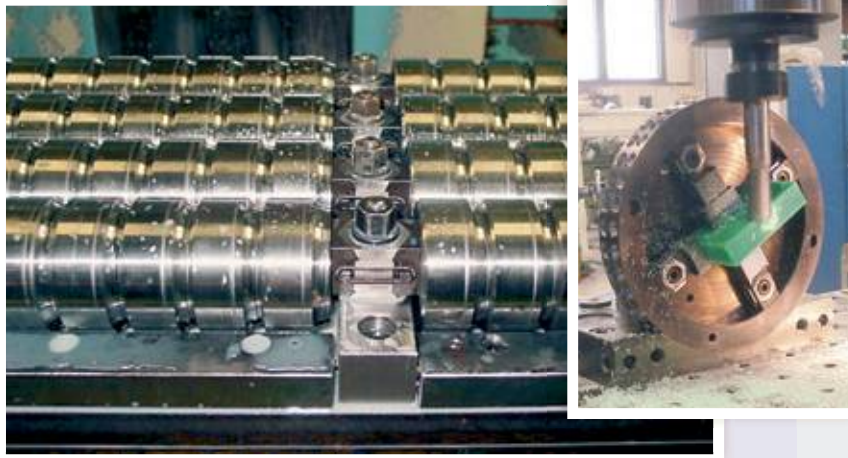
OK-VISE CLAMPFORCES

Horizontal forces of OK-Vise low profile clamps

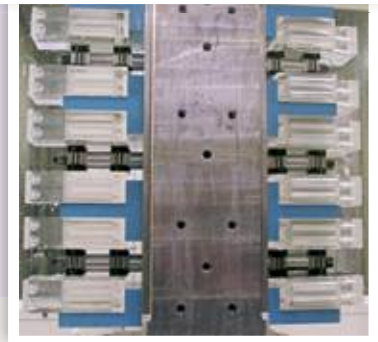
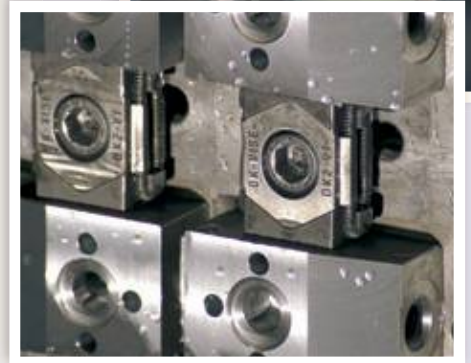
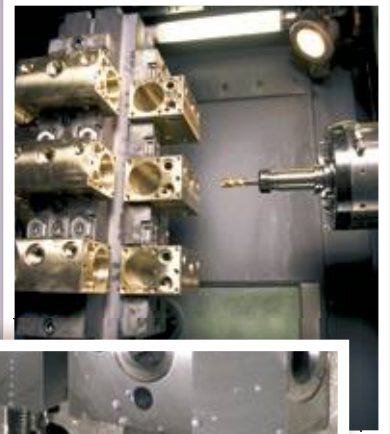
- AK2-VT-SO
- BK2-VT
- BK2-VT+3
- DK2-VT
- - DK2-VT+5
- DK2-WT
- FK2-VT
- - FK2-VT+5
- FK2-WT



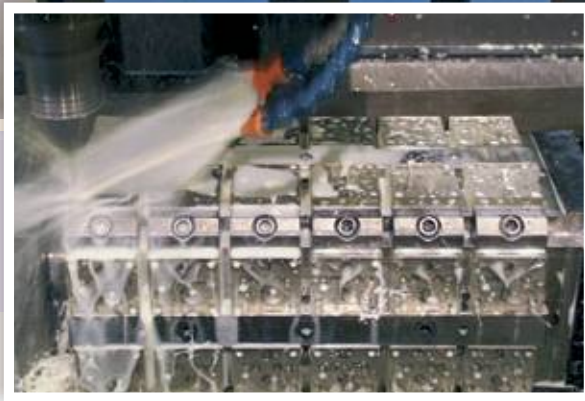
VMC applications



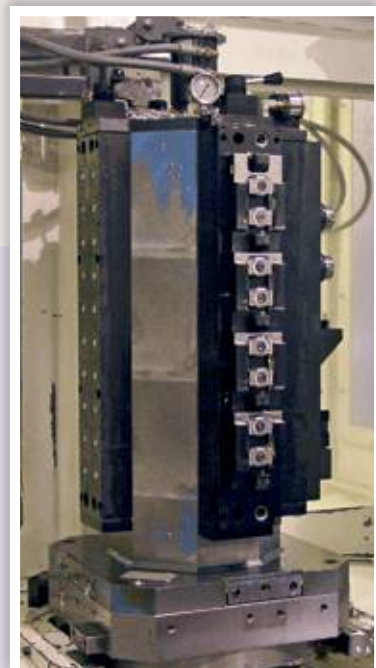
HMC applications



RPS applications

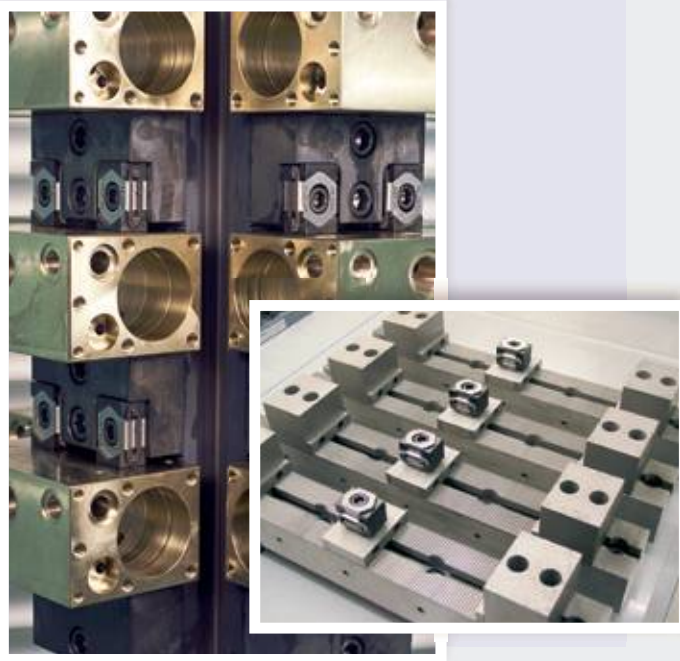


Hydraulic applications



MACHINING APPLICATIONS

Rail applications



T-slot applications



Plate applications



Grid applications

