

OK-VISE®

Clamping Method

TECHNICAL DATA



Small in Size – Giant in Performance

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LOW-PROFILE CLAMPS

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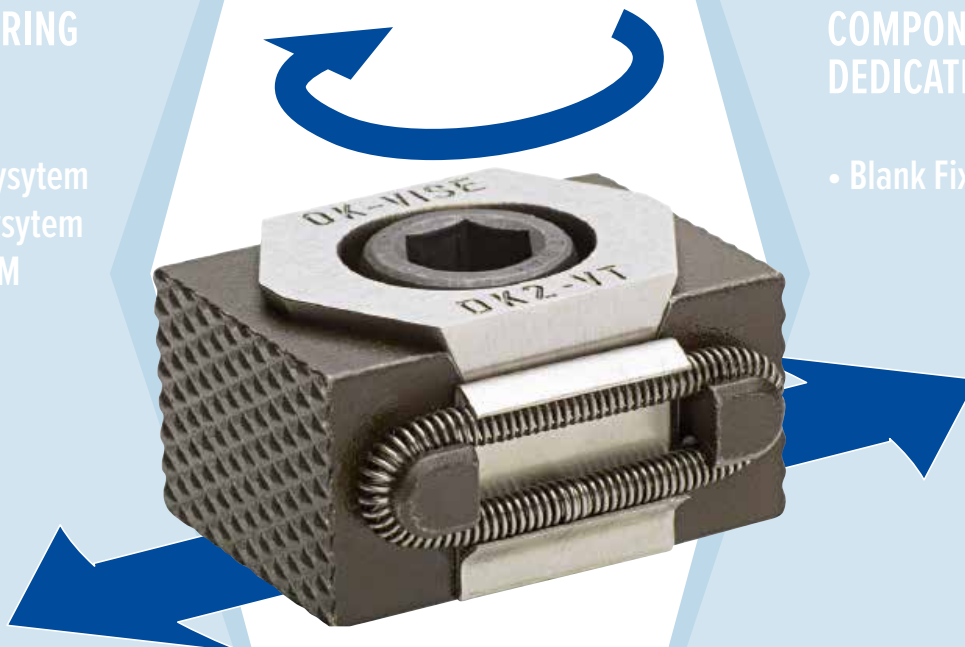
LOW-PROFILE CLAMPS

GENERIC FIXTURING CONCEPT

- Multi-Rail RM Sysytem
- Multi-Rail RH Sysytem
- Grid Fixturing RM Sysytem
- Combo-Rail

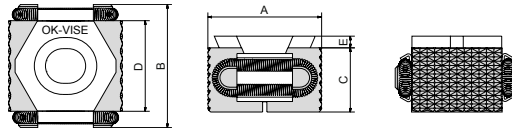
COMPONENTS FOR DEDICATED FIXTURING

- Blank Fixturing Sysytem



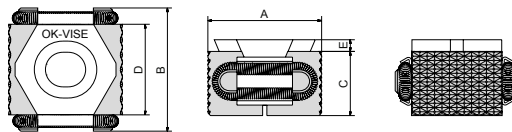
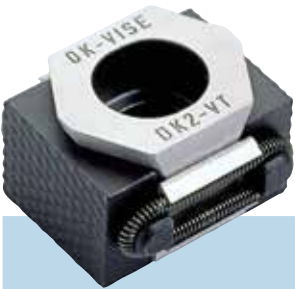
Low-Profile Clamps

SERRATED BASIC VERSION



max 2,5 tons!

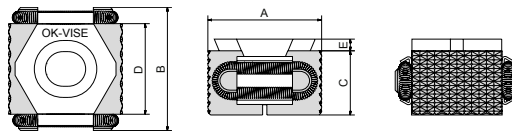
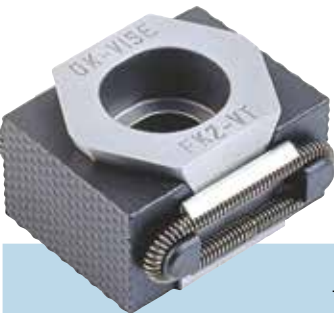
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
BK2-VT	27	29	31	29	15	21	2.5	M8x20	25	44	55	48-52



max 6,5 tons!

DK2-VTI measures given in inches and ounces.

Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	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

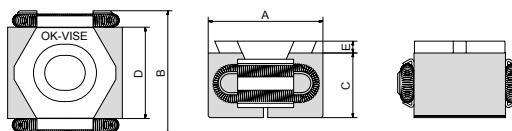
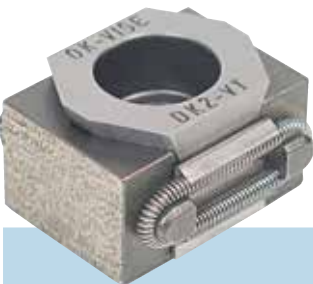


max 9 tons!

Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	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

Low-Profile Clamps

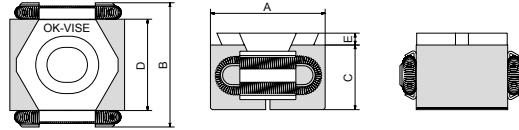
TUNGSTEN CARBIDE COATING



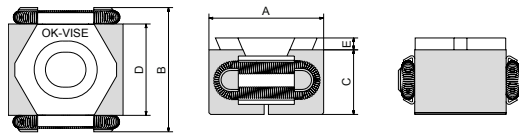
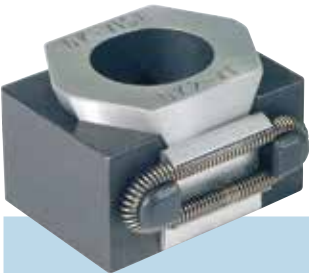
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
AK2-VT-DO	20	23	25	22	11	15	4.2	M5x25	10	10	22	60
BK2-VT-D	27	29	31	29	15	21	2.5	M8x20	25	44	55	60
DK2-VT-D	42	45	49	41	22	30	4	M12x30	65	145	180	60
DK2-VTI-D	1.65	1.77	1.92	1.51	0.86	1.18	0.15	1/2-1 1/4	65	145	6.34*	60
FK2-VT-D	57	60	64	56	29	42	5	M16x40	110	360	465	60

Low-Profile Clamps

SMOOTH BASIC VERSION

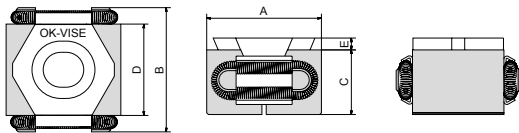


Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
BK2-VT-S	27	29	31	29	15	21	2.5	M8x20	25	44	55	48-52



DK2-VTI-S measures given in inches and ounces.

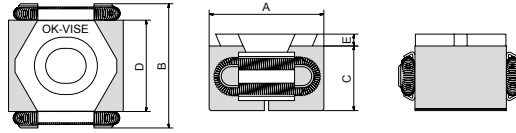
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max									
DK2-VT-S	42	45	49	41	22	30	4	M12x30	65	145	180	48-52
DK2-VTI-S	1.65	1.77	1.92	1.61	0.86	1.18	0.15	1/2-1 1/4	65	145	6.34*	48-52



Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
FK2-VT-S	57	60	64	56	29	42	5	M16x40	110	360	465	48-52

Low-Profile Clamps

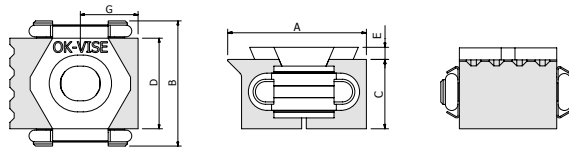
STAINLESS STEEL MODEL



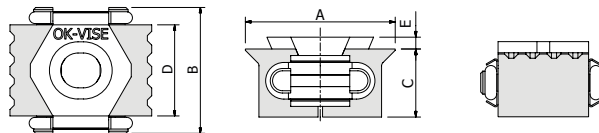
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
BK2-VT-SS	27	29	31	29	15	21	2.5	M8x20	25	44	55	48-52

Low-Profile Clamps

CLAMPS WITH KNIFE EDGE GRIP JAWS



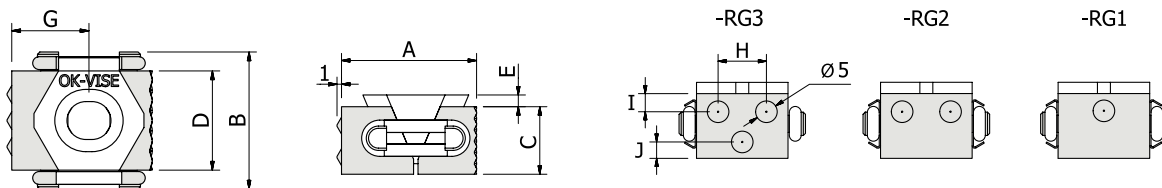
Type	A			G			B	C	D	E
	min	optimum	max	min	optimum	max				
BK2-VT-SG	30	31,5	34	13,7	14,5	15,7	29	15	21	2,5
DK2-VT-SG	46,5	49,8	53	21	22,5	24,5	41	22	30	4,4



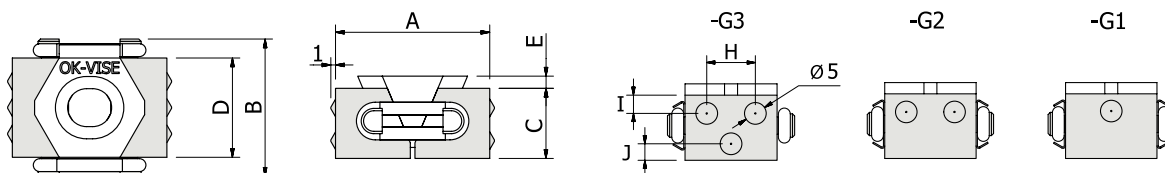
Type	A			B	C	D	E
	min	optimum	max				
BK2-VT-G	33	35	37	29	15	21	2,5
DK2-VT-G	51	54	57	41	22	30	4,4

Low-Profile Clamps

CLAMPS WITH PIN GRIP JAWS



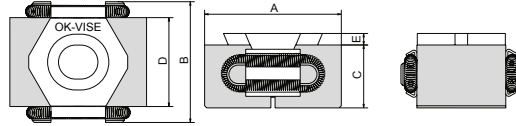
Type	A			B	C	D	E	H	I	J	G		
	min	optimum	max								min	optimum	max
BK2-VT-RG1	30	32	34	29	15	21	2.5	-	4	4	16,5	17,5	18,5
BK2-VT-RG2	30	32	34	29	15	21	2.5	11	4	4	16,5	17,5	18,5
BK2-VT-RG3	30	32	34	29	15	21	2.5	11	4	4	16,5	17,5	18,5
DK2-VT-RG1	47	50	54	41	22	30	5	-	5	5	26	27,5	29,5
DK2-VT-RG2	47	50	54	41	22	30	5	20	5	5	26	27,5	29,5
DK2-VT-RG3	47	50	54	41	22	30	5	20	5	5	26	27,5	29,5
FK2-VT-RG1	62	65	70	59	29	42	5	-	5	7	33,5	35	37,5
FK2-VT-RG2	62	65	70	59	29	42	5	24	5	7	33,5	35	37,5
FK2-VT-RG3	62	65	70	59	29	42	5	24	5	7	33,5	35	37,5



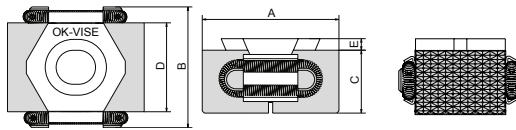
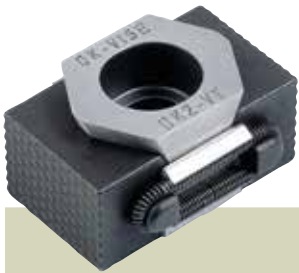
Type	A			B	C	D	E	H	I	J
	min	optimum	max							
BK2-VT-G1	33	35	37	29	15	21	2.5	-	4	4
BK2-VT-G2	33	35	37	29	15	21	2.5	11	4	4
BK2-VT-G3	33	35	37	29	15	21	2.5	11	4	4
DK2-VT-G1	52	55	59	41	22	30	5	-	5	5
DK2-VT-G2	52	55	59	41	22	30	5	20	5	5
DK2-VT-G3	52	55	59	41	22	30	5	20	5	5
FK2-VT-G1	67	70	75	59	29	42	5	-	5	7
FK2-VT-G2	67	70	75	59	29	42	5	24	5	7
FK2-VT-G3	67	70	75	59	29	42	5	24	5	7

Low-Profile Clamps

MACHINABLE JAW MODEL

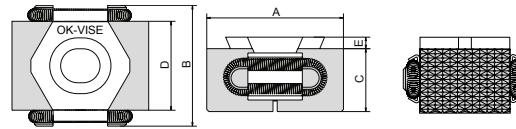
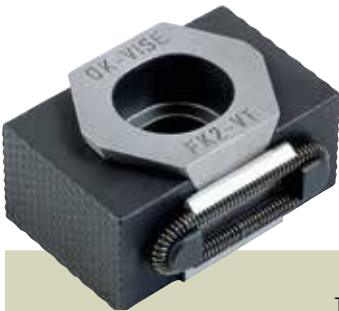


Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
BK2-VT+3	33	35	37	29	15	21	2.5	M8x20	25	43	70	30-34



Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max									
DK2-VT+5	52	55	59	41	22	30	4	M12x30	55	145	235	30-34
DK2-VTI+5	2.04	2.16	2.32	1.61	0.86	1.18	0.15	1/2-1 1/4	55	145	8.28*	30-34

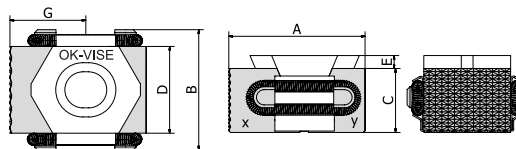
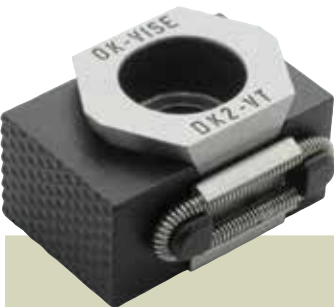
DK2-VTI+5 measures given in inches and ounces.



Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
FK2-VT+5	67	70	75	56	29	42	5	M16x40	100	360	550	30-34

Low-Profile Clamps

Combo model: MACHINABLE & SMOOTH JAW



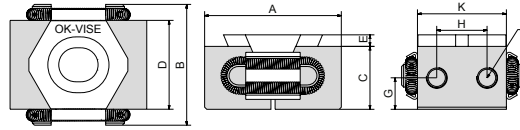
DK2-VTI+5S measures given in inches and ounces.

Type	G min	G opt	G max
BK2-VT+3S	16.5	17.5	18.5
DK2-VT+5S	26	27.5	29.5
DK2-VTI+5S	1.00	1.08	1.16
FK2-VT+5S	33.5	35	37.5

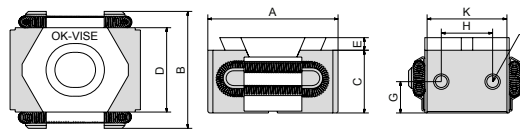
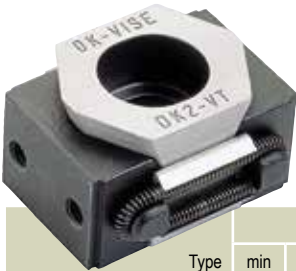
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC X	Hardness of jaws HRC Y
	min	optimum	max										
BK2-VT+3S	30	32	34	29	15	21	2.5	M8x20	22	43	65	30-34	48-52
DK2-VT+5S	47	50	54	41	22	30	4	M12x30	55	145	210	30-34	48-52
DK2-VTI+5S	1.85	1.97	2.12	1.61	0.86	1.18	0.15	1/2-1 1/4	55	145	210*	30-34	48-52
FK2-VT+5S	62	65	70	56	29	42	5	M16x40	100	360	500	30-34	48-52

Low-Profile Clamps

ADDITIONAL PIECE MODEL

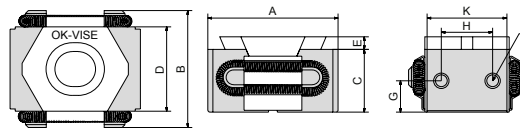


Type	A			B	C	D	E	G	H	K	L	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max													
BK2-VT-T	33	35	37	29	15	21	2.5	7.5	12	21	M5	M8x20	22	43	60	30-34



DK2-VTI-T measures given in inches and ounces.

Type	A			B	C	D	E	G	H	K	L	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max													
DK2-VT-T	46	49	53	41	22	30	4	11	18	28	M5	M12x30	55	145	200	30-34
DK2-VTI-T	1.81	1.92	2.08	1.61	0.86	1.18	0.15	0.43	0.7	1.1	M5	1/2-1 1/4	55	145	7.05*	30-34

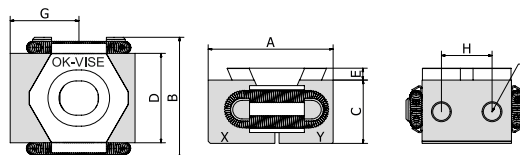
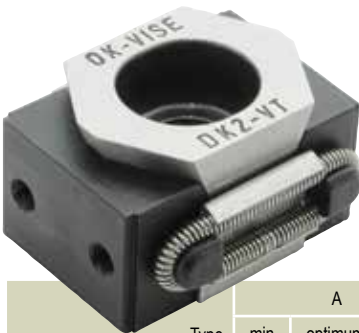


Type	A			B	C	D	E	G	H	K	L	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max													
FK2-VT-T	61	65	69	56	29	42	5	14.5	26	40	M5	M16x40	100	360	480	30-34

Low-Profile Clamps

Combo model:

ADDITIONAL PIECE & SMOOTH JAW



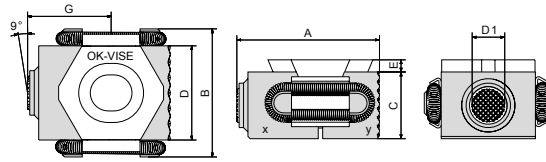
DK2-VT-TS measures given in inches and ounces.

Type	G min	G opt	G max
BK2-VT-TS	16.5	17.5	18.5
DK2-VT-TS	23	24.5	26.5
DK2-VTI-TS	0.90	0.96	1.05
FK2-VT-TS	30.5	32.5	35

Type	A			B	C	D	E	H	K	L	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC X	Hardness of jaws HRC Y
	min	optimum	max													
BK2-VT-TS	30	32	34	29	15	21	2.5	12	21	M5	M8x20	22	43	62	30-34	48-52
DK2-VT-TS	44	47	51	41	22	30	4	18	28	M5	M12x30	55	145	192	30-34	48-52
DK2-VTI-TS	1.73	1.85	2.00	1.61	0.86	1.18	0.15	0.7	1.1	M5	1/2-1 1/4	55	145	6.8*	30-34	48-52
FK2-VT-TS	59	63	67	56	29	42	5	26	40	M5	M16x40	100	360	475	30-34	48-52

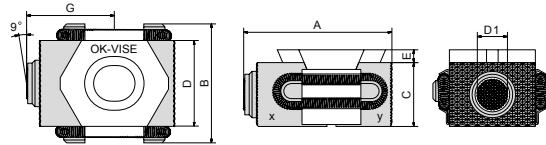
Low-Profile Clamps

SELF-ADJUSTABLE MODEL



Type	Diameter of serration (D1)	G min	G opt	G max
BK2-VT-B	7.2	19.5	20.5	21.5

Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g 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	M8x20	22	43	64	30-34	48-52



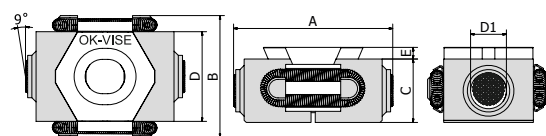
DK2-VTI-B measures given in inches and ounces.

Type	Diameter of serration (D1)	G min	G opt	G max
DK2-VT-B	10.7	31	32.5	34.5
DK2-VTI-B	0.42	1.22	1.27	1.35

Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC	Hardness of jaws HRC
	min	optimum	max										
DK2-VT-B	52	55	59	41	22	30	4	M12x30	55	145	212	30-34	48-52
DK2-VTI-B	2.04	2.16	2.32	1.61	0.86	1.18	0.15	1/2-1 1/4	55	145	7.40*	30-34	48-52

Low-Profile Clamps

TWO SELF-ADJUSTABLE JAWS



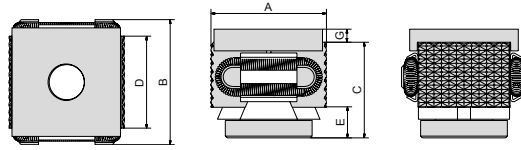
DK2-VTI+E measures given in inches and ounces.

Type	Diameter of serration (D1)
BK2-VT-E	7.2
DK2-VT-E	10.7
DK2-VTI-E	0.42

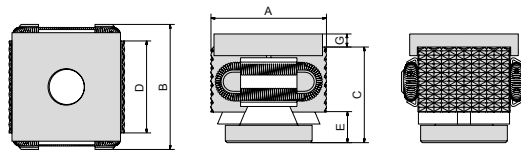
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.
	min	optimum	max								
BK2-VT-E	39	41	43	29	15	21	2.5	M8x20	22	43	72
DK2-VT-E	62	65	69	41	22	30	4	M12x40	55	145	242
DK2-VTI-E	2.44	2.56	2.72	1.61	0.86	1.18	0.15	1/2-1 1/4	55	145	8.54*

Low-Profile Clamps

SINGLE-WEDGE PULL-DOWN, SERRATED

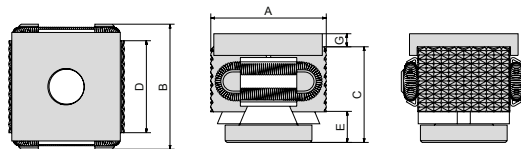


Bolt not included	Type	A			B	C m a x	D	E	G	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
		min	optimum	max										
	BK2-VT-PD	27	29	31	29	22	21	7	3	M8x20	25	44	68	48-52



DK2-VTI-PD measures given in inches and ounces.

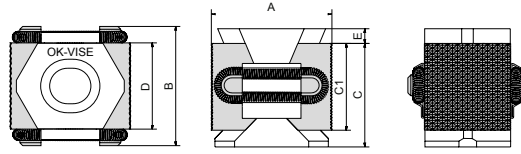
Bolt not included	Type	A			B	C m a x	D	E	G	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
		min	optimum	max										
	DK2-VT-PD	42	45	49	41	32	30	10	4	M12x60	65	145	270	48-52
	DK2-VTI-PD	1.65	1.77	1.93	1.61	1.26	1.18	0.39	0.16	1/2	65	145	9.54*	48-52



Bolt not included	Type	A			B	C m a x	D	E	G	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
		min	optimum	max										
	FK2-VT-PD	57	61	65	56	40.5	42	11.5	5	M16x60	110	360	620	48-52

Low-Profile Clamps

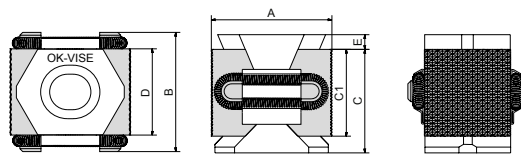
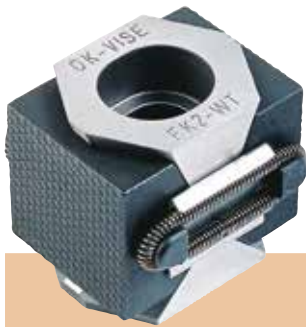
DOUBLE-WEDGE PULL-DOWN, SERRATED



max 9 tons!

DK2-WT1 measures given in inches and ounces.

Type	A			B	C max	C1	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max										
DK2-WT	42	46	49	41	36	30	30	5	M12x40	90	145	275	48-52
DK2-WT1	1.65	1.81	1.92	1.61	1.41	1.18	1.18	0.19	1/2-1 3/4	90	145	9.70*	48-52

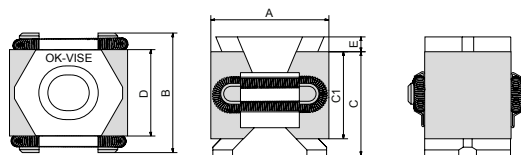


max 15 tons!

Type	A			B	C max	C1	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max										
FK2-WT	58	61	66	56	50	42	52	5	M16x60	150	360	730	48-52

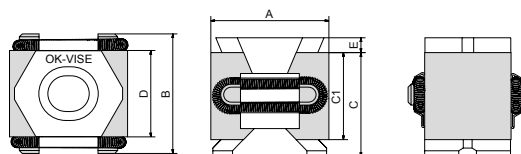
Low-Profile Clamps

DOUBLE-WEDGE PULL-DOWN, SMOOTH



DK2-WT1-S measures given in inches and ounces.

Type	A			B	C max	C1	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max										
DK2-WT-S	41	45	48	41	36	30	30	5	M12x40	90	145	275	48-52
DK2-WT1-S	1.61	1.77	1.88	1.61	1.41	1.18	1.18	0.19	1/2-1 3/4	90	145	9.70*	48-52



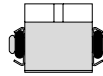
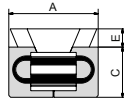
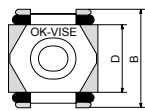
Type	A			B	C max	C1	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max										
FK2-WT-S	58	61	66	56	50	42	52	5	M16x60	150	360	730	48-52

Low-Profile Clamps

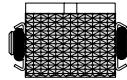
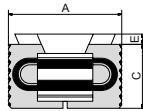
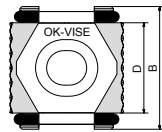
ECONOMY SERIES

The cost efficient choice!

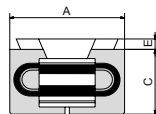
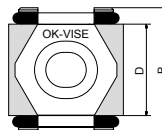
These models meet the demands of workholding when ultra precision and high clamping force are not necessary. They are made of the same raw material as our other models, and the bottom of the jaws are ground for precise positioning on the fixture base. AK2-VT-SO always comes with Viton o-rings.



Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
AK2-VT-SO	20	23	25	22	11	15	4.2	M5x25	10	10	22	48-52



Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
BK2-VT-O	28	30	32	29	15	21	4	M8x20	15	25	55	48-52



Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
BK2-VT-SO	28	30	32	29	15	21	3.5	M8x20	15	25	55	48-52