

COMPANY PROFILE

In the late 1970s Finnish entrepreneur and inventor Olli Kytölä bought his first numerically controlled machining centers, but he was not happy with the workholding solutions that were then available.

While fastening the laundry rope to the brick wall of his house, he started studying the screw anchor that he was using - and the rest is part of workholding history.



Hold-down principle

40 years later, 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.

In addition to low-profile clamps, we also manufacture components for various fixturing systems, which form the OK-VISE FIXTURING CONCEPT

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



More info: ok-vise.com/low-profile-clamps

OK-VISE LOW-PROFILE CLAMPS

Olli Kytölä's original invention is still the core of our product range. This unique workholding solution is designed to meet the demands of the modern metalworking, plastics, aerospace and electronics industries.



LOW-PROFILE CLAMPS

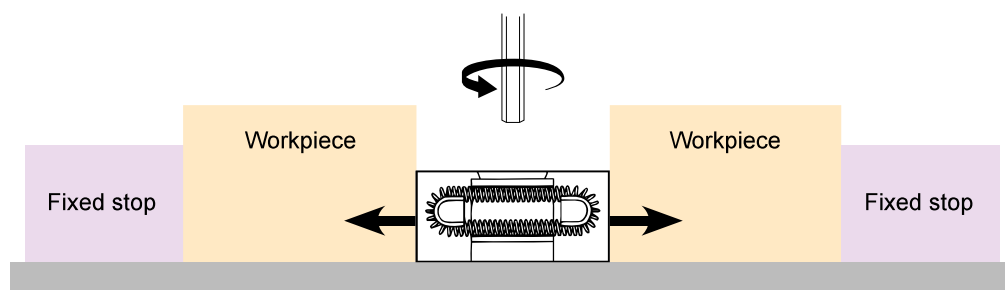
The OK-VISE clamping method is both an effective and time-saving solution because it allows full utilization of the fixturing platform. It also allows free tool access to the workpiece, is free of play and possesses extreme clamping force in a small space.

Efficient use of the machinable area leads to savings in tool changes, creates less operator interventions and results ultimately in extended cycle times while cutting down machine stop times.

Low-profile clamps do not require a lot of space when compared to traditional machine vises and the variety of jaw types on offer makes the clamp suitable for a wide range of machining applications.

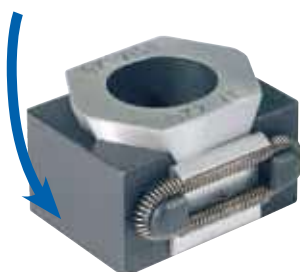
OPERATING PRINCIPLE

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.



SMOOTH JAWS

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



SERRATED JAWS

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



GRIP MODELS

When the friction offered by serrated jaws is not enough for your application, grip jaws can be used. Please notice that the jaw penetrates into the work piece, leaving some marks.



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 irregular 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.



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.



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.



A CORE COMPONENT OF ANY JAWS WORKHOLDING SYSTEM

OK-VISE low-profile clamps adapt optimally to any workholding system. They fit into grid pattern systems, T-slot tables, serrated rails and many other platforms. OK-VISE clamps are suitable for three-directional machining, 5-axis machining and many other modern machining methods. When fixtures are needed 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 play.

EXTREME CLAMPING FORCE

With extreme clamping force of 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 all types of CNC machining centers as well as FMS Systems.

ULTIMATE RELIABILITY

As the original inventor of the wedge-operated low-profile clamp, OK-VISE has decades of history of efficient and reliable installations world-wide.

With OK-VISE low-profile clamps, it is possible to achieve the highest level of reliability and safety.



ACCESSORIES

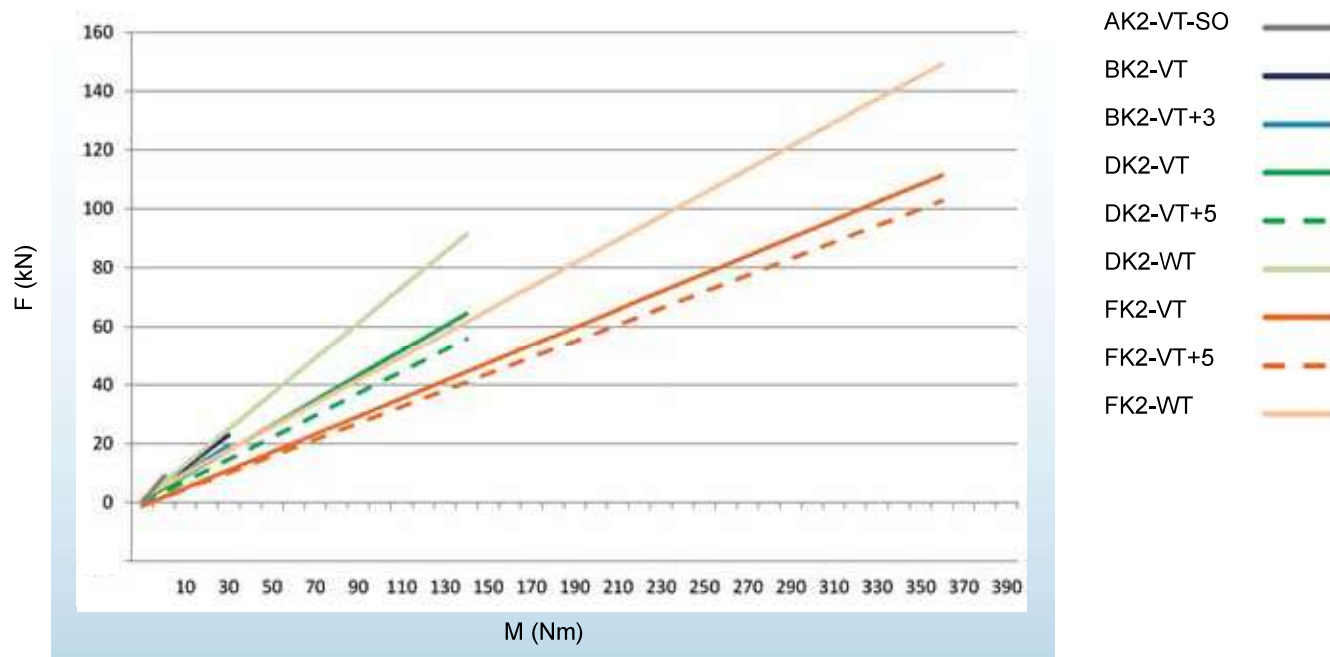
Several accessories can be utilized with OK-VISE clamps. Take a look at the expanding range of accessories at www.ok-vise.com/low-profile-clamps/accessories

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 |
| Grip jaw & serrated jaw combo | | BK2-VT-RG | DK2-VT-RG | DK2-VTI-RG | FK2-VT-RG |
| 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 |
| Machined Cross V jaws | | BK2-VT-C | DK2-VT-C | DK2-VTI-C | FK2-VT-C |
| 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



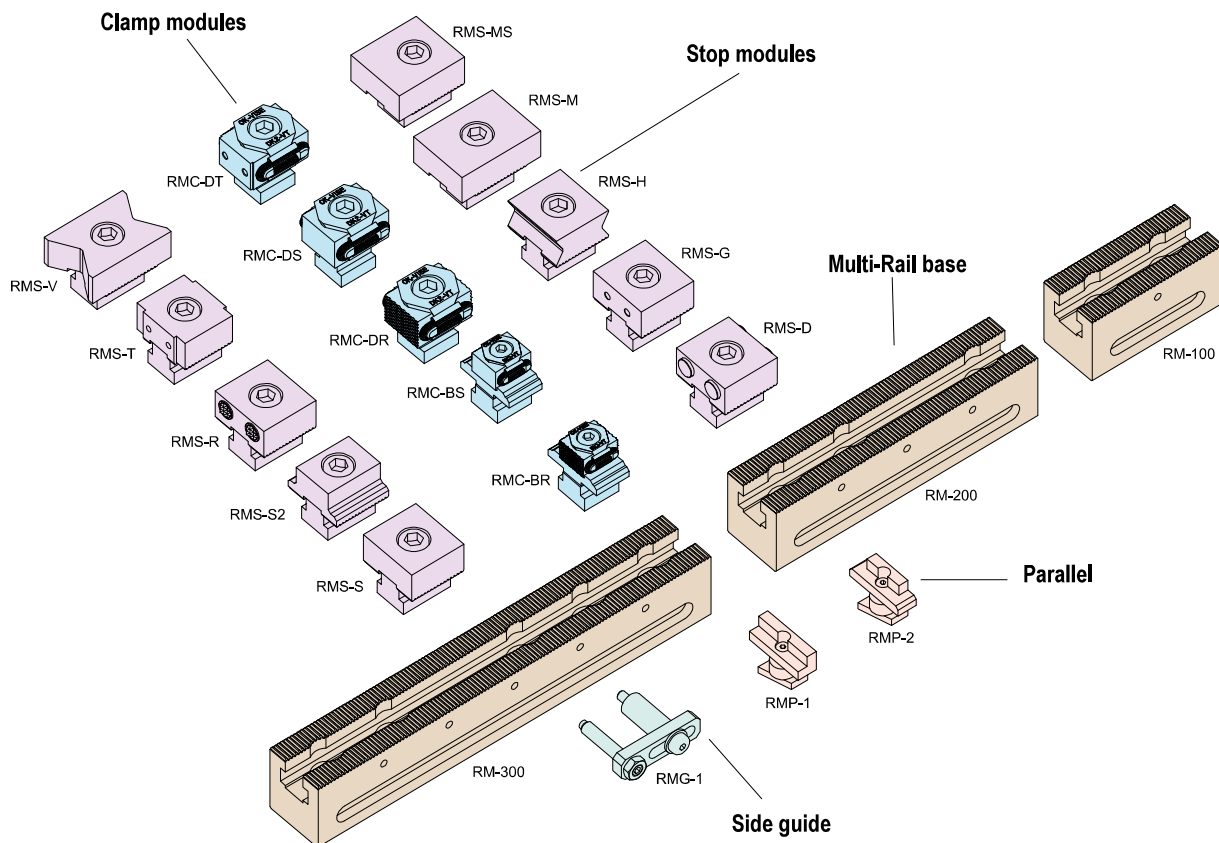
OK-VISE MULTI-RAIL RM SYSTEM

Multi-Rail is the new generic-purpose workholding system of OK-VISE.

Compared to a traditional machine vise, the Multi-Rail system offers the following benefits:

- Using the components of the system, even the most challenging workpiece types can be machined
- All sides of a workpiece can be machined with two setups
- Multiple workpieces can be clamped on the same area
- Workpiece will be safely fixtured in all conditions
- It is also possible to fasten very large work pieces

MULTI-RAIL RM SYSTEM COMPONENTS



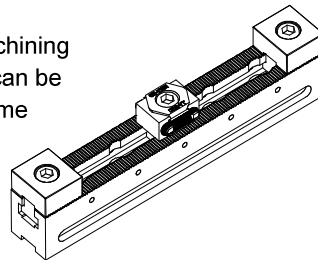
MULTI-RAIL RM FIXTURE SETS

To make selection of the components easier, the OK-VICE team has selected some basic sets to enable an easy start with the Multi-Rail system. In the pictures below you can see some solutions done with each set.



SRM-132GD1

- For three-directional machining
- One or two workpieces can be machined at the same time

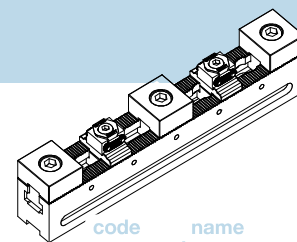
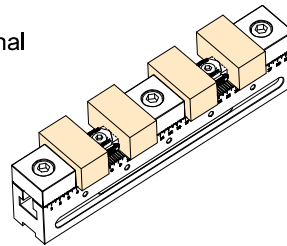


| code | name | pcs |
|--------|-----------------------|-----|
| RM-300 | multi-rail base | 1 |
| RMS-S | stop module smooth | 2 |
| RMC-DS | clamp module D smooth | 1 |



SRM-133GB1

- For three-directional machining
- Four workpieces can be machined at the same time

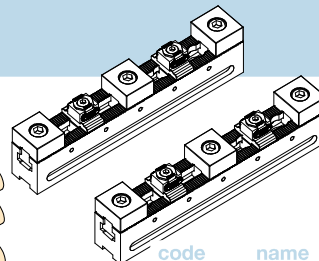
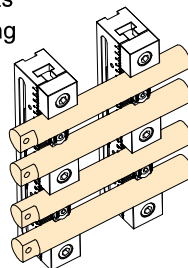


| code | name | pcs |
|--------|-----------------------|-----|
| RM-300 | multi-rail base | 1 |
| RMS-S | stop module smooth | 3 |
| RMC-BS | clamp module B smooth | 2 |



SRM-236GB1

- Two SRM-133GB1 sets
- Also suitable for holding long workpieces

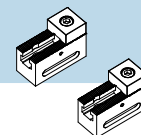
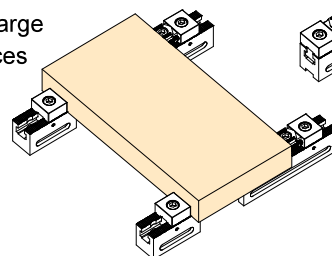


| code | name | pcs |
|--------|-----------------------|-----|
| RM-300 | multi-rail base | 2 |
| RMS-S | stop module smooth | 6 |
| RMC-BS | clamp module B smooth | 4 |



SRM-4C4GD1

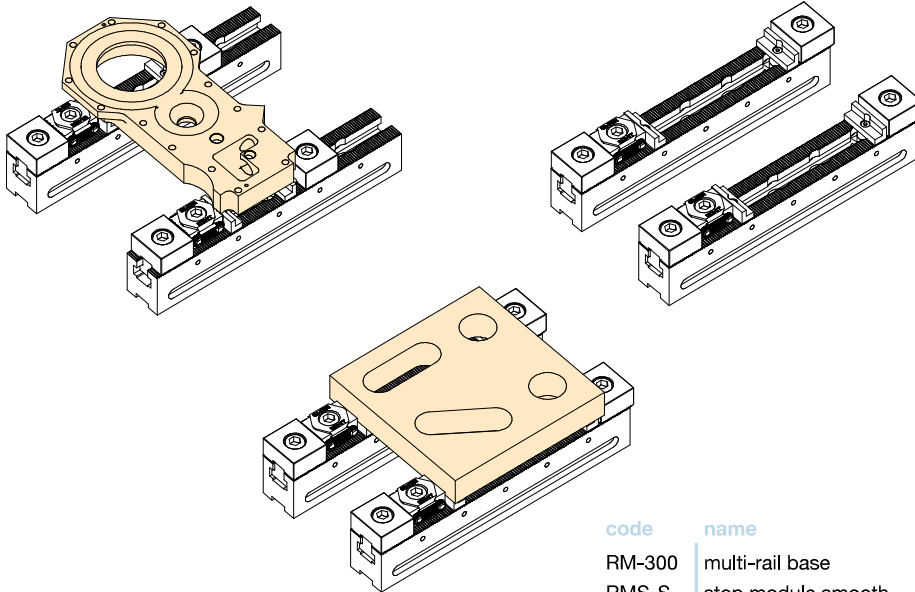
- To hold large workpieces



| code | name | pcs |
|--------|-----------------------|-----|
| RM-100 | multi-rail base | 2 |
| RM-200 | multi-rail base | 2 |
| RMS-S | stop module smooth | 4 |
| RMC-DS | clamp module D smooth | 2 |

MULTI-RAIL RM SYSTEM APPLICATIONS

SRM-Z101



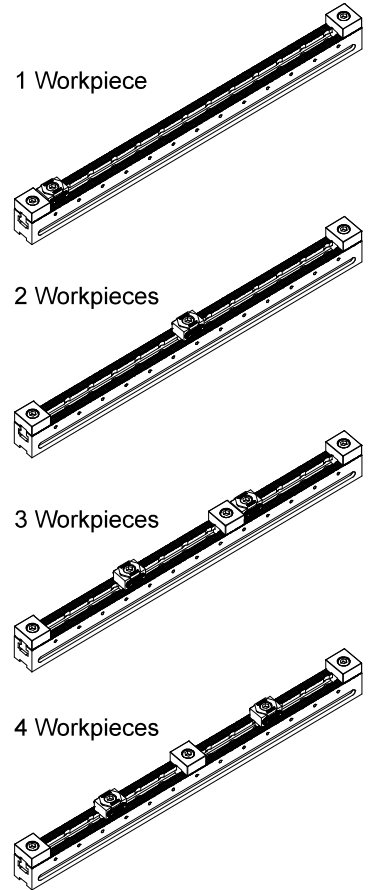
| code | name | pcs |
|--------|-----------------------|-----|
| RM-300 | multi-rail base | 2 |
| RMS-S | stop module smooth | 4 |
| RMC-DS | clamp module D smooth | 2 |
| RMP-1 | parallel block | 4 |

1 Workpiece

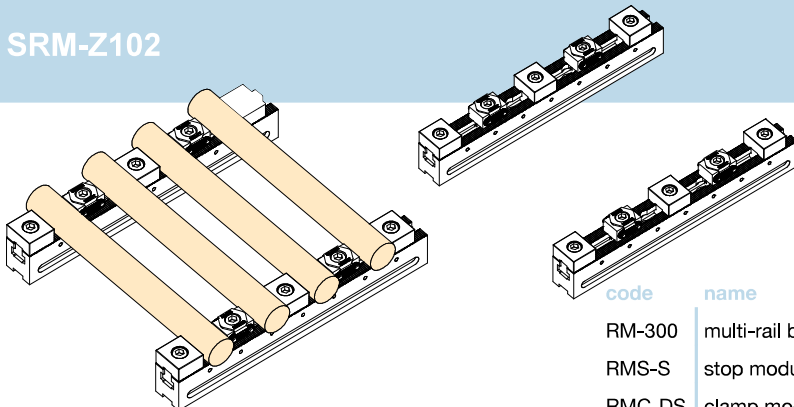
2 Workpieces

3 Workpieces

4 Workpieces



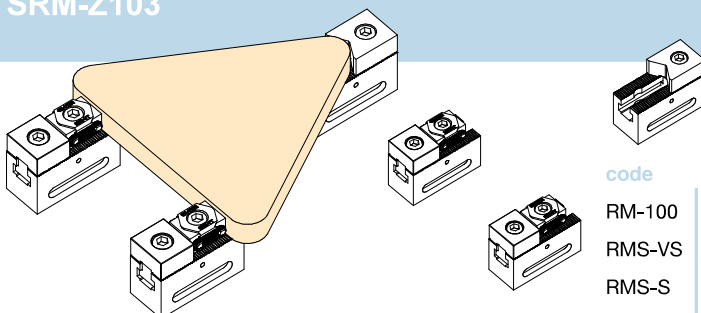
SRM-Z102



| code | name | pcs |
|--------|-----------------------|-----|
| RM-300 | multi-rail base | 2 |
| RMS-S | stop module smooth | 6 |
| RMC-DS | clamp module D smooth | 4 |



SRM-Z103



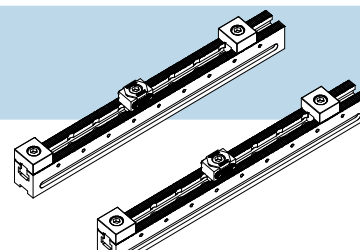
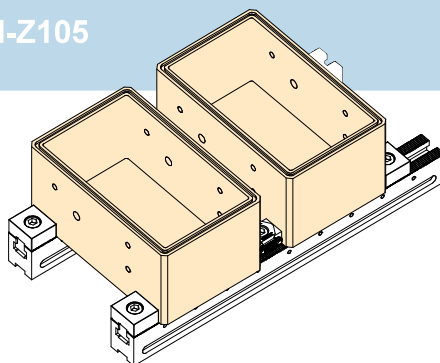
| code | name | pcs |
|--------|-----------------------|-----|
| RM-100 | multi-rail base | 3 |
| RMS-VS | stop module combo V/S | 1 |
| RMS-S | stop module smooth | 2 |
| RMS-DS | clamp module D smooth | 2 |



MULTI-RAIL RM SYSTEM APPLICATIONS



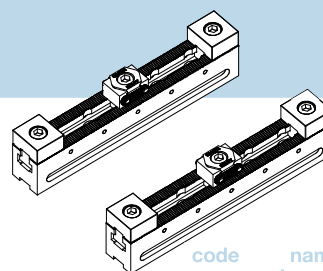
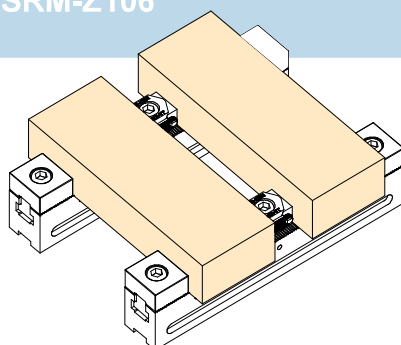
SRM-Z105



| code | name | pcs |
|--------|---------------------|-----|
| RM-500 | multi-rail base | 2 |
| RMS-S | stop module smooth | 4 |
| RMC-DS | clamp module smooth | 2 |



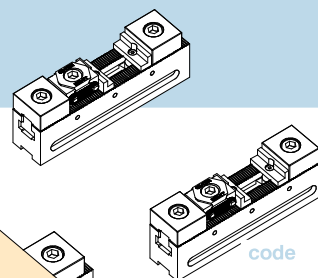
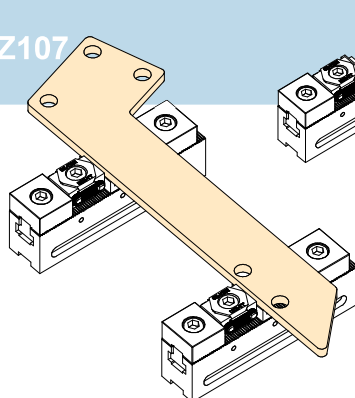
SRM-Z106



| code | name | pcs |
|--------|---------------------|-----|
| RM-300 | multi-rail base | 2 |
| RMS-S | stop module smooth | 4 |
| RMC-DS | clamp module smooth | 2 |



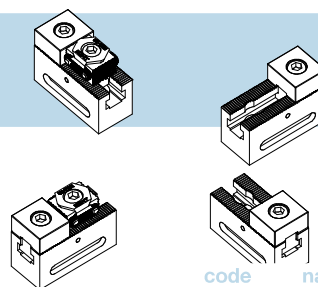
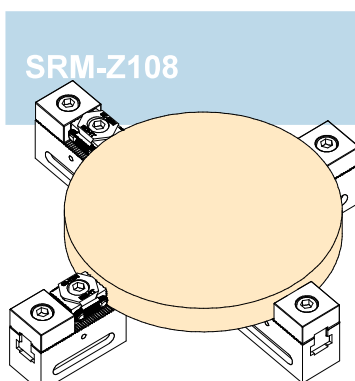
SRM-Z107



| code | name | pcs |
|--------|---------------------|-----|
| RM-200 | multi-rail base | 2 |
| RMS-S | stop module smooth | 4 |
| RMC-DS | clamp module smooth | 2 |
| RMP-1 | parallel block | 4 |



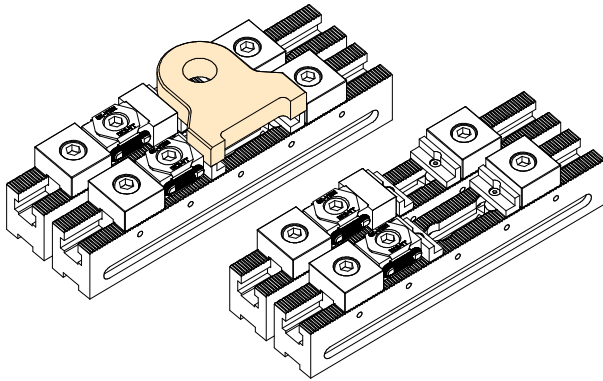
SRM-Z108



| code | name | pcs |
|--------|---------------------|-----|
| RM-100 | multi-rail base | 4 |
| RMS-S | stop module smooth | 4 |
| RMC-DS | clamp module smooth | 2 |

MULTI-RAIL RM SYSTEM APPLICATIONS

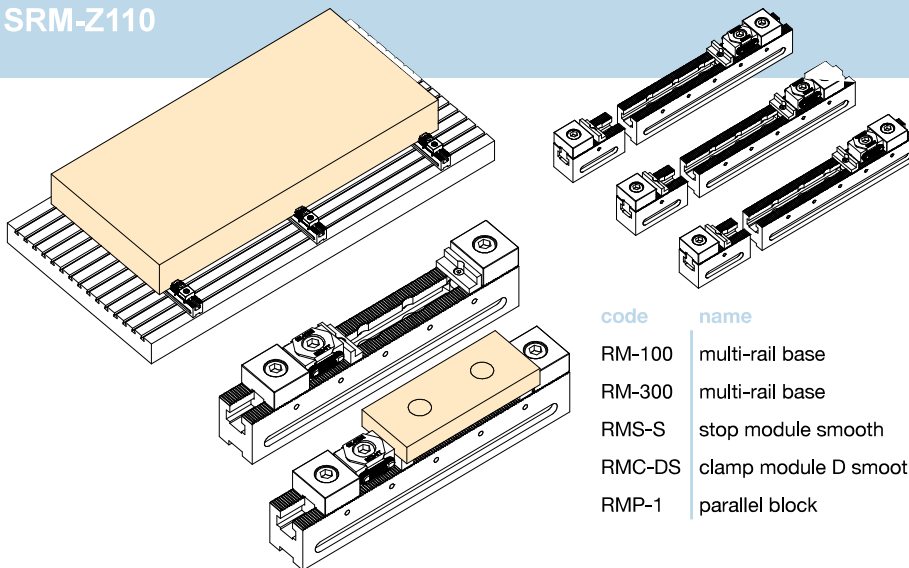
SRM-Z109



| code | name | pcs |
|---------|-------------------------|-----|
| RM-300 | multi-rail base | 2 |
| RMS-S | stop module smooth | 4 |
| RMC-DS | clamp module D smooth | 1 |
| RMC-DTS | clamp module D-T smooth | 1 |
| ADM | additional piece | 1 |
| RMP-1 | parallel block | 4 |



SRM-Z110



| code | name | pcs |
|--------|-----------------------|-----|
| RM-100 | multi-rail base | 3 |
| RM-300 | multi-rail base | 3 |
| RMS-S | stop module smooth | 6 |
| RMC-DS | clamp module D smooth | 3 |
| RMP-1 | parallel block | 6 |



OPTIONS

We also offer installation sets for the most common platforms like T-slot tables and grid systems.



Spigot installations to all leading zero-point systems – including OK-LOCK System – are available.



More info: ok-vise.com/multi-rail-system/



OK-VISE MULTI-RAIL RH SYSTEM

Multi-Rail RH is the new generic-purpose fixturing system from OK-VISE. Multi-Rail RH is optimal when the clamping force is over 4 tons and also when the workpieces are rather big.

FIXTURE SETS

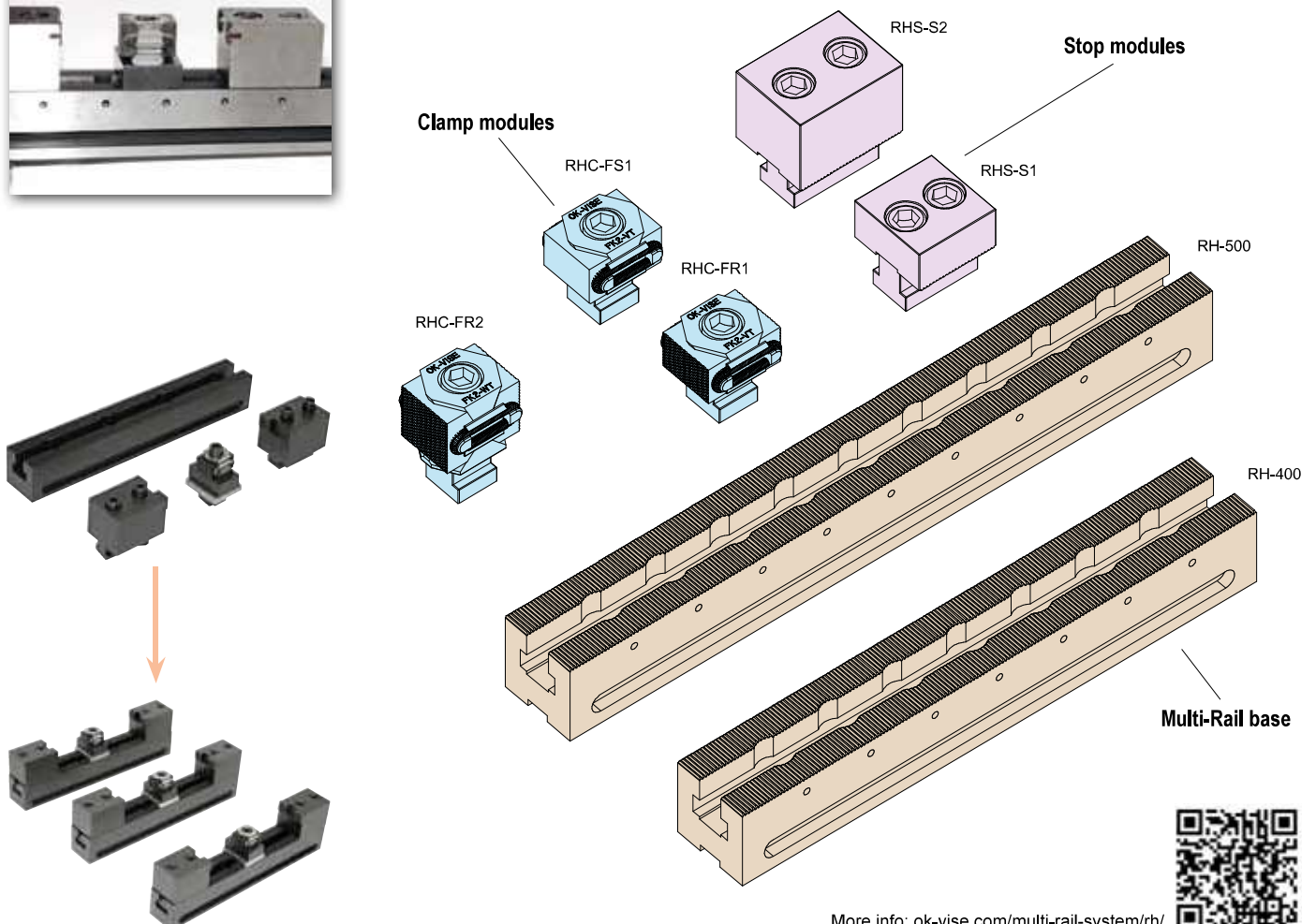
To make selection of the components easier, the OK-VISE team has created some basic sets to enable an easy start with the Multi-Rail system.

Compared to a traditional machine vise, the Multi-Rail RH system offers the following benefits:

- Using the components of the system, even the most challenging workpiece types can be machined.
- All sides of a workpiece can be machined with two setups.
- Multiple workpieces can be clamped on the same area.
- The workpiece is safely fixtured under all conditions.
- It is also possible to fasten very large work pieces.



MULTI-RAIL RH SYSTEM COMPONENTS

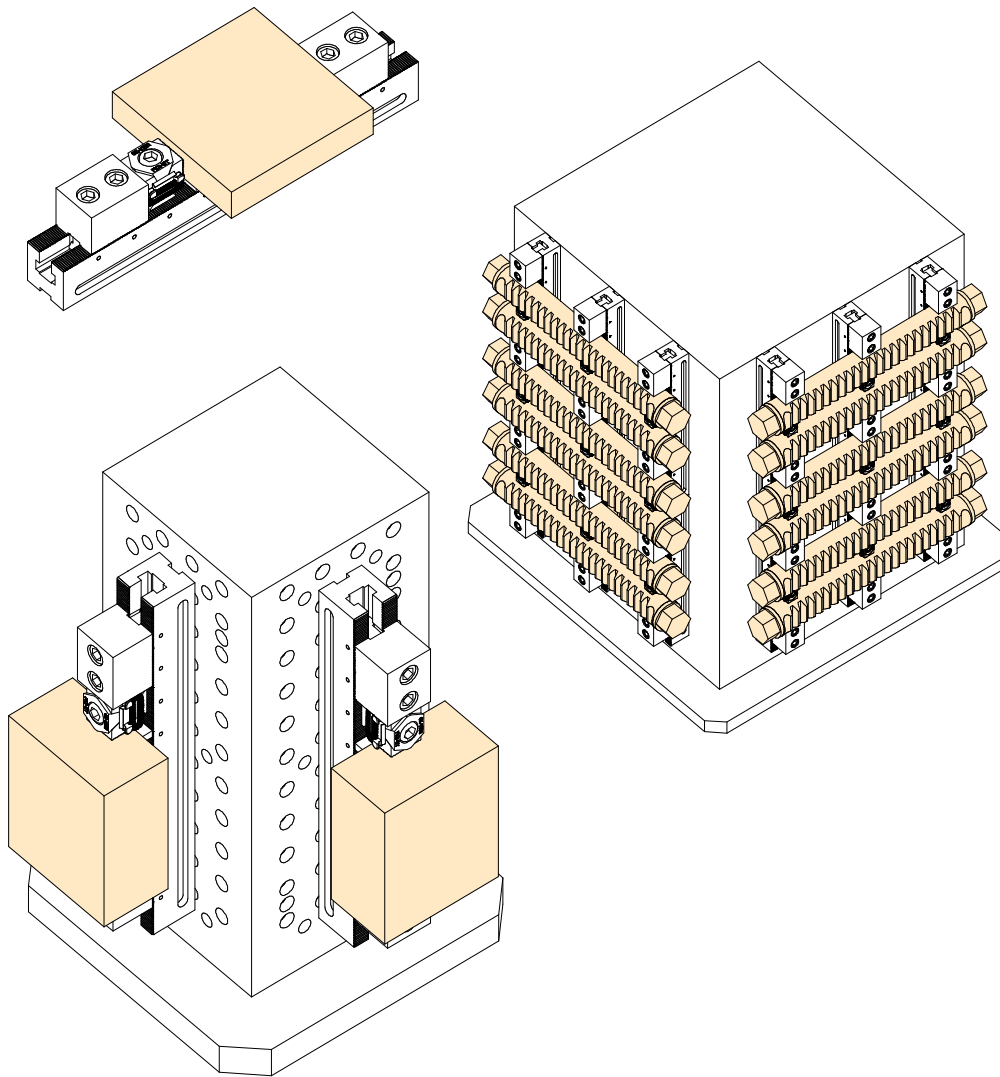


More info: ok-vise.com/multi-rail-system/rh/



MULTI-RAIL RH SYSTEM APPLICATIONS

In a modular system all the functions of a fixture are separated into individual modules. This means that when workpiece material, form or size changes, the modules of the fixture can be changed independently of each other. Using a well-chosen collection of basic modules – a set – a huge variety of workpieces can be clamped simply using the same modules.



We also offer installation sets for the most typical platforms like T-slot tables and grid systems.

