

# OK-VISE®

## Clamping Method

### TECHNICAL DATA

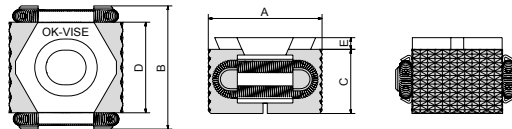
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Small in Size – Giant in Performance

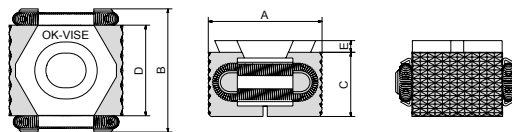
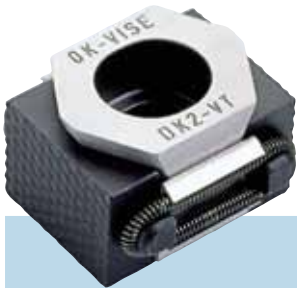


### SERRATED BASIC VERSION



max 2,5 tons!

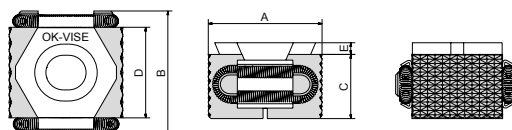
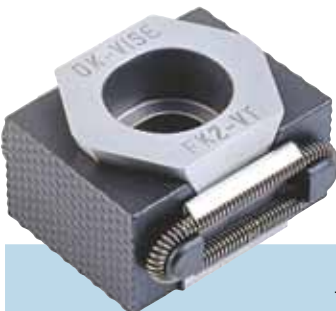
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
<b>BK2-VT</b>	27	29	31	29	15	21	2.5	M8x20	25	44	55	48-52



max 6,5 tons!

DK2-VTI measures given in inches and ounces.

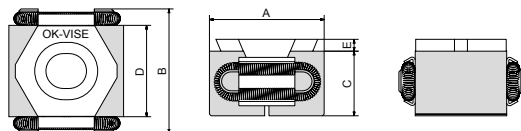
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max									
<b>DK2-VT</b>	42	45	49	41	22	30	4	M12x30	65	145	180	48-52
<b>DK2-VTI</b>	1.65	1.77	1.92	1.61	0.86	1.18	0.15	1/2-1 1/4	65	145	6.34*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



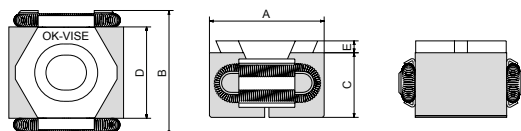
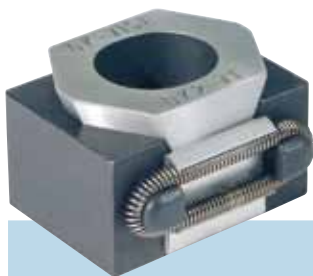
max 9 tons!

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									
<b>FK2-VT</b>	57	61	65	56	29	42	5	M16x40	110	360	465	48-52

## SMOOTH BASIC VERSION

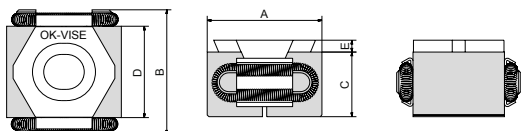


Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
<b>BK2-VT-S</b>	27	29	31	29	15	21	2.5	M8x20	25	44	55	48-52



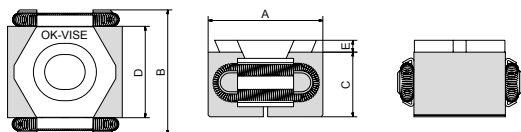
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max									
<b>DK2-VT-S</b>	42	45	49	41	22	30	4	M12x30	65	145	180	48-52
<b>DK2-VTI-S</b>	1.65	1.77	1.92	1.61	0.86	1.18	0.15	1/2-1 1/4	65	145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

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



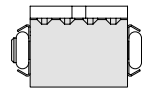
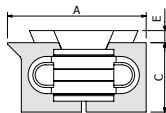
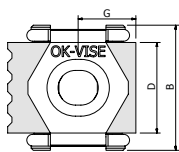
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
<b>FK2-VT-S</b>	57	60	64	56	29	42	5	M16x40	110	360	465	48-52

## STAINLESS STEEL MODEL

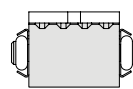
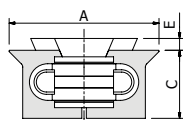
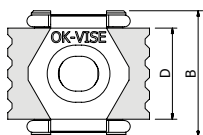


Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
<b>BK2-VT-SS</b>	27	29	31	29	15	21	2.5	M8x20	25	44	55	48-52

## CLAMPS WITH KNIFE EDGE GRIP JAWS

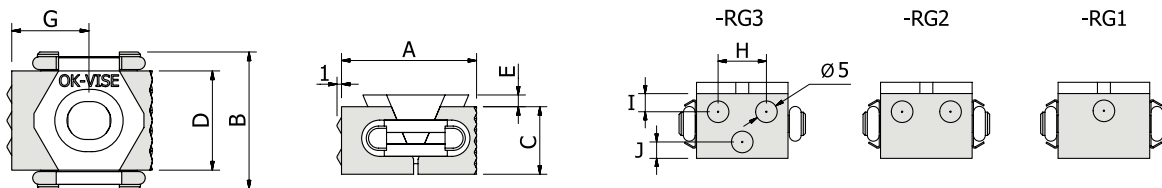


Type	A			G			B	C	D	E
	min	optimum	max	min	optimum	max				
<b>BK2-VT-SG</b>	30	31,5	34	13,7	14,5	15,7	29	15	21	2,5
<b>DK2-VT-SG</b>	46,5	49,8	53	21	22,5	24,5	41	22	30	4,4

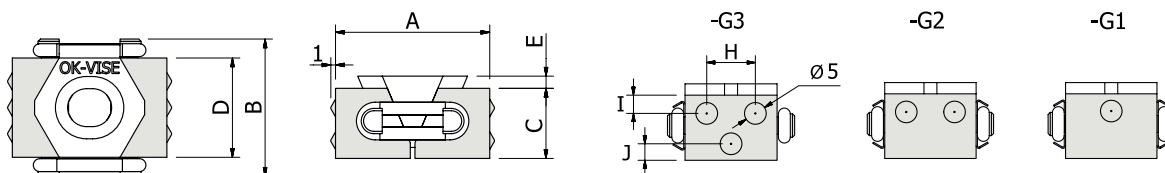


Type	A			B	C	D	E
	min	optimum	max				
<b>BK2-VT-G</b>	33	35	37	29	15	21	2,5
<b>DK2-VT-G</b>	51	54	57	41	22	30	4,4

## CLAMPS WITH PIN GRIP JAWS

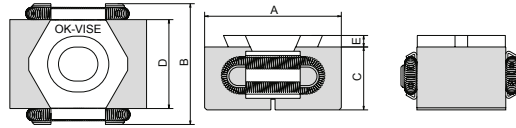


Type	A			B	C	D	E	H	I	J	G		
	min	optimum	max								min	optimum	max
<b>BK2-VT-RG1</b>	30	32	34	29	15	21	2.5	-	4	4	16,5	17,5	18,5
<b>BK2-VT-RG2</b>	30	32	34	29	15	21	2.5	11	4	4	16,5	17,5	18,5
<b>BK2-VT-RG3</b>	30	32	34	29	15	21	2.5	11	4	4	16,5	17,5	18,5
<b>DK2-VT-RG1</b>	47	50	54	41	22	30	5	-	5	5	26	27,5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

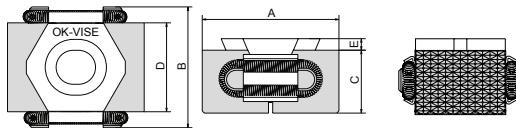
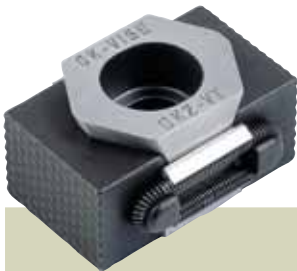


Type	A			B	C	D	E	H	I	J
	min	optimum	max							
<b>BK2-VT-G1</b>	33	35	37	29	15	21	2.5	-	4	4
<b>BK2-VT-G2</b>	33	35	37	29	15	21	2.5	11	4	4
<b>BK2-VT-G3</b>	33	35	37	29	15	21	2.5	11	4	4
<b>DK2-VT-G1</b>	52	55	59	41	22	30	5	-	5	5
<b>DK2-VT-G2</b>	52	55	59	41	22	30	5	20	5	5
<b>DK2-VT-G3</b>	52	55	59	41	22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

**MACHINABLE JAW MODEL**

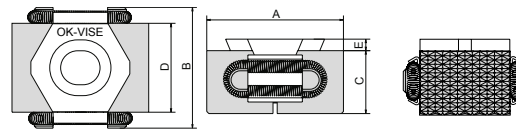
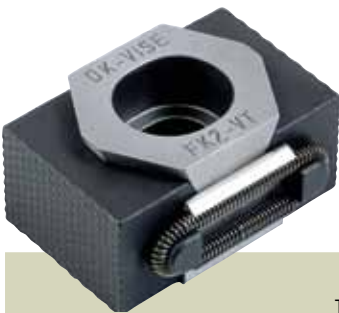


Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max									
<b>BK2-VT+3</b>	33	35	37	29	15	21	2.5	M8x20	25	43	70	30-34



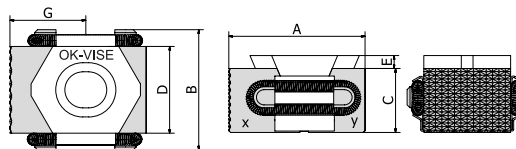
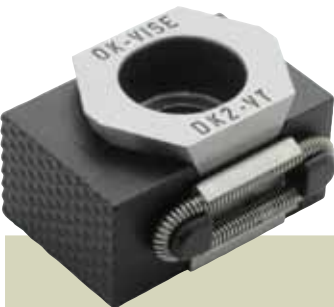
Type	A			B	C	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max									
<b>DK2-VT+5</b>	52	55	59	41	22	30	4	M12x30	55	145	235	30-34
<b>DK2-VTI+5</b>	2.04	2.16	2.32	1.61	0.86	1.18	0.15	1/2-1 1/4	55	145	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									
<b>FK2-VT+5</b>	67	70	75	56	29	42	5	M16x40	100	360	550	30-34

**Combo model: MACHINABLE & SMOOTH JAW**

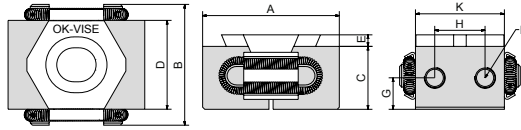


DK2-VTI+5S measures given in inches and ounces.

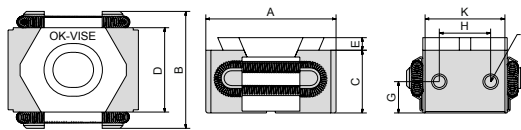
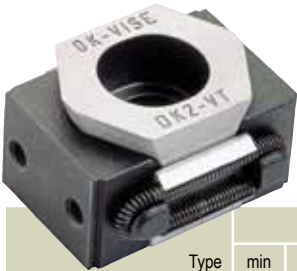
Type	G min	G opt	G max
BK2-VT+3S	16.5	17.5	18.5
DK2-VT+5S	26	27.5	29.5
DK2-VTI+5S	1.00	1.08	1.16
FK2-VT+5S	33.5	35	37.5

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										
<b>BK2-VT+3S</b>	30	32	34	29	15	21	2.5	M8x20	22	43	65	30-34	48-52
<b>DK2-VT+5S</b>	47	50	54	41	22	30	4	M12x30	55	145	210	30-34	48-52
<b>DK2-VTI+5S</b>	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
<b>FK2-VT+5S</b>	62	65	70	56	29	42	5	M16x40	100	360	500	30-34	48-52

**ADDITIONAL PIECE MODEL**

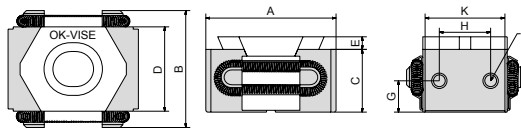


Type	A			B	C	D	E	G	H	K	L	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
	min	optimum	max													
<b>BK2-VT-T</b>	33	35	37	29	15	21	2.5	7.5	12	21	M5	M8x20	22	43	60	30-34



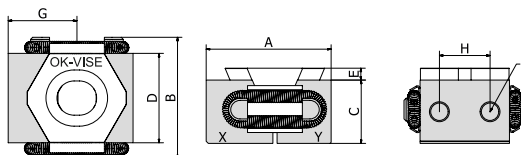
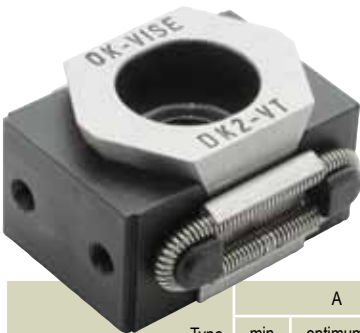
DK2-VTI-T measures given in inches and ounces.

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													
<b>DK2-VT-T</b>	46	49	53	41	22	30	4	11	18	28	M5	M12x30	55	145	200	30-34
<b>DK2-VTI-T</b>	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													
<b>FK2-VT-T</b>	61	65	69	56	29	42	5	14.5	26	40	M5	M16x40	100	360	480	30-34

**Combo model:  
ADDITIONAL PIECE & SMOOTH JAW**

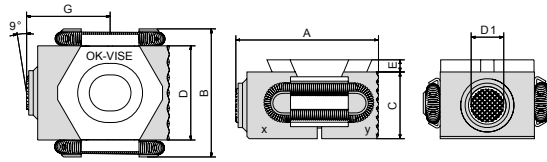


DK2-VT-TS measures given in inches and ounces.

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

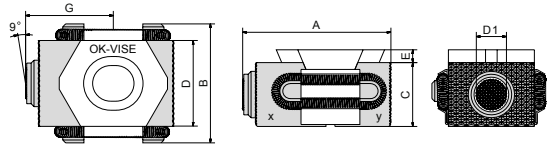
Type	A			B	C	D	E	H	K	L	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC X	Hardness of jaws HRC Y
	min	optimum	max													
<b>BK2-VT-TS</b>	30	32	34	29	15	21	2.5	12	21	M5	M8x20	22	43	62	30-34	48-52
<b>DK2-VT-TS</b>	44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

## 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										
<b>BK2-VT-B</b>	33	35	37	29	15	21	2.5	M8x20	22	43	64	30-34	48-52

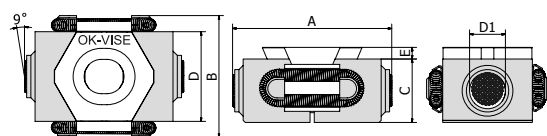
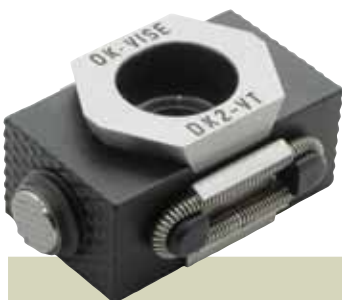


DK2-VTI-B measures given in inches and ounces.

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										
<b>DK2-VT-B</b>	52	55	59	41	22	30	4	M12x30	55	145	212	30-34	48-52
<b>DK2-VTI-B</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

## TWO SELF-ADJUSTABLE JAWS

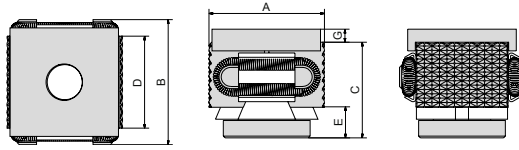


DK2-VTI+E measures given in inches and ounces.

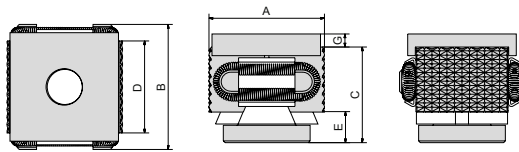
Type	Diameter of serration (D1)
BK2-VT-E	7.2
DK2-VT-E	10.7
DK2-VTI-E	0.42

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								
<b>BK2-VT-E</b>	39	41	43	29	15	21	2.5	M8x20	22	43	72
<b>DK2-VT-E</b>	62	65	69	41	44	30	4	M12x40	55	145	242
<b>DK2-VTI-E</b>	2.44	2.56	2.72	1.61	0.86	1.18	0.15	1/2-1 1/4	55	145	8.54*

## SINGLE-WEDGE PULL-DOWN, SERRATED

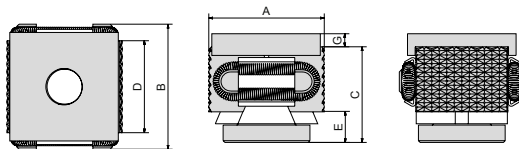


<i>Bolt not included</i>	Type	A			B	C m a x	D	E	G	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g approx.	Hardness of jaws HRC
		min	optimum	max										
	<b>BK2-VT-PD</b>	27	29	31	29	22	21	7	3	M8x20	25	44	68	48-52



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

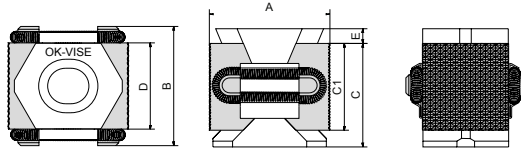
<i>Bolt not included</i>	Type	A			B	C m a x	D	E	G	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
		min	optimum	max										
	<b>DK2-VT-PD</b>	42	45	49	41	32	30	10	4	M12x60	65	145	270	48-52
	<b>DK2-VTI-PD</b>	1.65	1.77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



<i>Bolt not included</i>	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										
	<b>FK2-VT-PD</b>	57	61	65	56	40.5	42	11.5	5	M16x60	110	360	620	48-52



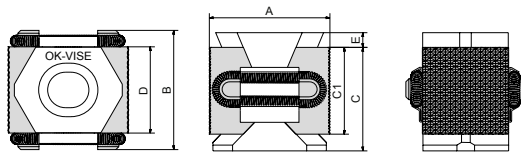
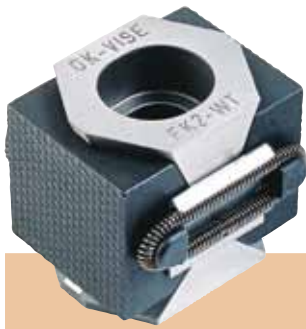
## DOUBLE-WEDGE PULL-DOWN, SERRATED



max 9 tons!

DK2-WT1 measures given in inches and ounces.

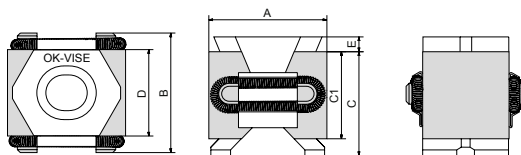
Type	A			B	C max	C1	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max										
<b>DK2-WT</b>	42	46	49	41	36	30	30	5	M12x40	90	145	275	48-52
<b>DK2-WT1</b>	1.65	1.81	1.92	1.61	1.41	1.18	1.18	0.19	1/2-1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



max 15 tons!

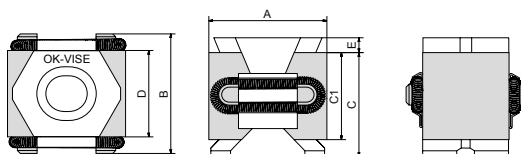
Type	A			B	C max	C1	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max										
<b>FK2-WT</b>	58	61	66	56	50	42	52	5	M16x60	150	360	730	48-52

## 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										
<b>DK2-WT-S</b>	41	45	48	41	36	30	30	5	M12x40	90	145	275	48-52
<b>DK2-WT1-S</b>	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

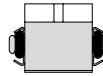
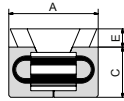
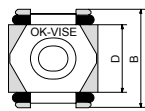


Type	A			B	C max	C1	D	E	Socket Head Screw DIN 912	Pressing force of Jaws, kN max	Tightening torque, Nm max	Weight in g (*oz) approx.	Hardness of jaws HRC
	min	optimum	max										
<b>FK2-WT-S</b>	58	61	66	56	50	42	52	5	M16x60	150	360	730	48-52

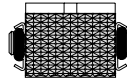
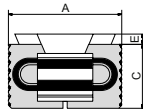
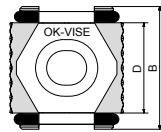
## ECONOMY SERIES

The cost efficient choice!

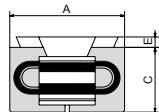
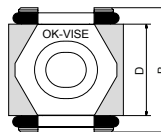
These models meet the demands of workholding when ultra precision and high clamping force are not necessary. They are made of the same raw material as our other models, and the bottom of the jaws are ground for precise positioning on the fixture base. AK2-VT-SO always comes with Viton o-rings.



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									
<b>AK2-VT-SO</b>	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									
<b>BK2-VT-O</b>	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									
<b>BK2-VT-SO</b>	28	30	32	29	15	21	3.5	M8x20	15	25	55	48-52