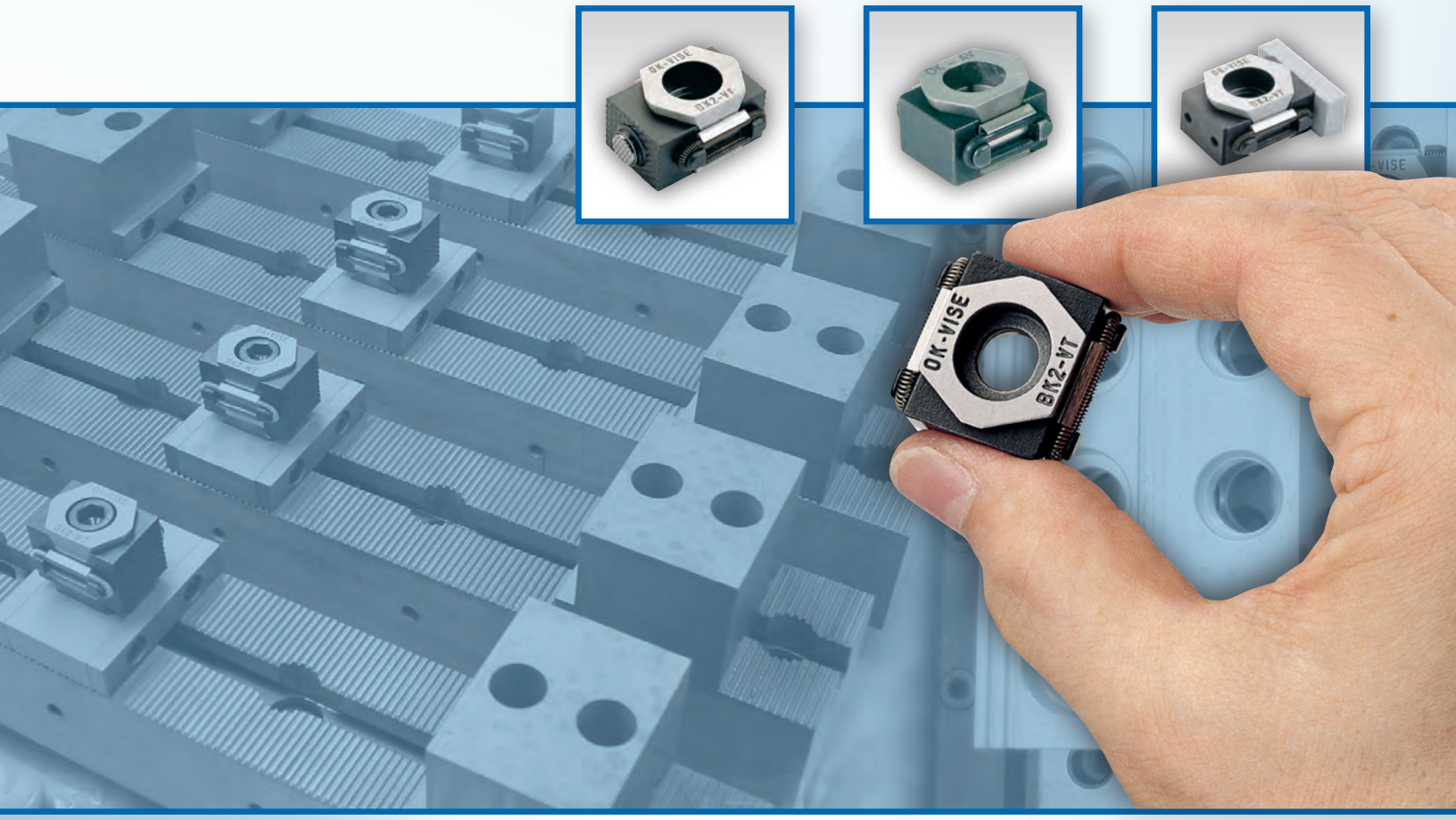
Jergens® / OK-VISE®

WORKHOLDING CLAMPS AND ACCESSORIES

SMALL IN SIZE – GIANT IN PERFORMANCE



WORKHOLDING SOLUTIONS | SPECIALTY FASTENERS | LIFTING SOLUTIONS

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Jergens®
MANUFACTURING EFFICIENCY

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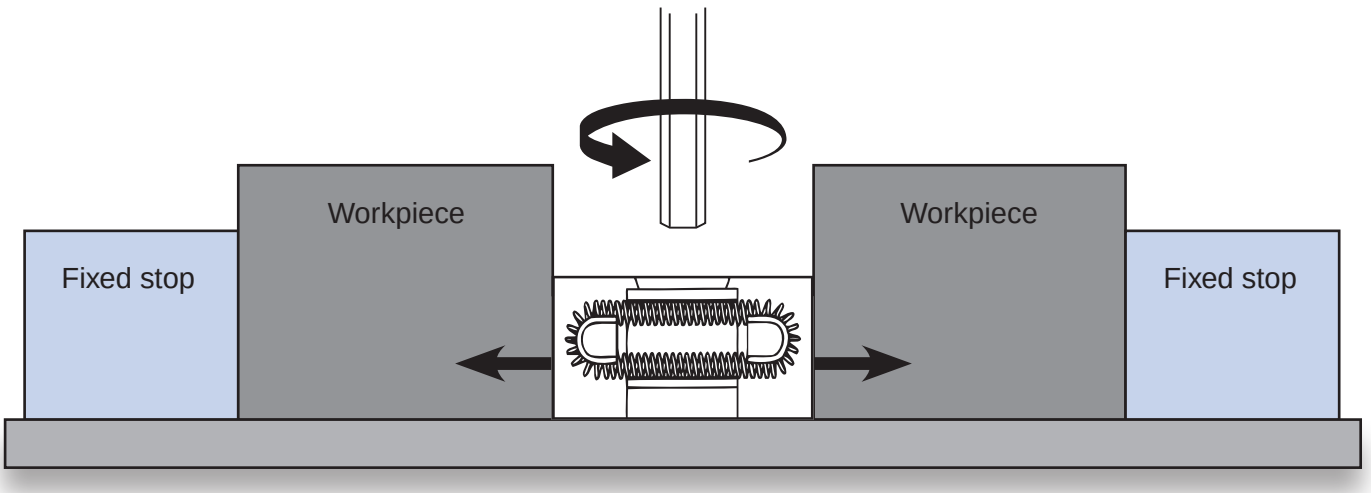
Operating Principle

Jergens/OK-VISE low-profile clamps function on the principle that when tightened down they expand, simultaneously pressing the workpieces against the solid stops and preventing any possibility of play. These clamps are designed to fit between the workpieces and take very little space on the fixture plate. Small in size, yet possessing an excellent clamping force up to 150 kN, these clamps exert a holding force which 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 investment other than fixed stops 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 thru hardened. The clamping operation involves one bolt (M5-M16) ensuring quick set up times.

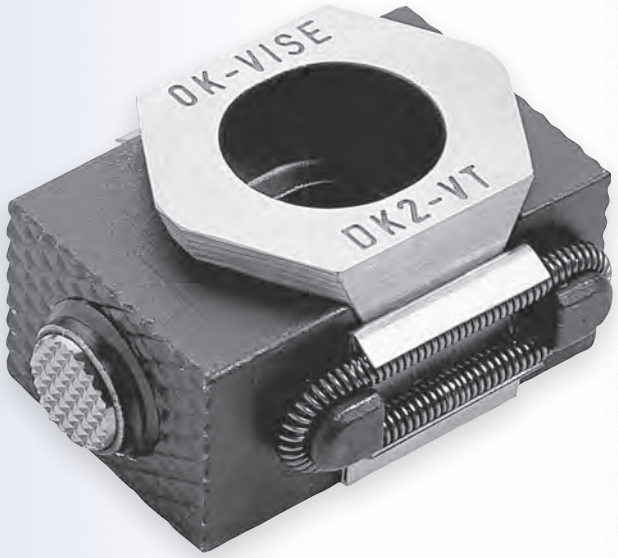
Jergens/OK-VISE low-profile clamps come in two basic models, one with a single-wedge construction and the other with a double-wedge construction that creates a pull-down action. We also offer a line of machinable jaw models for workpieces of irregular shape and a special models for castings and wire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



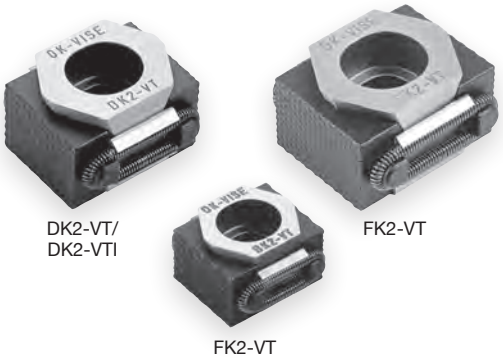
Jergens® / OK•VISE®

WORKHOLDING CLAMPS AND ACCESSORIES

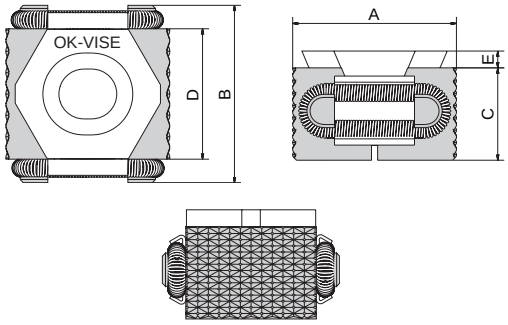
OK•VISE Fixtures



Serrated Jaw Clamp



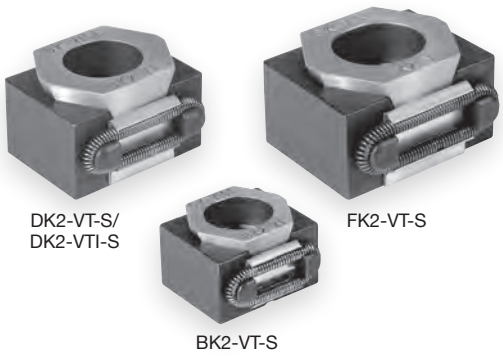
General-purpose clamps for your shop. Serration creates high friction, which ensures reliable clamping in any circumstances.



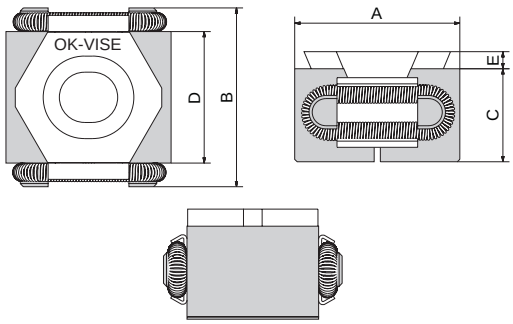
Part Number	A			B	C	D	E	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC
	Min	Optimum	Max									
BK2-VT	27	29	31	29	15	21	2.5	M8x20	25 (5620)	44 (32.4)	55 (0.12)	48-52
DK2-VT	42	45	49	41	22	30	4	M12x30	65 (14,612)	145 (107)	180 (0.4)	48-52
DK2-VTI*	1.65	1.77	1.92	1.61	0.86	1.18	0.15	1/2-13 X 1 1/4"	65 (14,612)	145 (107)	0.4	48-52
FK2-VT	57	61	65	56	29	42	5	M16x40	110 (24,729)	360 (265)	465 (1.03)	48-52

*DK2-VTI measures given in inches and pounds.

Smooth Jaw Clamp



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

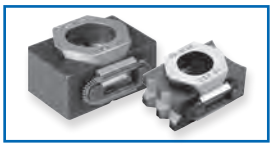


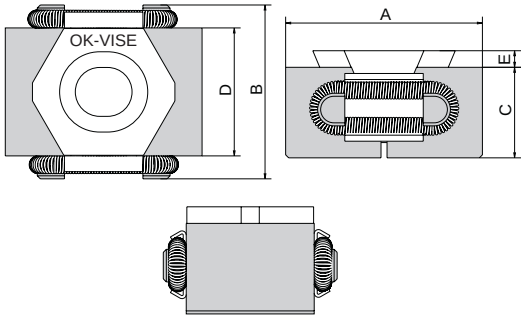
Part Number	A			B	C	D	E	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC
	Min	Optimum	Max									
BK2-VT-S	27	29	31	29	15	21	2.5	M8x20	25 (5620)	44 (32.4)	55 (0.12)	48-52
DK2-VT-S	42	45	49	41	22	30	4	M12x30	65 (14,612)	145 (107)	180 (0.4)	48-52
DK2-VTI-S*	1.65	1.77	1.92	1.61	0.86	1.18	0.15	1/2-13 X 1 1/4"	65 (14,612)	145 (107)	0.4	48-52
FK2-VT-S	57	60	64	56	29	42	5	M16x40	110 (24,729)	360 (265)	465 (1.03)	48-52

*DK2-VTI-S measures given in inches and pounds.

Machinable Jaw Clamp

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.

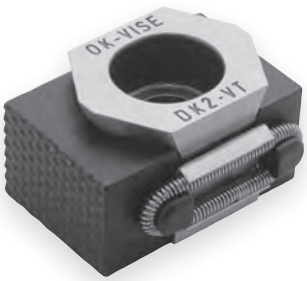


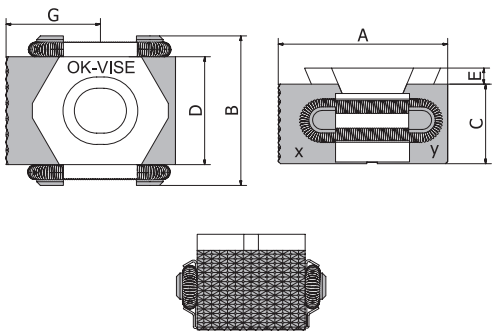


Part Number	A			B	C	D	E	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC
	Min	Optimum	Max									
BK2-VT+3	33	35	37	29	15	21	2.5	M8x20	25 (5620)	43 (31.7)	70 (0.16)	30-34
DK2-VT+5	52	55	59	41	22	30	4	M12x30	55 (12,364)	145 (107)	235 (0.52)	30-34
DK2-VTI+5*	2.04	2.16	2.32	1.61	0.86	1.18	0.15	1/2-13 X 1 1/4"	55 (12,364)	145 (107)	0.52	30-34
FK2-VT+5	67	70	75	56	29	42	5	M16x40	100 (22,480)	360 (265)	550 (1.21)	30-34

*DK2-VTI+5 measures given in inches and pounds.

Machinable & Smooth Jaw Clamp



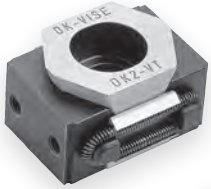


Part Number	A			G			B	C	D	E	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC X	Hardness of Jaws HRC Y
	Min	Optimum	Max	Min	Optim um	Max										
BK2-VT+3S	30	32	34	16.5	17.5	18.5	29	15	21	2.5	M8x20	22 (4,975)	43 (31.7)	65 (0.14)	30-34	48-52
DK2-VT+5S	47	50	54	26	27.5	29.5	54	22	30	4	M12x30	55 (12,364)	145 (107)	210 (0.46)	30-34	48-52
DK2-VTI+5S*	1.85	1.97	2.12	1.00	1.08	1.16	1.61	0.86	1.18	0.15	1/2-13 X 1 1/4"	55 (12,364)	145 (107)	0.52	30-34	48-52
FK2-VT+5S	62	65	70	33.5	35	37.5	56	29	42	5	M16x40	100 (22,480)	360 (265)	500 (1.21)	30-34	48-52

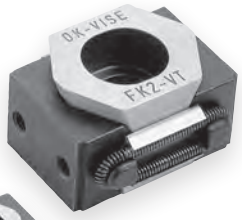
*DK2-VTI+5S measures given in inches and pounds.

Jergens WORKHOLDING SOLUTIONS GROUP

Mounting Jaw Clamp



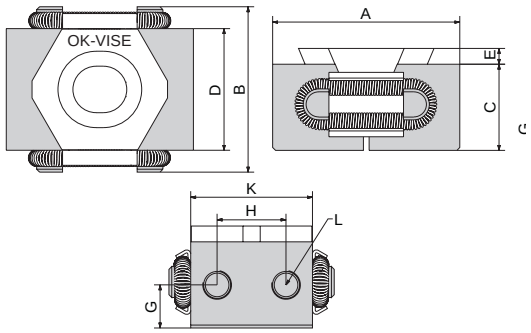
DK2-VT-T/
DK2-VTI-T



FK2-VT-T

BK2-VT-T

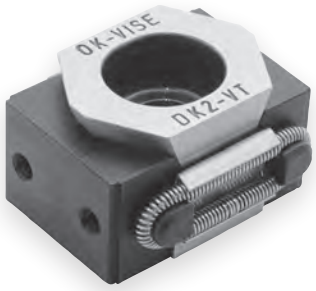
Additional piece models have machined female threadings (M5) for socket head screws on the side of the jaw, making it quick and easy to use various additional pieces which can also be machined into different shapes.

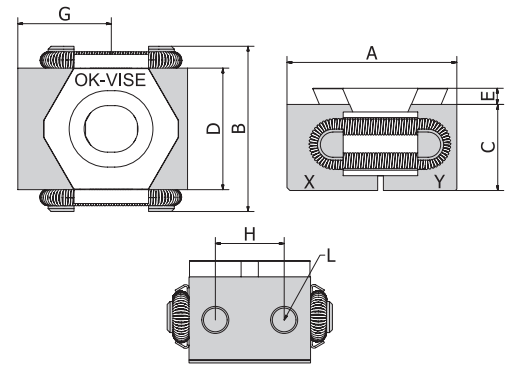


Part Number	A			B	C	D	E	G	H	K	L	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC
	Min	Optimum	Max													
BK2-VT-T	33	35	37	29	15	21	2.5	7.5	12	21	4xM5	M8x20	22 (4,975)	43 (31.7)	60 (0.13)	30-34
DK2-VT-T	46	49	53	41	22	30	4	11	18	28	4xM5	M12x30	55 (12,364)	145 (107)	200 (0.44)	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	4xM5	1/2-13 X 1 1/4"	55 (12,364)	145 (107)	7.05	30-34
FK2-VT-T	61	65	70	56	29	42	5	14.5	26	40	4xM5	M16x40	100 (22,480)	360 (265)	480 (1.06)	30-34

*DK2-VTI-T measures given in inches and pounds.

Mounting & Smooth Jaw Clamp





Part Number	A			G			B	C	D	E	H	K	L	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC X	Hardness of Jaws HRC Y
	Min	Optimum	Max	Min	Optimum	Max													
BK2-VT-TS	30	32	34	16.5	17.5	18.5	29	15	21	2.5	12	21	4xM5	M8x20	22 (4,975)	43 (31.7)	62 (0.14)	30-34	48-52
DK2-VT-TS	47	50	54	23	24.5	26.5	41	22	30	4	18	28	4xM5	M12x30	55 (12,364)	145 (107)	192 (0.42)	30-34	48-52
DK2-VTI-TS*	1.85	1.97	2.12	0.90	0.96	1.05	1.61	0.86	1.18	0.15	0.7	1.1	4xM5	1/2-13 X 1 1/4"	55 (12,364)	145 (107)	6.8	30-34	48-52
FK2-VT-TS	62	65	70	30.5	32.5	35	56	29	42	5	26	40	4xM5	M16x40	100 (22,480)	360 (265)	475 (1.05)	30-34	48-52

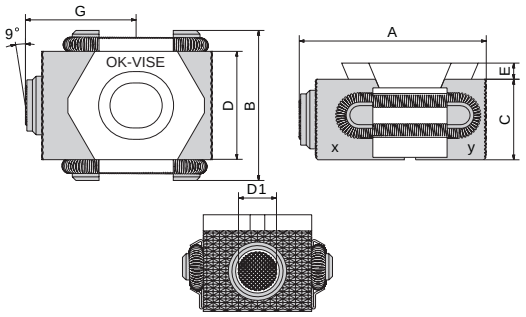
*DK2-VT-TS measures given in inches and pounds.

Self-Adjustable Jaw Clamp

DK2-VT-B/
DK2-VTI-B

BK2-VT-B

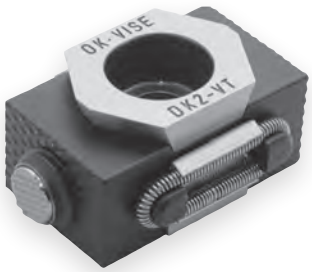
These clamps have a self-adjustable ball gripper screw inserted into a clamp jaw. The ball bearing at the end is made of steel and equipped with torsion protection, allowing the ball to self-adjust up to 9 degrees. This makes clamping irregular-shaped parts and castings more flexible

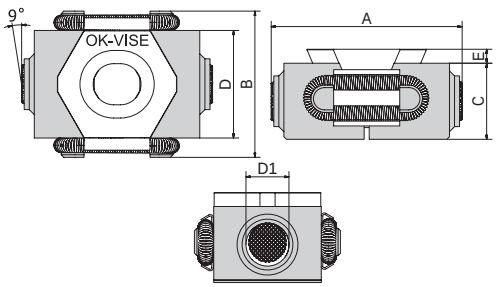


Part Number	A			G			B	C	D	E	Dia. of Serration (D1)	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC X	Hardness of Jaws HRC Y
	Min	Optimum	Max	Min	Optimum	Max											
BK2-VT-B	33	35	37	19.5	20.5	21.5	29	15	21	2.5	7.2	M8x20	22 (4,975)	43 (31.7)	64 (0.14)	30-34	48-52
DK2-VT-B	52	55	59	31	32.5	34.5	41	22	30	4	10.7	M12x30	55 (12,364)	145 (107)	212 (0.41)	30-34	48-52
DK2-VTI-B*	2.04	2.16	2.32	1.22	1.27	1.35	1.61	0.86	1.18	0.15	0.42	1/2-13 X 1 1/4"	55 (12,364)	145 (107)	0.46	30-34	48-52

*DK2-VTI-B measures given in inches and pounds.

Two Self-Adjustable Jaw Clamp





Part Number	A			B	C	D	E	Dia. of Serration (D1)	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC X	Hardness of Jaws HRC Y
	Min	Optimum	Max											
BK2-VT-E	39	41	43	29	15	21	2.5	7.2	M8x20	22 (4,975)	43 (31.7)	72 (0.16)	30-34	48-52
DK2-VT-E	62	65	69	41	44	30	4	10.7	M12x30	55 (12,364)	145 (107)	242 (0.54)	30-34	48-52
DK2-VTI-E*	2.44	2.56	2.72	1.61	0.86	1.18	0.15	0.42	1/2-13 X 1 1/4"	55 (12,364)	145 (107)	0.53	30-34	48-52

*DK2-VT+E measures given in inches and pounds.

Jergens WORKHOLDING SOLUTIONS GROUP

Single-Wedge Pull-Down, Serrated Clamp

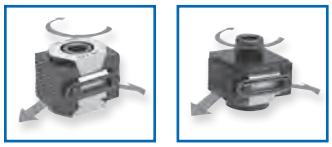
DK2-VT-PD/
DK2-VTI-PD

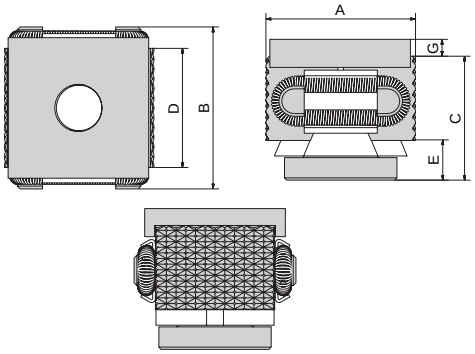
FK2-VT-PD

BK2-VT-PD

Bolt not included

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

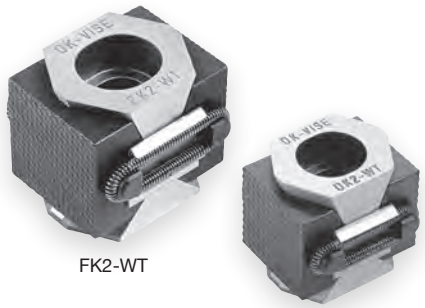




Part Number	A			B	C	D	E	G	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC
	Min	Optimum	Max										
BK2-VT-PD	27	29	31	29	22	21	7	3	M8x20	25 (5620)	44 (32.4)	68 (0.15)	48-52
DK2-VT-PD	42	45	49	41	32	30	10	4	M12x30	65 (14,612)	145 (107)	270 (0.60)	48-52
DK2-VTI-PD*	1.65	1.77	1.93	1.61	1.26	1.18	0.39	0.16	1/2	65 (14,612)	145 (107)	0.60	48-52
FK2-VT-PD	57	61	65	56	40.5	42	11.5	5	M16x40	110 (24,729)	360 (265)	620 (1.37)	48-52

*DK2-VTI-PD measures given in inches and pounds.

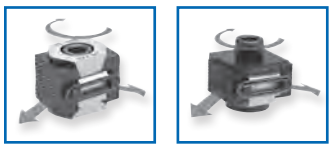
Double-Wedge Pull-Down, Serrated Clamp

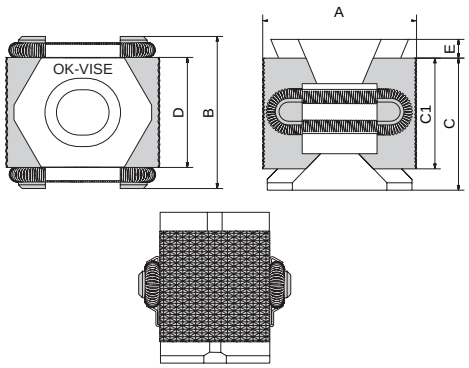


FK2-WT

DK2-WT/
DK2-WTI

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

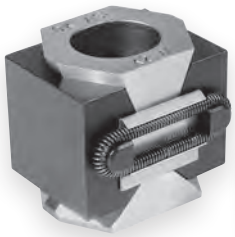




Part Number	A			B	C	C1	D	E	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC
	Min	Optimum	Max										
DK2-WT	42	46	49	41	36	30	30	5	M12x40	90 (20,232)	145 (107)	275 (0.61)	48-52
DK2-WTI*	1.65	1.81	1.92	1.61	1.41	1.18	1.18	0.19	1/2-13 X 1 3/4"	90 (20,232)	145 (107)	0.61	48-52
FK2-WT	58	61	66	56	50	–	52	5	M16x60	150 (33,721)	360 (265)	730 (1.61)	48-52

*DK2-WTI measures given in inches and pounds.

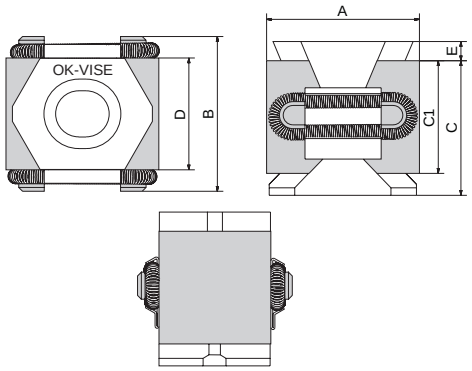
Double-Wedge Pull-Down, Smooth Clamp



FK2-WT-S

DK2-WT-S/
DK2-WTI-S

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



Part Number	A			B	C	C1	D	E	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC
	Min	Optimum	Max										
DK2-WT-S	41	45	48	41	36	30	30	5	M12x40	90 (20,232)	145 (107)	275 (0.61)	48-52
DK2-WTI-S*	1.61	1.77	1.88	1.61	1.41	1.18	1.18	0.19	1/2-13 X 1 3/4"	90 (20,232)	145 (107)	0.61	48-52
FK2-WT-S	58	61	66	56	50	–	52	5	M16x60	150 (33,721)	360 (265)	730 (1.61)	48-52

*DK2-WTI-S measures given in inches and pounds.

Economy Clamp

BK-VT-O

BK2-VT-SO

AK2-VT-SO

The cost efficient choice!

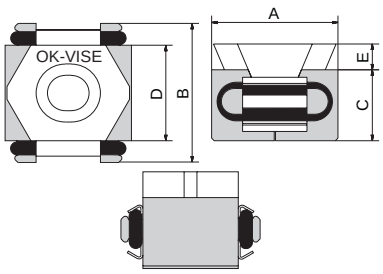
These models meet the demands of workholding when ultra precision and high clamping force are not necessary. They are made of the same raw material as our other models, and the bottom of the jaws are ground for precise positioning on the fixture base. AK2-VT-SO always comes with Viton o-rings.

Only the bottom of the jaw is ground. Only our two smallest series clamps are available in the economy model (AK2-VT-SO).

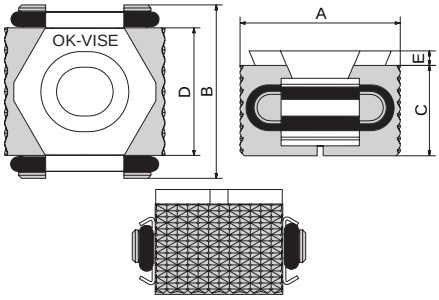
Part Number	A			B	C	D	E	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (*lbs) approx.	Hardness of Jaws HRC
	Min	Optimum	Max									
AK2-VT-SO	20	23	25	22	11	15	4.2	M5x25	10 (2,248)	10 (7.4)	22 (0.05)	48-52
BK-VT-O	27	29	31	29	15	21	2.5	M8x20	15 (3,372)	25 (18.4)	55 (0.12)	48-52
BK2-VT-SO	27	29	31	29	15	21	2.5	M8x20	15 (3,372)	25 (18.4)	55 (0.12)	48-52

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

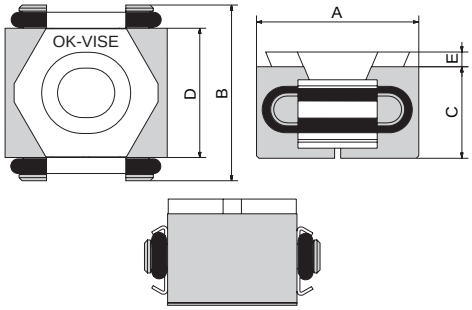
AK2-VT-SO



BK-VT-O



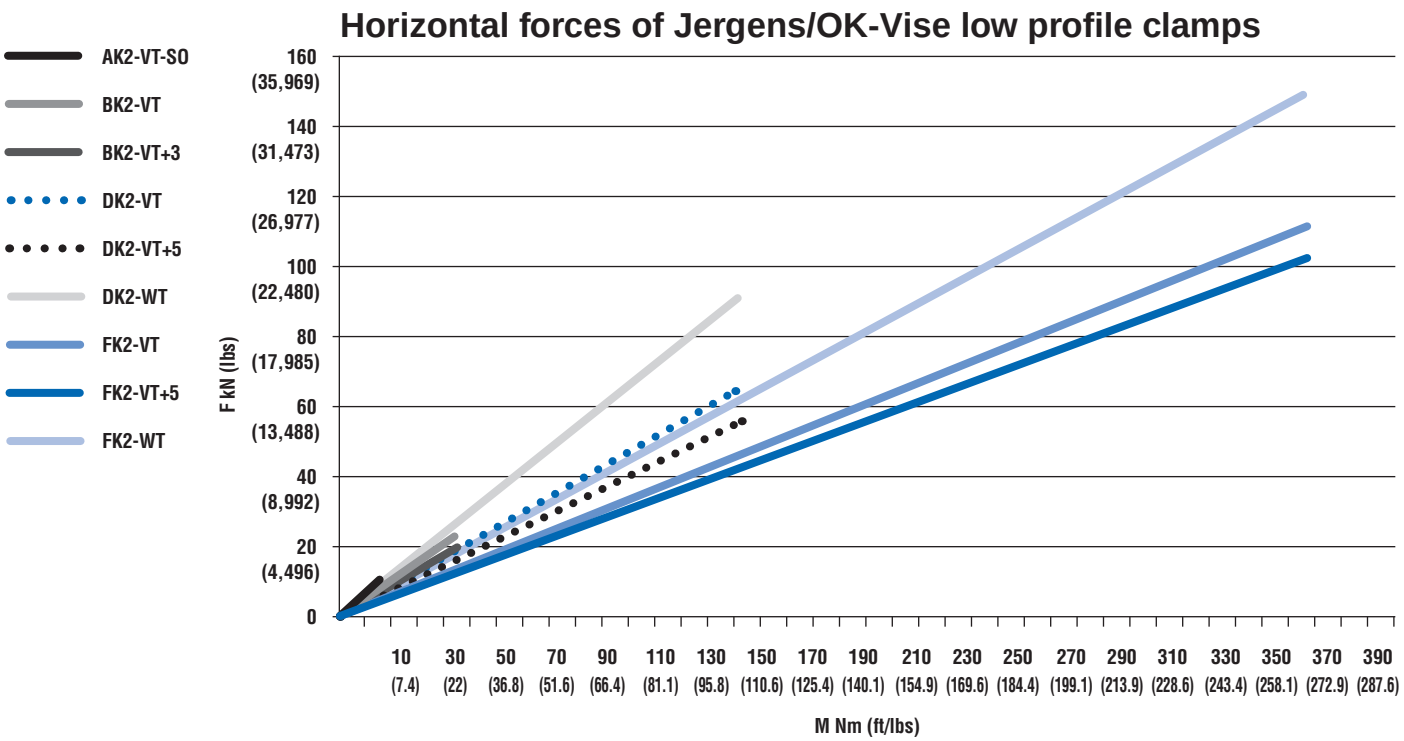
BK2-VT-SO



Low-Profile Clamps

Size	A	B	D	D (In)	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
Mounting jaw model	–	BK2-VT-T	DK2-VT-T	DK2-VTI-T	FK2-VT-T
Mounting jaw 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	–	–	21
Economy-series, serrated	–	BK2-VT-O	–	15	21
Economy-series, smooth	AK2-VT-SO	BK2-VT-SO	29	15	21
Metric bolt	M5	M8	M12	–	M16
Imperial bolt	3/16"	5/16"	–	1/2"	5/8"
Force up to kN (lbs)	10 (2,248)	25 (5,620)	90 (20,232)	90 (20,232)	150 (33,721)

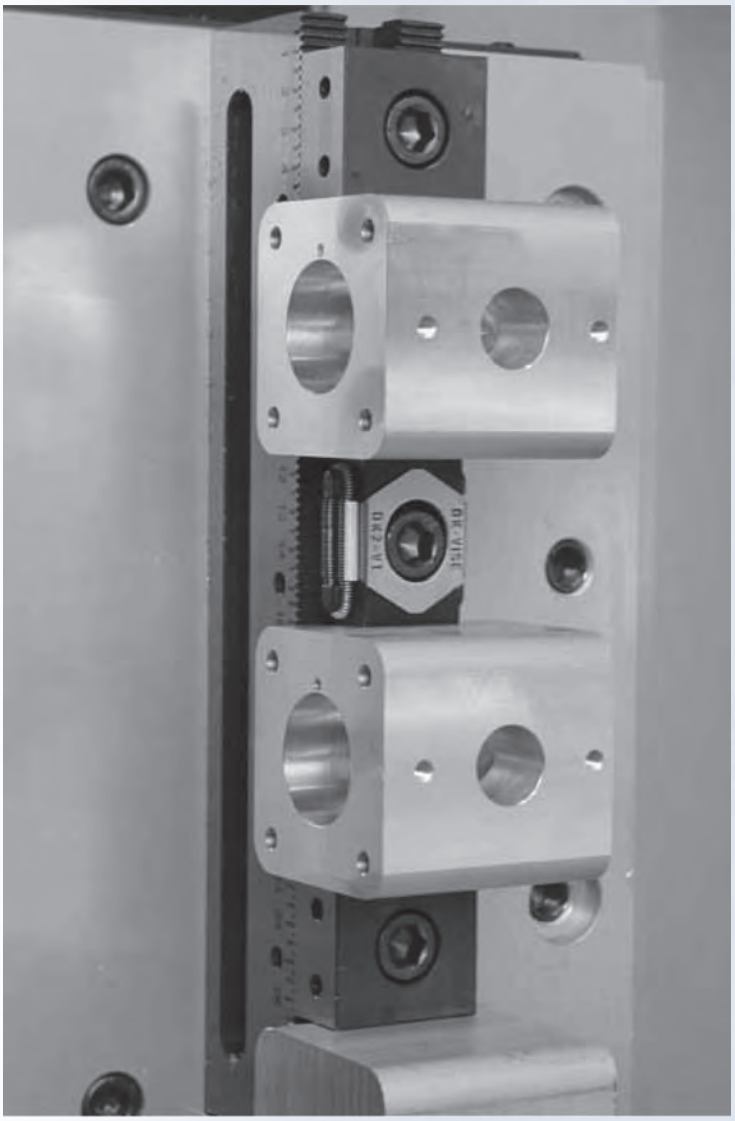
Clampforces



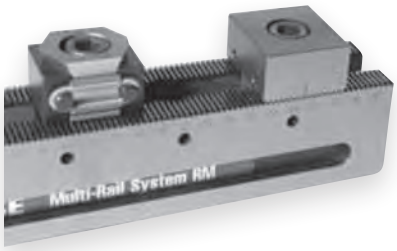
MULTI-RAIL RM SYSTEM

Jergens® / OK-VISE®

WORKHOLDING CLAMPS AND ACCESSORIES



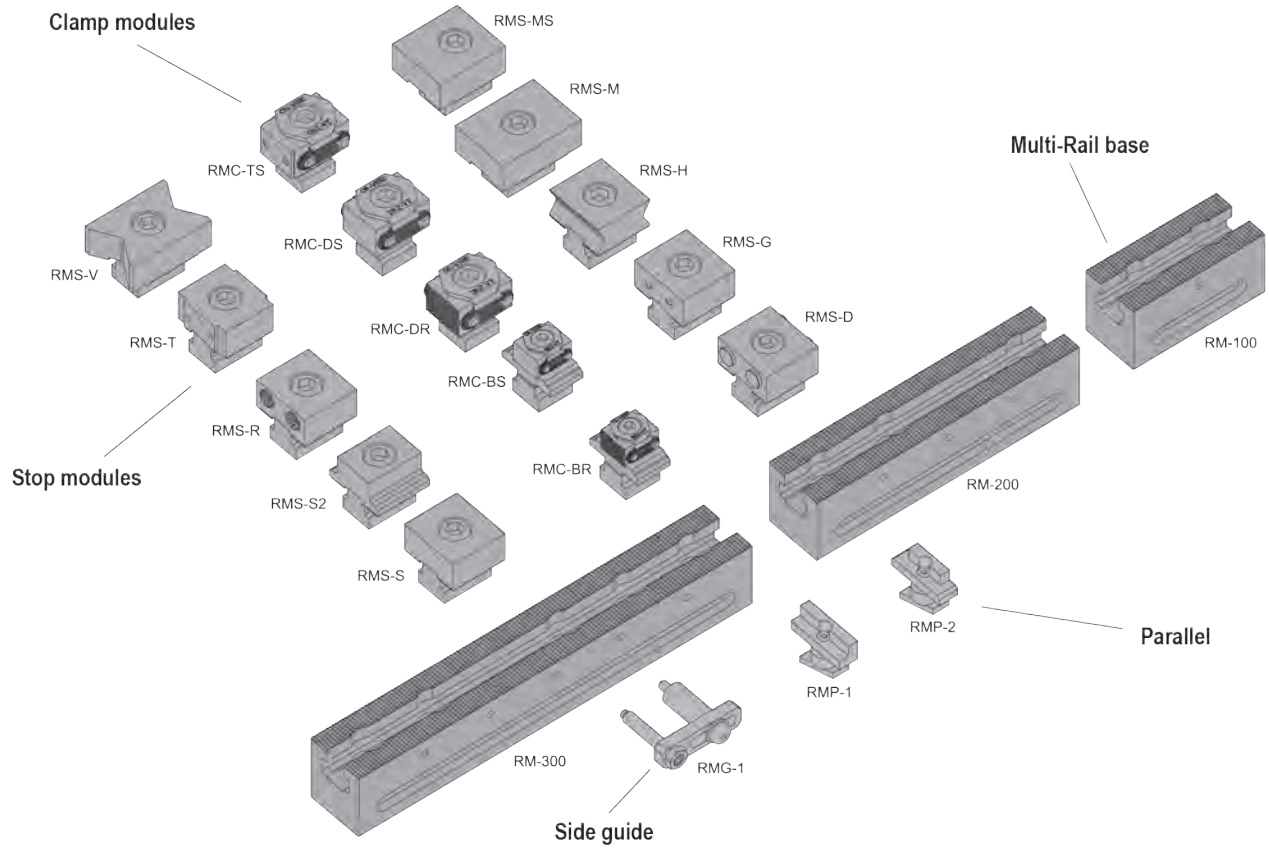
Multi-Rail RM System

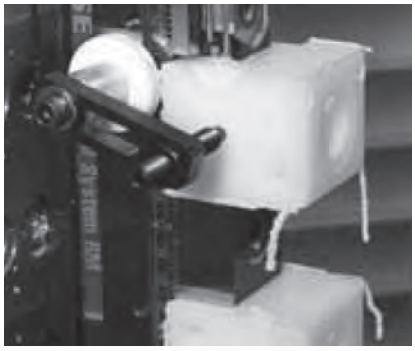


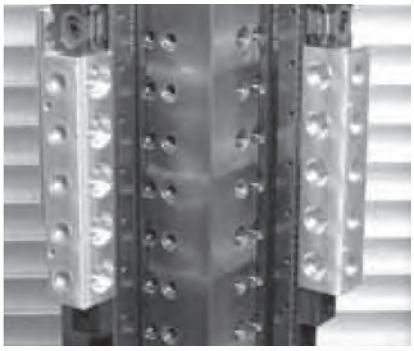
Multi-Rail is the new generic-purpose workholding system of Jergens/OK-VISE. Compared to a traditional machine vise, the Multi-Rail system offers the following benefits:

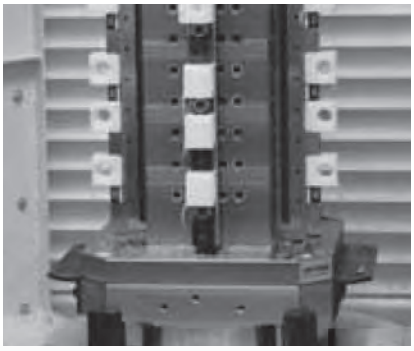
- Using the components of the system, even the most challenging workpiece types can be machined
- All sides of a workpiece can be machined with two setups
- Multiple workpieces can be clamped on the same area
- Workpiece will be safely fixtured
- It is also possible to clamp very large work pieces

Multi-Rail RM System Components

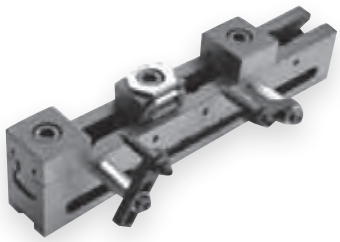






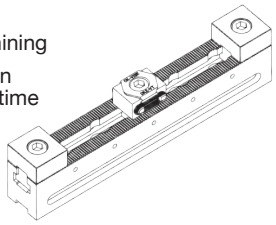


SRM-132GD1



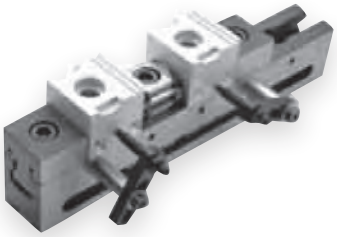
To make selection of the components easier, the Jergens/OK-Vise team has selected some basic sets to enable an easy start with the Multi-Rail system. In the pictures below you can see some solutions done with each set.

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

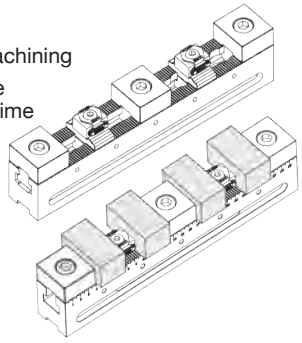


Code	Name	Pcs
RM-300	Multi-Rail Base	1
RMS-S	Stop Module Smooth	2
RMC-DS	Clamp Module D Smooth	1

SRM-132GD1

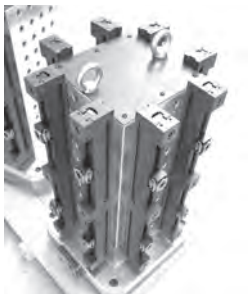


- For three-directional machining
- Four workpieces can be machined at the same time

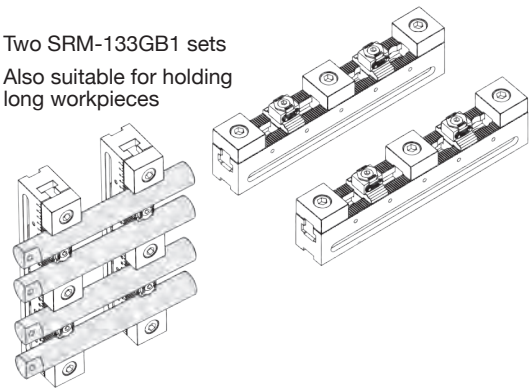


Code	Name	Pcs
RM-300	Multi-Rail Base	1
RMS-S	Stop Module Smooth	3
RMC-BS	Clamp Module B Smooth	2

SRM-236GB1

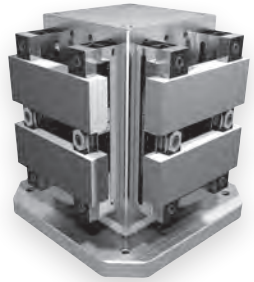


- Two SRM-133GB1 sets
- Also suitable for holding long workpieces

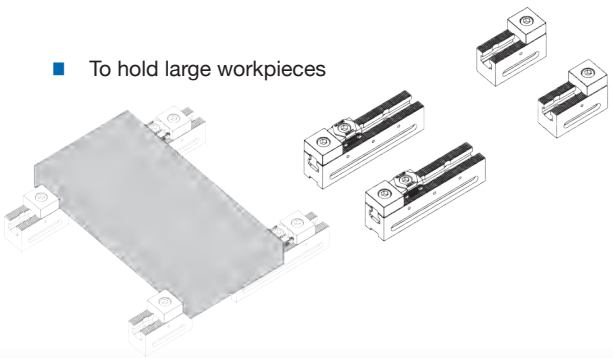


Code	Name	Pcs
RM-300	Multi-Rail Base	2
RMS-S	Stop Module Smooth	6
RMC-BS	Clamp Module B Smooth	4

SRM-4C4GD1

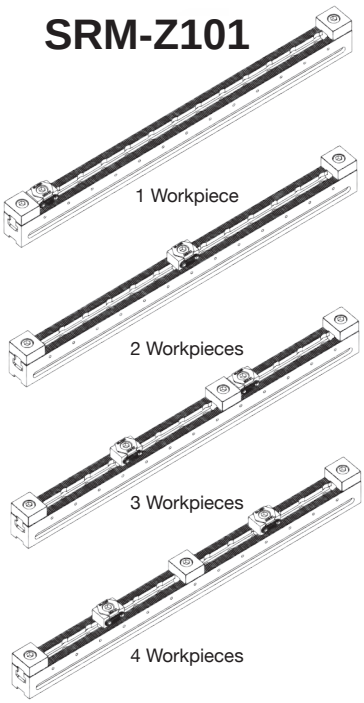


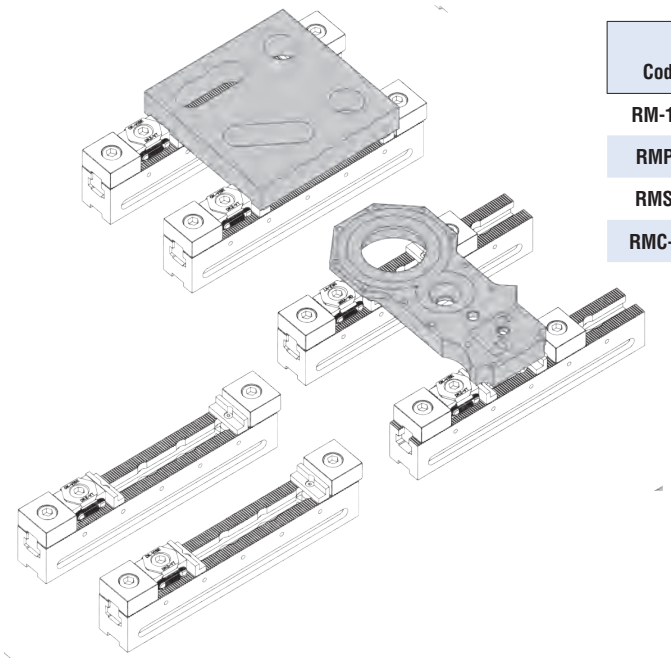
- To hold large workpieces



Code	Name	Pcs
RM-100	Multi-Rail Base	2
RM-200	Multi-Rail Base	2
RMC-DS	Clamp Module D Smooth	2
RMC-S	Stop Module Smooth	4

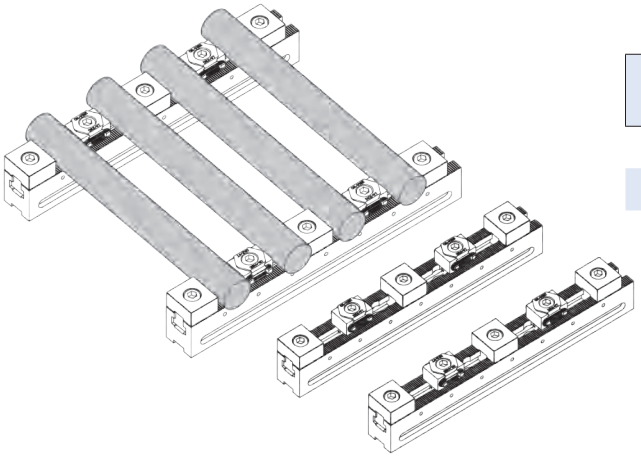
SRM-Z101





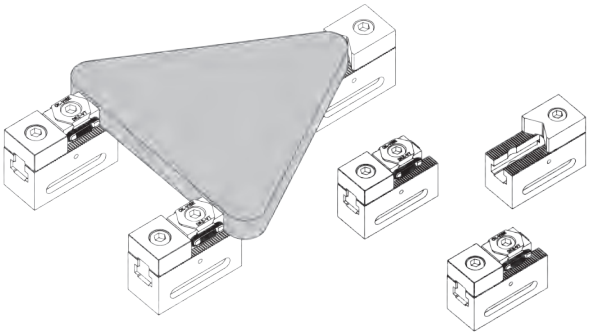
Code	Name	Pcs
RM-100	Multi-Rail Base	2
RMP-1	Parallel Block	4
RMS-S	Stop Module Smooth	4
RMC-DS	Clamp Module D Smooth	2

SRM-Z102



Code	Name	Pcs
RM-300	Multi-Rail Base	2
RMS-S	Stop Module Smooth	6
RMC-DS	Clamp Module D Smooth	4

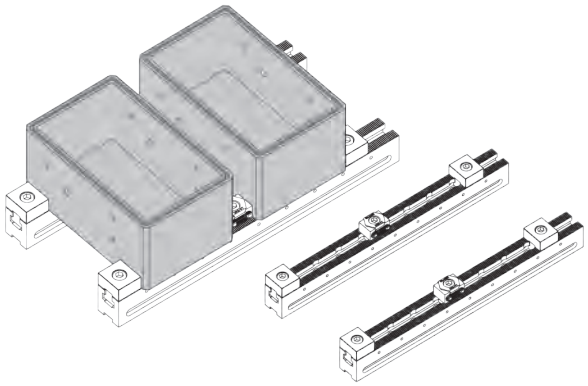
SRM-Z103



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

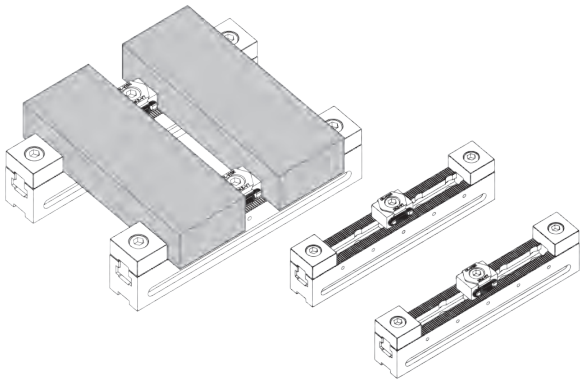
Jergens WORKHOLDING SOLUTIONS GROUP

SRM-Z105



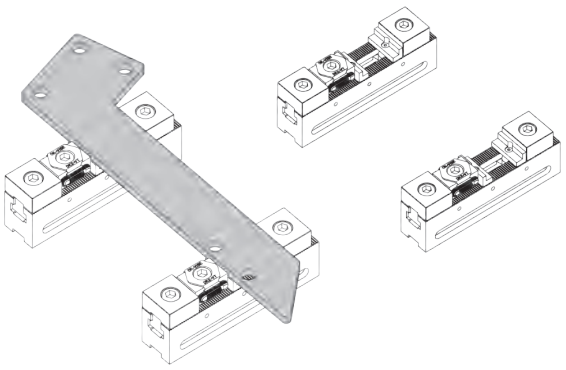
Code	Name	Pcs
RM-S	Stop Module Smooth	4
RMC-DS	Clamp Module Smooth	2
RM-500	Multi-Rail Base	2

SRM-Z106



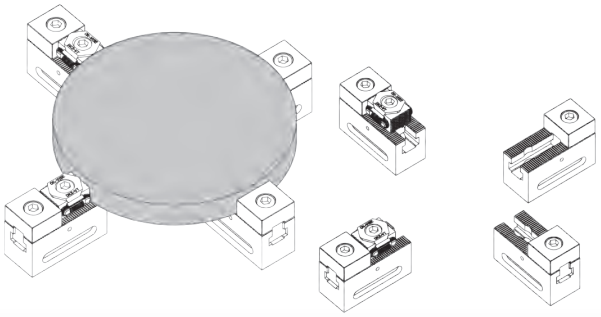
Code	Name	Pcs
RM-300	Multi-Rail Base	2
RMS-S	Stop Module Smooth	4
RMC-DS	Clamp Module Smooth	2

SRM-Z107



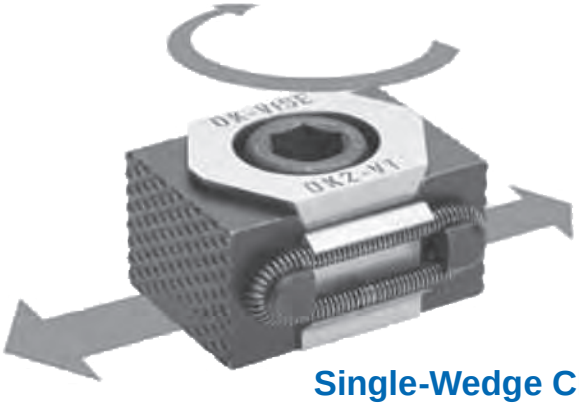
Code	Name	Pcs
RM-200	Multi-Rail Base	2
RMS-S	Stop Module Smooth	4
RMC-DS	Clamp Module Smooth	2
RMP-1	Parallel Block	4

SRM-Z108



Code	Name	Pcs
RM-100	Multi-Rail Base	4
RMS-S	Stop Module Smooth	4
RMC-DS	Clamp Module Smooth	2

Basic Modules

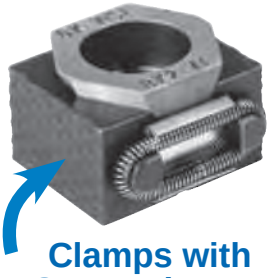


Single-Wedge Clamp

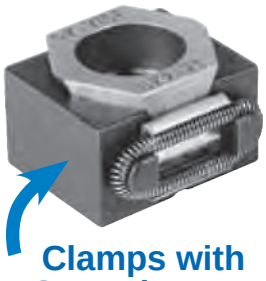
Jergens/OK-Vise low-profile clamps are the core components of our Multi-Rail system. Our low-profile clamps are available with various jaw types. In the Multi-Rail RM system, clamps of sizes D and B can be used.

Multi-Rail RM sets are built using few basic modules:

- Clamp modules
- Stop modules
- Side guides
- Paralles and riser blocks



Clamps with Serrated Jaws



Clamps with Smooth Jaws

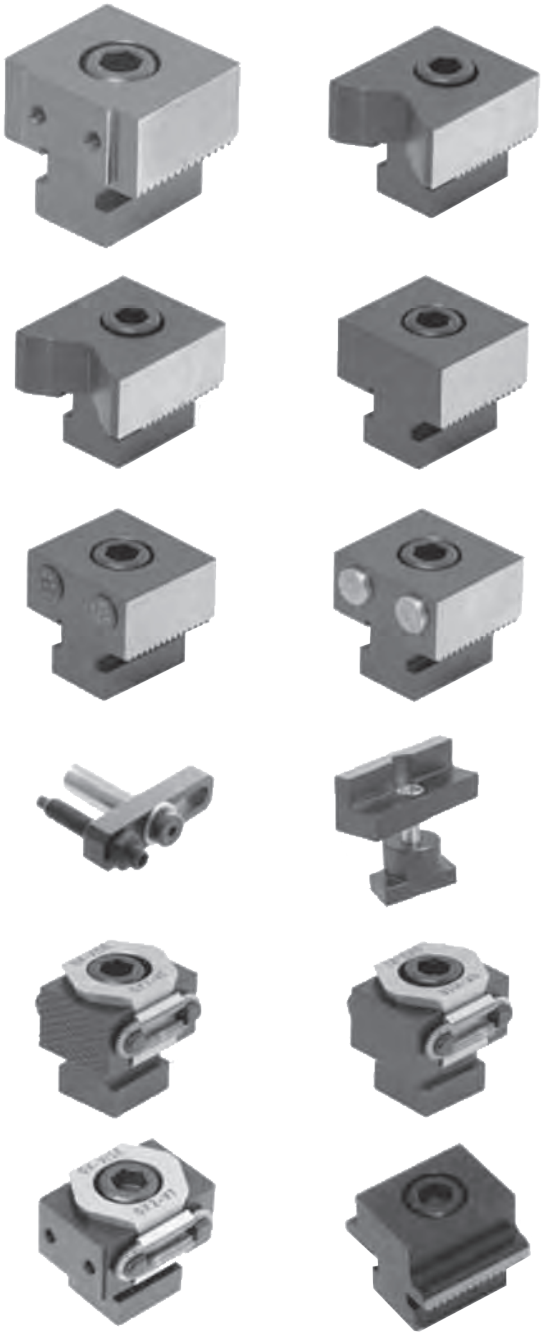
Pull-Down Models

- Double Wedge
- Single Wedge

Clamps with Machinable Jaws

Additional Piece Models

Clamps with Self-Adjustable Jaws



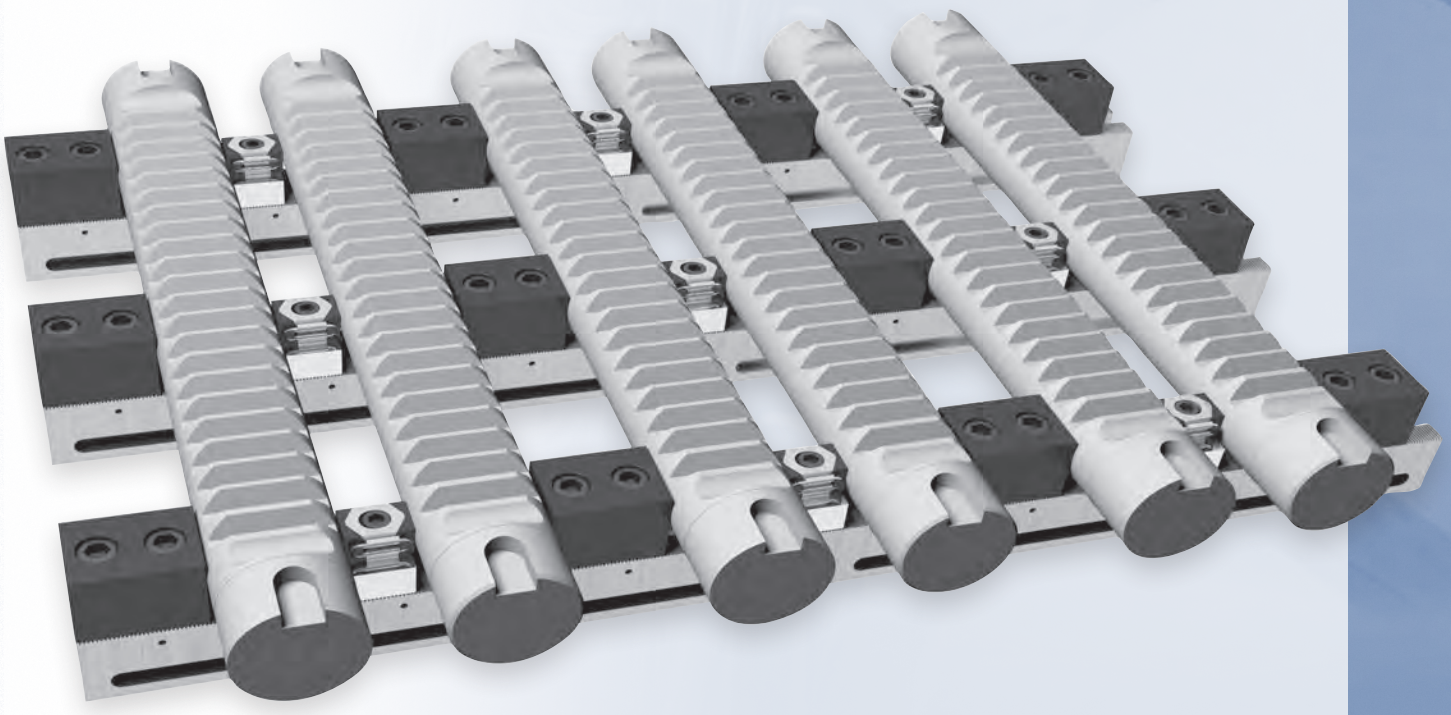
Jergens® / OK-VISE®
WORKHOLDING CLAMPS AND ACCESSORIES

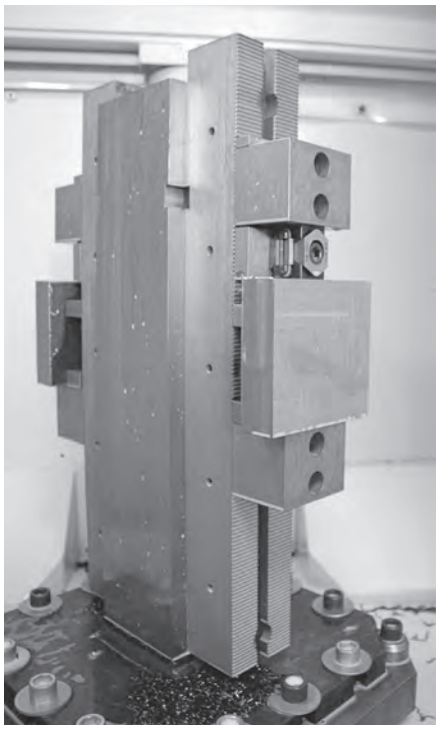
Multi-Rail RH System

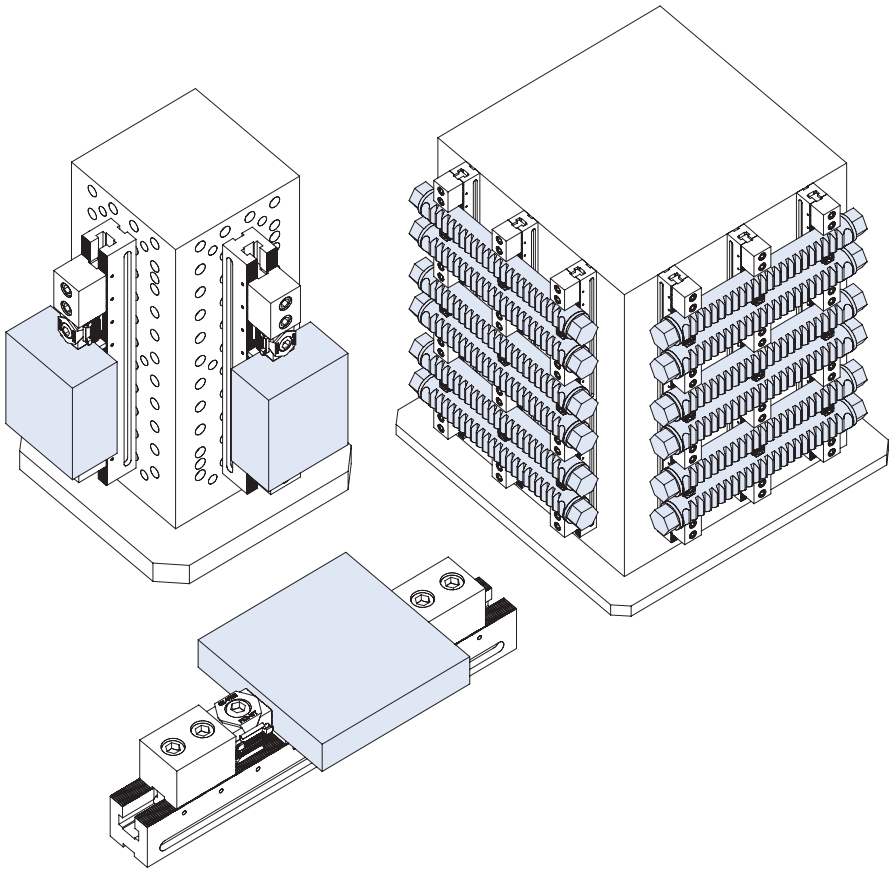
Multi-Rail RH is the new generic-purpose fixturing system from Jergens/OK-VISE. Multi-Rail RH is optimal when the clamping force is over 4 tons and also when the work pieces are rather big.

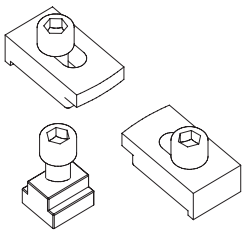
Fixture Sets
To make selection of the components easier, the Jergens/OK-VISE team has created some basic sets to enable an easy start with the Multi-Rail system. Compared to a traditional machine vise, the Multi-Rail RH system offers the following benefits:

- 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 circumstances.
- It is also possible to clamp very large work pieces.





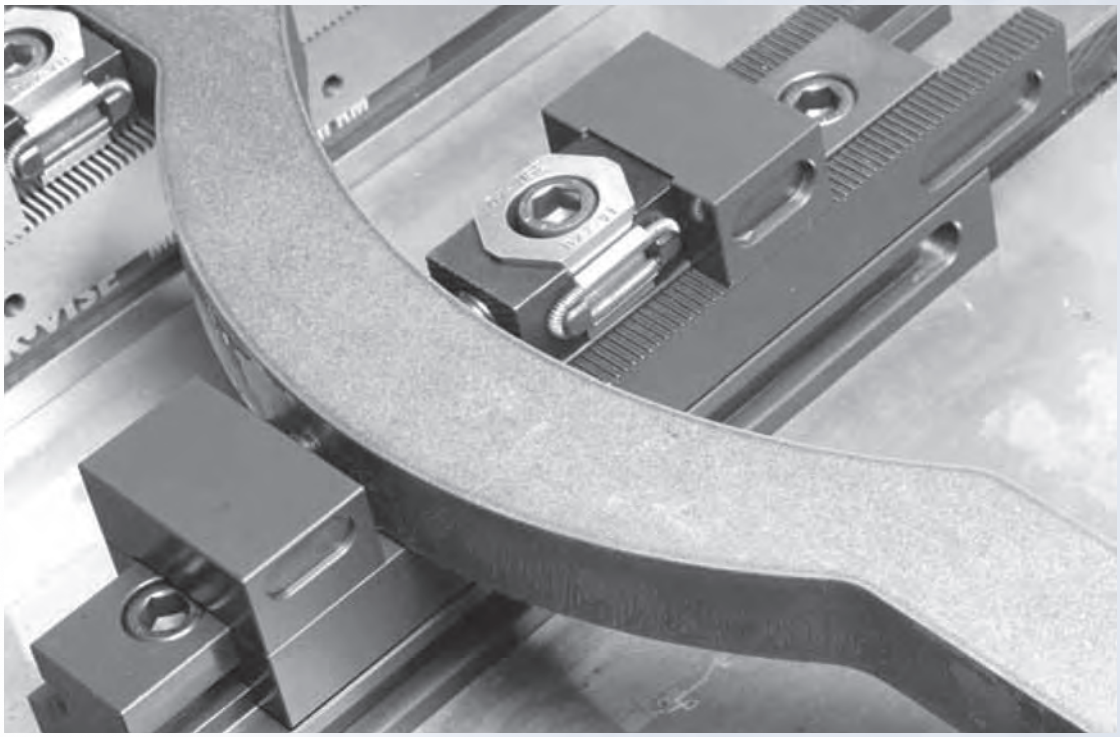




Jergens® / OK-VISE®
WORKHOLDING CLAMPS AND ACCESSORIES

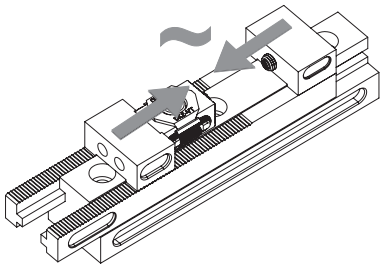
Combo-Rail

Jergens/OK-VISE Combo-Rail is a unique patent-pending design from us.There are several operating modes available: Floating Mode, Centralizing Mode and Machine Vice Mode.

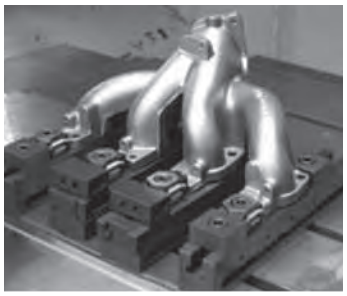


Floating Mode

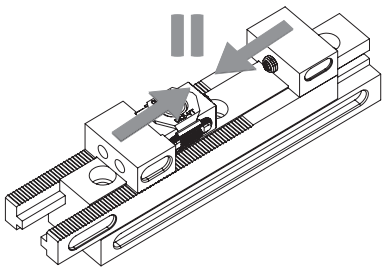
This is the most fascinating operating mode of the Combo-Rail. Here the fixture adjusts to the place of the workpiece.This is often needed while clamping inaccurate workpieces like castings, forgings or flame cut work pieces.Therefore floating mode installation normally needs positioning with some other means, like two Multi-Rail units, positioning pins, positioning by a robot etc.



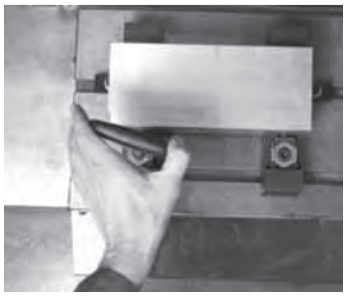
Centralizing Mode



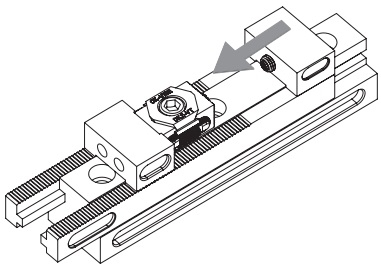
The jaws move synchronously. The center line of a casting or similar workpiece remains in the same place even if the outer dimensions of the workpiece changes. Centralizingmode



Machine Vice Mode

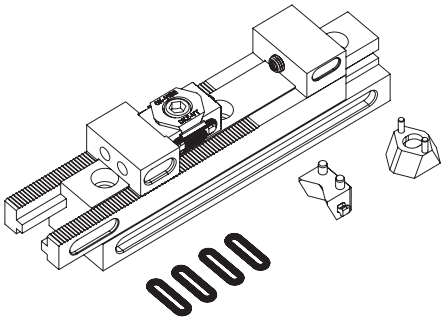


In this mode the other jaw is fixed to the base Compared to traditional Vises, in this method the ergonomics are radically improved in vertical machining centres



Universal Mode

CRH-K250 is a Combo-Rail unit that can be set in all three modes as mentioned before, operating modes by changing the jaw or wedge components (all included). All workpieces from 0 to 120 mm size can be clamped. The base height is 50 mm and total lenght is 250 mm.

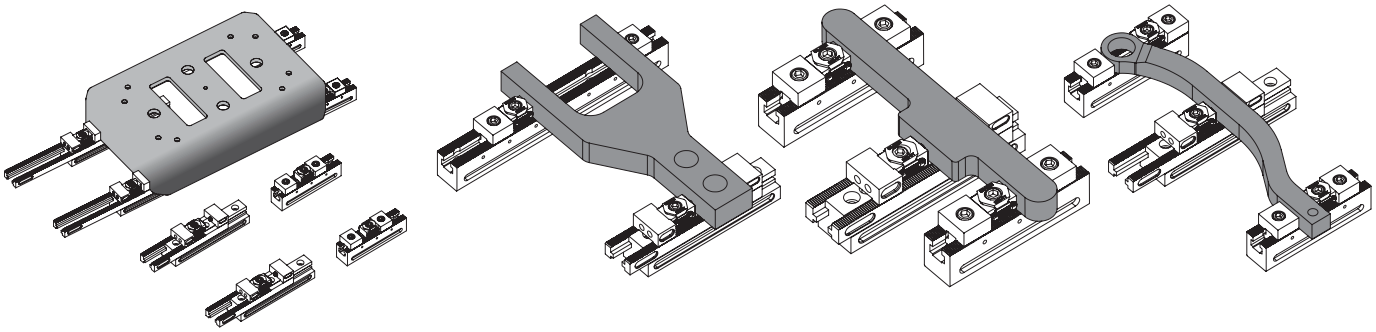


Jergens
WORKHOLDING SOLUTIONS GROUP

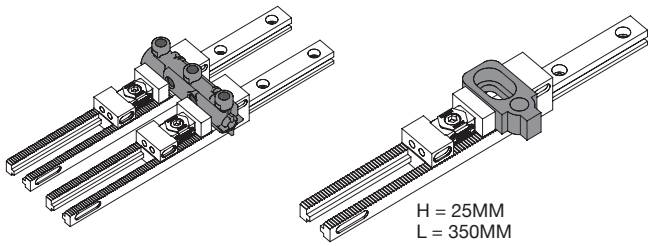
Combo-Rail Applications

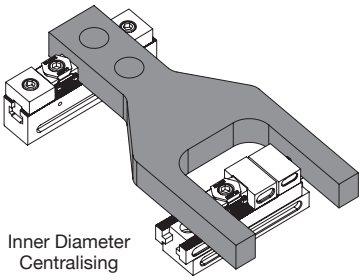
Please notice that the Combo-Rail units can be combined with most of OK-VISE Fixturing Concept components. Especially combining Combo-Rail units with Jergens/OK-VISE Multi-Rail has been proven to be a versatile combination.

Floating Mode



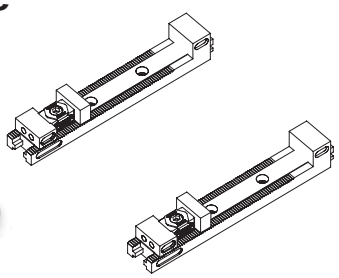
Centralizing Mode

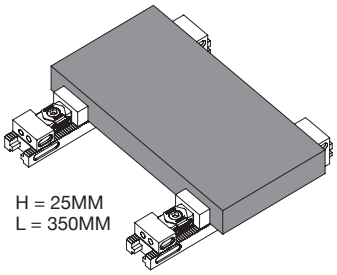




Machine Vise Mode

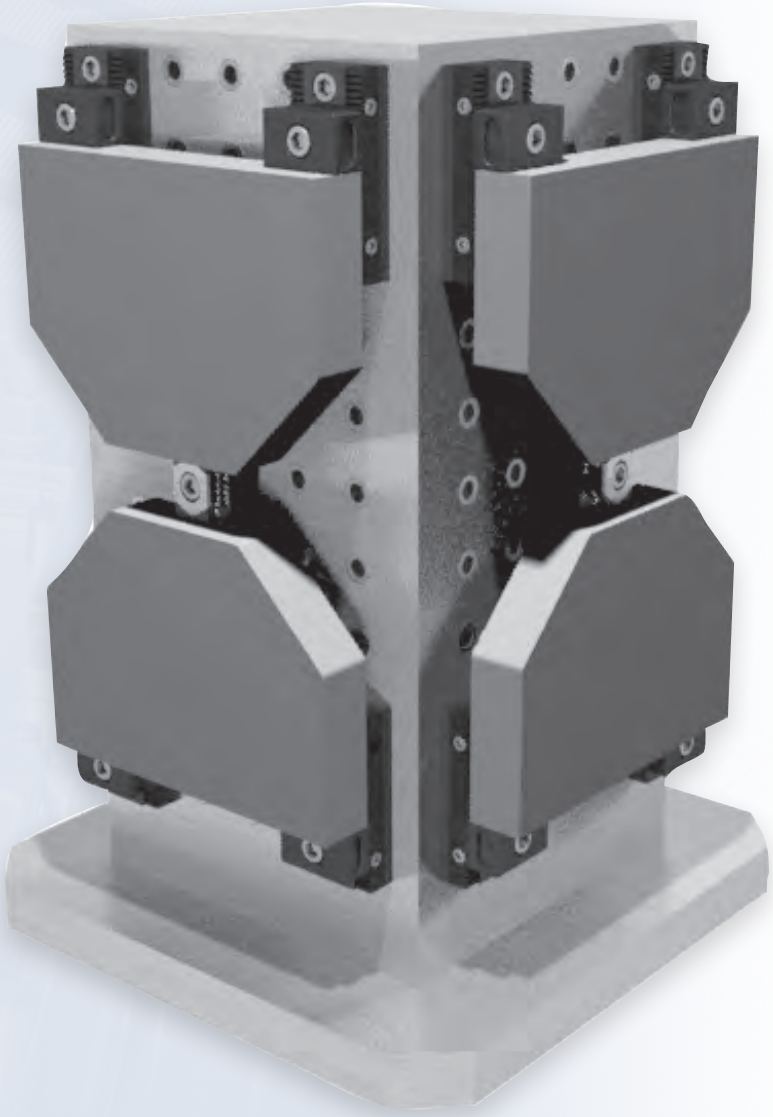
There are several adapter sets available for various platforms.





Jergens® / OK-VISE®

WORKHOLDING CLAMPS AND ACCESSORIES

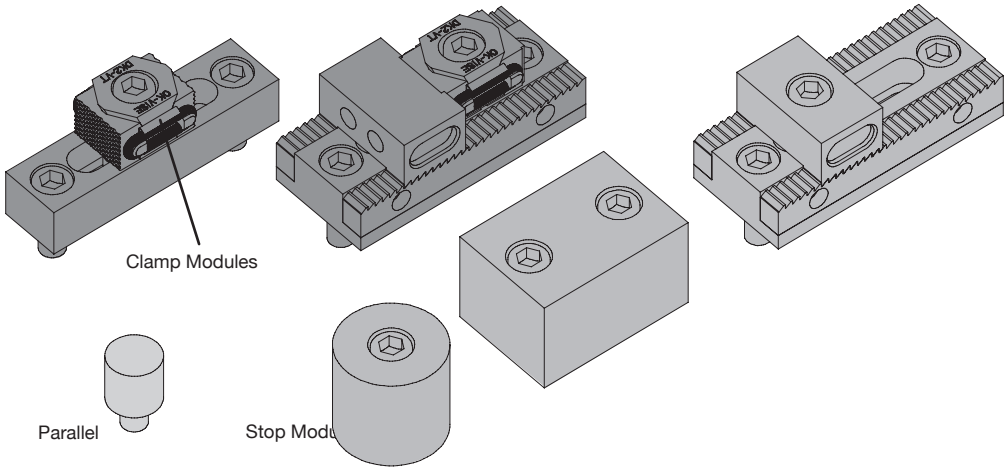


Jergens WORKHOLDING SOLUTIONS GROUP

Grid Fixturing System

Grid Fixturing System is the new generic-purpose fixturing system from Jergens/OK-VISE. It can be adapted to the grid platforms of leading workholding suppliers. With the Grid Fixturing System very complex forms of workpieces can be also clamped.On a grid platform you can also combine Jergens/OK-VISE modules with the components of other suppliers.

Grid Fixturing System Components



Clamp Module	
GCD-DR1	Serrated Jaws, D-Series
GCD-DS1	Smooth Jaws, D-Series
GCD-BR1	Serrated Jaws, B-Series
GCD-BS1	Smooth Jaws, B-Series
GCS-DS1	Adjustable, Smooth D-Series Jaw
GCS-DR1	Adjustable, Serrated D-Series Jaw

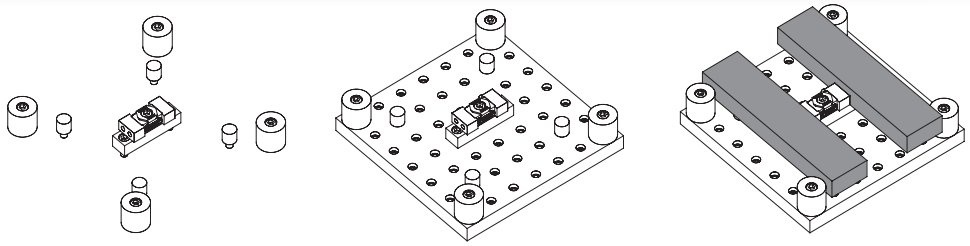
Stop Module	
GS-SF1	Round Smooth
GS-SF2	Rectangular, Fixed, Smooth
GS-SA1	Adjustable, Smooth
GR-RF1	Round, Serrated
GR-RF2	Rectangular, Fixed, Serrated
GR-RA1	Adjustable, Serrated

Parallel	
GP-1	Round

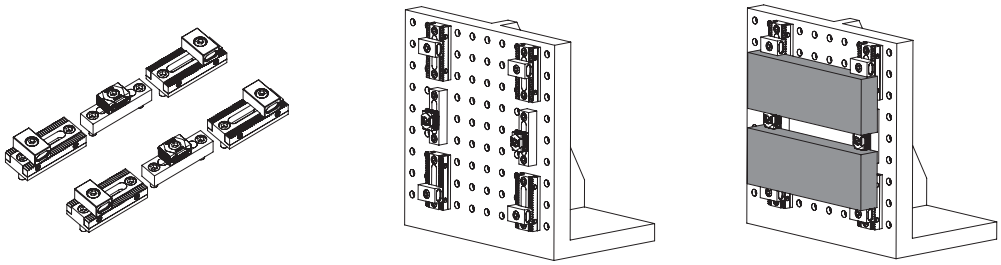
Grid Fixturing System – Applications

To make selection of the components easier, the Jergens/OK-VISE team has selected some basic sets to enable an easy start with the Grid system. In the pictures below you can see the solutions done with each set. We recommend platforms of leading suppliers. Grid plate is normally not included in the set.

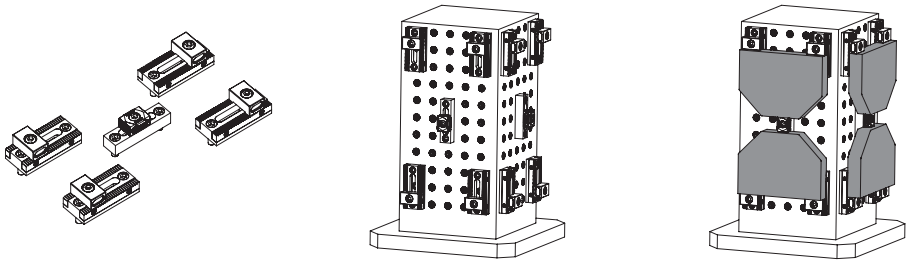
SG-Z01



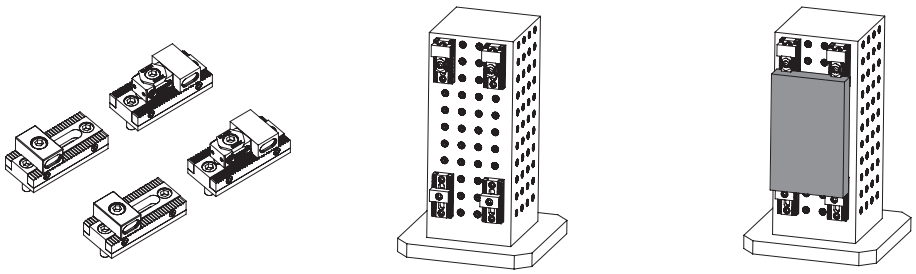
SG-Z02



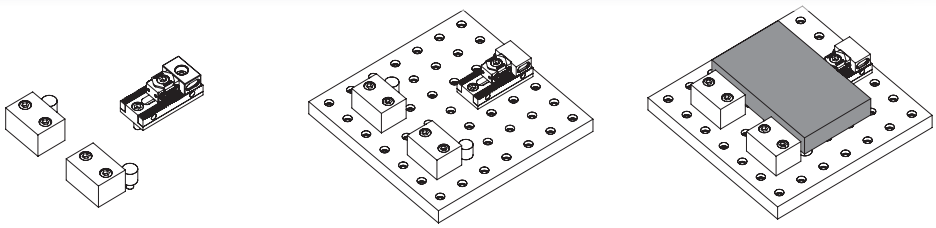
SG-Z03



SG-Z04



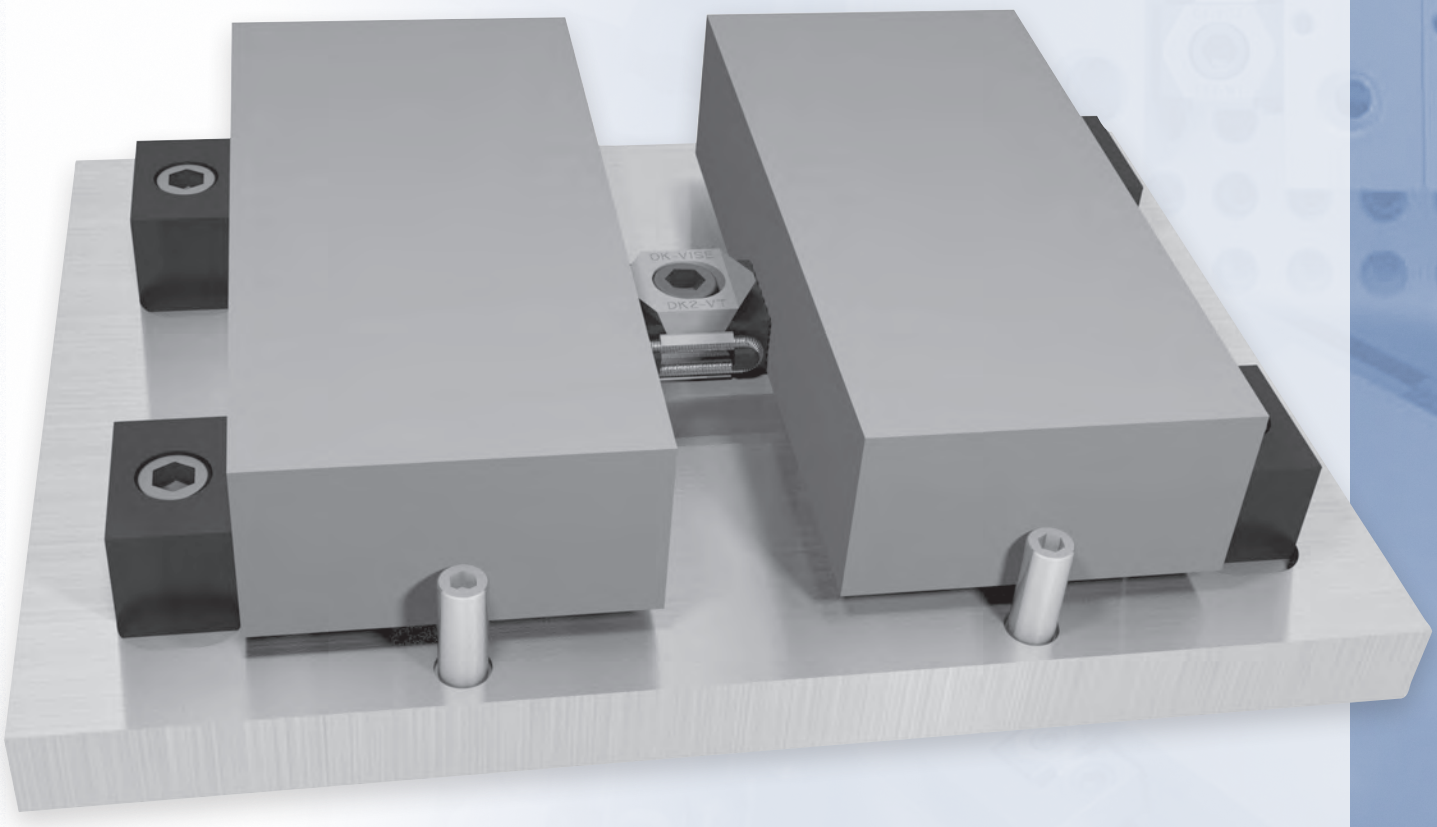
SG-Z05



BLANK FIXTURING SYSTEM

Jergens® / OK-VISE®

WORKHOLDING CLAMPS AND ACCESSORIES



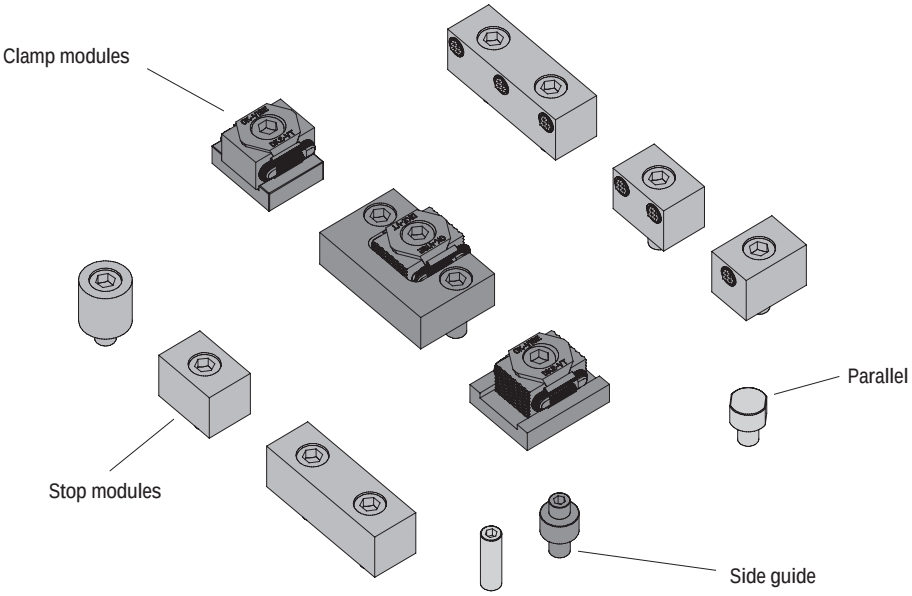
Blank Fixturing System

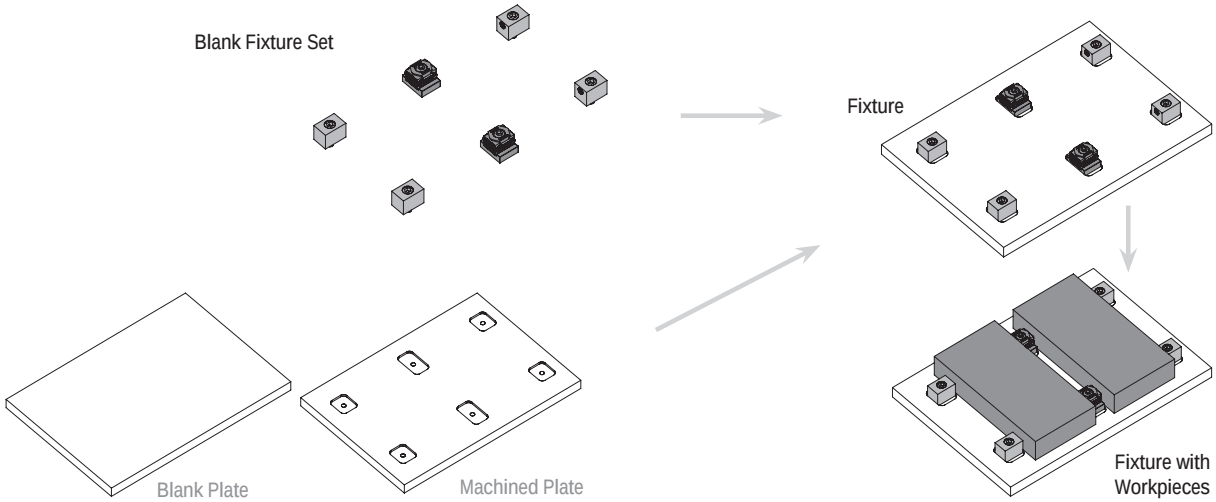
The Jergens/OK-VISE Blank Fixturing System is designed for cases when dedicated (product-specific) fixtures are needed. This is typical in high-volume production. Blank plates are used as a platform on which to build the fixture. Aluminium and steel blanks are recommended.

In addition to OK-VISE low-profile clamps and bolts, a variety of components are now available. Various clamp modules, stopper modules, side guides and parallels (or riser blocks) are the basic modules of the system. High-friction jaws in stopper modules and clamps ensure reliable clamping when high machining forces are used.

When sensitive contact with the workpiece is a must, then smooth, diamond-surface or contour-machined jaws are optimal. Now designing dedicated fixtures is easier than ever.

Blank Fixturing System Components

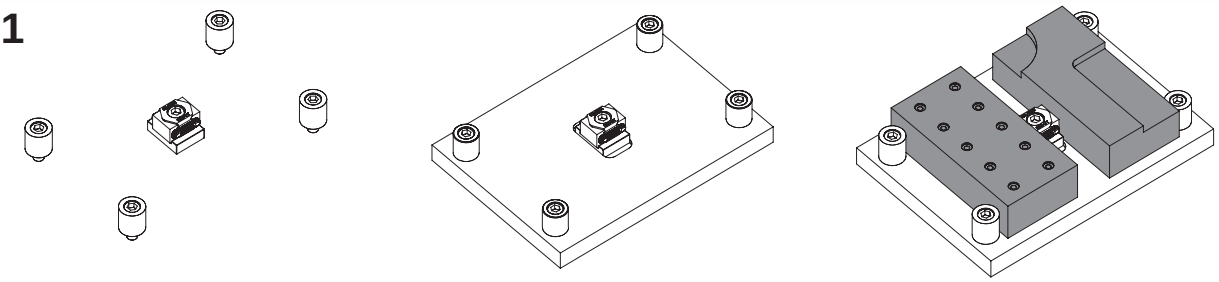




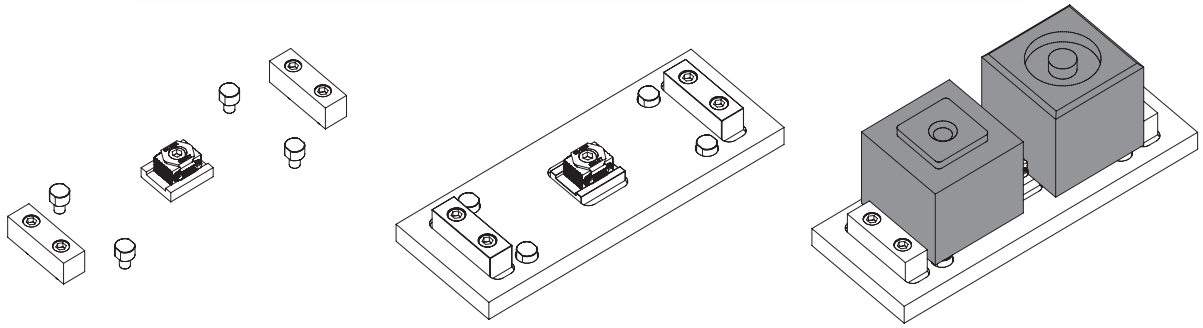
Blank Fixturing System – Applications

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

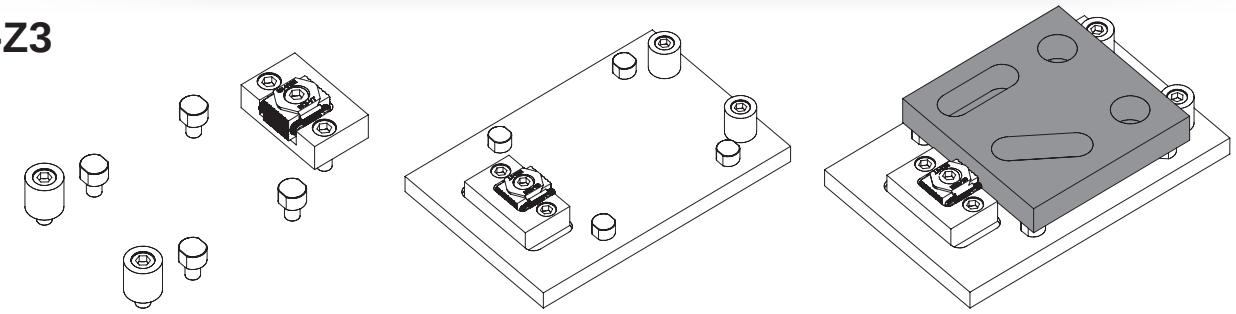
SK-Z1



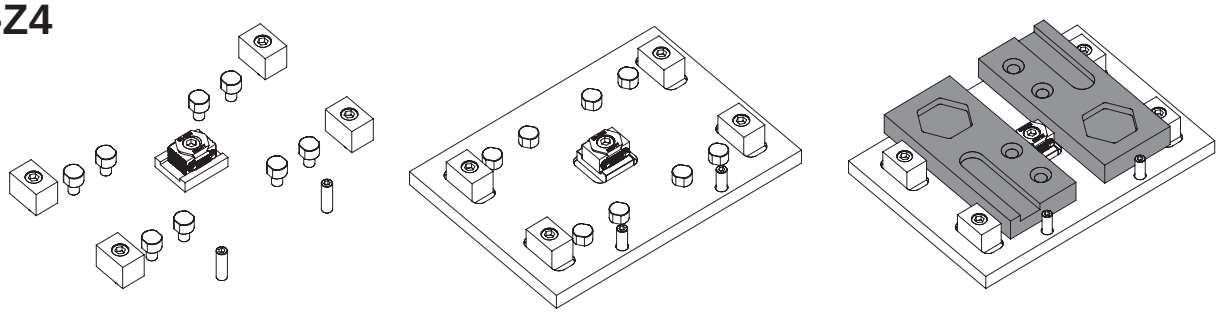
SK-Z2



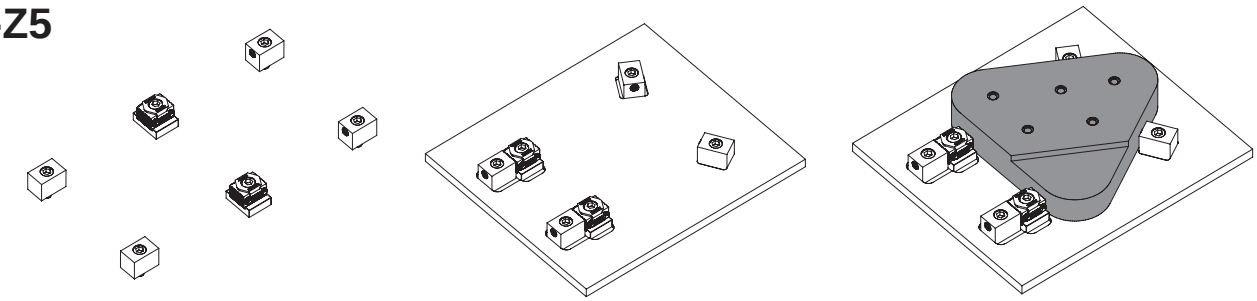
SK-Z3



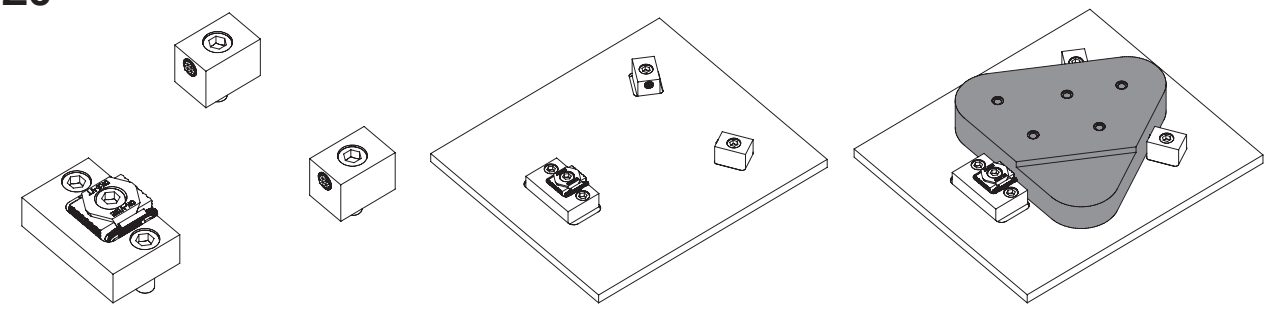
SK-Z4



SK-Z5

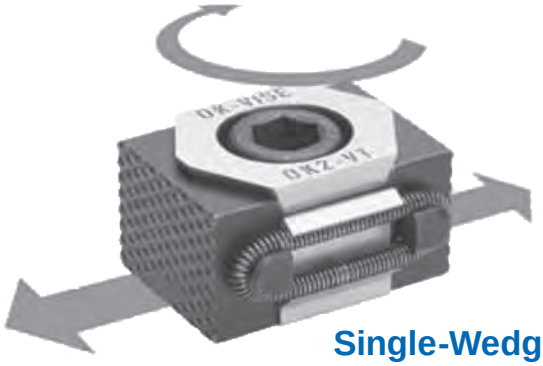


SG-Z6



Jergens WORKHOLDING SOLUTIONS GROUP

Blank Fixturing System – Low-Profile Clamps



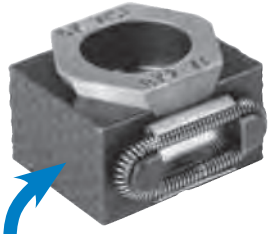
Single-Wedge Clamp

Jergens/OK-Vise low-profile clamps are the core components of our Blank system. Our low-profile clamps are available with various jaw types.

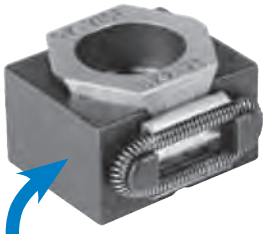
Pull-Down Models

- Double Wedge
- Single Wedge

Clamps with Machinable Jaws



Clamps with Serrated Jaws



Clamps with Smooth Jaws

Additional Piece Models

Clamps with Self-Adjustable Jaws

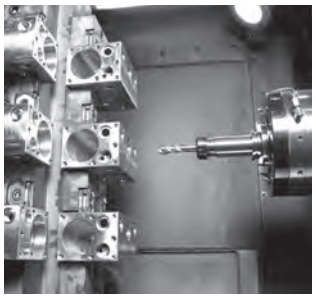
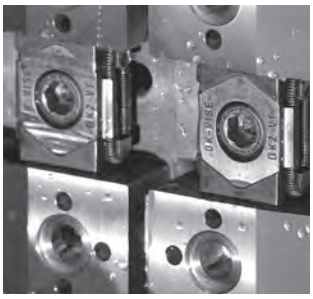
Clamp Module	
KCD-DR1	Dual Directional Long, Serrated, D
KCD-DS1	Dual Directional Long, Smooth, D
KCD-DS2	Dual Directional, Smooth, D
KCD-DR2	Dual Directional, Serrated, D
KCS-DR1	Single Directional, Serrated, D
KCS-DS1	Single Directional, Smooth, D

Stop Module	
KS-S1	Smooth
KS-S2	Smooth
KS-SO1	Round, Smooth
KS-R1	Serrated
KS-R2	Serrated
KS-R3	Serrated
KS-S2	Smooth
KS-D1	Diamond
KS-D2	Diamond
KS-D3	Diamond

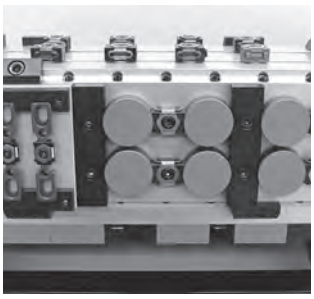
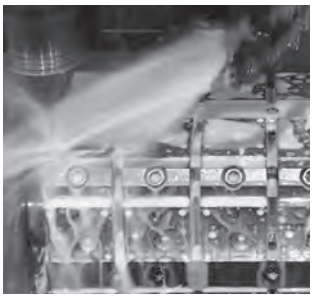
Parallels	
KP-1	Wide Pin

Side Guides	
KG-1	Pin
KG-2	Pin with Integrated Parallel

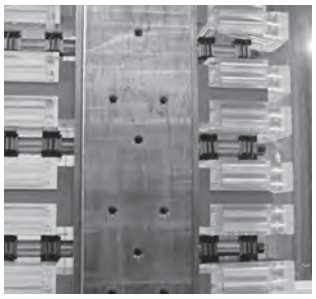
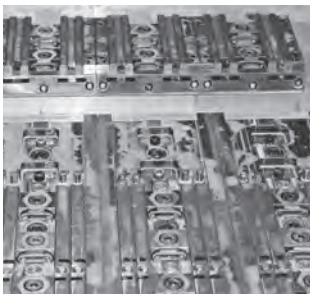
HMC Applications

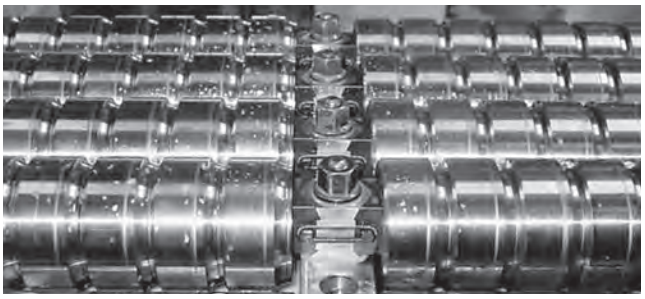
RPS Applications

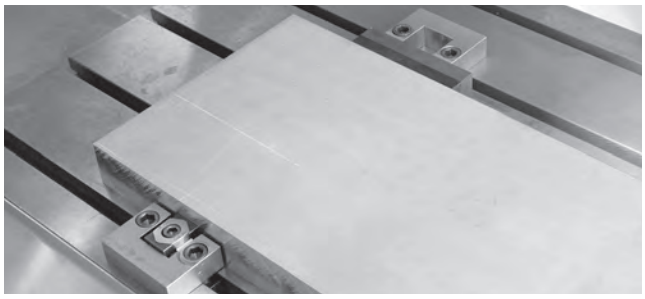
Hydraulic Applications

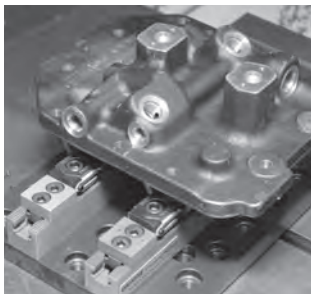
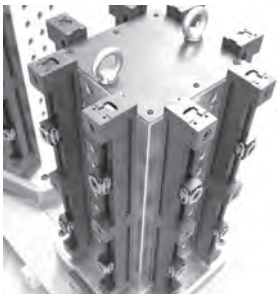
VMC Applications



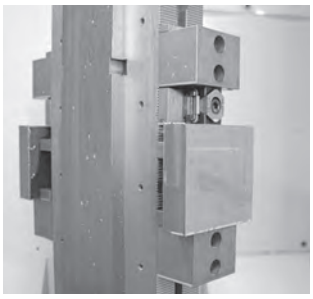
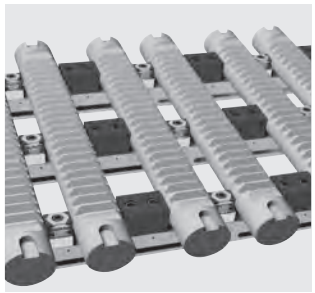
T-Slot Applications



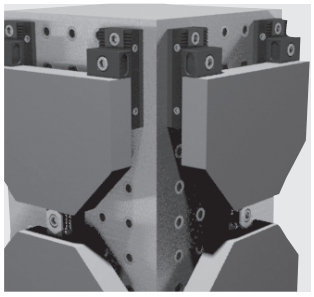
Multi-Rail RM Applications

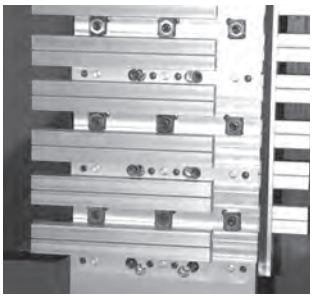
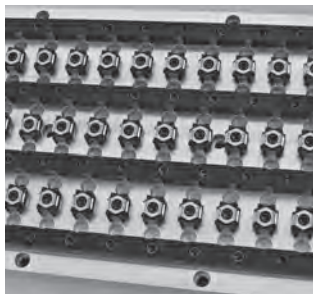
Multi-Rail RH Applications

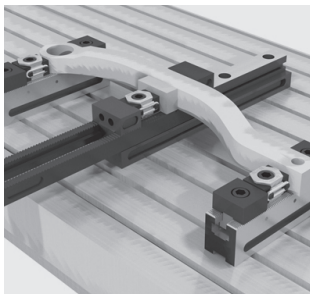
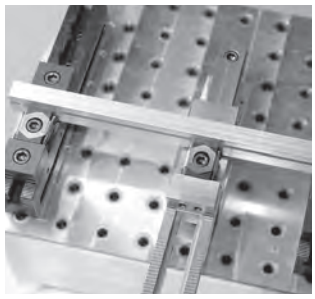
Grid Applications




Blank Plate Applications

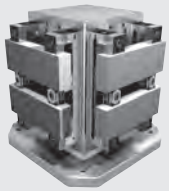
Combo-Rail Applications

Fixturing and Components

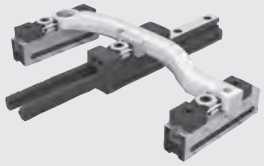
GENERIC FIXTURING COMPONENTS

Multi-Rail RM System



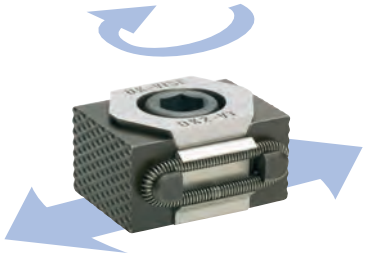
Multi-Rail RH System

Combo-Rail



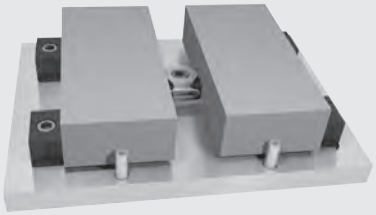
Grid Fixturing System

LOW-PROFILE CLAMPS



COMPONENTS FOR DEDICATED FIXTURING

Blank Fixturing System



A Core Component of any Modern Workholding System

Jergens/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 low-profile clamps on machinable plates. Jergens/OK-VISE clamps are suitable for three-directional machining, 5-axis machining, and many other modern machining methods.

Absolute Stability

The key feature of the Jergens/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, Jergens/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 Jergens/OK-VISE low-profile clamps, it is possible to achieve the highest level of effectiveness.

Jergens®

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