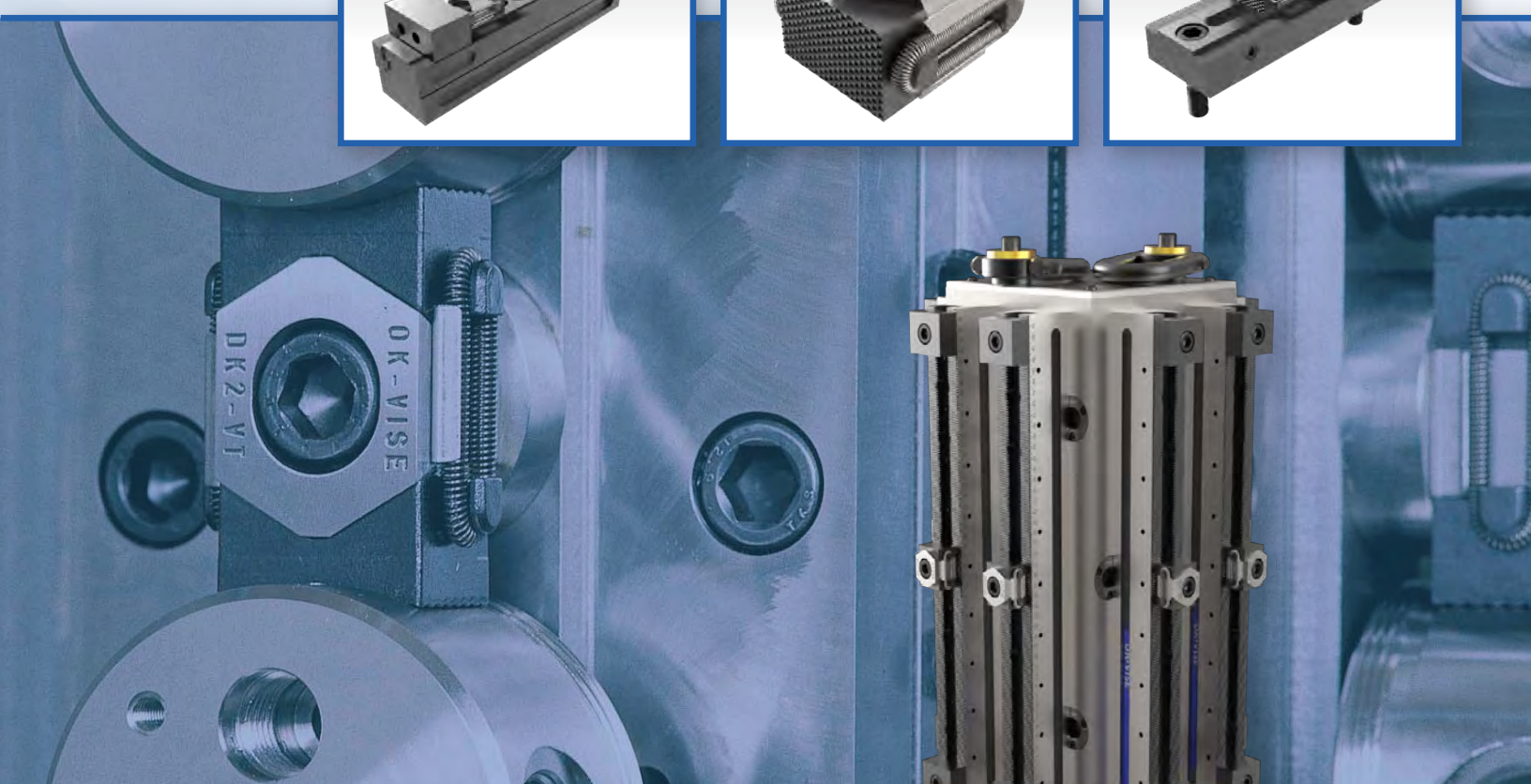
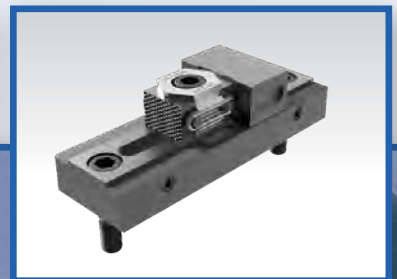
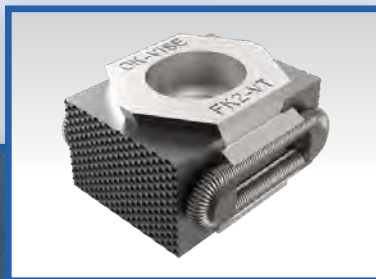
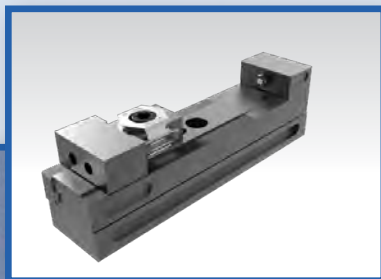




Jergens®

LOW PROFILE CLAMPING

SPACE-SAVING CLAMPS AND SYSTEMS FOR INCREASED PRODUCTIVITY



JERGENS COMPANY PROFILE



Jergens Company Profile

Jergens Inc. was founded in 1942 by Jack Schron, Sr. and his father Christy, to provide standard components for building jigs and fixtures. Today the fourth generation of family involvement continues stronger than ever. Throughout its eighty-year history the company has grown into three separate operating divisions: Tooling Component Division (TCD), Acme Industrial Company (AIC), and Advanced Systems Group (ASG) Division of Jergens. While all divisions are vital to the Jergens family, the TCD Division is the centerpiece of our manufacturing capabilities. In June 1999, Jergens moved into a new 110,000 square foot facility and prides itself by manufacturing over 80% of its product offering, as well as setting the standard for producing the highest quality components in our industry.

Jergens now comprises 3 distinct business units: Workholding Solutions, Lifting Solutions and Specialty Fasteners. Building on its reputation of uncompromising quality standards, Jergens is committed to helping its customers achieve leaner, more profitable manufacturing, and continues to add products and engineered solutions for an integrated approach to “Manufacturing Efficiency.”

Today, you’ll find our tooling components, fasteners and hoist rings at work in just about every industry on every continent. And our innovative Quick Change Workholding Solutions like Ball Lock® Mounting System have changed the way manufacturers worldwide think about productivity.

Jergens actively supports global, multinational and internationally based customers with metric dimensioned product offerings as well as many inch threaded products that are common in aerospace and industrial applications around the world. In important manufacturing markets in Canada, Europe, Asia and Latin America, Jergens representatives and stocking distributors have represented Jergens for more than 40 years. Our international representatives are trained technically on our products and provide expertise to customers and sub dealers in applying Jergens technologies to local industries. In recent years, two wholly owned affiliates were formed to serve the Chinese and Indian markets. Jergens (Shanghai) Commercial Co., Ltd, opened in 2006 and Jergens India Private Ltd., Navi Mumbai India opened in 2009. These fully registered trading subsidiaries employ trained multi-lingual engineers and commercial managers who provide marketing and importing, warehousing, distribution and technical support to our customers, distributors and local representatives.

Acme Industrial, located in Carpentersville, Illinois, is a premium manufacturer of precision drill bushings and keylocking thread inserts. Our ASG Division specializes in products for light assembly ranging from torque controlled electric screwdrivers to automation systems.

In addition to our unique product designs, we lead the industry with unparalleled customer service and delivery. Our website is a good example of our commitment to be the most innovative company in our industry. Customers and distributors can check stock and order on-line, view the Jergens catalog, and even download 2D, 3D and solid model CAD drawings in a variety of formats.

Visit our website at www.jergensinc.com for the latest news and product information, as well as links to our other divisions. The Jergens family thanks you for your business.

LOW PROFILE CLAMPING

Jergens OK-Vise®

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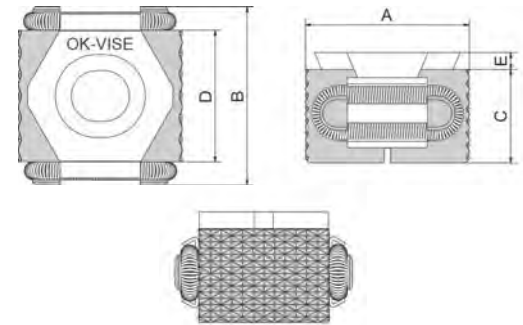
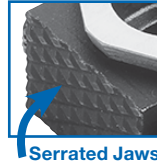
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Serrated Jaw Clamp



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



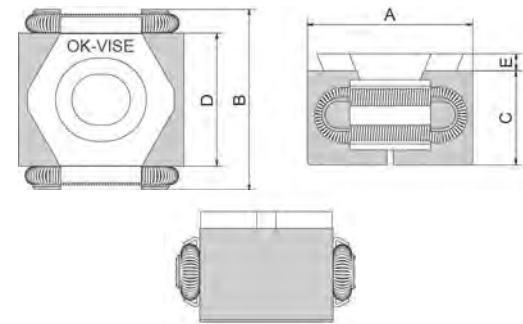
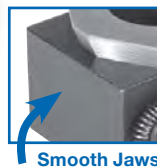
Part Number	A			B	C	D	E	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC
	Min	Optimum	Max									
BK2-VT	27	29	31	29	15	21	2.5	M8x20	25 (5620)	44 (32.4)	55 (0.12)	48-52
DK2-VT	42	45	49	41	22	30	4	M12x30	65 (14,612)	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
BK2-VT-SS**	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.

**STAINLESS STEEL

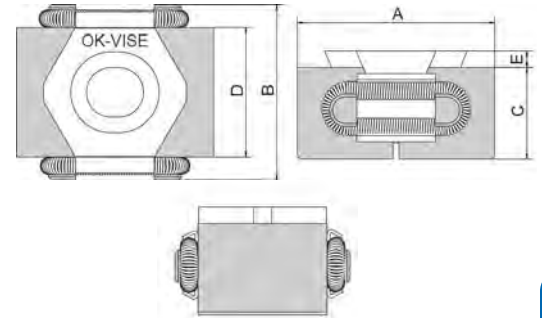
Machinable Jaw Clamp


 DK2-VT+5/
DK2-VTI+5

FK2-VT+5

BK2-VT+3

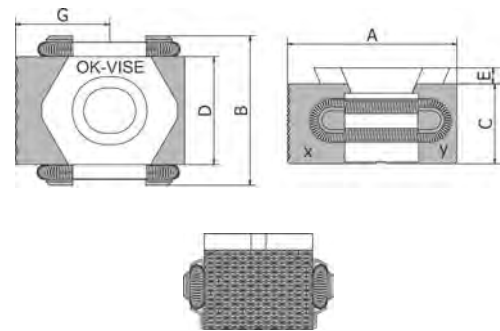
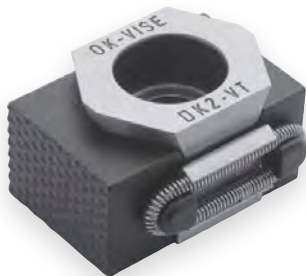
Single-wedge clamps are also available with extended jaws and can be machined to suit the geometry of the workpiece. The smallest model can be machined up to 3 mm and the larger ones up to 5 mm.



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



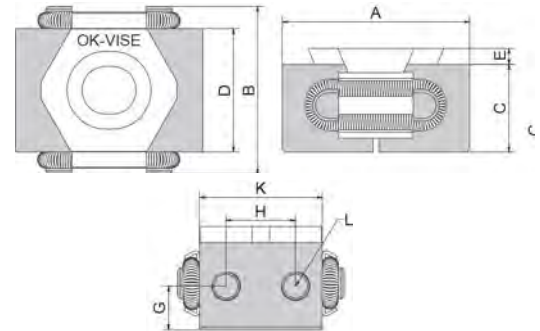
Part Number	A			G			B	C	D	E	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC X	Hardness of Jaws HRC Y
	Min	Optimum	Max	Min	Optimum	Max										
BK2-VT+3S	30	32	34	16.5	17.5	18.5	29	15	21	2.5	M8x20	22 (4,975)	43 (31.7)	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.

Mounting Jaw Clamp



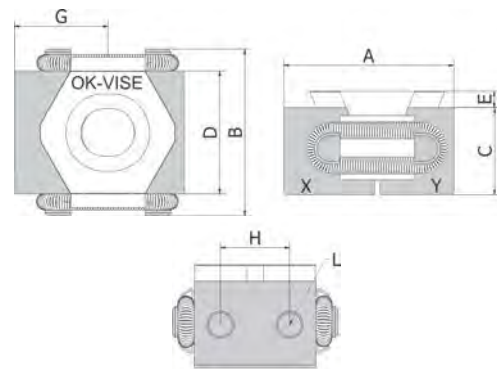
Additional piece models have machined female threads (M5) for socket head screws on the side of the jaw, making it quick and easy to use various additional pieces which can also be machined into different shapes.



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	2xM5	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	2xM5	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	2xM5	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	2xM5	M16x40	100 (22,480)	360 (265)	475 (1.05)	30-34	48-52

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

See page 10 for Soft Jaws

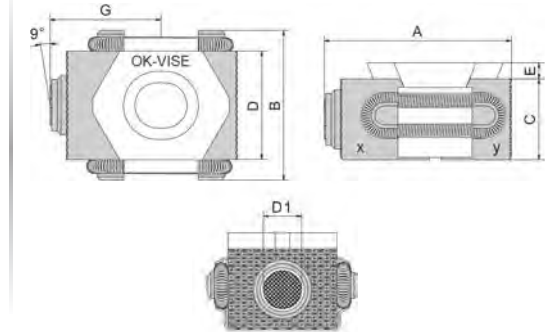
LOW PROFILE CLAMPING

Self-Adjustable Jaw Clamp


 DK2-VT-B/
 DK2-VTI-B

BK2-VT-B

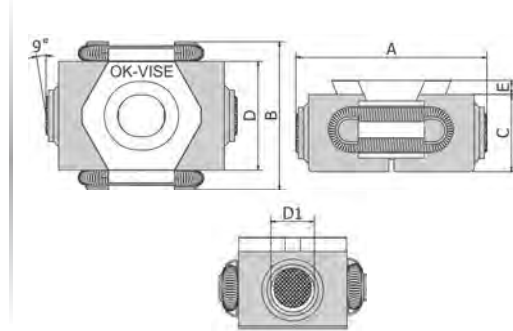
These clamps have a self-adjustable ball gripper screw inserted into a clamp jaw. The ball bearing at the end is made of steel and equipped with torsion protection, allowing the ball to self-adjust up to 9 degrees. This makes clamping irregular-shaped parts and castings more flexible



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.

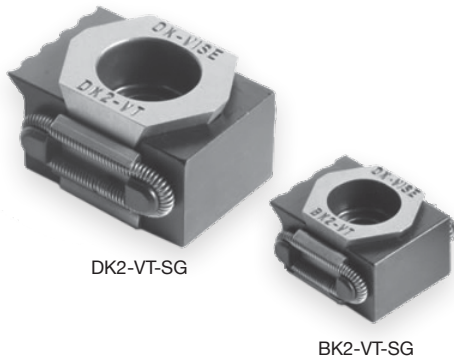
Two Self-Adjustable Jaw Clamp



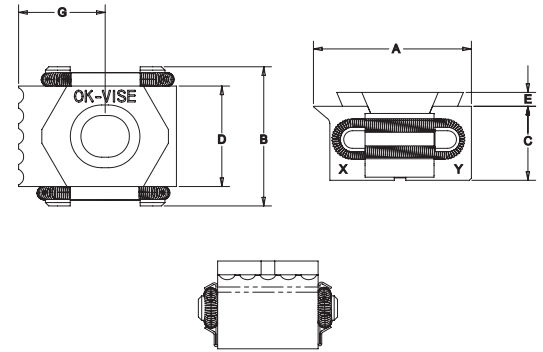
Part Number	A			B	C	D	E	Dia. of Serration (D1)	Socket Head Screw DIN 912	Clamping Force of Jaws kN (lbs)	Tightening Torque Nm (ft/lbs)	Weight in g (lbs) approx.	Hardness of Jaws HRC X	Hardness of Jaws HRC Y
	Min	Optimum	Max											
BK2-VT-E	39	41	43	29	15	21	2.5	7.2	M8x20	22 (4,975)	43 (31.7)	72 (0.16)	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-VTI+E measures given in inches and pounds.

Knife Edge Grip Jaw Clamp



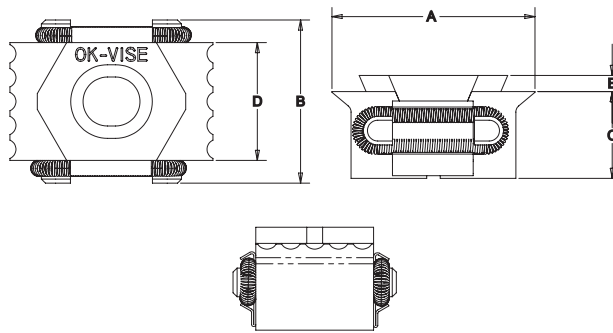
These clamps have a knife edge grip jaw with serrated teeth. The knife edge penetrates into softer materials to prevent part movement. They are available with one grip jaw and one smooth jaw or a grip jaw on both sides.



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	Optimum	Max										
BK2-VT-SG	30	32	34	16.3	17.4	18.5	29	15	21	2.5	M8x20	22 (4,975)	43 (31.7)	64 (0.14)	38-42	48-52
DK2-VT-SG	46.6	49.9	53.3	25.5	27.2	28.9	41	22	30	4	M12x30	55 (12,364)	145 (107)	212 (0.41)	38-42	48-52
DK2-VTI-SG*	1.83	1.96	2.10	1.00	1.07	1.14	1.61	0.86	1.18	0.15	1/2-13x1 1/4"	55 (12,364)	145 (107)	212 (0.41)	38-42	48-52

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

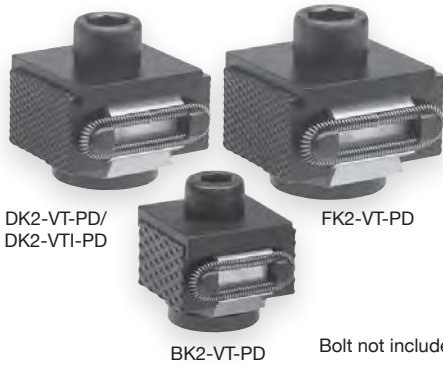
Two Knife Edge Grip Jaw Clamp



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-G	33	35	37	29	15	21	2.5	M8x20	22 (4,975)	43 (31.7)	64 (0.14)	38-42
DK2-VT-G	51	54.4	57.8	41	22	30	4	M12x30	55 (12,364)	145 (107)	212 (0.41)	38-42
DK2-VTI-G*	2.01	2.14	2.28	1.61	0.86	1.18	0.15	1/2-13x1 1/4"	55 (12,364)	145 (107)	212 (0.41)	38-42

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

Single-Wedge Pull-Down, Serrated Clamp

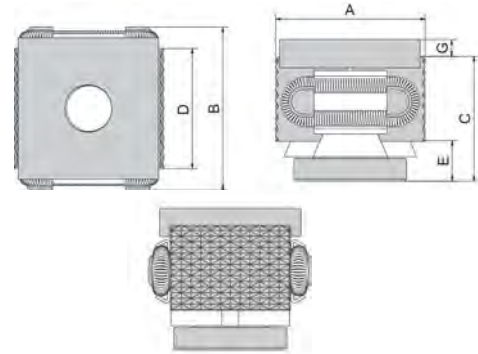

 DK2-VT-PD/
DK2-VTI-PD

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.

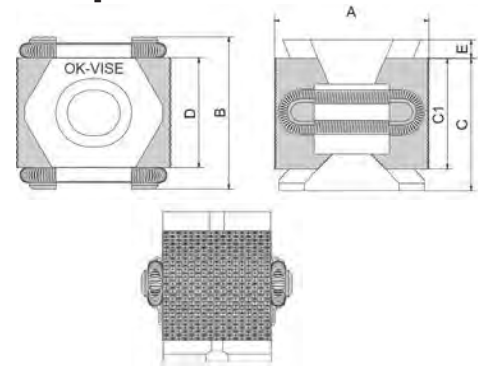
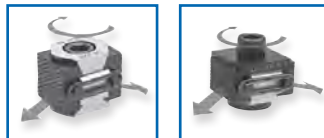
Double-Wedge Pull-Down, Serrated Clamp



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	-	42	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

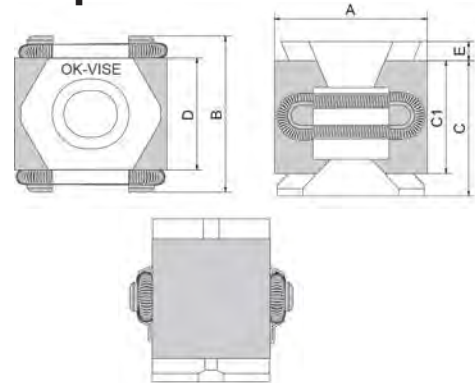
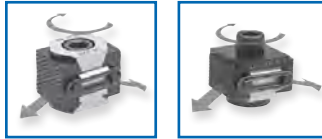


FK2-WT-S



DK2-WT-S/
DK2-WTI-S

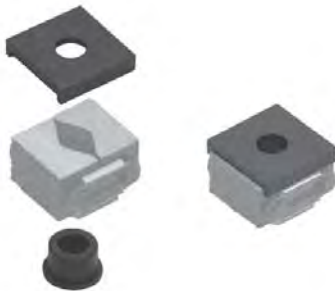
In addition to holding the workpiece in place, pull-down clamps also generate pull-down action, pressing workpieces down onto the fixture plate.



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	-	42	5	M16x60	150 (33,721)	360 (265)	730 (1.61)	48-52

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

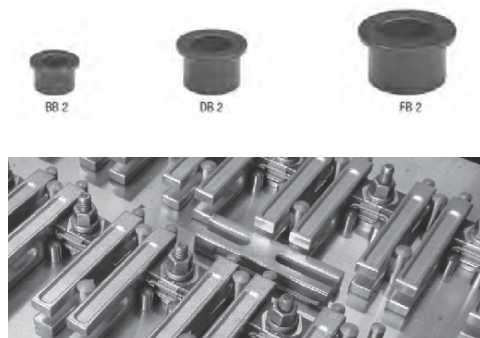
Pull Down Sets



Single-wedge clamps can be transformed into pull-down clamps by using pull-down sets. When the set is installed, the clamp is simply turned upside down and a plate and bushing are attached. Normally serrated single-wedge clamps are recommended for use with the pulldown sets. Pull-down sets are available for B, D and F-series clamps

Part Number	Clamp Size
PD-SET B	B
PD-SET D	D
PD-SET F	F

Stud Bushings



Normally, SHCS are used for installation of the OKVISE low-profile clamps. However, in some cases using a stud for fastening proves to be more practical. For example, when the clamp has to be fastened to a plate with a relatively short thread, the thread may easily get damaged by a standard bolt. When a stud with a special OK-VISE bushing and a hex nut are used, it can prevent damage to tapped holes in expensive fixture plates and tooling columns

Part Number	Clamp Size
BB2	B
DB2	D
FB2	F

Economy Clamp

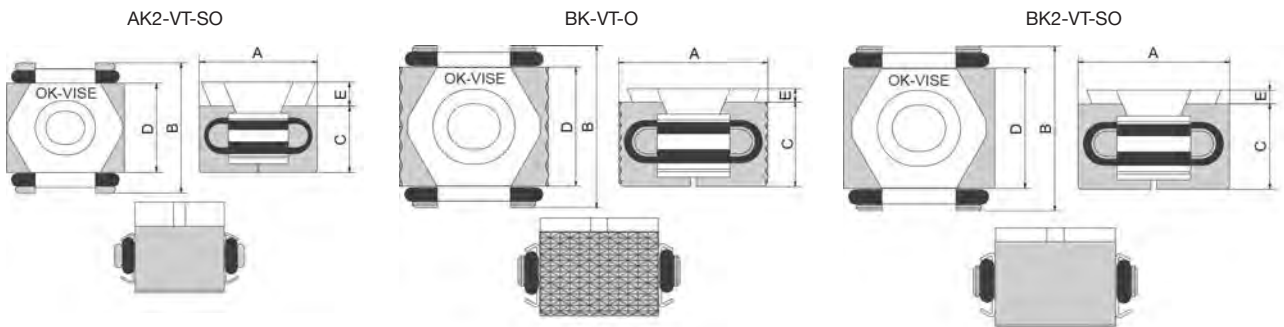


The cost efficient choice!

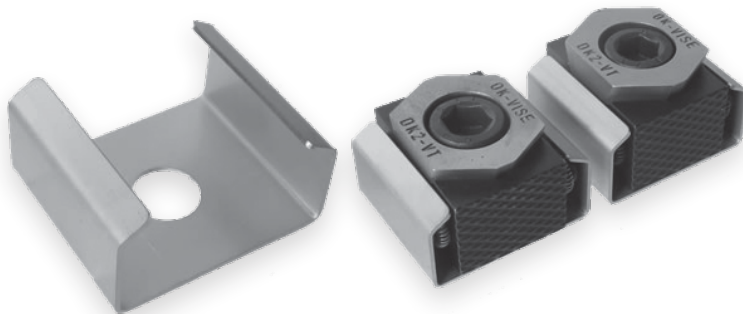
These models meet the demands of workholding when ultra precision and high clamping force are not necessary. They are made of the same raw material as our other models, and the bottom of the jaws are ground for precise positioning on the fixture base. AK2-VT-SO always comes with Viton o-rings.

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
BK2-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



Protection Plate

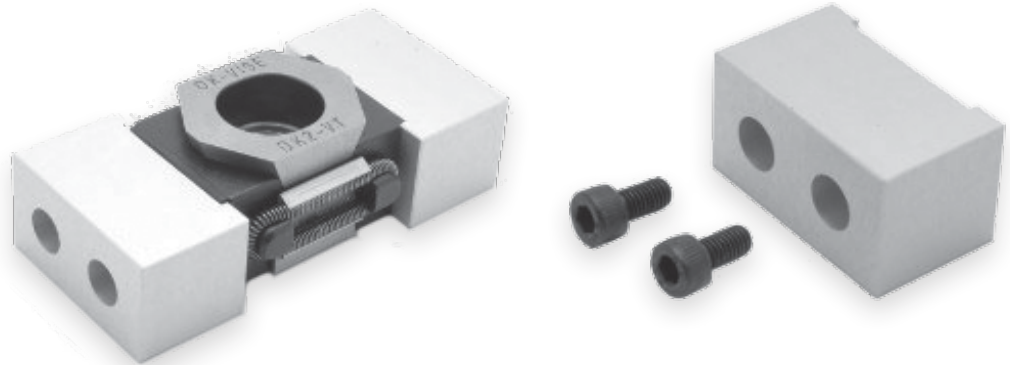


Protection plates are used to cover OK Vise return springs. They help keep chips out and guard against damage from general use. They are available for B and D size clamps.

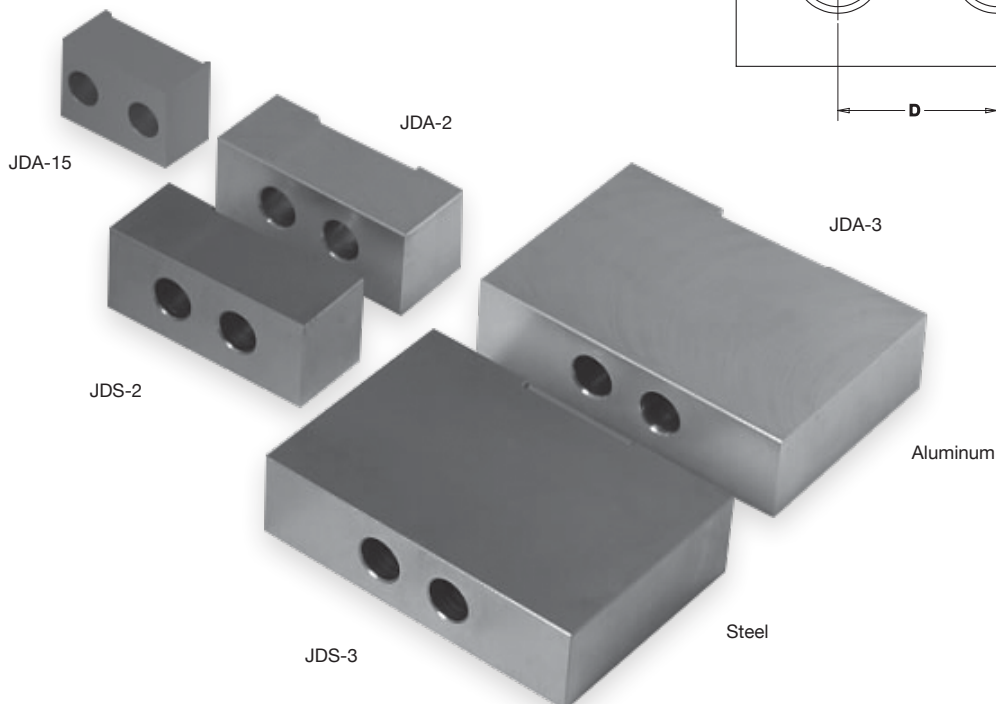
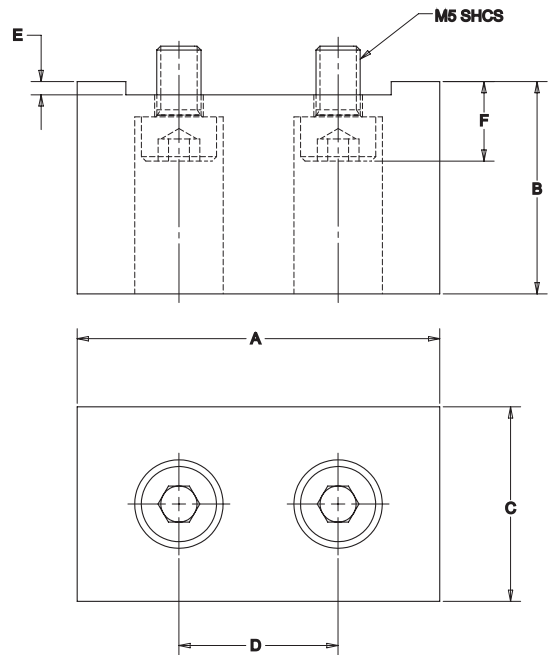
Part Number	Clamp Size
PB-1	B
PD-1	D

Soft Jaws for Mounting Style Clamps and Stops

These additional pieces are fastened with two M5 screws (included) to the threads in OK-VISE mounting jaw models. They are used like traditional soft jaws where users can machine them into different shapes. These additional pieces are available for B-, D- and F- series clamps. See Page 4.



Part Number	Clamp size	A	B	C	D	E	F	Material
JBA-10	B	29	17	14.9	12	-	7	Aluminum
JDA-15	D	41	24	22	18	1.5	9	Aluminum
JDA-2	D	56	26.5	22	18	1.5	9	Aluminum
JDS-2	D	56	26.5	22	18	1.5	9	Steel
JDA-3	D	80	55	22	18	1.5	9	Aluminum
JDS-3	D	80	55	22	18	1.5	9	Steel
JFA-18	F	56	29	28.5	26	1.5	11	Aluminum

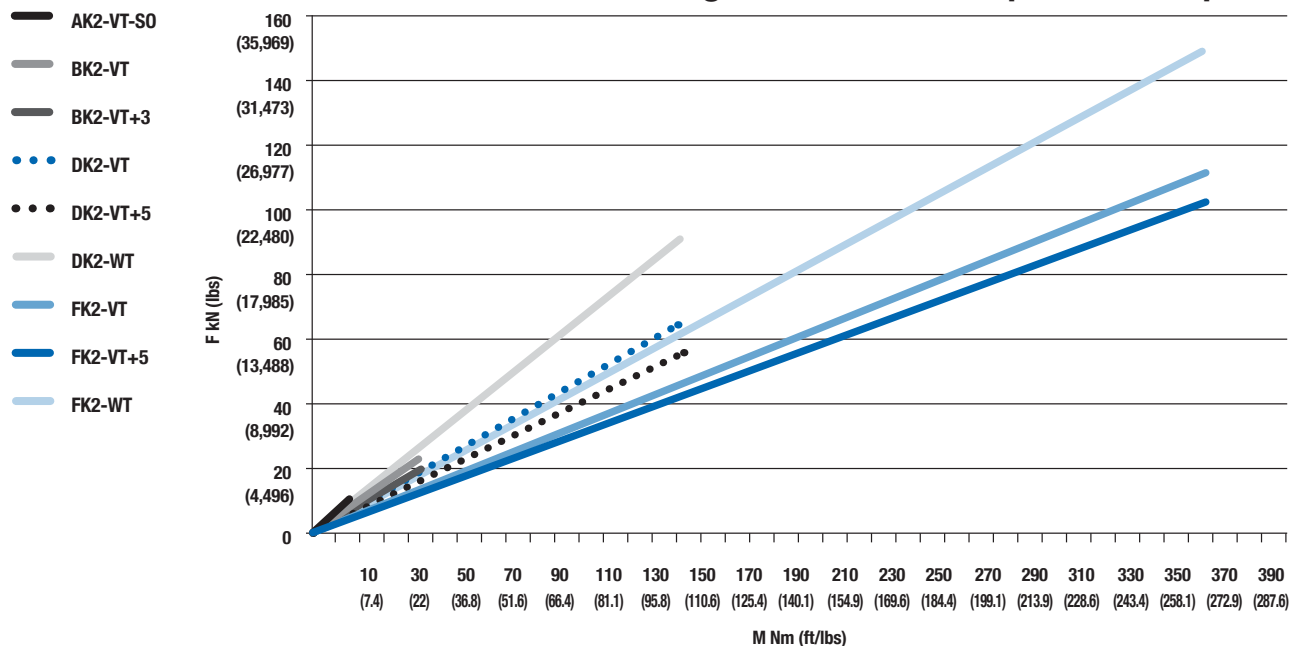


Low-Profile Clamps

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	—
Knife Edge Grip model	—	BK2-VT-SG	DK2-VT-SG	DKS-VTI-SG	—
Two Knife Edge Grip Jaws	—	BK2-VT-G	DK2-VT-G	DK2-VTI-G	—
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-0	—	15	21
Economy-series, smooth	AK2-VT-S0	BK2-VT-S0	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

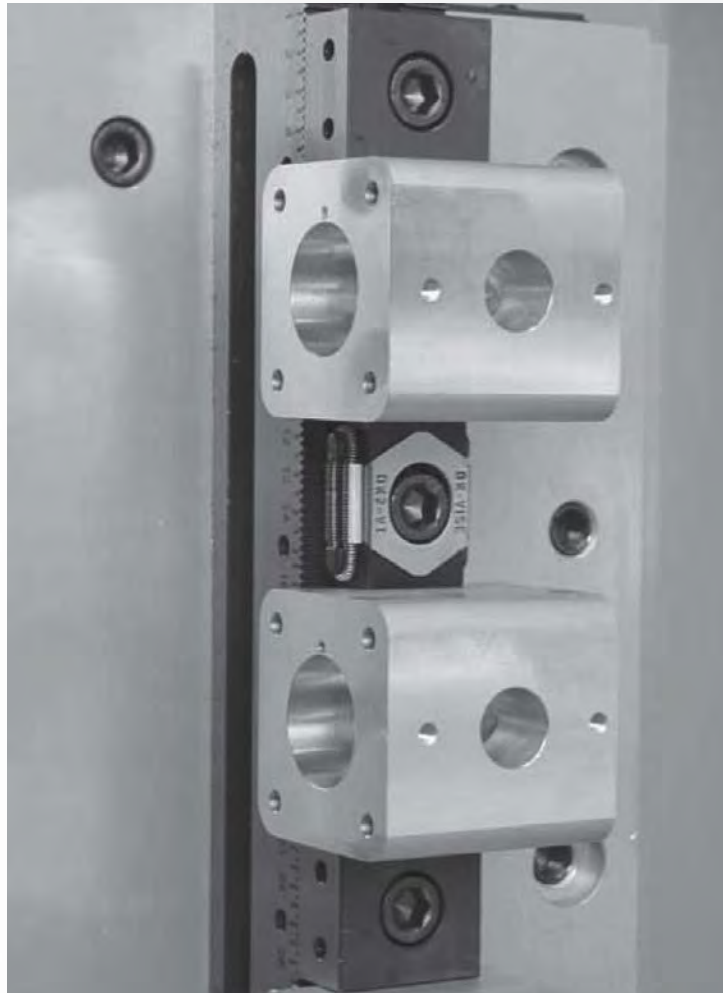
Horizontal forces of Jergens/OK-Vise low profile clamps



MULTI-RAIL RM SYSTEM

Jergens / **OK-VISE**®

WORKHOLDING CLAMPS AND ACCESSORIES



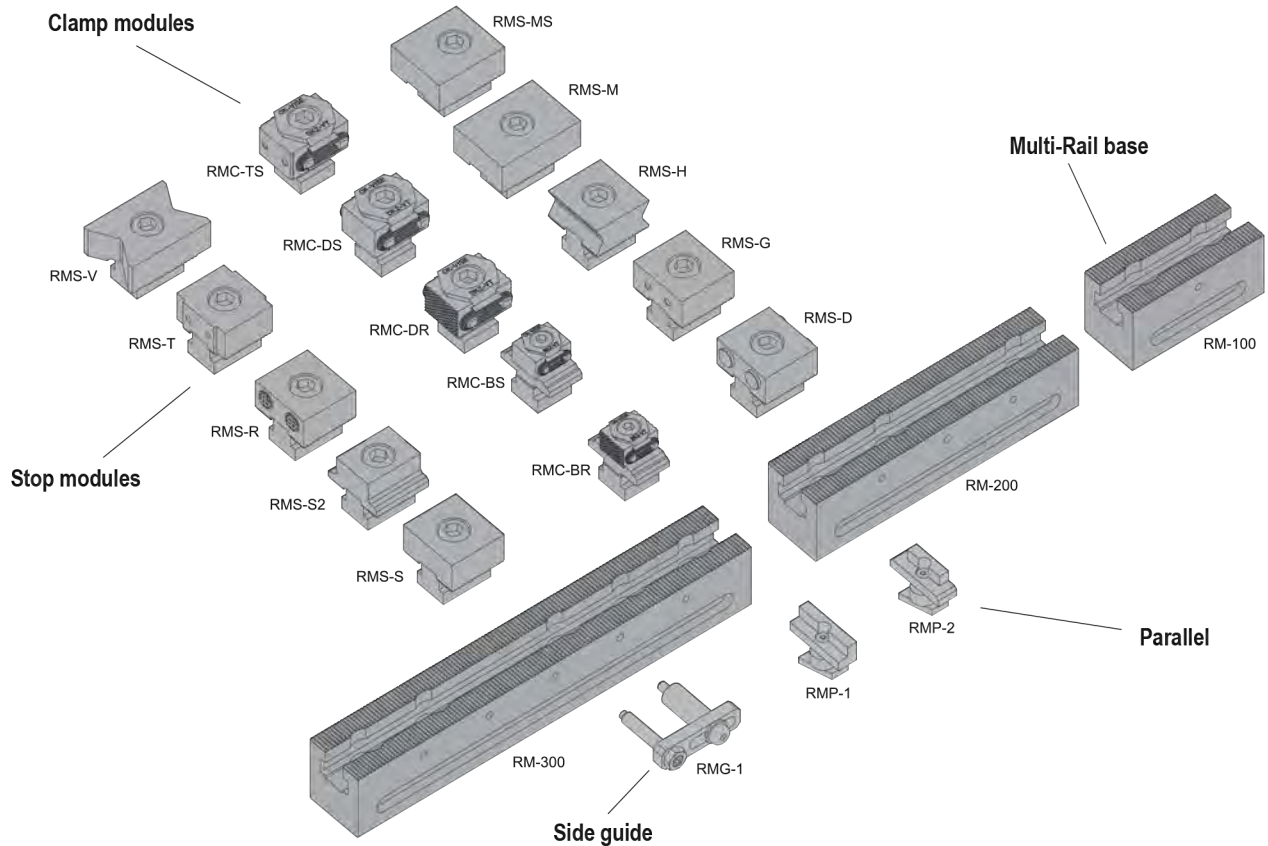
Multi-Rail RM System



Multi-Rail is the new generic-purpose workholding system of Jergens/OK-VICE. 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



Base Rail RM Series

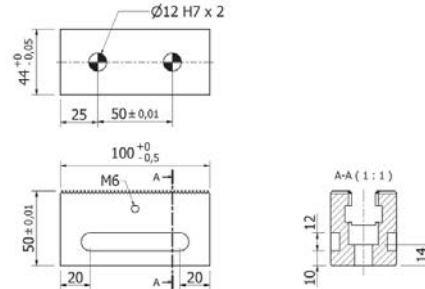
The OK-VISE Multi-Rail base is the strongest on the market due to its steep serration profile. It has been designed for D- and B-series clamp modules and can withstand up to 4 tons clamping force. The pitch of the serration is 2,5 mm, and the size of the RM profile is 44 x 50 mm. The accuracy from every serration to the positioning hole is ± 0.01 mm.

RM-100

This is the shortest rail, with two 12 mm H7 positioning holes.



Part Number	Size
RM-100	100MM

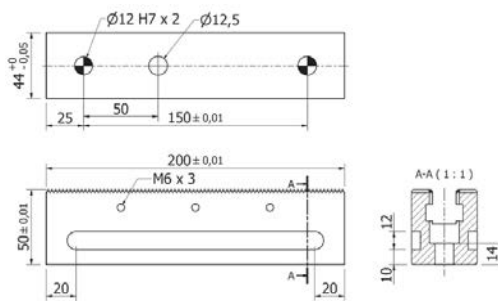


RM-200

A rail 200 mm in length provides better adjustability than the shortest RM-100 rail.



Part Number	Size
RM-200	200MM

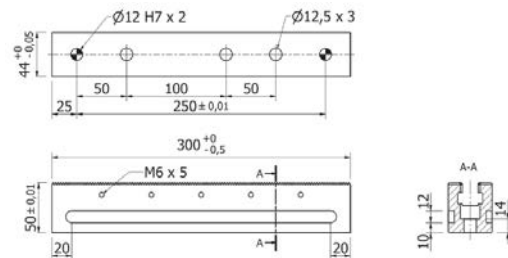


RM-300

This length rail is most commonly used to replace old-fashioned machine vises.



Part Number	Size
RM-300	300MM

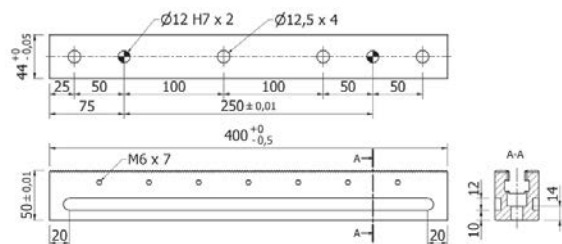


RM-400

On Multi-Rail base rails L=400...700 mm, positioning hole is the second one from the end of each rail. Please note that the end of the rail is different from the start. The numbering of the scale starts from the left.



Part Number	Size
RM-400	400MM



LOW PROFILE CLAMPING

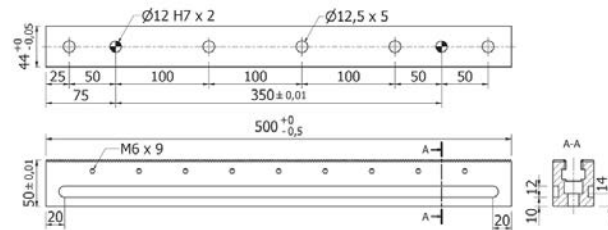
Base Rail RM Series

RM-500

A good universal rail for VMC and HMC machining.

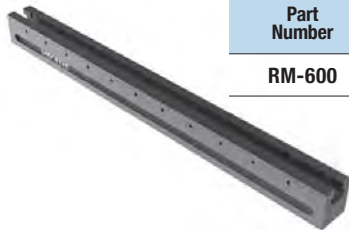


Part Number	Size
RM-500	500MM

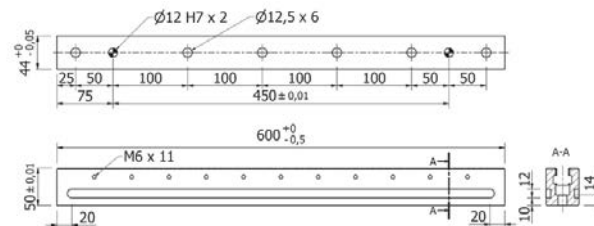


RM-600

This rail length is very popular on tooling blocks.

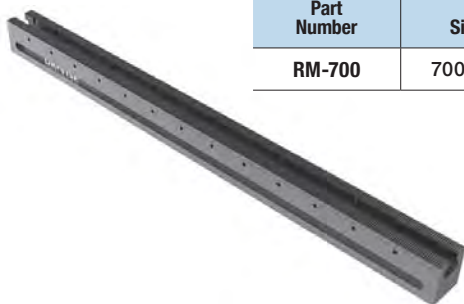


Part Number	Size
RM-600	600MM

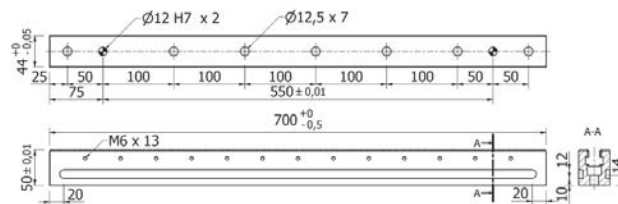


RM-700

This is the longest standard rail produced by OK-VICE. Special length rails (also longer than RM-700) are also available.



Part Number	Size
RM-700	700MM

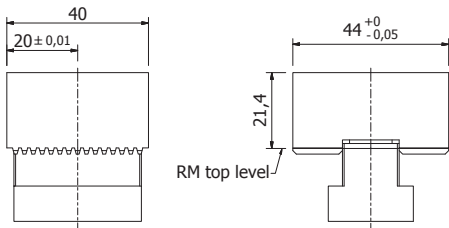
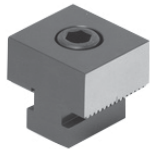


Multi-Rail RM Stop Modules

- All modules feature serrated undersides to mesh with RM rail bases and resist high clamping forces
- Multiple styles adapt to a wide range for workpieces
- Easily re-position on rail base to reduce setup time
- All modules include T-nut and SHCS
- Recommend installation torque: 37 ft*lbs (50 Nm) Min. – 74 ft*lbs (100 Nm) Max.

Smooth Stop

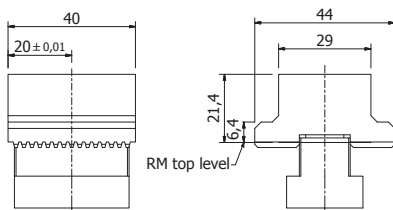
The most common stop is RMS-S, which has two smooth and nitrided jaws. The accuracy from the serrations to the jaw surface is $\pm 0.01\text{mm}$



Part Number	Wt. (lbs)
RMS-S	0.88

Smooth Stop - Narrow

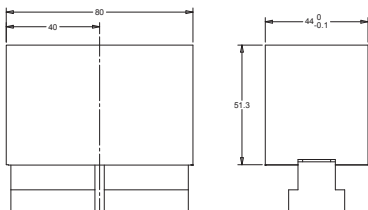
A narrow version of the smooth stop, about the same width as a B-series clamp



Part Number	Wt. (lbs)
RMS-S2	0.75

Smooth Stop - Tall

A tall version of the smooth stop. The extended length and additional mounting screw provide extra support when clamping high on workpieces



Part Number	Wt. (lbs)
RMS-S3	3.52

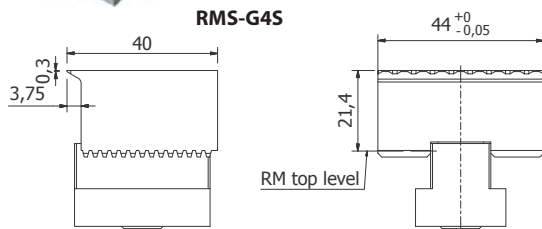
Multi Rail RM Stop Modules

Knife Edge Stop



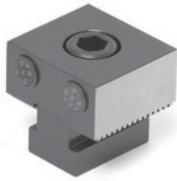
This model has a knife edge grip jaw on one side. The serrated teeth of the knife edge can penetrate into softer materials to prevent workpiece movement. The second side of the stop is a smooth face jaw

Part Number	Wt. (lbs)
RMS-G4S	0.80

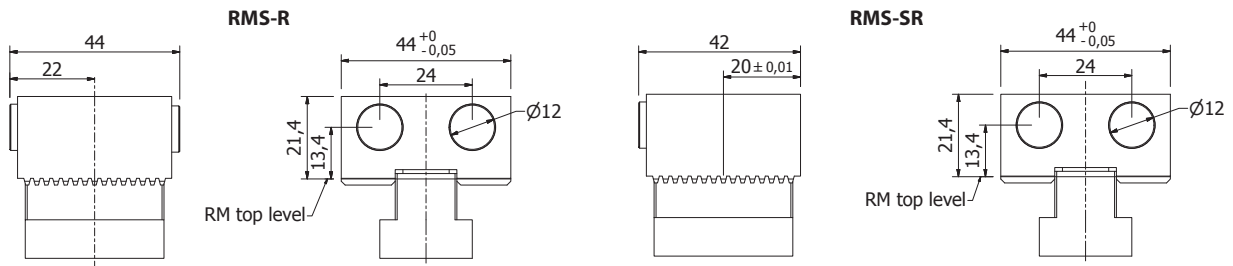


Serrated Pad Stops

These stops feature round serrated contact areas that hold both large and small workpieces firmly in position. The accuracy from the rail serrations to the jaw face serrations is $\pm 0.25\text{mm}$

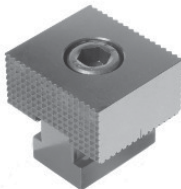


Part Number	Description	Wt. (lbs)
RMS-R	Serrated Pads on Both Faces	0.86
RMS-SR	1 Face with Serrated Pads, 1 Smooth Face	0.86

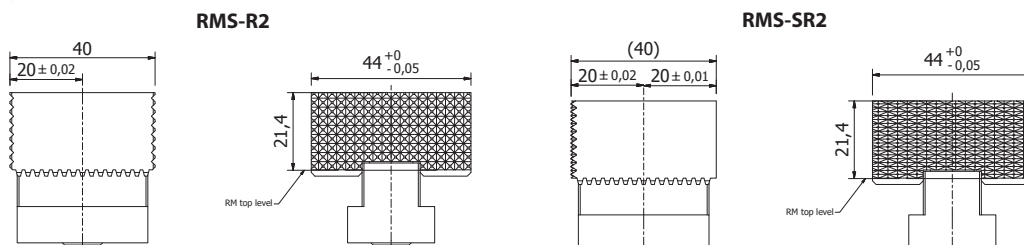


Serrated Face Stop

These stops have serrations covering the entire face of the jaw. The Jaw faces are nitrided

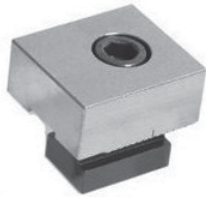


Part Number	Description	Wt. (lbs)
RMS-R2	Both Faces Serrated	0.88
RMS-SR2	1 Serrated Face, 1 Smooth Face	0.88



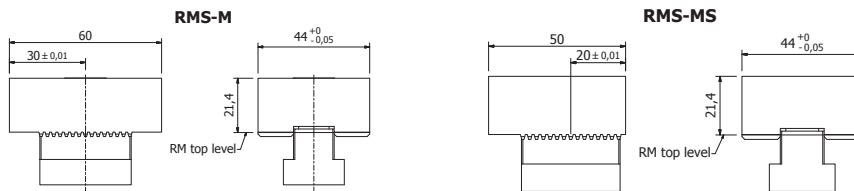
Multi Rail RM Stop Modules

Machinable Stops



Machinable stops are especially suitable machining complex workpieces, or when extreme accuracy is needed and product-specific jaws are used for machining

Part Number	Description	Wt. (lbs)
RMS-M	Both Faces Machinable	1.21
RMS-MS	1 Machinable Face, 1 Smooth Face	1.01

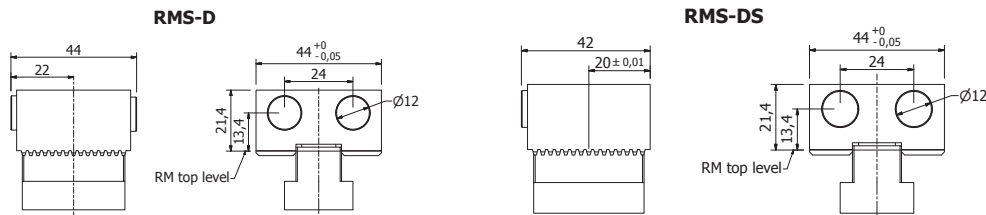


Diamond Gripper Stops

These stops feature round diamond grippers that hold parts securely in place with additional friction. The accuracy from the rail serrations to the diamond grippers is ±0.25mm



Part Number	Description	Wt. (lbs)
RMS-D	Diamond Grippers on Both Faces	0.86
RMS-DS	1 Diamond Gripper Face, 1 Smooth Face	0.86

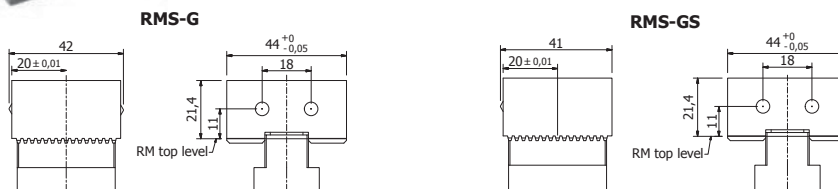


Point Gripper Stops

These models have two HSS pins that penetrate into the workpiece, leaving tiny marks on it. The friction is much higher than that of using the standard serrated jaw, against soft steel the friction co-efficient factor is up to 0,8



Part Number	Description	Wt. (lbs)
RMS-G	Point Grippers on Both Faces	0.88
RMS-GS	1 Point Gripper Face, 1 Smooth Face	0.86

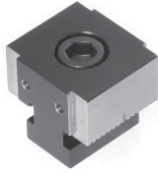


LOW PROFILE CLAMPING

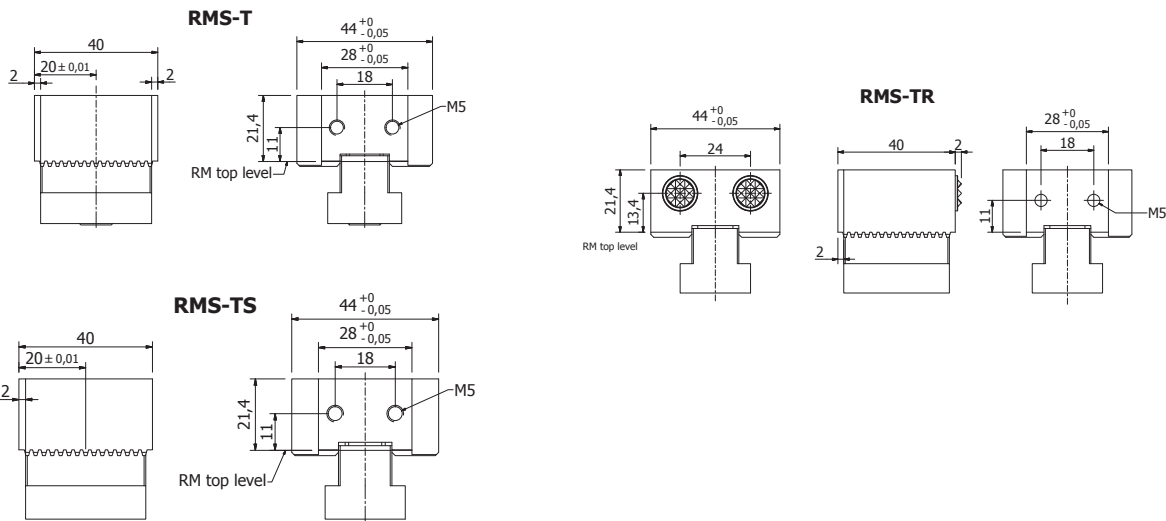
Multi Rail RM Stop Modules

Mounting Jaw Stops

These stops use the same bolt-on soft jaws used by the D-Series low profile mounting jaw clamps. See page 10 for bolt on soft jaws



Part Number	Description	Wt. (lbs)
RMS-T	Mount Jaw on Both Faces	0.88
RMS-TS	1 Mounting Jaw Face, 1 Smooth Face	0.88
RMS-TR	1 Mounting Jaw Face, 1 Serrated Pad Face	0.88

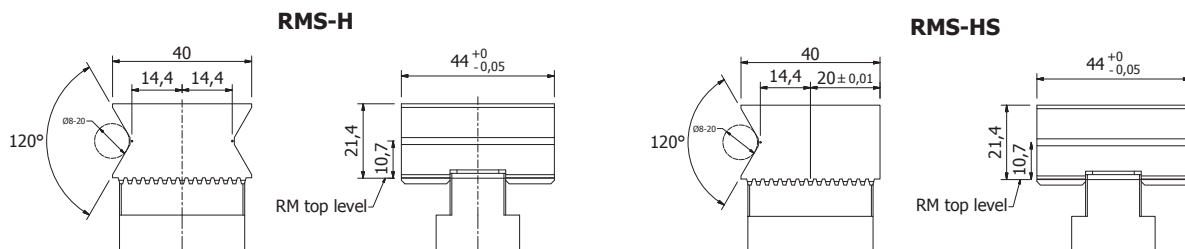


Horizontal V-Stops

These stops feature a horizontal V shape ideal for holding small round parts and bars



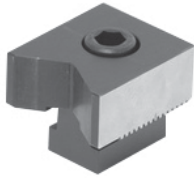
Part Number	Description	Wt. (lbs)
RMS-H	Horizontal V on Both Faces	0.86
RMS-HS	1 Horizontal V Face, 1 Smooth Face	1.00



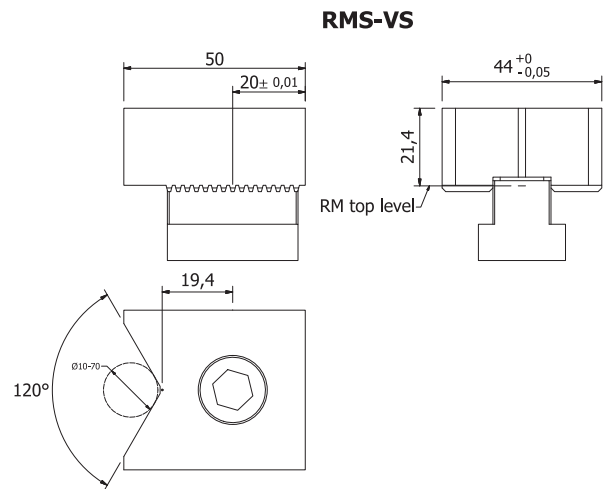
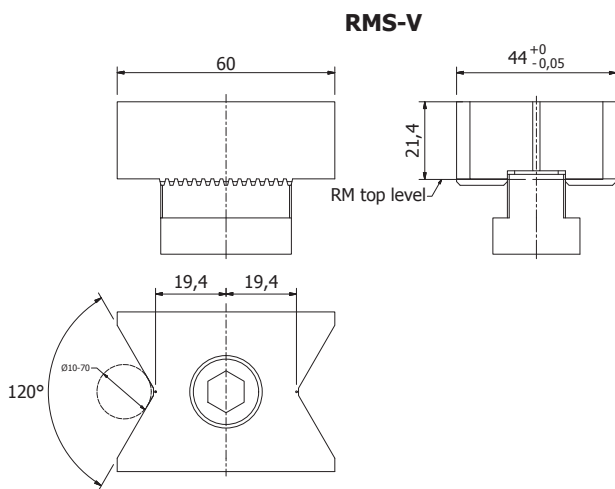
Multi Rail RM Stop Modules

Vertical V-Stops

These stops feature a vertical V shape ideal for holding round parts of various sizes



Part Number	Description	Wt. (lbs)
RMS-V	Vertical V on Both Faces	1.08
RMS-VS	1 Vertical V Face, 1 Smooth Face	1.00

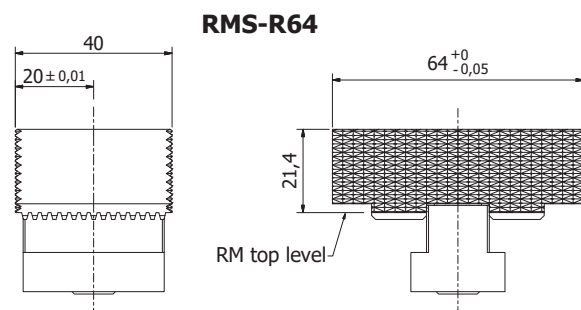
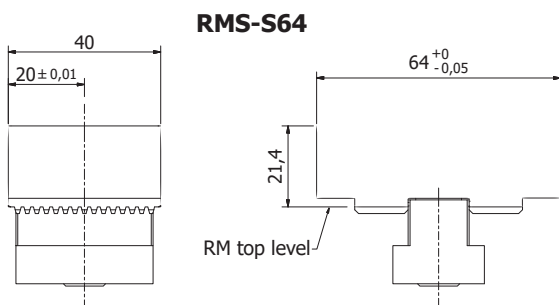


Wide Stops

Wide stops are available with smooth or serrated faces. These models are ideal for holding larger workpieces where a clamping width wider than the rail base is needed. The contact areas are nitrided



Part Number	Description	Wt. (lbs)
RMS-S64	Wide Stop, Both Faces Smooth	1.30
RMS-R64	Wide Stop, Both Faces Serrated	1.30



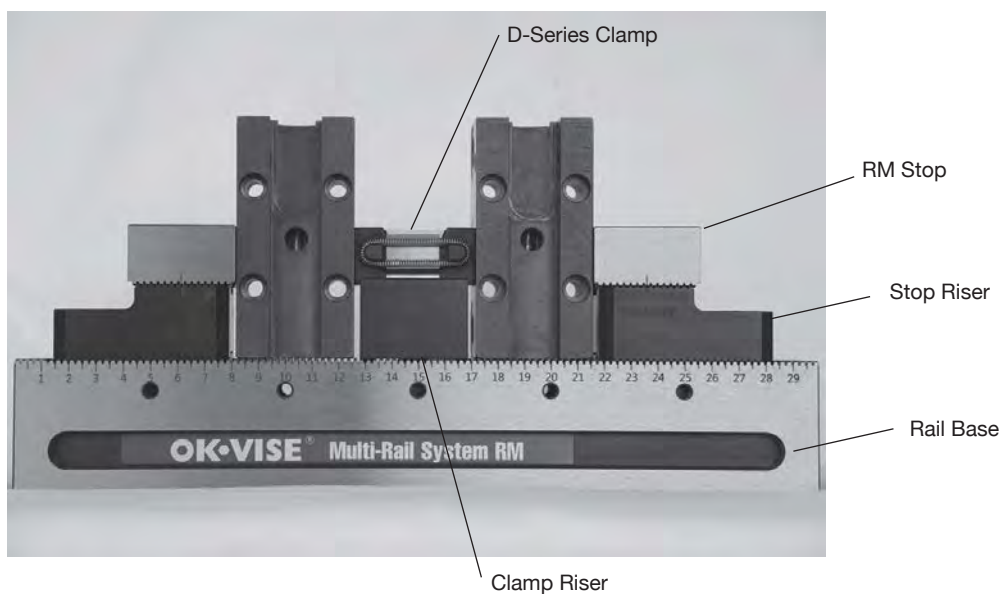
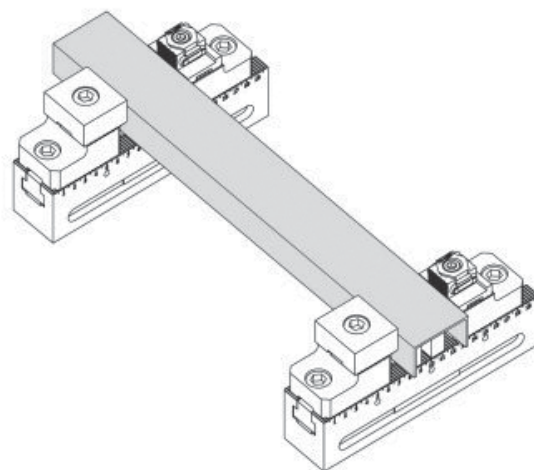
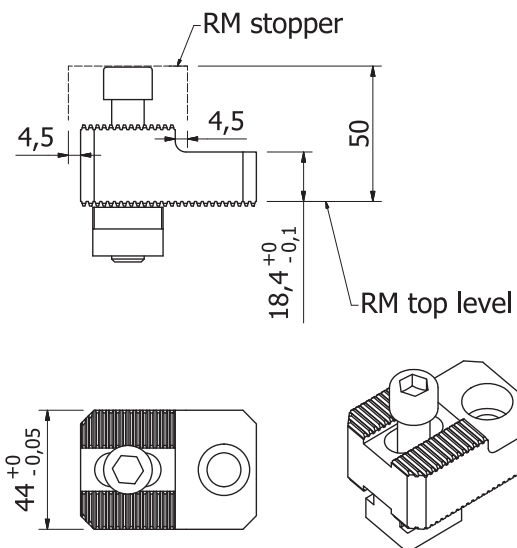
Multi Rail RM Stop Modules

Stop Riser

This serrated riser block lifts up RM stoppers 28 mm, the RM serration is both on the bottom and the top of the block. Additional RM T-nut and longer bolt are included, so stoppers like RMS-S, RMS-R etc. will work directly on this riser block. The bolt and T-nut form the original stopper are used the lower hole of the riser block



Part Number	Wt. (lbs)
RMRS-28	1.01



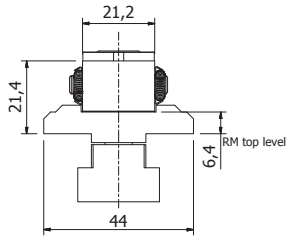
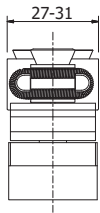
Multi Rail RM Clamp Modules

B-Series RM Clamps

These clamp modules feature a standard B-series clamp combined with a socket head cap screw, riser plate, and t-nut

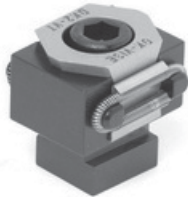


Part Number	Description	Wt. (lbs)
RMC-BS	2 Smooth Face Jaws	0.45
RMC-BR	2 Serrated Face Jaws	0.45
RMC-BSR	1 Smooth Face Jaw, 1 Serrated Face Jaw	0.45



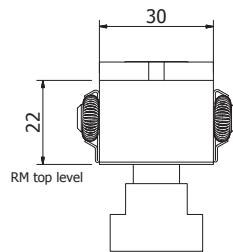
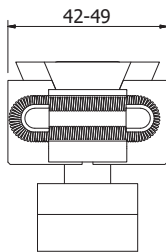
D-Series RM Clamps

These clamp modules feature a standard D-series clamp combined with a socket head cap screw and t-nut

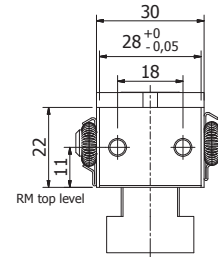
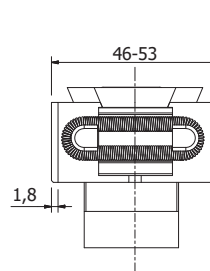


Part Number	Description	Wt. (lbs)
RMC-DS	2 Smooth Face Jaws	0.62
RMC-DR	2 Serrated Face Jaws	0.62
RMC-DSR	1 Smooth Face Jaw, 1 Serrated Face Jaw	0.62
RMC-DT	2 Mounting Jaw Faces	0.62
RMC-DTS	1 Mounting Jaw Face, 1 Smooth Jaw	0.62
RMC-DTR	1 Mounting Jaw Face, 1 Serrated Jaw	0.62

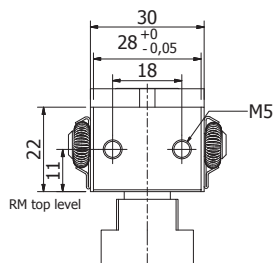
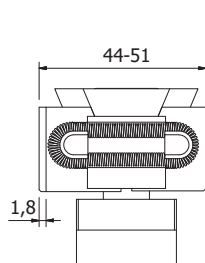
**RMC-DS
RMC-DR
RMC-DSR**



RMC-DT



**RMC-DTS
RMC-DTR**



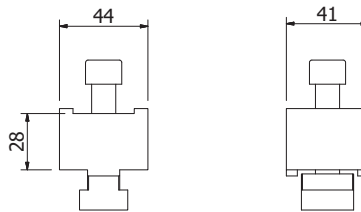
Multi Rail RM Clamp Modules

Clamp Riser



This unit raises a D-Series clamp 28mm above the top surface of an RM rail base. It includes the riser block, extended length screw, and t-nut. Suitable for use with D-Series clamps only

Part Number	Wt. (lbs)
RMRC-28	1.17



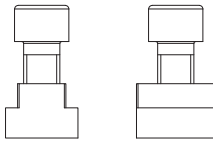
Adapter Sets



These adapter sets make standard B or D series clamps compatible with the RM rail system so users can build their own RM clamp modules. They include a screw and t-nut. RMA-BP1 also includes a riser plate

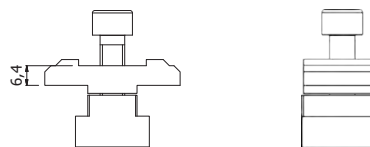
Part Number	Wt. (lbs)
RMA-D1	0.22
RMA-BP1	0.3 1

RMA-D1



Suitable in Multi-Rail RM with D size clamp

RMA-BP1



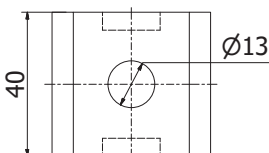
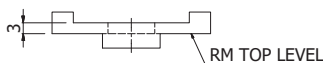
Suitable in Multi-Rail RM with B size clamp

Rotation Stop Plate



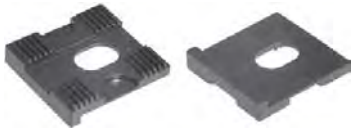
This plate is used with D-series clamps to prevent the clamp rotating on the rail.

Part Number	Wt. (lbs)
PRD-1	0.11



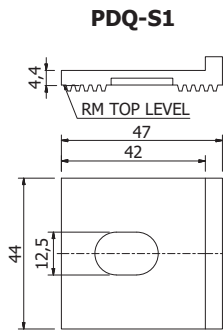
Multi Rail RM Clamp Modules

Speed Plates

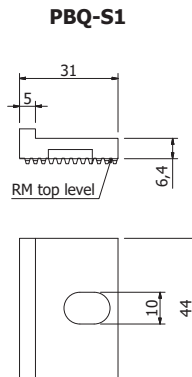


The speed plate option enables users of Multi-Rail RM to move clamp modules on the rail into a different position in just a few seconds. It also replaces one stopper module to save space. Available for D or B series clamps. Please notice this module holds clamping force in one direction only

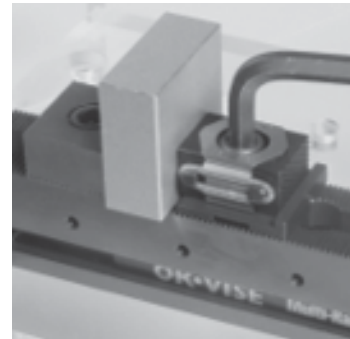
Part Number	Description	Wt. (lbs)
PBQ-S1	1 Speed Plate for B-Series Clamp	0.15
PDQ-S1	1 Speed Plate for D-Series Clamp	0.15



Suitable D-size clamps with short back jaw (smooth or serrated).



Suitable B-size clamps with short back jaw (smooth or serrated).

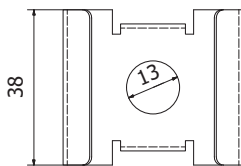
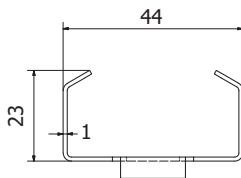


Rotation Stop Plate with Spring Guards



This rotation stop plate also features a guard on each side to protect the return springs. It is compatible with D-series clamps only

Part Number	Wt. (lbs)
PRD-2	0.07



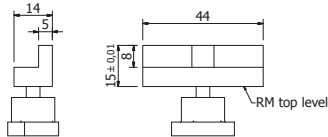
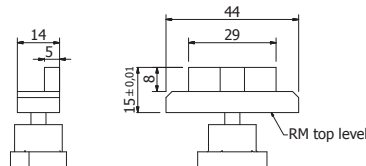
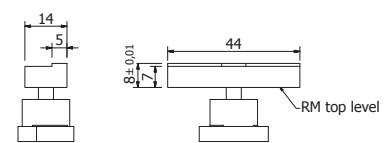
Multi Rail RM Parallels and Side Guides

T-Slot Parallels



Parallels assist in the positioning of a workpiece on the RM rail. They also protect the serrations of the rail by providing a raised datum surface. This style mounts with a special t-nut specifically designed for the RM rail base

Part Number	Description	Wt. (lbs)
RMP-1	15mm Height, Full Width	0.15
RMP-2	15mm Height, Narrow Width	0.13
RMP-1H8	8mm Height, Full Width	0.13

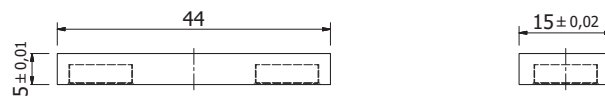
RMP-1

RMP-2

RMP-1H8


Magnetic Parallel



This style parallel mounts with magnets to the face of a smooth stop or directly on the serrations of a rail base

Part Number	Wt. (lbs)
RMP-MG1	0.07

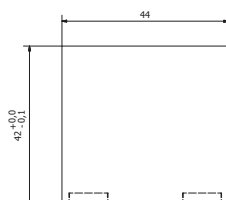


Tall Magnetic Parallel

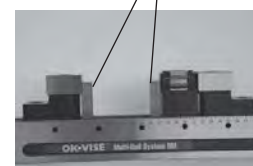


This style mounts with magnets directly on the serrations of a rail base. The extended height allows it to be used with the clamp and stop risers. This version is machinable

Part Number	Wt. (lbs)
RMP-M42	0.58

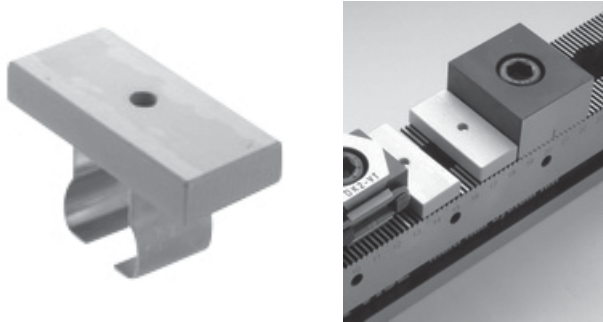


Parallels



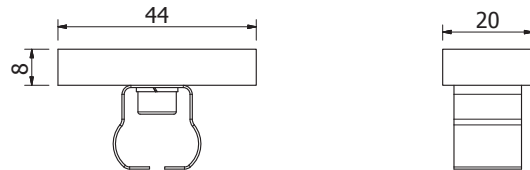
Multi Rail RM Parallels and Side Guides

Snap-in Parallel

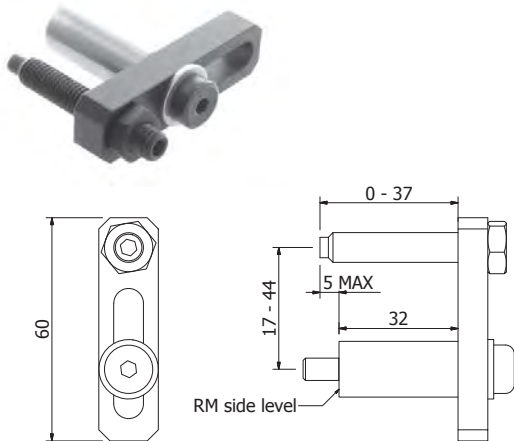


This parallel features a spring clip that snaps into the rail t-slot, which speeds up installation

Part Number	Wt. (lbs)
RMP-J1	0.07



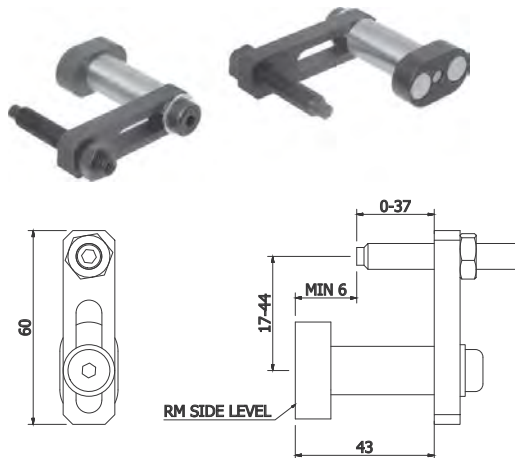
Side Guide



Side guides are designed to assist in positioning the workpiece on the Multi-Rail. They mount to the tapped holes in the side of the rail and can be adjusted to many positions

Part Number	Wt. (lbs)
RMG-1	0.24

Magnetic Side Guide

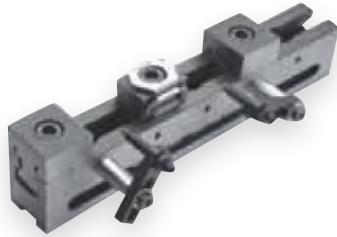


This side guide mounts to the side of the rail with a magnetic base. It can be moved rapidly from one place to another. Using this type of side guide, users can adjust each side guide for a specific product and keep the guide ready for the next production batch. The magnetic base can be ordered by itself (M1).

Part Number	Description	Wt. (lbs)
RMG-M1	Side Guide w/ Magnetic Base	0.33
M1	Magnetic Base	0.09

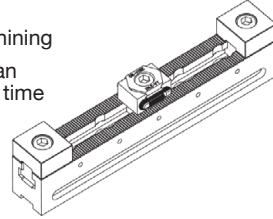


RM Application #1



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

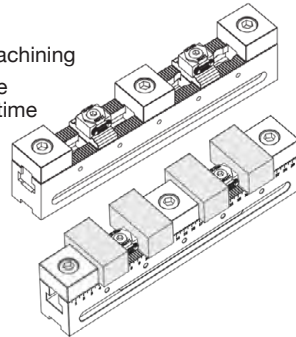


Code	Name	Pcs
RM-300	Multi-Rail Base	1
RMS-S	Stop Module Smooth	2
RMC-DS	Clamp Module D Smooth	1

RM Application #2



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

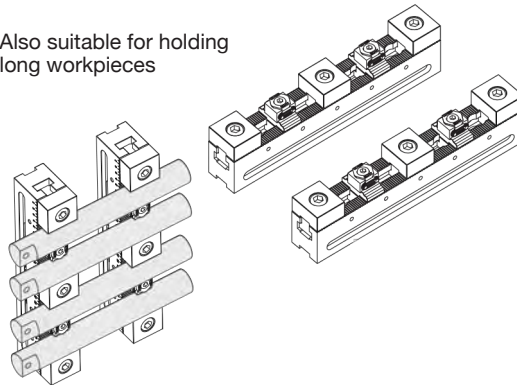


Code	Name	Pcs
RM-300	Multi-Rail Base	1
RMS-S	Stop Module Smooth	3
RMC-BS	Clamp Module B Smooth	2

RM Application #3



- Also suitable for holding long workpieces

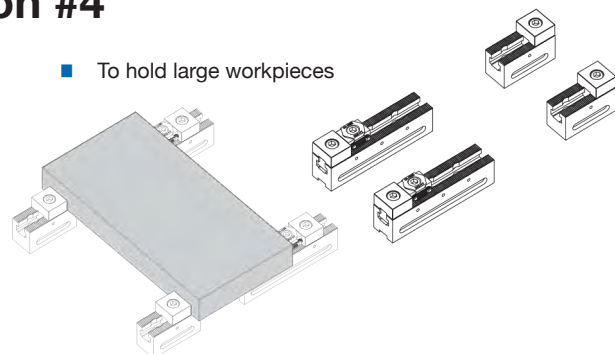


Code	Name	Pcs
RM-300	Multi-Rail Base	2
RMS-S	Stop Module Smooth	6
RMC-BS	Clamp Module B Smooth	4

RM Application #4

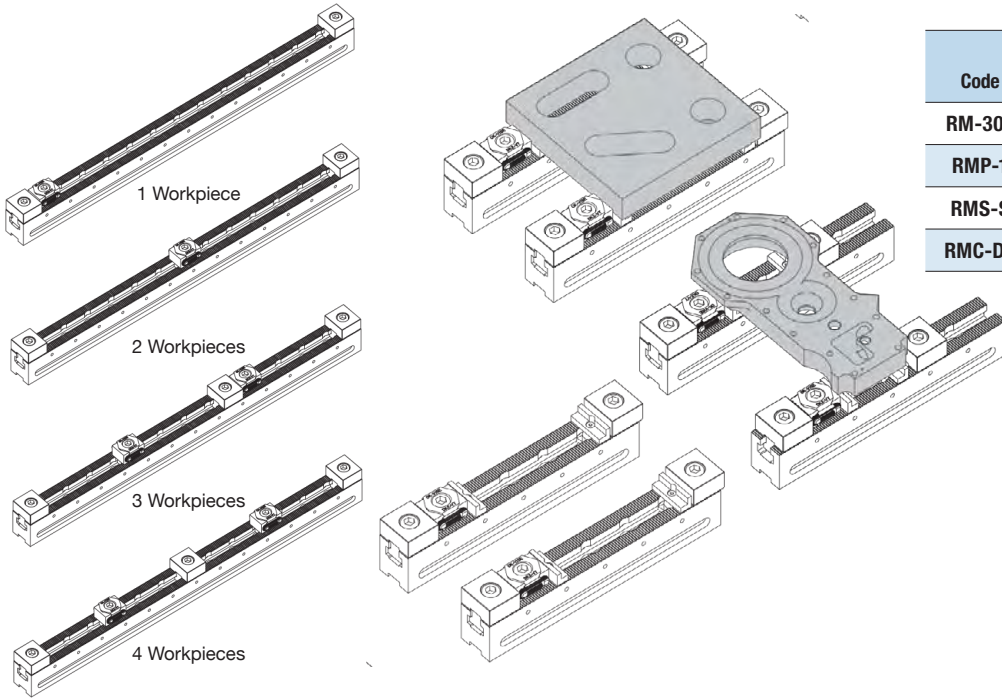


- To hold large workpieces



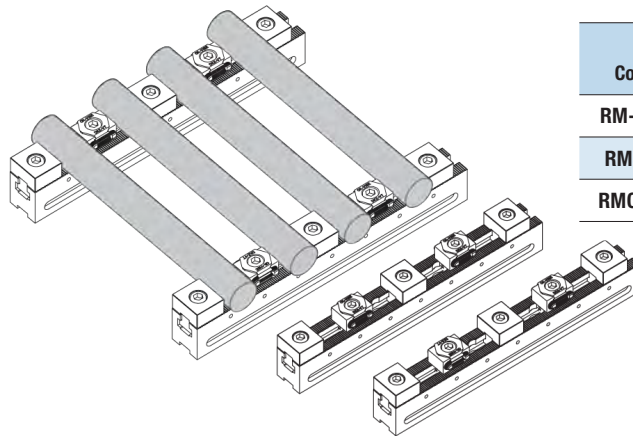
Code	Name	Pcs
RM-100	Multi-Rail Base	2
RM-200	Multi-Rail Base	2
RMC-DS	Clamp Module D Smooth	2
RMS-S	Stop Module Smooth	4

RM Application #5



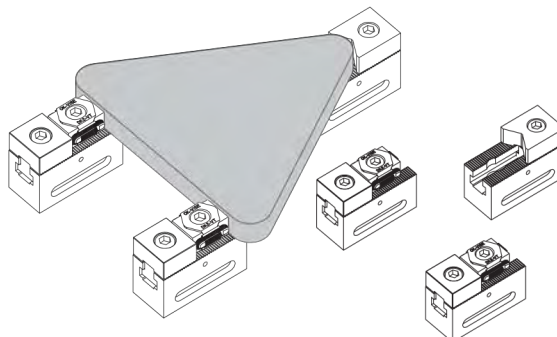
Code	Name	Pcs
RM-300	Multi-Rail Base	2
RMP-1	Parallel Block	4
RMS-S	Stop Module Smooth	4
RMC-DS	Clamp Module D Smooth	2

RM Application #6



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

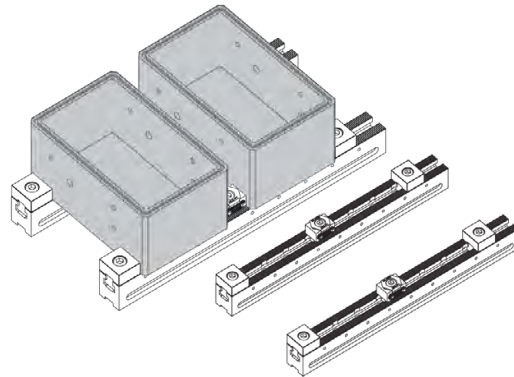
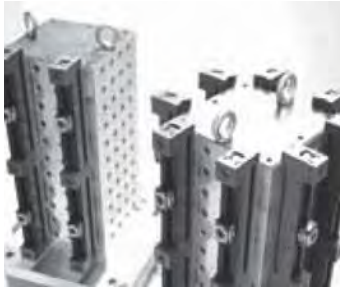
RM Application #7



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

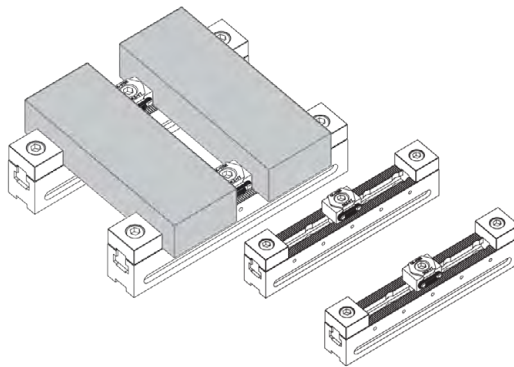
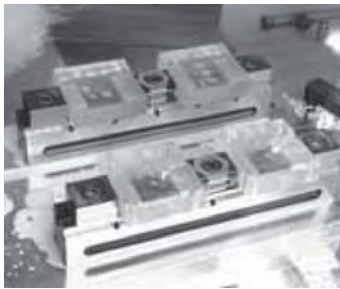
LOW PROFILE CLAMPING

RM Application #8



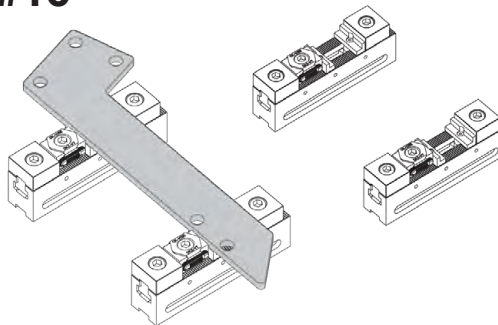
Code	Name	Pcs
RM-S	Stop Module Smooth	4
RMC-DS	Clamp Module Smooth	2
RM-500	Multi-Rail Base	2

RM Application #9



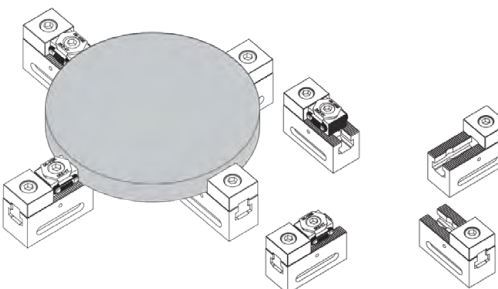
Code	Name	Pcs
RM-300	Multi-Rail Base	2
RMS-S	Stop Module Smooth	4
RMC-DS	Clamp Module Smooth	2

RM Application #10



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

RM Application #11



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

Basic Modules

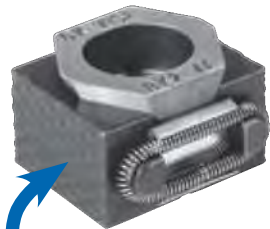
Jergens/OK-Vise low-profile clamps are the core components of our Multi-Rail system. Our low-profile clamps are available with various jaw types. In the Multi-Rail RM system, clamps of sizes D and B can be used.

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

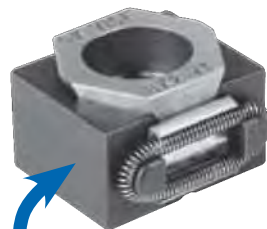
- Clamp modules
- Stop modules
- Side guides
- Parallels and riser blocks



Single-Wedge Clamp



Clamps with Serrated Jaws



Clamps with Smooth Jaws



Pull-Down Models

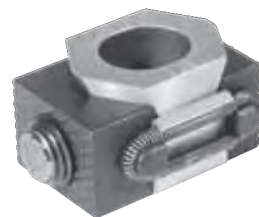
- Double Wedge
- Single Wedge



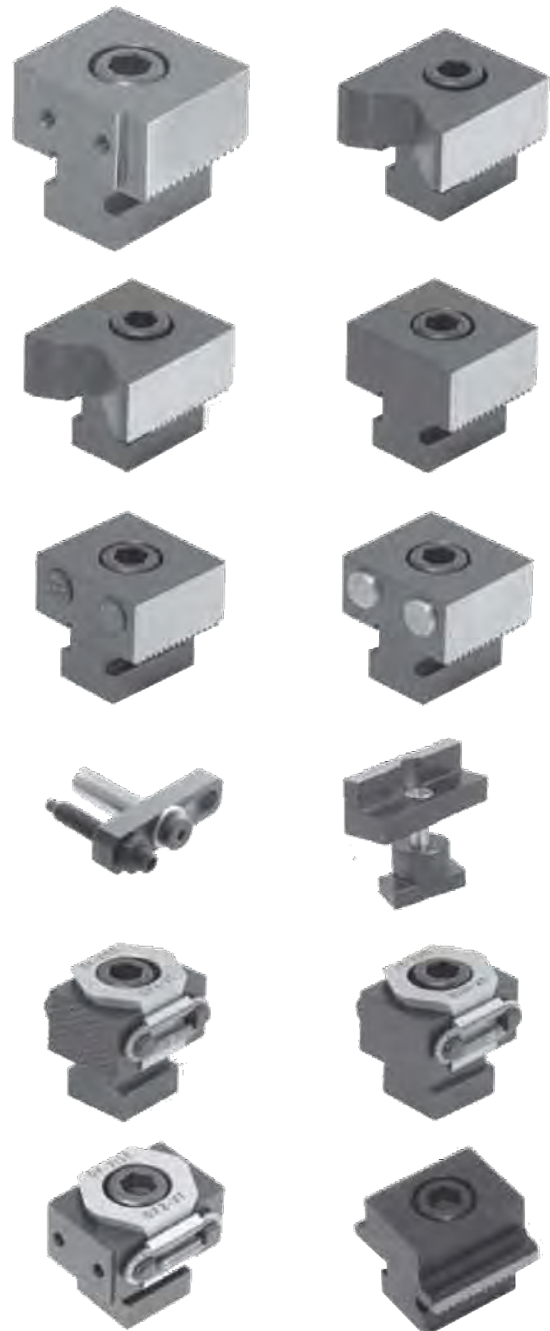
Clamps with Machinable Jaws



Additional Piece Models



Clamps with Self-Adjustable Jaws



MULTI-RAIL RH SYSTEM

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.

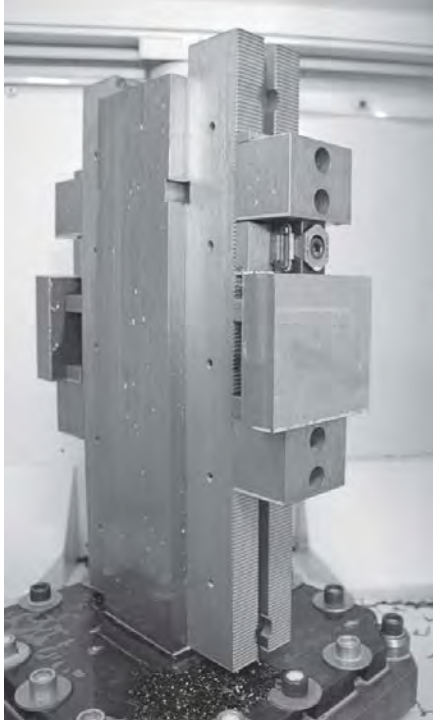
Fixture Sets

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.



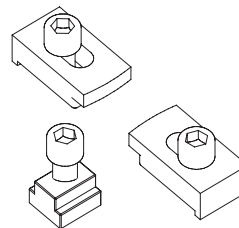
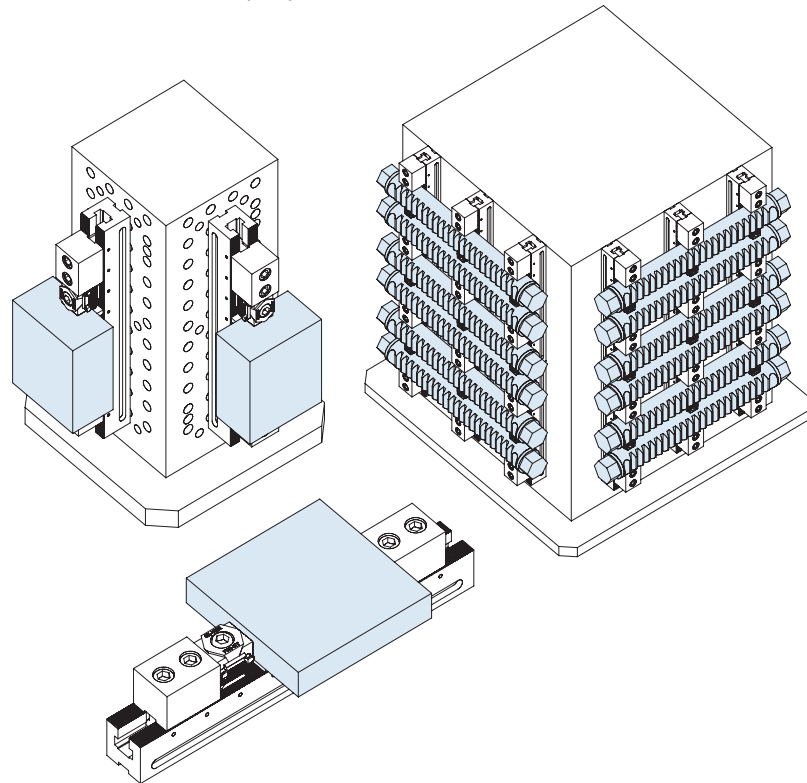
Multi-Rail RH System



In a modular system all the functions of a fixture are divided 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.

Jergens/OK-VICE low-profile clamps are the core component of our Multi-Rail system. Our low-profile clamps are available with various jaw types. In the Multi-Rail RH system, clamps of sizes D and F can be used.

The original Jergens/OK-VICE low-profile clamps are known worldwide as a core component of any modern fixturing system. In the machining industry, the Jergens/OK-VICE name stands for quality.



We also offer installation sets for the most typical platforms like T-slot tables Jergens Fixture Pro System and other Grid Systems.

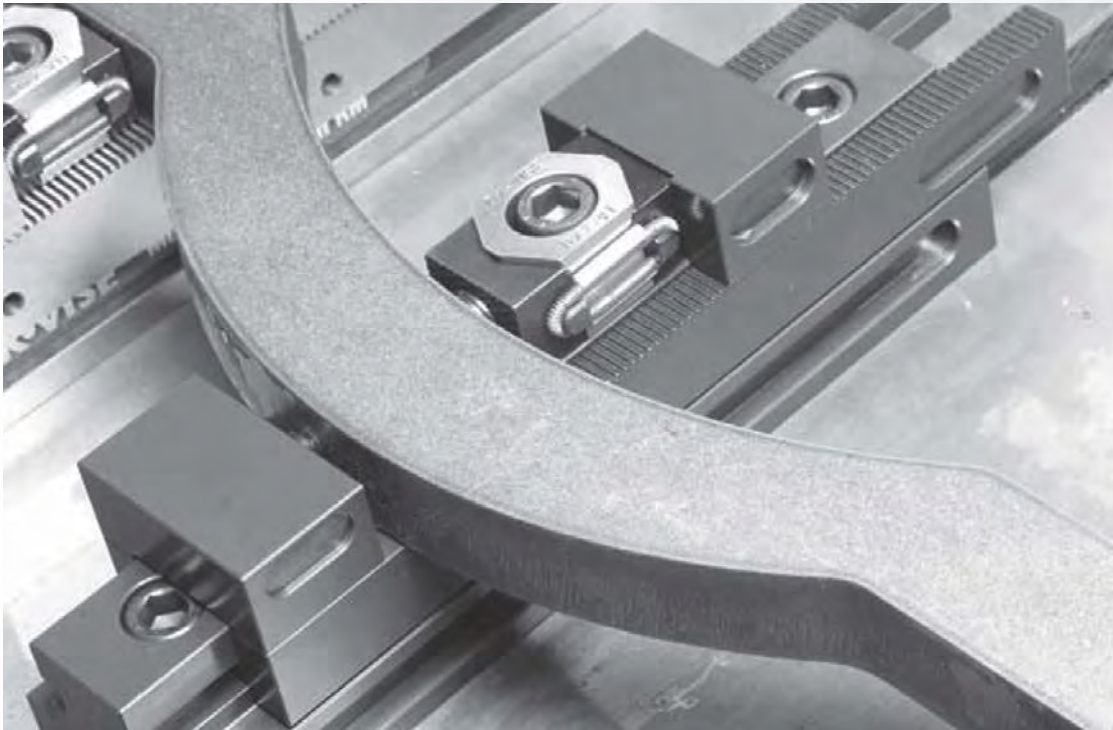
COMBO-RAIL

Jergens[®] / OK-VISE[®]

WORKHOLDING CLAMPS AND ACCESSORIES

Combo-Rail

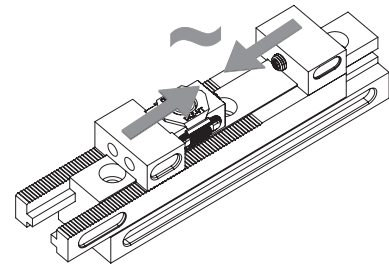
Jergens/OK-VISE Combo-Rail is a unique patent-pending design from us. There are several operating modes available: Floating Mode, Centralizing Mode and Machine Vice Mode.



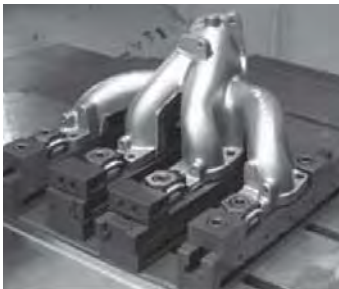
Floating Mode



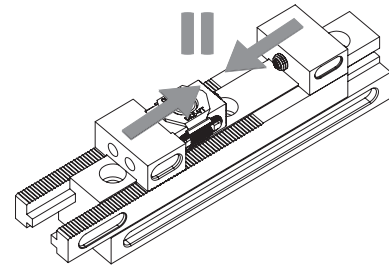
This is the most fascinating operating mode of the Combo-Rail. Here the fixture adjusts to the place of the workpiece. This is often needed while clamping inaccurate workpieces like castings, forgings or flame cut work pieces. Therefore floating mode installation normally needs positioning with some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



Centralizing Mode



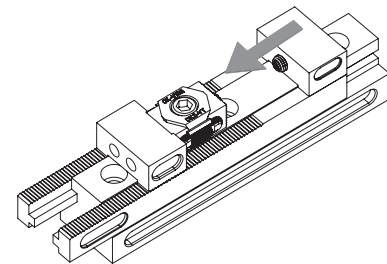
The jaws move synchronously. The center line of a casting or similar workpiece remains in the same place even if the outer dimensions of the workpiece changes. Centralizing mode



Machine Vise Mode

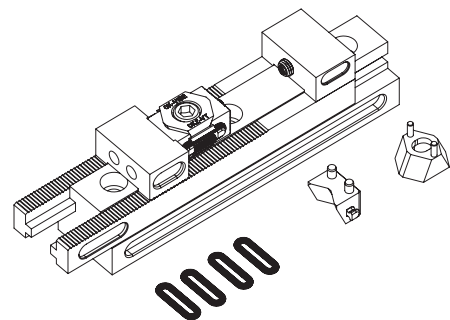


In this mode the other jaw is fixed to the base. Compared to traditional Vises, in this method the ergonomics are radically improved in vertical machining centres



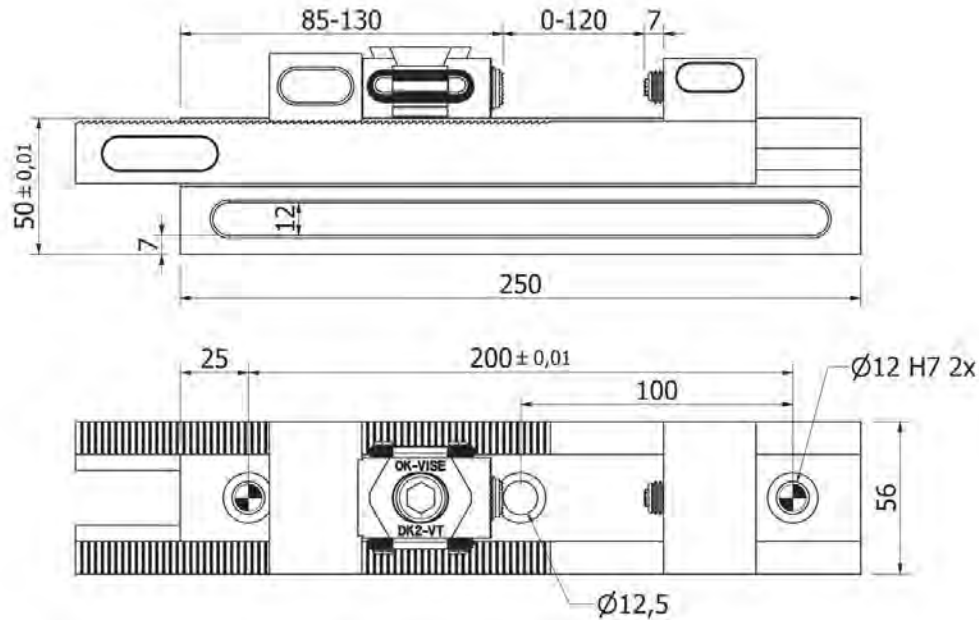
Universal Mode

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 length is 250 mm.



LOW PROFILE CLAMPING

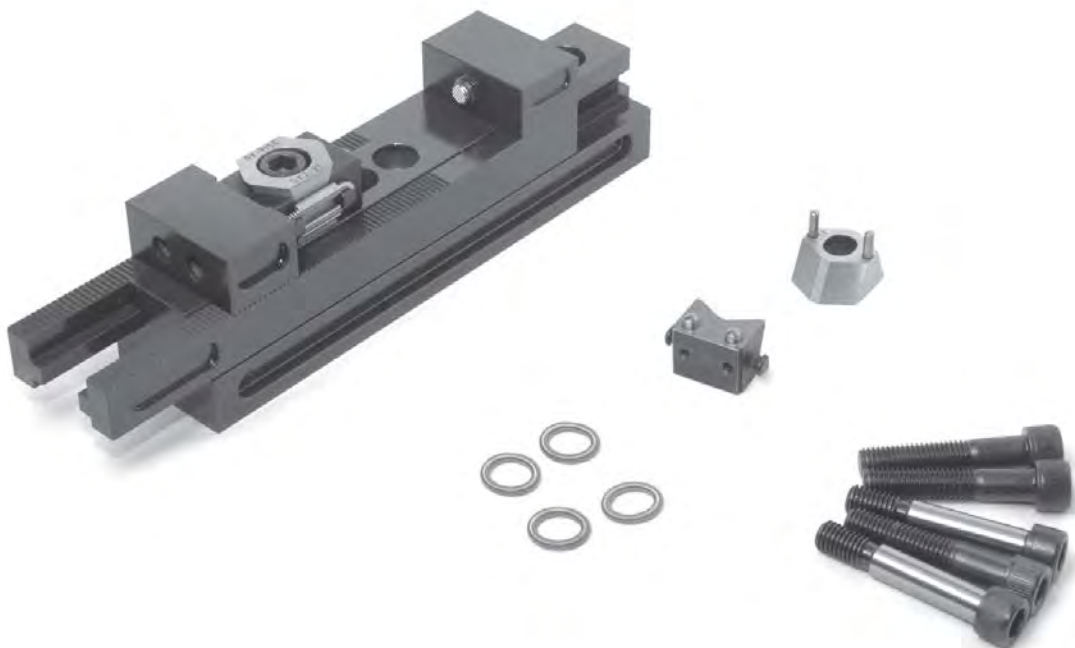
CRH-K250



CRH-K250 is a Combo-Rail unit that can be set in three operating modes:

- Floating mode
- Centralizing mode
- Machine vise mode

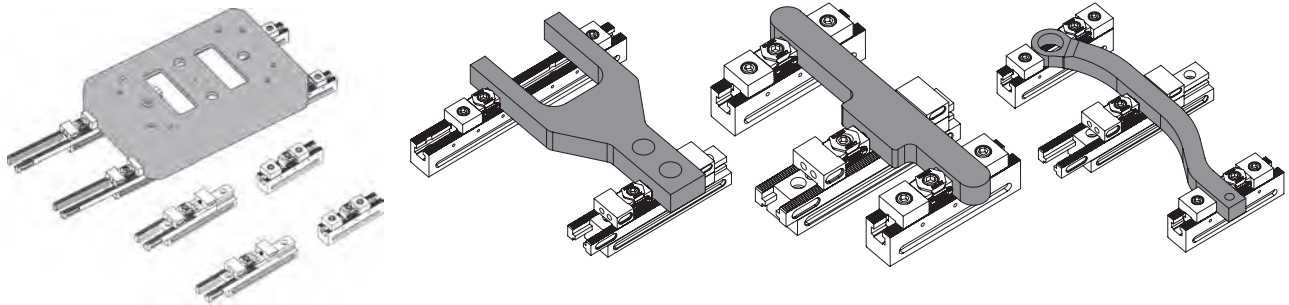
Switch operating modes by changing the jaw or wedge components (all included). Any workpiece of the size from 0 to 120 mm can be clamped. The base height is 50 mm and the total length is 250 mm.



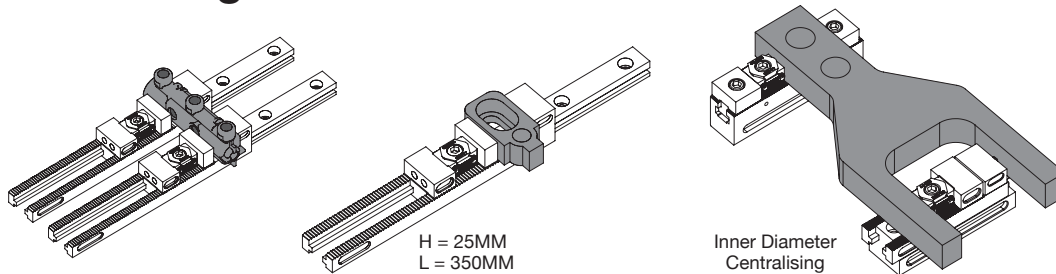
Combo-Rail Applications

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.

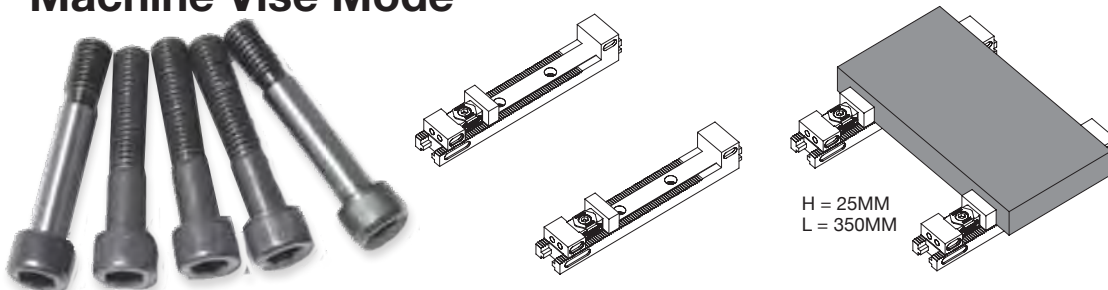
Floating Mode



Centralizing Mode



Machine Vise Mode

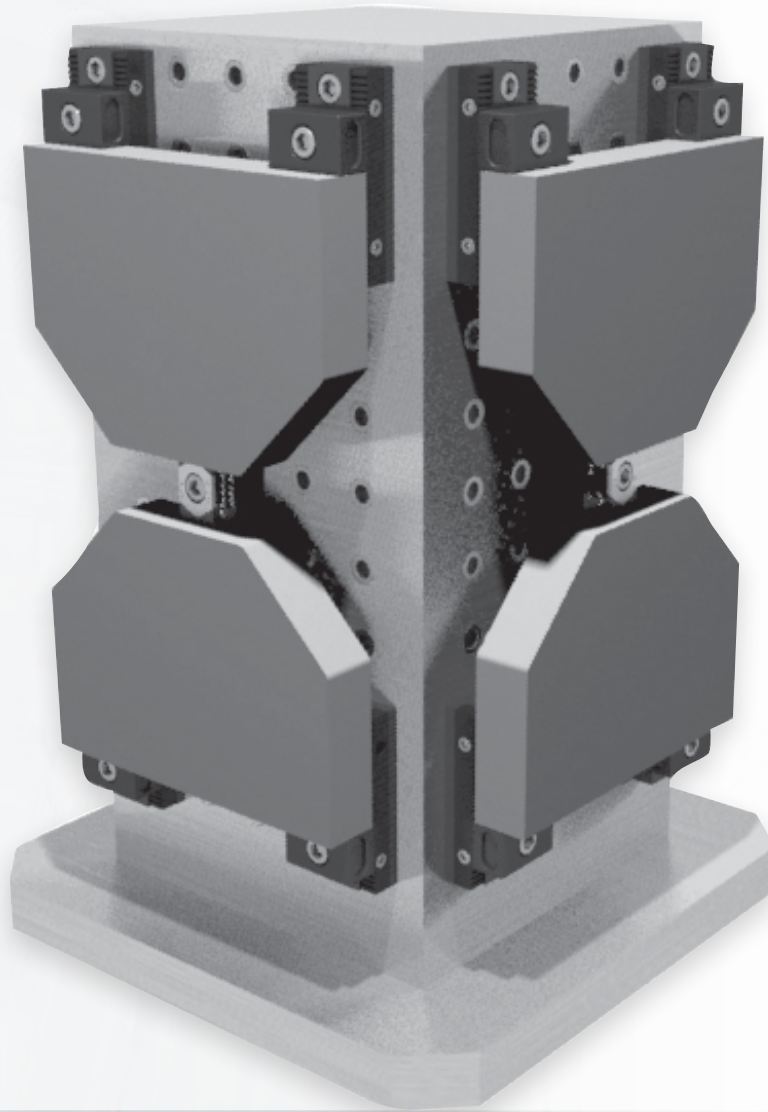


There are several adapter sets available for various platforms.

GRID FIXTURING SYSTEM

Jergens[®] / **OK-VISE**[®]

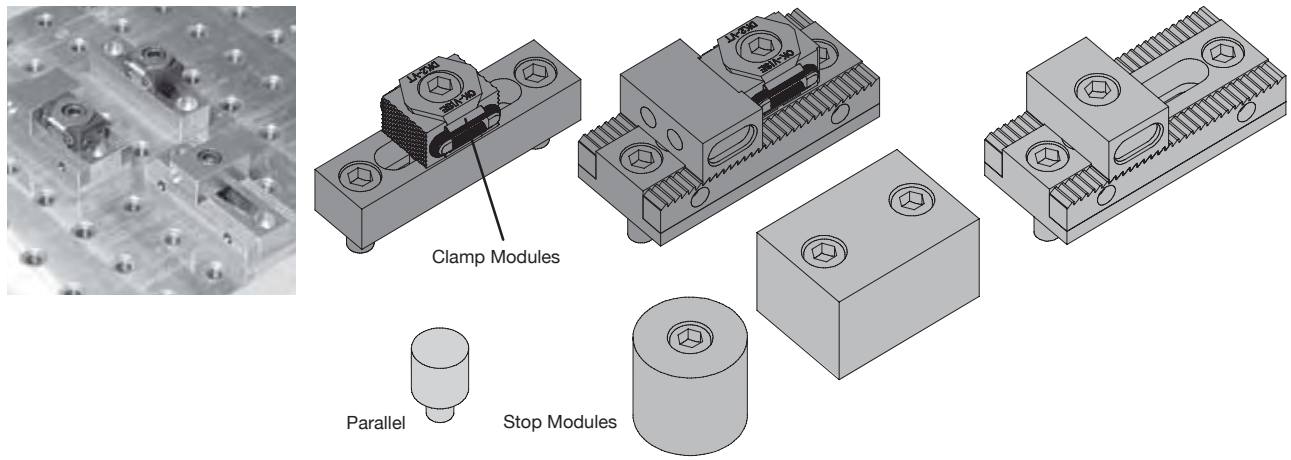
WORKHOLDING CLAMPS AND ACCESSORIES



Grid Fixturing System

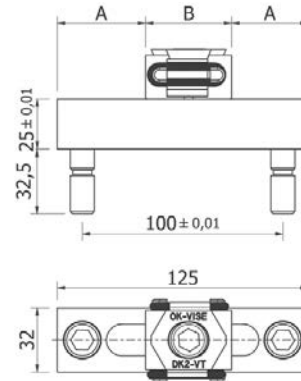
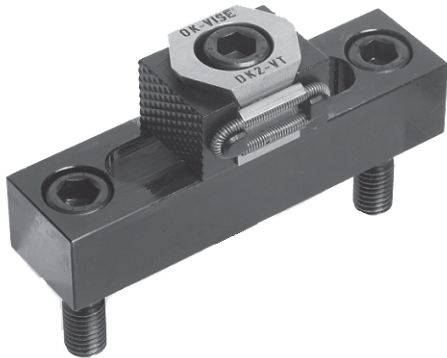
Grid Fixturing System is the new generic-purpose fixturing system from Jergens/OK-VISE. It can be adapted to the grid platforms of leading workholding suppliers. With the Grid Fixturing System very complex forms of workpieces can be also clamped. On a grid platform you can also combine Jergens/OK-VISE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

Grid Fixturing System Components



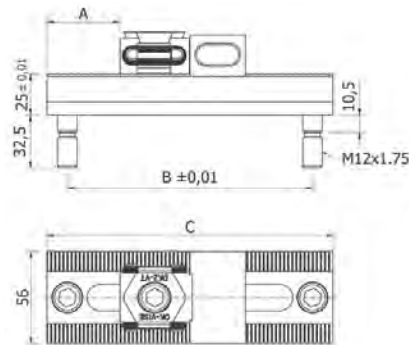
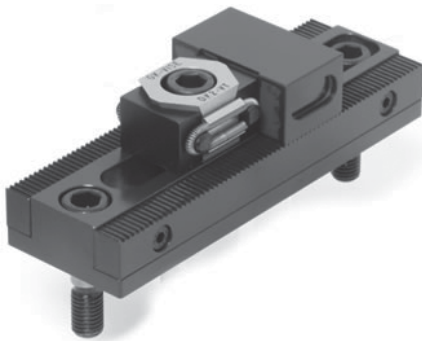
Clamp Module		Stop Module		Parallel	
GCD-DR1	Serrated Jaws, D-Series	GS-SF1	Round Smooth	GP-1	Round
GCD-DS1	Smooth Jaws, D-Series	GS-SF2	Rectangular, Fixed, Smooth		
GCS-DS1	Adjustable, Smooth D-Series Jaw	GS-SA1	Adjustable, Smooth		
GCS-DR1	Adjustable, Serrated D-Series Jaw	GS-RA1	Adjustable, Serrated		
GCS-DR2	Adjustable, Serrated D-Series Jaw	GS-SA2	Adjustable, Smooth		
GCS-DS2	Adjustable, Smooth D-Series Jaw	GS-RA2	Adjustable, Serrated		
GCS-DS3	Adjustable, Smooth D-Series Jaw				

Clamp Module, Dual Directional



Part Number	Jaw Face	A	B
GCD-DR1	Serrated	8-71	42-49
GCD-DS1	Smooth	8-71	42-49

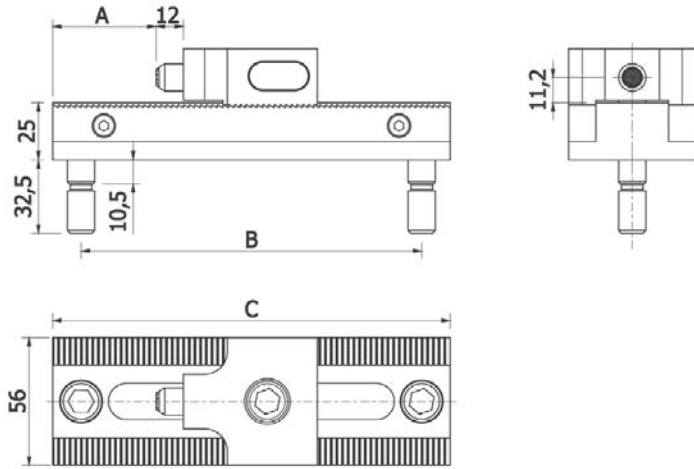
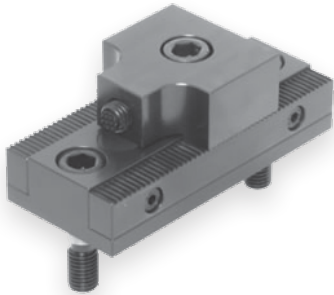
Clamp Module, Single Direction



Part Number	Jaw Face	A	B	C
GCS-DR1	Serrated	10-45	100	125
GCS-DR2	Serrated	10-95	150	175
GCS-DS1	Smooth	10-45	100	125
GCS-DS2	Smooth	10-95	150	175
GCS-DS3	Smooth	10-68	110-150**	175

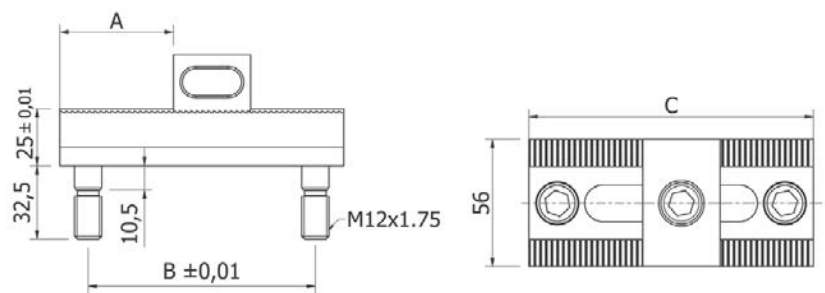
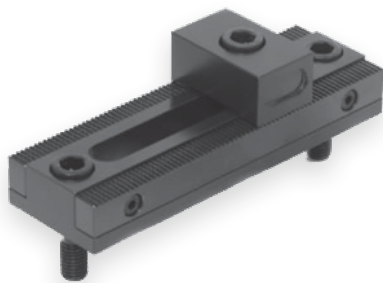
**Variable Mounting Pattern, tolerance does not apply

Adjustable Stop Module, Serrated



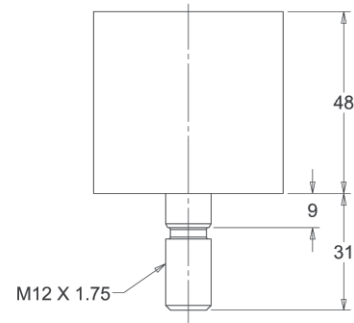
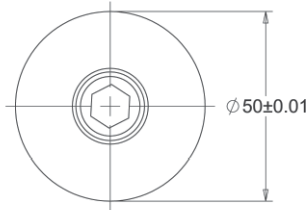
Part Number	A	B	C
GS-RA1	0-39	100	125
GS-RA2	0-87	150	175

Adjustable Stop Module, Smooth

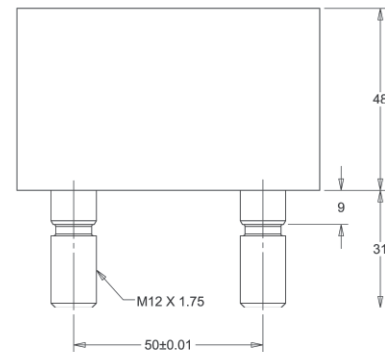
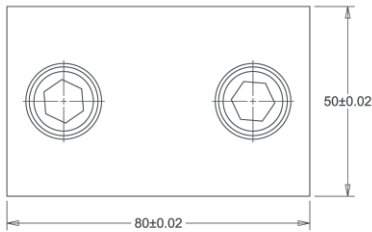


Part Number	A	B	C
GS-SA1	15-76	100	125
GS-SA2	15-126	150	175

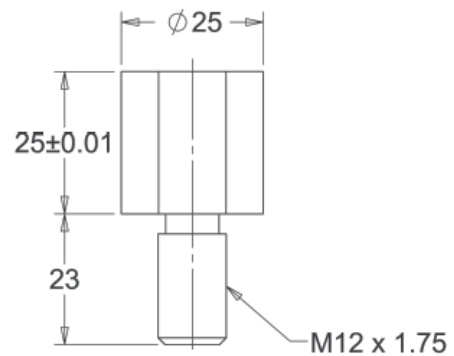
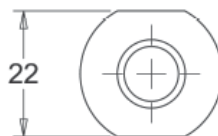
Round Fix Stop, Smooth GS-SF1



Rectangular Fix Stop, Smooth GS-SF2



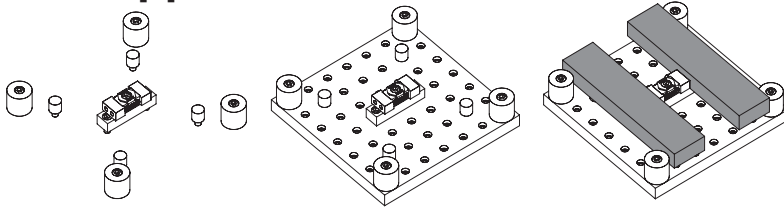
Parallel Riser Block GP-1



Grid Fixturing System – Applications

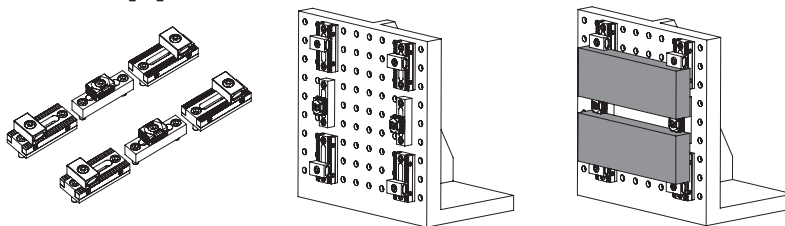
To make selection of the components easier, the Jergens/OK-VISE team has selected some basic sets to enable an easy start with the Grid system. In the pictures below you can see the solutions done with each set. We recommend platforms of leading suppliers. Grid plate is normally not included in the set.

Grid Application #1



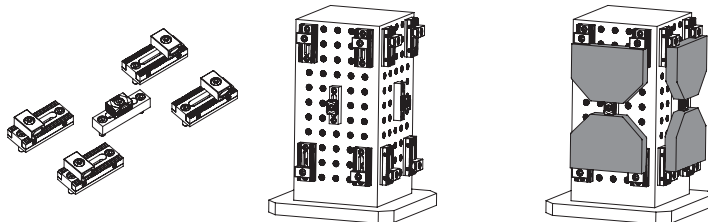
Part Number	Description	Qty
GCD-DT1	Mounting Jaw, D Series Clamp Module	1
GP-1	Parallel, Round	4
GS-SF1	Round Smooth Stop Module	4
JDA-3	Machinable Jaw	2

Grid Application #2



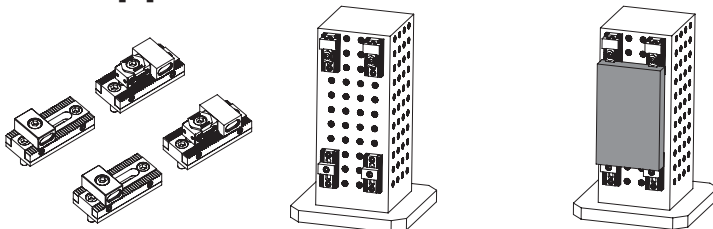
Part Number	Description	Qty
GCD-DS1	Smooth Jaw, D Series Clamp Module	2
GS-SA1	Adjustable Smooth Stop Module	4

Grid Application #3



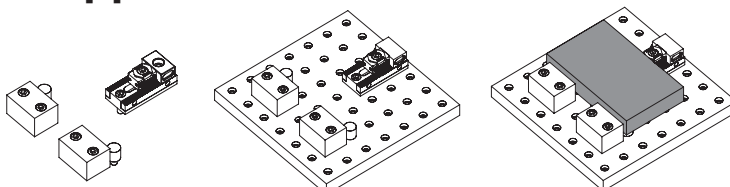
Part Number	Description	Qty
GCD-DS1	Smooth Jaw, D Series Clamp Module	1
GS-SA1	Adjustable Smooth Stop Module	4

Grid Application #4



Part Number	Description	Qty
GCS-DS1	Adjustable Smooth, D Series Clamp Module	2
GS-SA1	Adjustable Smooth Stop Module	2

Grid Application #5

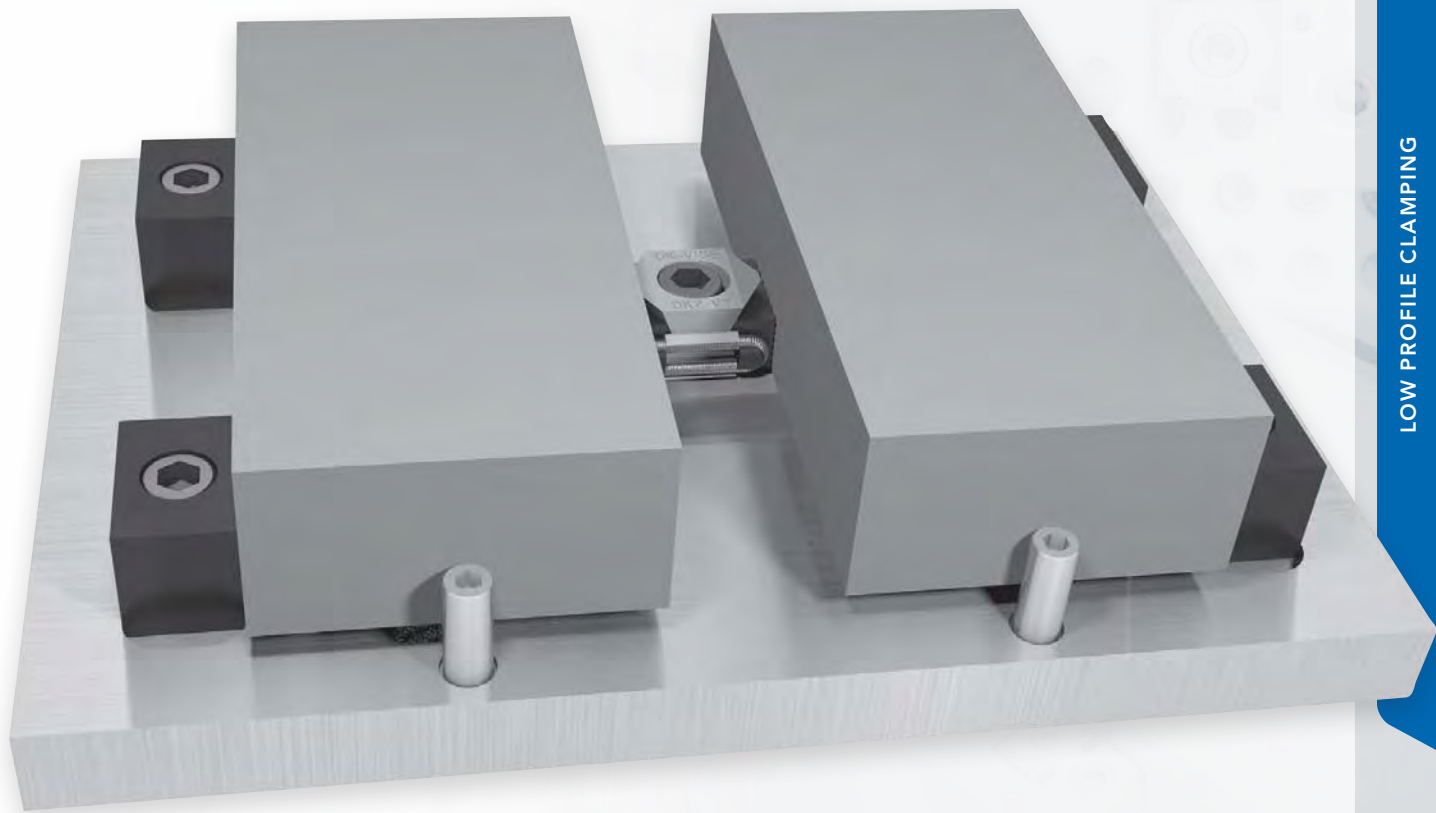


Part Number	Description	Qty
GCS-DS1	Adjustable Smooth, D Series Clamp Module	1
GP-1	Parallel, Round	2
GS-SF2	Rectangular Fixed Smooth Stop Module	2

BLANK FIXTURING SYSTEM

Jergens[®] / **OK-VISE**[®]

WORKHOLDING CLAMPS AND ACCESSORIES



LOW PROFILE CLAMPING

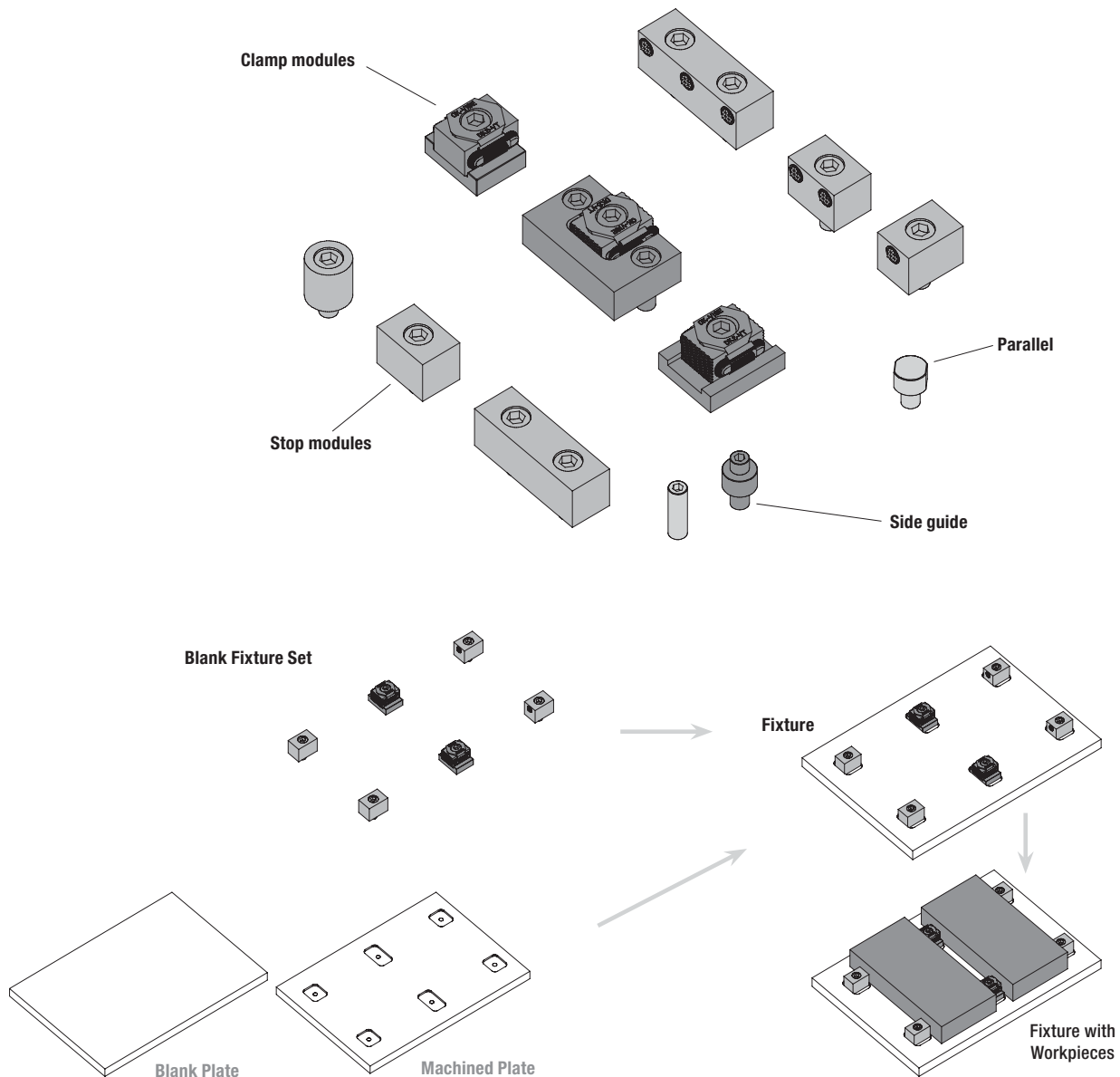
Blank Fixturing System

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.

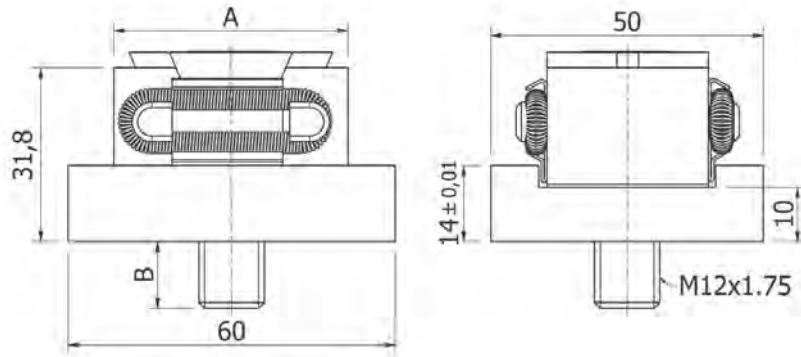
When sensitive contact with the workpiece is a must, then smooth, diamond-surface or contour-machined jaws are optimal. Now designing dedicated fixtures is easier than ever.

Blank Fixturing System Components



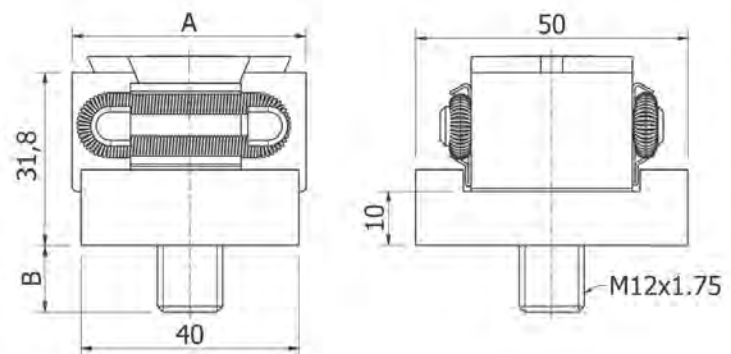
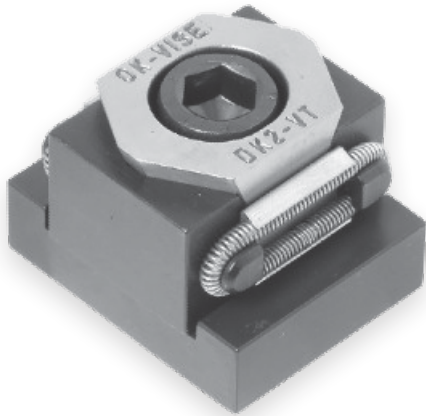
LOW PROFILE CLAMPING

Clamp Modules, Dual Directional (Extended Base)



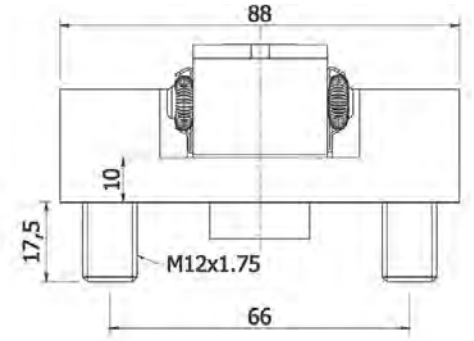
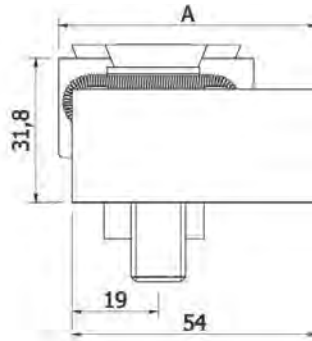
Part Number	Jaw Face	A	B
KCD-DR1	Serrated	42-49	11-20
KCD-DS1	Smooth	42-49	11-20

Clamp Modules, Dual Directional



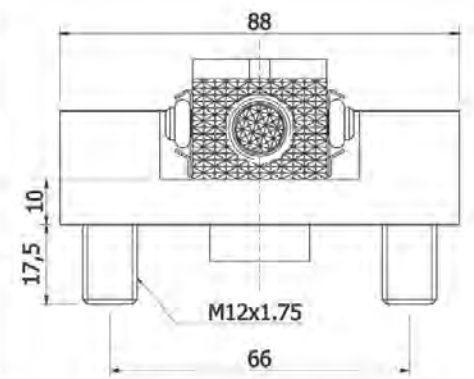
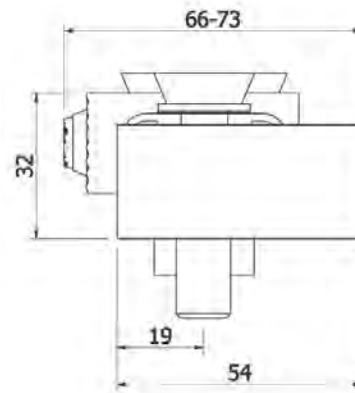
Part Number	Jaw Face	A	B
KCD-DR2	Serrated	42-49	11-20
KCD-DS2	Smooth	42-49	11-20

Clamp Modules, Single Direction

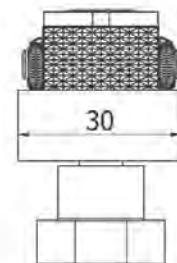
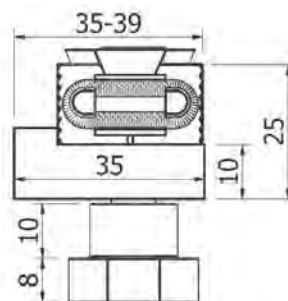
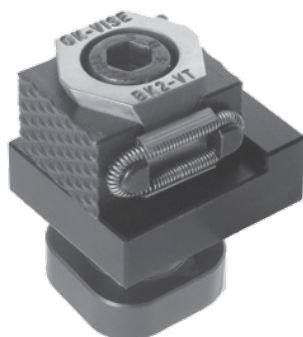


Part Number	Jaw Face	A
KCS-DR1	Serrated	56-63
KCS-DS1	Smooth	56-63

KCS-DES1

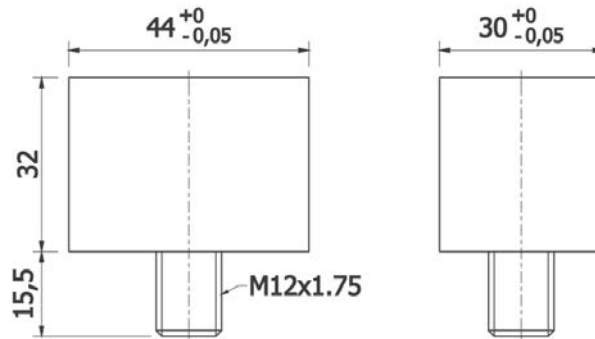
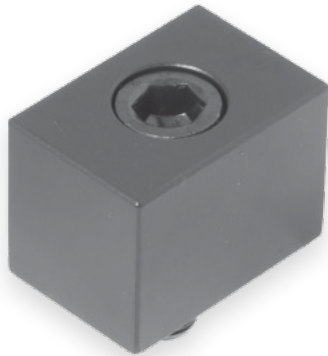


KCS-BR3

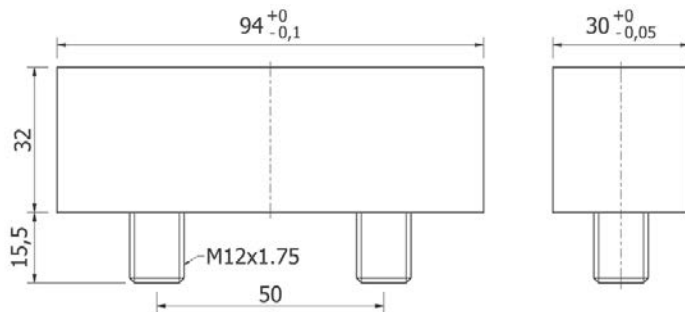


LOW PROFILE CLAMPING

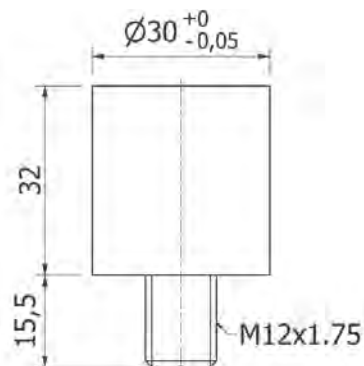
Smooth Stoppers KS-S1



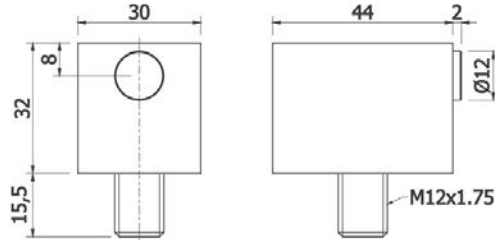
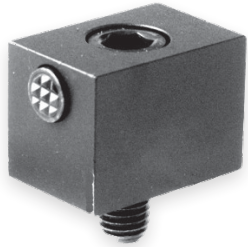
KS-S2



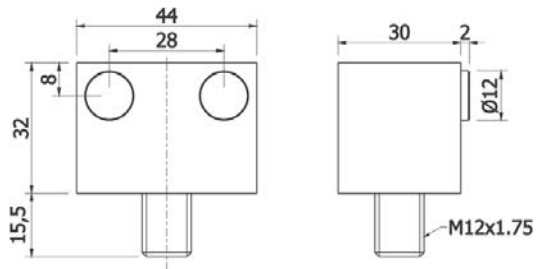
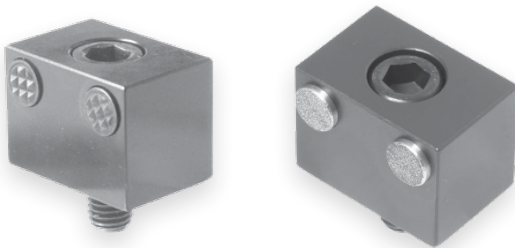
KS-S01



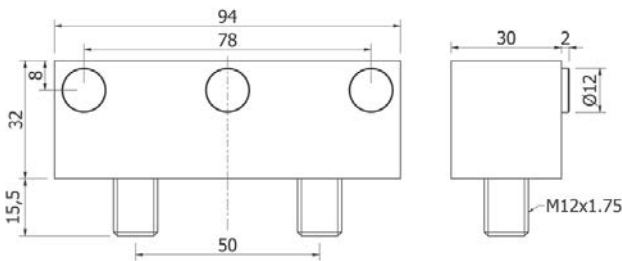
Serrated and Diamond Stoppers



Part Number	Gripper Style
KS-D1	Diamond
KS-R1	Serrated

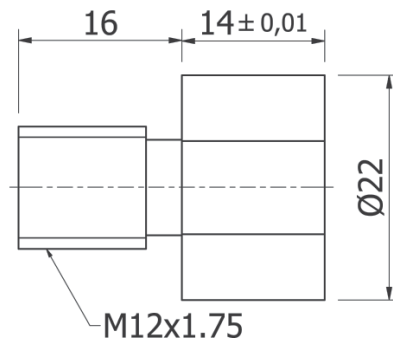
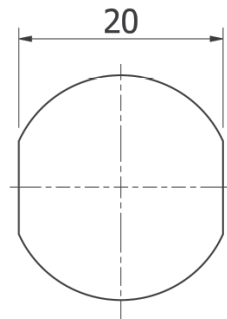


Part Number	Gripper Style
KS-D2	Diamond
KS-R2	Serrated

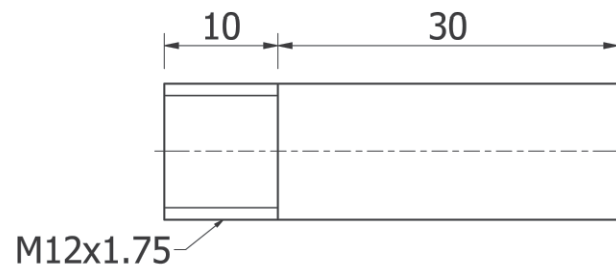
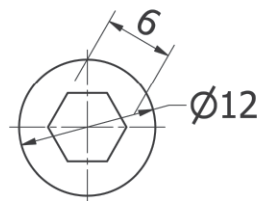


Part Number	Gripper Style
KS-D3	Diamond
KS-R3	Serrated

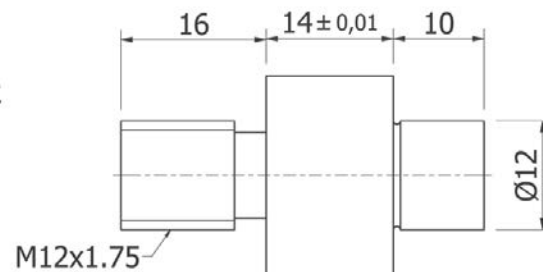
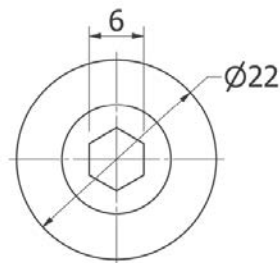
Blank System Riser Block KP-1



Blank System Side Guides KG-1



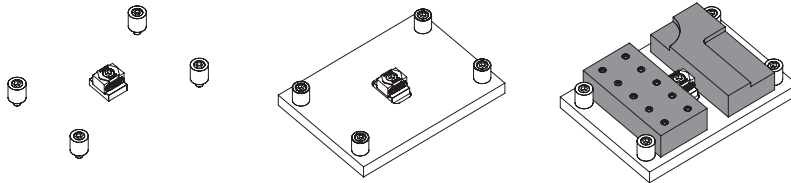
KG-2



Blank Fixturing System – Applications

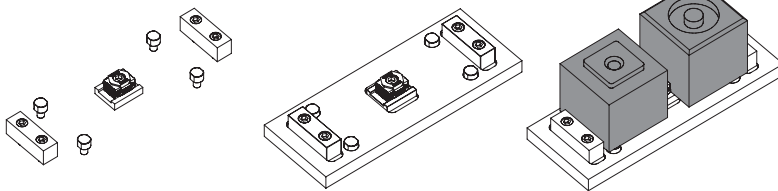
To make selection of the components easier, the Jergens/OK-VISE team has selected some basic sets to enable an easy start with the Blank system. In the pictures below you can see the solutions done with each set.

Blank Application #1



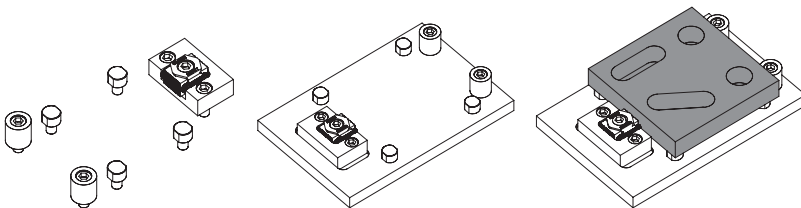
Part Number	Description	Qty
KCD-DS2	Smooth Jaw, D Series Clamp Module	1
KS-S01	Round Smooth Stop Module	4

Blank Application #2



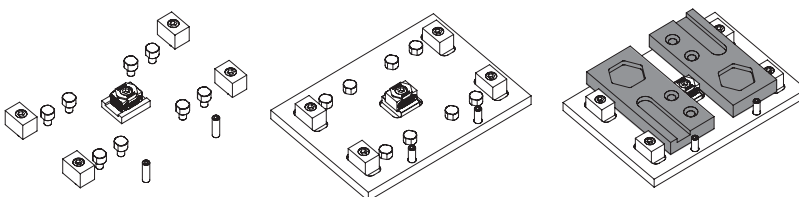
Part Number	Description	Qty
KCD-DS1	Smooth Jaw, D Series Clamp Module	1
KP-1	Parallel, Round	4
KS-S2	Rectangular Fixed Smooth Stop Module	2

Blank Application #3



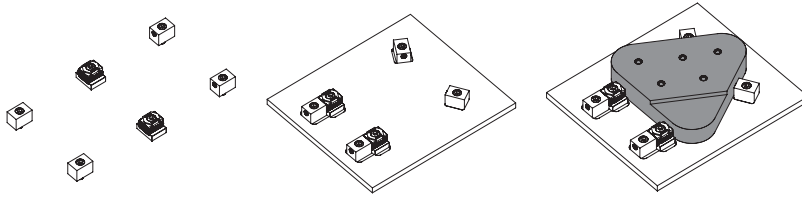
Part Number	Description	Qty
KCS-DS1	Smooth Jaw, D Series Clamp Module	1
KP-1	Parallel, Round	4
KS-S01	Round Smooth Stop Module	2

Blank Application #4



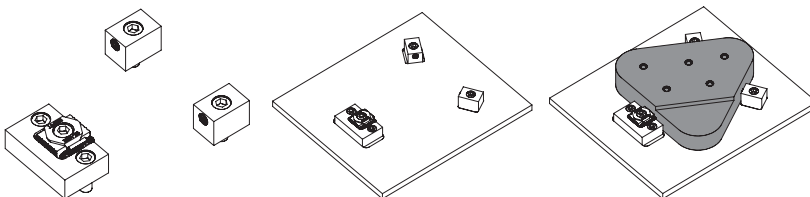
Part Number	Description	Qty
KCD-DS1	Smooth Jaw, D Series Clamp Module	1
KP-1	Parallel, Round	8
KS-S2	Rectangular Fixed Smooth Stop Module	4
KG-1	Round Side Guide	2

Blank Application #5



Part Number	Description	Qty
KCD-DS2	Smooth Jaw, D Series Clamp Module	2
KS-S1	Rectangular Fixed Smooth Stop Module	2
KS-R1	Single Gripper Stop Module	2

Blank Application #6



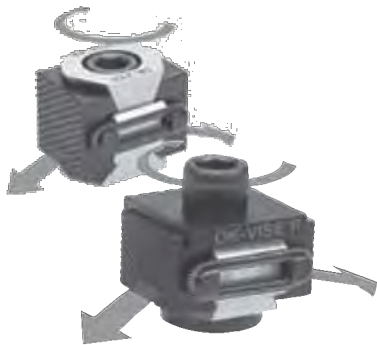
Part Number	Description	Qty
KCS-DS1	Smooth Jaw, D Series Clamp Module	1
KS-R1	Single Gripper Stop Module	2

Blank Fixturing System – Low-Profile Clamps

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



Single-Wedge Clamp

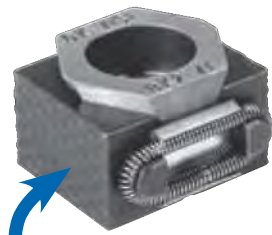


Pull-Down Models

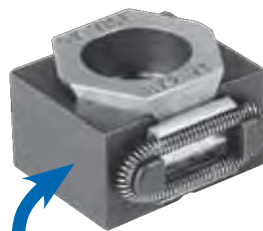
- Double Wedge
- Single Wedge



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-S01	Round, Smooth
KS-R1	Serrated
KS-R2	Serrated
KS-R3	Serrated
KS-S3	Smooth
KS-D1	Diamond
KS-D2	Diamond
KS-D3	Diamond

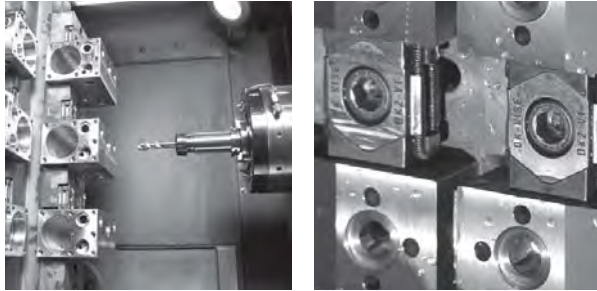
Parallels Module

KP-1	Wide Pin
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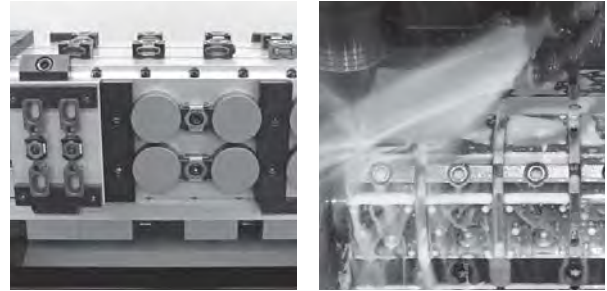
Side Guides

KG-1	Pin
KG-2	Pin with Integrated Parallel

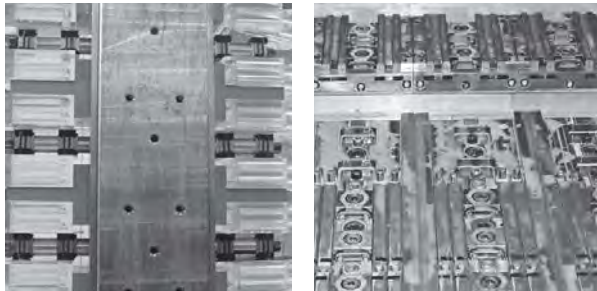
HMC Applications



RPS Applications



Hydraulic Applications



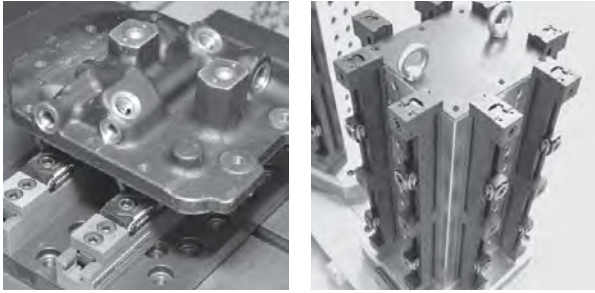
VMC Applications



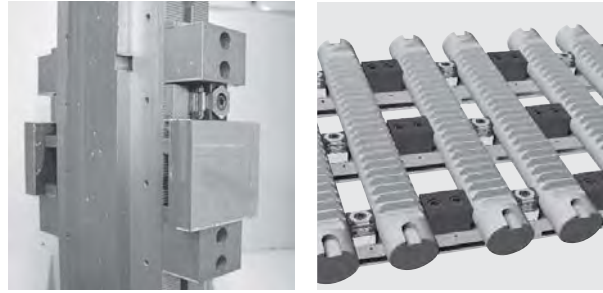
T-Slot Applications



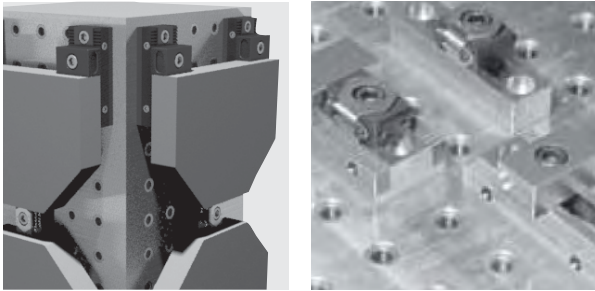
Multi-Rail RM Applications



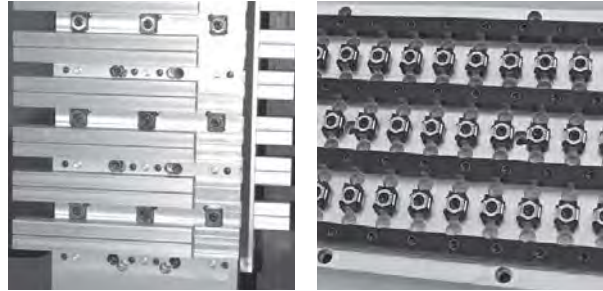
Multi-Rail RH Applications



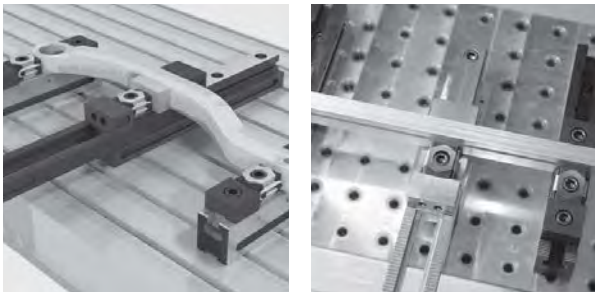
Grid Applications



Blank Plate Applications

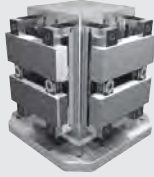



Combo-Rail Applications





Fixturing and Components

GENERIC FIXTURING COMPONENTS

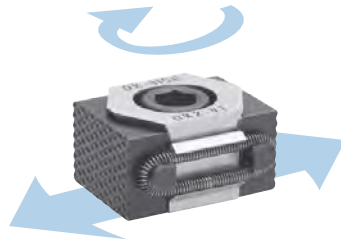
Multi-Rail RM System


Multi-Rail RH System



Combo-Rail


Grid Fixturing System


LOW-PROFILE CLAMPS



COMPONENTS FOR DEDICATED FIXTURING

Blank Fixturing System


Lo-Profile Micro™ Clamps

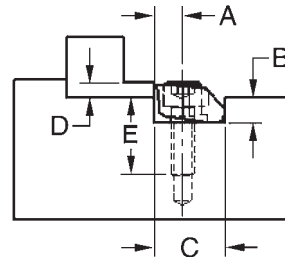


Problem: You require a clamping device which can grip low on a work piece, has exceptional horizontal and vertical holding force, and can be mounted below the fixture plate surface.

Solution: Jergens new Lo-Profile Micro clamps are the answer!

Material:

- Available in tool steel or brass
- Extraordinary horizontal and vertical force
- Extremely low profile – as low as .075
- Very small foot print
- High resistance to pull-out
- Choose among three sizes with inch or metric screws
- Knife and blunt edge styles



Lo-Profile Micro™ Clamps

Part Number	Description	A	B	C	D*	E	Clamp Width	Screw Size	Torque (ft/lbs)	Max. Holding Force (lbs)	Total Throw	Clamps Per Package
13201	Tool Steel, Knife Edge	.150	.140	.375	.075	.260	.375	4-40	1.30	650	.0075	8
13202	Tool Steel, Blunt Edge	.150	.140	.375	.075	.260	.375	4-40	1.30	650	.0075	8
13203	Brass, Blunt Edge	.150	.140	.375	.075	.220	.375	4-40	.41	200	.0075	8
13211	Tool Steel, Knife Edge	.200	.187	.500	.100	.390	.500	8-32	3.70	1,500	.0160	8
13212	Tool Steel, Blunt Edge	.200	.187	.500	.100	.390	.500	8-32	3.70	1,500	.0160	8
13213	Brass, Blunt Edge	.200	.187	.500	.100	.340	.500	8-32	2.00	400	.0160	8
13221	Tool Steel, Knife Edge	.300	.280	.750	.150	.570	.750	1/4-20	14.50	3,600	.0240	6
13222	Tool Steel, Blunt Edge	.300	.280	.750	.150	.570	.750	1/4-20	14.50	3,600	.0240	6
13223	Brass, Blunt Edge	.300	.280	.750	.150	.440	.750	1/4-20	4.10	950	.0240	6
13224	Tool Steel, Knife Edge	.400	.450	1.000	.250	.710	1.000	3/8-16 x 1"	30.00	6,000	0.050	4
13225	Tool Steel, Blunt Edge	.400	.450	1.000	.250	.710	1.000	3/8-16 x 1"	30.00	6,000	0.050	4
13226	Tool Steel, Knife Edge	.600	.640	1.500	.375	.710	1.500	1/2-13 x 1 1/4"	108.30	12,000	0.075	2
13227	Tool Steel, Blunt Edge	.600	.640	1.500	.375	.710	1.500	1/2-13 x 1 1/4"	108.30	12,000	0.075	2

* Combination horizontal and vertical force.

Metric Lo-Profile Micro™ Clamps

Part Number	Description	A	B	C	D*	E	Clamp Width	Screw Size	Max. Holding Force (N)	Torque (Nm)	Total Throw	Clamps Per Package
13251	Tool Steel, Knife Edge	3.81	3.55	9.52	1.90	—	9.52	M2.5	2,800	1.8	.190	8
13252	Tool Steel, Blunt Edge	3.81	3.55	9.52	1.90	—	9.52	M2.5	2,800	1.8	.190	8
13253	Brass, Blunt Edge	3.81	3.55	9.52	1.90	—	9.52	M2.5	875	.56	.190	8
13261	Tool Steel, Knife Edge	5.08	4.75	12.70	2.54	—	12.70	M4	6,600	5.6	.406	8
13262	Tool Steel, Blunt Edge	5.08	4.75	12.70	2.54	—	12.70	M4	6,600	5.6	.406	8
13263	Brass, Blunt Edge	5.08	4.75	12.70	2.54	—	12.70	M4	1,750	2.8	.406	8
13271	Tool Steel, Knife Edge	7.62	7.11	19.05	3.81	—	19.05	M6	16,000	22.5	.610	6
13272	Tool Steel, Blunt Edge	7.62	7.11	19.05	3.81	—	19.05	M6	16,000	22.5	.610	6
13273	Brass, Blunt Edge	7.62	7.11	19.05	3.81	—	19.05	M6	4,200	5.6	.610	6
13274	Tool Steel, Knife Edge	10.16	11.43	25.40	6.350	18.03	25.40	M10 x 25mm	26,000	40.6	1.270	4
13275	Tool Steel, Blunt Edge	10.16	11.43	25.40	6.350	18.03	25.40	M10 x 25mm	26,000	40.6	1.270	4
13276	Tool Steel, Knife Edge	15.24	16.26	38.10	9.520	19.56	38.10	M12 x 30mm	50,000	145.0	1.900	2
13277	Tool Steel, Blunt Edge	15.24	16.26	38.10	9.520	19.56	38.10	M12 x 30mm	50,000	145.0	1.900	2

* Combination horizontal and vertical force.

LOW PROFILE CLAMPING

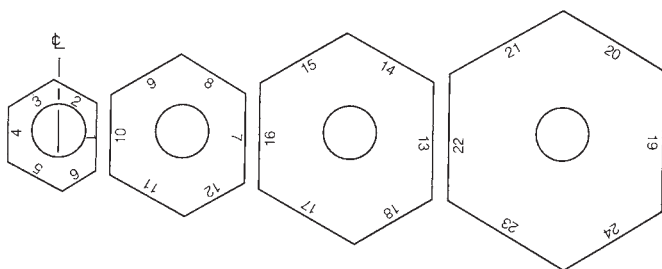
Adjustable Micro™ Clamps



Measured from the centerline, each face of these low profile clamps increases 1mm (.0394) from the smallest to the largest face.

Adjustable Micro Clamps decrease design and set-up times for modular fixtures, work cubes, and standard fixtures. Without changing hole locations, clamping range from 12mm to 35mm can be achieved.

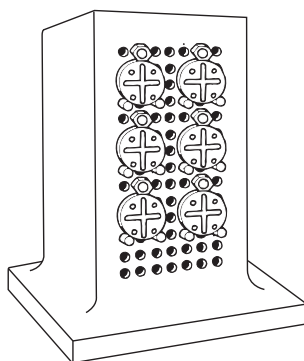
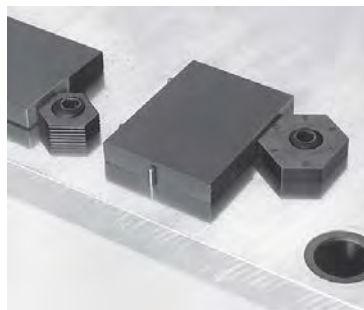
The clamps are available with either smooth or serrated faces which make them ideal for clamping machined parts, castings, and rough cut stock. The clamps work with a cam action, always following the contour of the workpiece for maximum surface contact.



- Cam action
- Low profile
- Available in four sizes
- Heat treated and plated
- Serrated or smooth edges
- Adjustable clamps and stops
- Includes Cam Screw*

Face #	Distance From Center Line	Face #	Distance From Center Line	Face #	Distance From Center Line	Face #	Distance From Center Line
1	12mm (.4724)	7	18mm (.7086)	13	24mm (.9449)	19	30mm (1.1811)
2	13mm (.5118)	8	19mm (.7480)	14	25mm (.9842)	20	31mm (1.2205)
3	14mm (.5512)	9	20mm (.7874)	15	26mm (1.0236)	21	32mm (1.2598)
4	15mm (.5906)	10	21mm (.8268)	16	27mm (1.0630)	22	33mm (1.2992)
5	16mm (.6299)	11	22mm (.8661)	17	28mm (1.1024)	23	34mm (1.3386)
6	17mm (.6693)	12	23mm (.9055)	18	29mm (1.1417)	24	35mm (1.3780)

Locking Screw is 1/2-13 for inch sizes and 12M for metric sizes; total distance of movement is .100".

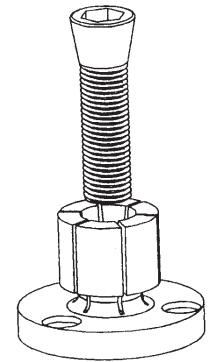
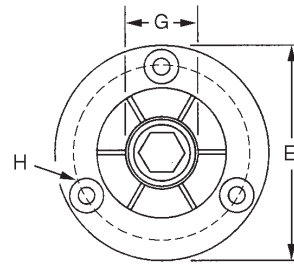
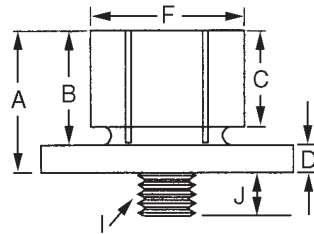


Inch Part Number	Metric Part Number	Description
68601	68651	1-6 smooth
68602	68652	7-12 smooth
68603	68653	13-18 smooth
68604	68654	19-24 smooth
68611	68661	1-6 serrated
68612	68662	7-12 serrated
68613	68663	13-18 serrated
68614	68664	19-24 serrated

All clamps include a cam screw. Clamps are 10mm (.394) thick.

Part Number	Thread	Max. Torque Holding Force
68202	Cam Screw 1/2-13	65 Ft/lbs. – 4000 lbs.
68199	Cam Screw M12	88N.M. – 17,800 N.

ID Expansion Clamp



The ID expansion clamp is the ideal way to hold parts on an inside diameter for multiple machining on a vertical or horizontal machining center.

The larger diameter of the clamp is held to a close tolerance for precision locating in a machined pocket on work cubes and fixture plates.

The customer machines the mild steel clamp to match the bore of the part ensuring proper fit. Often times the clamps can be remachined for different size jobs.

- Body Material: Mild Steel
- Low Profile
- Ideal for Secondary Operations on Lathe Parts
- Easily Machined to Size on Lathe or Mill
- Excellent for Palletized Setups
- Allows More Parts Per Workcube or Fixture Plate
- Tighten with Hex Key or Hydraulic Pull Cylinders (Drill clearance hole for longer bolt into hydraulic cylinder)
- Instructions included with each clamp



Part Number	A	B	C	D	+0.000 -0.002 E	F	G+	H*	I	J	Torque (ft/lbs)	Holding Force (lbs)	Replacement Screw
68401	.42	.30	.24	.12	.787	.29	.16	2-56 on .540 BHC	2-56	.16	.05	250	68900
68402	.86	.63	.59	.23	1.170	.49	.28	6-32 on .825 BHC	8-32	.30	3.6	950	68901
68403	.98	.75	.59	.23	1.240	.56	.48	6-32 on .910 BHC	1/4-20	.50	13.3	1,900	68902
68404	.98	.75	.59	.23	1.476	.79	.53	6-32 on 1.140 BHC	5/16-18	.56	27.6	2,500	68903
68405	1.13	.88	.69	.25	1.968	1.06	.71	8-32 on 1.550 BHC	3/8-16	.71	49.3	4,500	68904
68406	1.25	1.0	.81	.25	2.205	1.39	.90	8-32 on 1.790 BHC	1/2-13	.71	120.0	5,900	68905
68407	1.56	1.25	1.06	.31	2.736	1.65	1.15	10-32 on 2.200 BHC	5/8-11	.79	224.0	10,000	68906
68408	1.56	1.25	1.06	.31	2.972	2.03	1.15	10-32 on 2.515 BHC	5/8-11	.79	224.0	10,000	68906
68409	1.79	1.48	1.27	.31	4.232	3.06	1.15	1/4-20 on 3.646 BHC	5/8-11	.79	224.0	10,000	68907
68410	1.79	1.48	1.27	.31	5.232	4.06	1.15	1/4-20 on 4.648 BHC	5/8-11	.79	224.0	10,000	68907
68411	1.79	1.48	1.27	.31	6.89	5.23	1.15	1/4-20 on 4.648 BHC	5/8-11	.79	224.0	10,000	68907
68412	1.79	1.48	1.27	.31	9.85	6.00	1.15	1/4-20 on 5.250 BHC	5/8-11	.79	125.0	6,000	68907

Metric

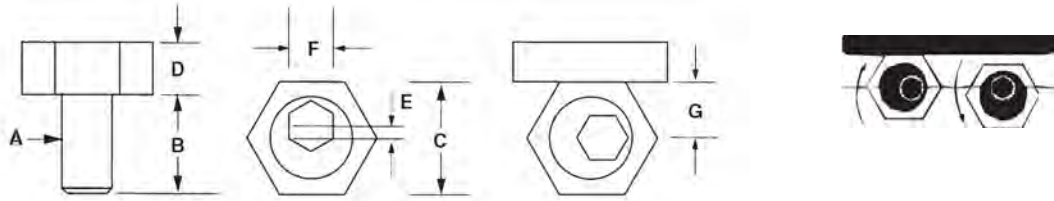
Part Number	A	B	C	D	+0.00 -0.05 E	F	G+	H*	I	J	Torque (Nm)	Holding Force (N.)	Replacement Screw
68829	10.7	7.6	6.1	3.0	20.0	7.4	4.1	M2 on 13.7 BHC	M2	4.1	.70	1,113	68909
68830	21.8	16.0	15.0	5.9	29.72	12.4	8.0	M3 on 20.95 BHC	M4	7.2	5.00	4,228	68910
68831	24.9	19.0	15.0	5.9	31.5	14.2	12.2	M3 on 23.1 BHC	M6	11.2	17.00	8,455	68911
68832	24.9	19.0	15.0	5.9	37.5	20.0	13.5	M3 on 29.0 BHC	M8	13.2	34.00	11,125	68912
68833	28.6	22.2	17.5	6.4	50.0	27.0	18.0	M4 on 39.4 BHC	M10	16.3	60.00	20,025	68913
68834	31.8	25.4	20.6	6.4	56.0	35.3	23.0	M4 on 45.5 BHC	M12	20.3	150.00	26,255	68914
68835	39.6	31.8	27.0	7.9	69.5	42.0	29.3	M5 on 55.9 BHC	M16	21.4	280.00	44,500	68915
68836	39.6	31.8	27.0	7.9	75.5	51.5	29.3	M5 on 63.9 BHC	M16	21.4	280.00	44,500	68915
68837	45.5	37.6	32.3	7.9	107.5	77.7	29.3	M6 on 92.6 BHC	M16	19.3	280.00	44,500	68916
68838	45.5	37.6	32.3	7.9	132.90	103.0	29.3	M6 on 118.06 BHC	M16	19.3	280.00	44,500	68916
68839	45.5	37.6	32.3	7.9	175.0	132.9	29.3	M6 on 118.06 BHC	M16	19.3	280.00	44,500	68916
68850	45.5	37.6	32.3	7.9	250.2	152.4	29.3	M6 on 133.35 BHC	M16	19.3	170.00	26,000	68916

* (3) Mounting Screws Included

+ Minimum diameter the "F" dimension can be machined too.

LOW PROFILE CLAMPING

Micro™ Clamps



Jergens Micro™ Clamps feature both high hold down forces and low profiles, which makes them ideal for building fixtures on Ball Lock® fixturing plates. Two simple components make them work: a hardened steel socket cap screw with an offset head and a hexagonal washer. A half turn tightens or loosens the workpiece.

- Low profile makes computer programming easier
- Cam action provides fast, strong clamping
- Small size allows more parts per load
- Requires only a tapped hole in your fixture
- Available in stainless steel
- Note clockwise rotation recommended workpiece stop should be on the right of the Clamp.

Part Number Steel	Part Number Stainless	A	B	C	D	Total Distance of Measurement E	Key Size F	G*	Maximum Holding Force	Replacement Screw
68501	—	8-32	.350	.312	.110	.030	5/64	.150	205	68521
68502	—	10-32	.340	.500	.160	.040	3/32	.250	350	68533
68503	68153	1/4-20	.470	.625	.190	.040	1/8	.308	800	68523
68505	—	5/16-24	.460	.812	.190	.040	3/16	.400	750	68525
68506	68515	5/16-18	.460	.812	.190	.040	3/16	.400	750	68526
68507	—	3/8-16	.710	.812	.250	.050	3/16	.400	2,000	68527
68509	—	1/2-13	.900	1.000	.375	.100	5/16	.500	4,000	68529
68511	—	5/8-11	1.125	1.187	.500	.100	3/8	.590	6,000	68531

* This measurement is the correct location to drill and tap the hole from the edge of the work piece.

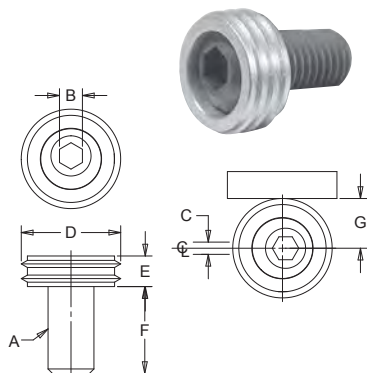
Metric

Part Number Steel	Part Number Stainless	A	B	C	D	Total Distance of Measurement E	Key Size F	G*	Maximum Holding Force (N)
68571	—	M4 x 0.7	9.6	7.93	2.8	.76	3	3.8	910
68572	68551	M6 x 1.0	11.2	15.86	4.75	1.01	4	7.8	3,558
68573	68553	M8 x 1.25	15.0	20.61	4.75	1.01	5	10.15	3,355
68574	—	M10 x 1.5	19.0	20.61	6.35	1.52	7	10.15	8,895
68575	—	M12 x 1.75	22.8	25.38	9.52	2.03	8	12.7	17,790
68576	—	M16 x 2.0	28.5	30.13	12.69	2.54	12	15.0	26,680

* This measurement is the correct location to drill and tap the hole from the edge of the work piece.

Replacement Screws available, contact customer service for more information.

Knife Edge Clamps



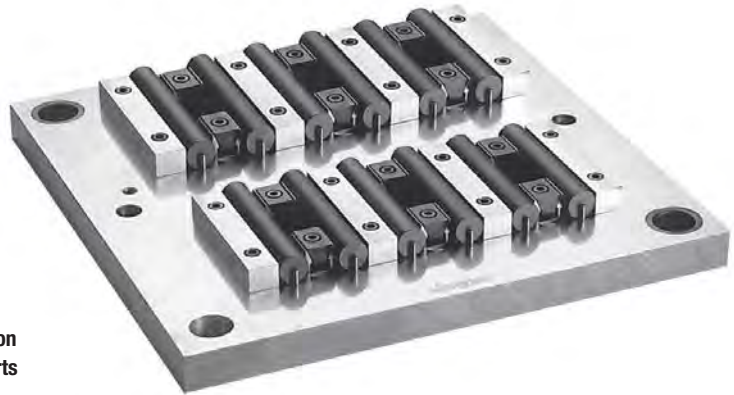
Knife edge clamps can be used for clamping rough cut stock, castings, or any material that requires a hardened clamping element. Hardened steel, brass-plated.

Replacement Screws available, contact customer service for more information.

Part Number	A	B	C	D	E	F	G*	Torque (ft. lbs)	Max. Holding Force (lbs)
68547	3/8-16	3/16	0.050	0.812	0.250	0.710	0.400	16.6	2,000
68548	1/2-13	5/16	0.080	1.000	0.375	0.900	0.500	52	4,000
68549	5/8-11	3/8	0.100	1.187	0.500	1.125	0.590	80	6,000
Metric								(Nm)	(N)
68840	M10	7M	1.27	20.60	6.35	19.00	10.15	28	8,900
68841	M12	8M	2.03	25.40	9.52	22.80	12.70	88	17,800
68842	M16	12M	2.54	30.15	12.70	28.50	15.00	135	26,700

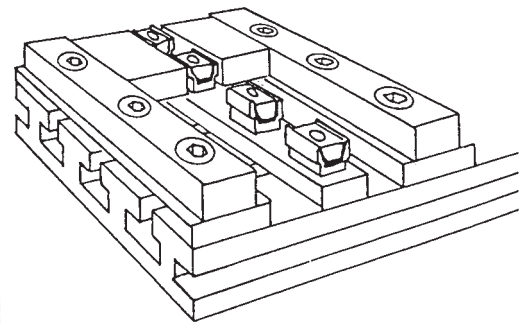
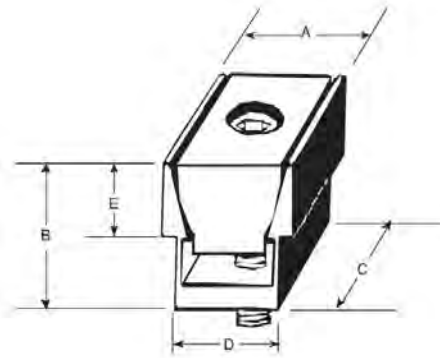
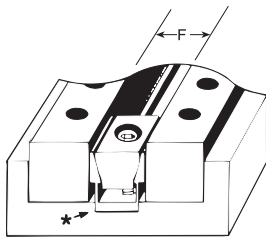
* This measurement is the correct location to drill and tap the hole from the edge of the work piece.

Expanding Micro™ Clamps



Jergens Expanding Micro Clamps allow you to fixture more parts on your fixture plates. The unique expanding design can hold two parts at once when used with a positive stop.

- Minimizes tool changes
- Holds two parts with equilateral clamping action
- Ideal for clamping flat or round work pieces
- Reduces wasted space
- Aluminum Housing, Steel Wedge



*A shallow slot, a little wider than D dimension, will insure clamp remains in line with workpiece.

Part Number	A	B	C	D*	E	F†	Thread Size	Maximum Spread	Maximum Holding Force (lbs)	Key Size
68706	.240	.250	.320	.210	.100	.250	2-56	.265	200	5/64
68707	.360	.380	.470	.310	.185	.375	4-40	.395	310	3/32
68701	.485	.500	.625	.410	.220	.500	8-32	.540	500	9/64
68702	.735	.750	.940	.632	.375	.750	1/4-20	.800	1,500	3/16
68703	.980	1.00	1.250	.820	.500	1.000	5/16-18	1.060	2,000	1/4
68704	1.470	1.50	1.875	1.215	.750	1.500	1/2-13	1.590	3,500	3/8
68705	1.960	2.00	2.500	1.625	1.000	2.000	5/8-11	2.100	6,000	1/2

Metric

Part Number	A	B	C	D*	E	F†	Thread Size	Maximum Spread	Maximum Holding Force (N)	Key Size
68716	6.1	6.9	8.1	5.3	3.6	6.4	M2	6.7	880	1.5
68717	9.1	9.7	11.9	7.9	4.7	9.5	M2.5	10	1,350	2
68711	12.3	14.5	15.9	10.4	5.6	12.7	M4	13.2	2,224	3
68712	18.6	19.0	23.8	16.1	9.5	19.0	M6	20.3	6,670	5
68713	24.8	25.9	31.7	20.8	12.7	25.4	M8	26.9	8,895	6
68714	37.3	38.6	47.6	30.8	19.0	38.1	M12	39.9	15,565	10
68715	49.7	51.5	63.5	41.2	25.4	50.8	M16	53.0	26,690	14

†F is the distance needed between workpieces for clamp clearance. Drill and tap mounting hole on the center of F dimension.

LOW PROFILE CLAMPING

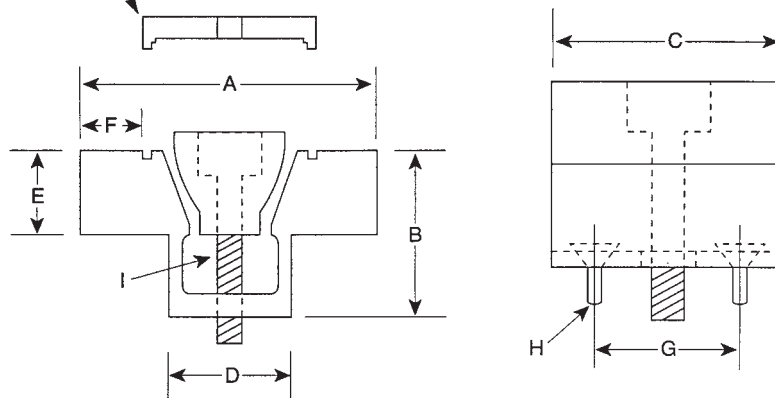
Machinable Expanding Micro™ Clamps



The compact Machinable Expanding Micro™ Clamp is available with extra material on the clamping jaw so it can be machined to conform to the shape of your workpiece – enabling you to fixture unusual applications easily. The specially designed steel wedge spreads the clamping force uniformly on both sides of the aluminum channel. Clamps may be ordered with a unique locking plate to make the clamp rigid while machining the jaw to your specifications, without vibration.

- Material: Channel 7075-76 Aluminum
- Mounting Screws Included
- Compact Design
- Allows more parts to be mounted on Fixture

NOTE: Locking plate is used only to machine jaws, remove to clamp workpiece.



Part Number With Locking Plate	Part Number Without Locking Plate	A*	B	C	D	E	F†	G	Mounting Screw **H	I	Maximum Holding Force (lbs)	Recommended Expansion Stroke (in)
68770	68771	1.125	0.50	0.62	0.420	0.18	0.18	0.400	2-56	8-32	500	0.015
68772	68773	1.500	0.75	0.94	0.632	0.37	0.26	0.624	6-32	1/4-20	1,500	0.015
68774	68775	2.000	1.00	1.25	0.820	0.50	0.39	0.812	6-32	5/16-18	2,000	0.020
68776	68777	3.000	1.50	1.87	1.215	0.75	0.62	1.200	10-32	1/2-13	3,500	0.030
68778	68779	4.000	2.00	2.50	1.625	1.00	0.80	1.625	1/4-20	5/8-11	6,000	0.040

* The distance needed between workpieces for clamp clearance, drill and tap mounting holes on the center of "A" dimension.

† The amount of machinable stock on jaws.

** Mounting Screws Included

Metric

Part Number With Locking Plate	Part Number Without Locking Plate	A*	B	C	D	E	F†	G	Mounting Screw **H	I	Maximum Holding Force (N)	Recommended Expansion Stroke (mm)
68870	68871	28.6	12.7	15.7	10.67	6.3	4.6	10.16	M2	M4	2,224	0.4
68872	68873	38.1	19.1	23.9	16.05	9.4	6.6	15.87	M4	M6	6,670	0.4
68874	68875	50.8	25.4	31.8	20.83	12.7	9.9	20.62	M4	M8	8,895	0.6
68876	68877	76.2	38.1	47.5	30.86	19.1	15.7	30.48	M5	M12	15,565	0.8
68878	68879	101.6	50.8	63.5	41.28	25.4	20.3	41.28	M6	M16	26,690	1.1

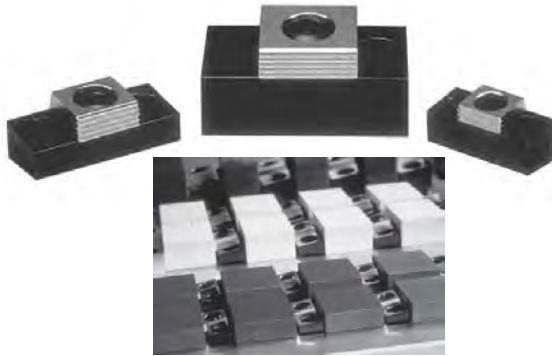
* The distance needed between workpieces for clamp clearance, drill and tap mounting holes on the center of "A" dimension.

† The amount of machinable stock on jaws.

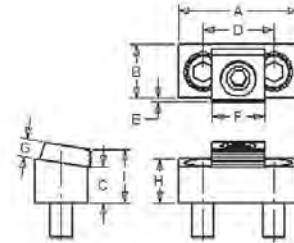
** Mounting Screws Included



Micro™ Toe Clamps



This cam action fixture clamp provides positive down force while using very little space on the fixture. Workpieces can be clamped in series by using the back surface of a clamp to locate the next workpiece. The hardened steel clamping element has both a smooth surface for machined workpieces and a serrated clamping surface for rougher work. The height of the clamp can be adjusted by milling the slot deeper in the fixture plate.



Part Number	A	B	C	D	E†	F	G	H	I	Cam Screw	Distance of Movement	Mounting Screws	Torque (ft/lbs)	Holding Force(lbs)
68731	1.70	.75	.50	1.00	.090	.75	.25	.62	.845	68527	.050	5/16-18 x 3/4 LH	20.8	2,000
68732	2.12	1.00	.45	1.32	.110	1.00	.38	.62	.960	68529	.100	3/8-16 x 3/4 LH	65.0	4,000
68733	2.95	1.50	.99	2.00	.130	1.50	.50	1.25	1.70	68531	.100	1/2-13 x 1 1/4 SHCS	100.0	6,000

† "E" is the distance needed between the front of the clamp base and the workpiece.

Metric

Part Number	A	B	C	D	E†	F	G	H	Cam Screw	Distance of Movement	Mounting Screws	Torque (ft/lbs)	Holding Force(lbs)
68781	43.2	19.0	12.7	25.4	2.3	19.0	6.4	15.75	M10	1.6	M8	28.0	8,900
68782	54.0	25.4	11.4	33.5	2.8	25.4	9.7	15.75	M12	2.0	M10	88.0	17,800
68783	75.0	38.1	25.2	50.8	3.3	38.1	12.7	2.5	M16	—	M12	—	—

† "E" is the distance needed between the front of the clamp base and the workpiece.

Micro™ T-Slot Toe Clamps



This clamp is like the Micro Toe Clamp, only it is designed to be used in the T-slots of machine tables. It provides positive down force while maintaining a low profile. The hardened steel clamping element has both a smooth surface for machined work pieces and a serrated clamping surface for rougher work.

Inch

Part Number	T-Slot Size	A	B	C	D	E	F ¹	F ²	Max. Torque/Holding Force (Ft Lbs/Lbs)
68750	No T-nut or Mtg. Screw	1.94	1.12	0.62	1.00	0.38	1.00	0.875	65/4,000
68741	9/16	1.94	1.12	0.62	1.00	0.38	1.00	0.875	65/4,000
68742	5/8	1.94	1.12	0.62	1.00	0.38	1.00	0.875	65/4,000
68743	11/16	1.94	1.12	0.62	1.00	0.38	1.00	0.875	65/4,000
68744	3/4	1.94	1.12	0.62	1.00	0.38	1.00	0.875	65/4,000

Metric

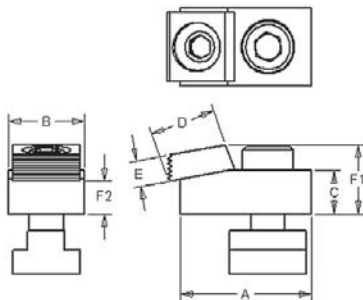
Part Number	T-Slot Size	A	B	C	D	E	F ¹	F ²	Max Torque/Holding Force (N.m./N.)
68791	14	50	28.5	15.7	25.4	9.6	25.4	22.2	88.00/17,800
68792	16	50	28.5	15.7	25.4	9.6	25.4	22.2	88.00/17,800
68793	18	50	28.5	15.7	25.4	9.6	25.4	22.2	88.00/17,800
68794	No T-nut or Mtg. Screw	50	28.5	15.7	25.4	9.6	25.4	22.2	88.00/17,800

F¹ - The distance from the top of the back of the washer to the bottom of the clamp body.
F² - The distance from the top of the front of the washer to the bottom of the clamp body.

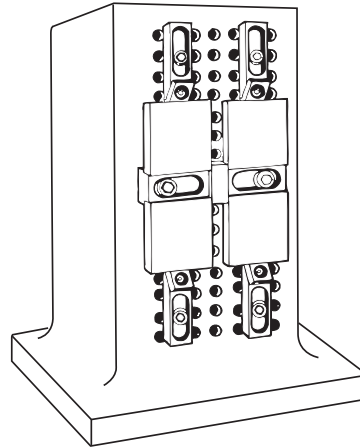
Metric

Part Number	T-Slot Size	Part Number	T-Slot Size
68750	No T-nut or Mtg. Screw	68791	14
68741	9/16	68792	16
68742	5/8	68793	18
68743	11/16	68794	No T-nut or Mtg. Screw
68744	3/4		

Torque mounting bolt to 110 Ft/Lbs (150 N.m.)

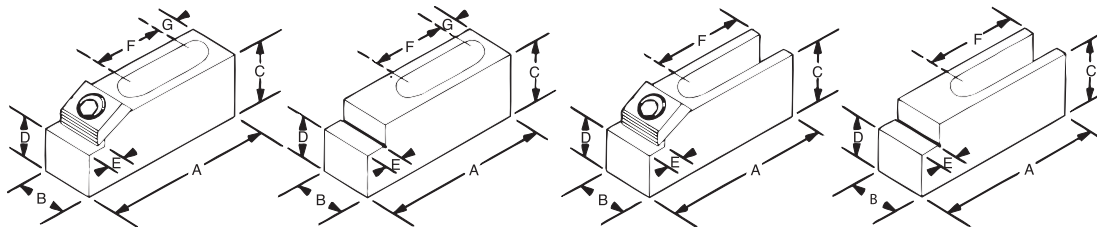


Micro™ Edge Clamps



The Micro Edge Clamp offers increased versatility through its unique elevated clamping abilities.

- Workpiece is elevated for through milling and drilling
- Cam action provides positive holddown force
- Provides flexible set-ups for hard to hold parts
- Works in plates, both with tapped hole layouts or T-slot configurations
- Can be mounted vertically or horizontally
- Built-in stops locate workpiece for repeat positioning
- Larger sizes are ideal for mold shop applications
- Tapered mounting slot prevents movement when clamping pressure is applied
- Hardened steel clamping element, low carbon steel body



Closed slot style

Open slot style

Inch

Part Number	Item	A	B	C	+0.000 -.0130 D	E	F	G	Cam Screw Part Number	Mounting Screw	Slot
68721	Clamp	2.50	.75	.62	.4600	.31	.83	.53	68527	5/16	Closed
68722	Stop	2.50	.75	.75	.4600	.31	1.11	.53	—	5/16	Closed
68723	Clamp	3.75	1.12	.62	.4800	.37	1.68	.50	68529	1/2	Closed
68724	Stop	3.75	1.12	.87	.4800	.37	1.68	.50	—	1/2	Closed
68725	Clamp	4.21	1.50	1.62	1.3780	.37	1.82	—	68535	5/8	Open
68726	Stop	4.21	1.50	2.00	1.3780	.37	1.82	—	—	5/8	Open

Metric

Part Number	Item	A	B	C	+0.000 -.0005 D	E	F	G	Cam Screw Part Number	Mounting Screw	Slot
68821	Clamp	63.5	19.1	15.8	11.68	8.0	21.1	13.5	68532	M8	Closed
68822	Stop	63.5	19.1	19.1	11.68	8.0	28.2	13.5	—	M8	Closed
68823	Clamp	95.3	28.5	15.8	12.19	9.4	42.7	12.7	68534	M12	Closed
68824	Stop	95.3	28.5	22.1	12.19	9.4	42.7	12.7	—	M12	Closed
68825	Clamp	107.0	38.1	41.2	35.00	9.4	46.2	NA	68535	M16	Open
68826	Stop	107.0	38.1	50.8	35.00	9.4	46.2	NA	—	M16	Open

Modular Mini Vise



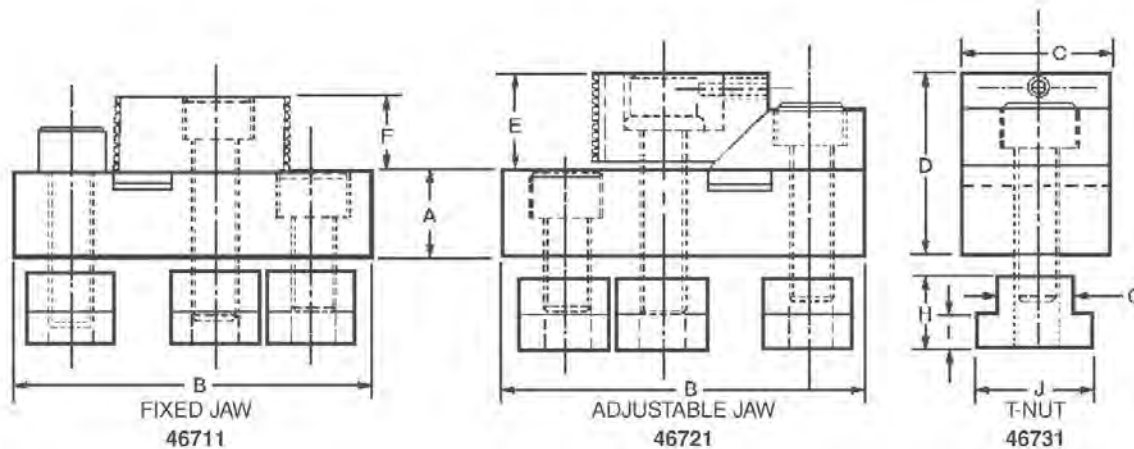
- Material: C-1018
- Finish: Black Oxide
- Case Hardened 58-62 Rc

Part Number	Description
46711	Fixed Jaw Clamp
46721	Adj. Jaw Clamp
46731	T-Slot Nut

The Jergens Modular Mini Vise provides accurate location and positive holding. The bases are hardened and ground to the same height as Jergens Rest Pads for accurate location. The jaws are serrated and hardened to provide positive holding. These versatile clamps may be used as shown, or the jaws may be reversed to allow the workpiece to rest on the machine table or fixture base. The clamps can be made part of a dedicated fixture by removing the T-nuts and fastening the 3/8-16" cap screws directly to the fixture.

To use the Jergens Modular Mini Vise: position the fixed jaw clamp and tighten all three cap screws to secure the clamp. Position the adjustable clamp and tighten the outside cap-screws. Insert the workpiece and tighten the center cap screw. The adjustable jaw will force the workpiece down against the base and over against the fixed jaw clamp.

The 46711 clamp has a fixed jaw for locating. The 46721 clamp has an adjustable jaw for clamping. Each clamp is supplied with three 3/8-16" cap screws and three 46731 T-nuts.



+0.000 -0.0005 A	B	C	Maximum Height D	E	F	Table Slot G	H	I	J
.7205	3	1 1/4	1-9/16	3/4	5/8	5/8	5/8	11/32	1





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