OK-VISE Blank System

Technical data

The OK-VISE Blank Fixturing System is designed for cases when dedicated (product-specific) fixtures are needed. This is typical in high-volume production or when special optimization of the fixture is needed.

Blank plates are used as a platform on which to build the fixture – aluminium and steel blanks are recommended. Then pockets for the modules will be machined, modules are installed and the fixture is ready. So, building fixturing is easier than ever!

As in every OK-VISE Fixturing Concept system, the basic modules in the Blank System are clamp, stopper, side guide and riser block modules.
To resist the clamping and machining forces, a pocket should be machined to the blank plate. Pictures of the pockets are available in the installation instruction.

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.

Catalogue Blank 10-2021 contains the best selling modules in Blank System

You can download this document in
https://www.ok-vise.com/en/products/brochures

Please notice: an updated version you can get directly in a following way:

- Use Chrome browser
- Open page https://www.ok-vise.com/en/blank-system-2021
- Press Ctrl+P
- Save pdf or print to paper

(If design does not look send the file to us, we check if printer settings can make a difference)

Catalogue Blank 10-2021

Blank System modules

As in every OK-VISE Fixturing Concept system, the basic modules in the Blank System are clamp, stopper, side guide and riser block modules.

To resist the clamping and machining forces, a pocket should be machined to the blank plate. Pictures of the pockets are available in the underlined installation instruction.

Single-directional clamp modules (KCS-)

In most cases, code format is KCS-sjn, where s corresponds to a clamp size (B or D), j is a jaw type (Serrated, Smooth) and n is a frame type.

Almost all other jaw combinations are also available. For example, in KCS-DES1 model, E stands for a self-aligning jaw and S – for a smooth jaw.

KCS-DX modules recomended maximum clamp tightening moment is 70Nm. Maximim force is 30KN.

KCS-DR1 and KCS-DS1

KCS-DS1 has smooth jaw, KCS-DR1 serrated

There are also "A" models that are optimized specially for robotic loading of workpieces, for KCS-DR1A.
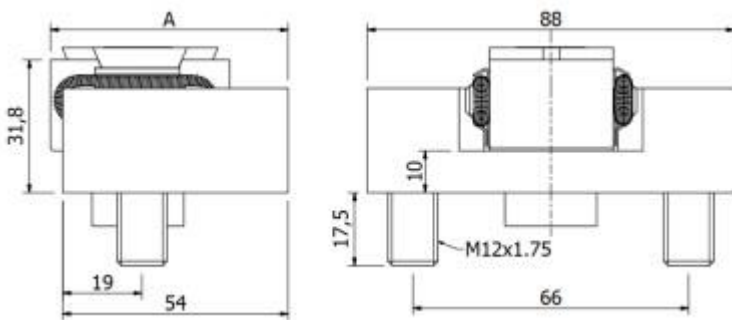
KCS–DES1

This module has one jaw with self-aligning jaw.

KCS–DT1
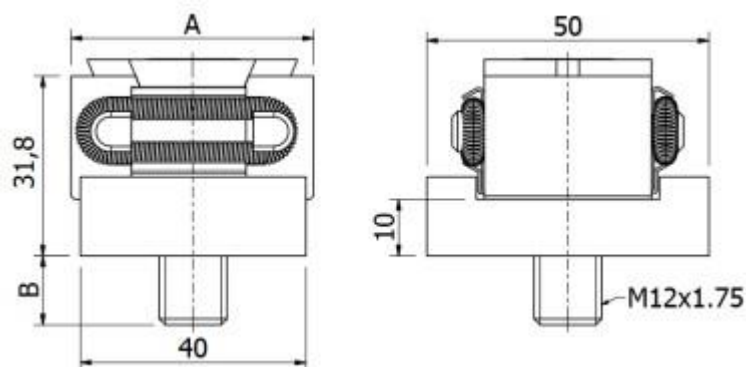
This module has one jaw for additional pieces.

Dual–directional clamp modules (KCD–)

These modules clamp in two directions, enabling to clamp two workpieces.

In most cases, code format is KCD-sjn, where s corresponds to a clamp size (B or D), j is a jaw type (Serrated, Smooth) and n is a plate type.
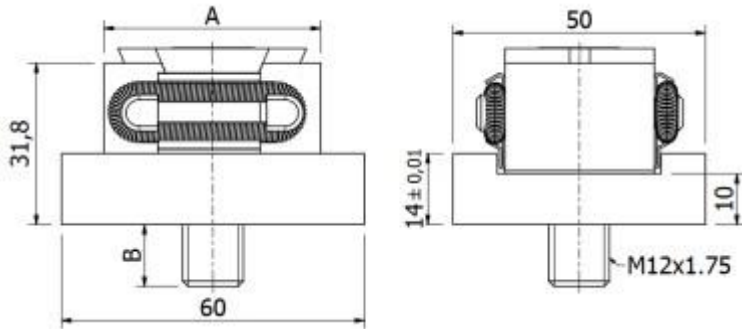
KCD–DS2 and KCD–DR2

KCD-DS2 has smooth jaws, KCD-DR2 has serrated jaws.

KCD–DS1 and KCD–DR1

The support plate extends beyond the clamp jaw, acting also as riser block. KCD–DS1 has smooth jaws, KCD–DR1 has serrated jaws.

Stopper modules (KS–)

Stopper modules positions the workpiece.

In most cases, code format is KS–Sx, where S corresponds to a smooth jaw type and x is a stopper type.
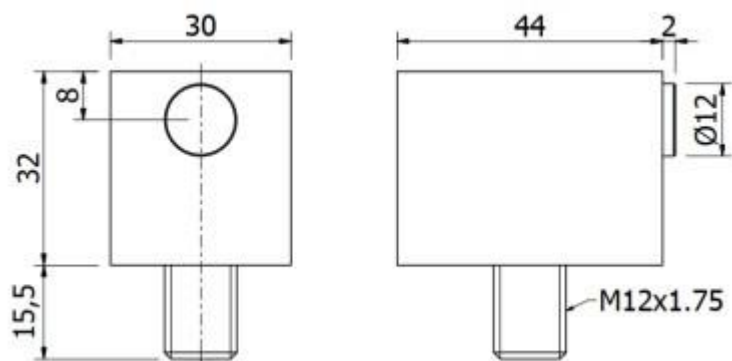
S= smooth

R = serrated
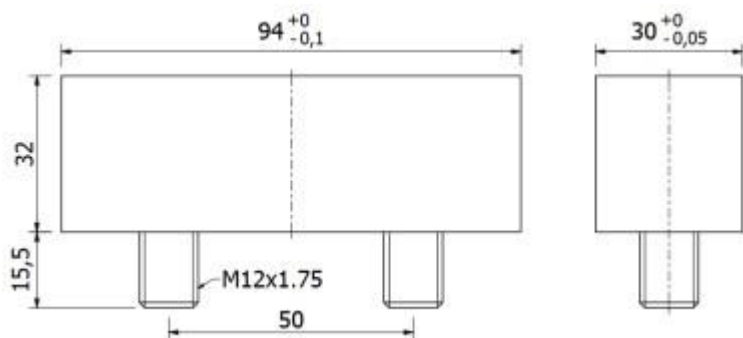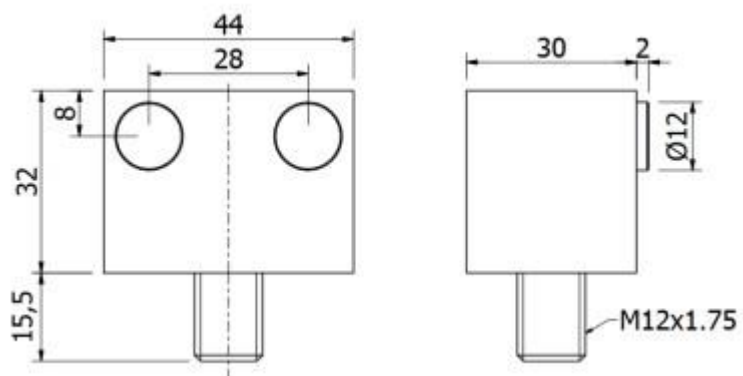
D = diamond or tungsten carbide coating

KS–S1
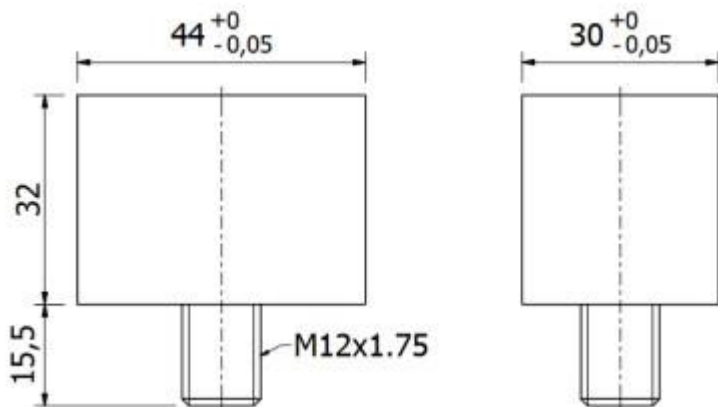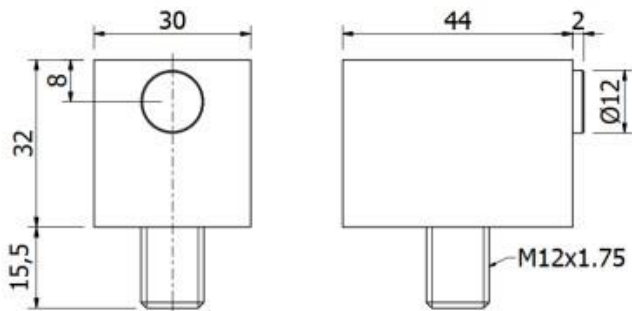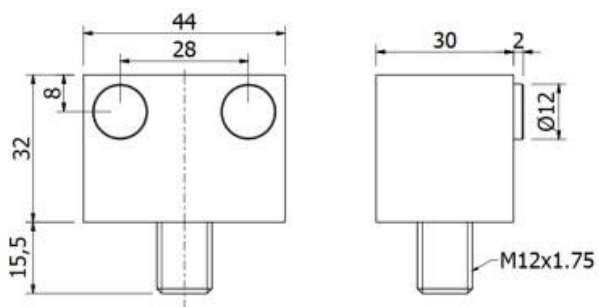
KS–R1

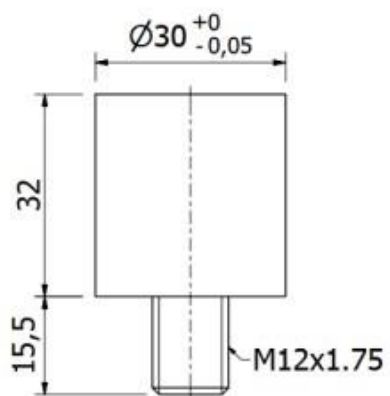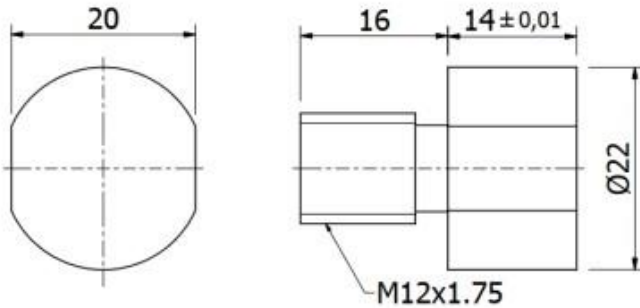# KS–S2

KS–R2

KS–D1

KS–D2

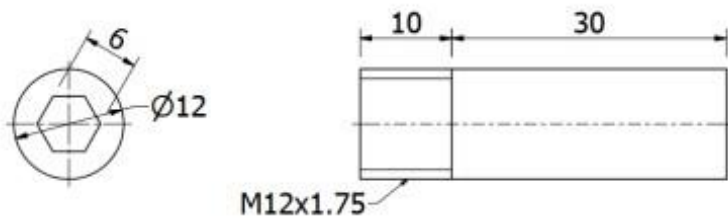# KS–SO1

Blank System riser blocks (KP–)

In most cases, code format is KP–n, where n is a type.

Blank System side guides (KG–)

In most cases, the code format is KG–n, where n is a guide type. Max tightening torque 30Nm.

KG–1

KG–2