

You've got to
CNC this!



The New One-Lok™ Single Station CNC Vise

FEATURING Chip-Free Solid Base | BoltFast™ Jaw System | QwikSlide Moveable Jaw



CNC the difference.



The One-Lok CNC Vise is an evolution in workholding. The design of every other vise on the market today is based on 1950s knee mill technology, but, as every machinist knows, CNC milling is a completely different work environment.

The One-Lok was created from the ground up for use in CNC milling. Its unique design makes it possible to capture dramatic improvements in speed, precision, and versatility.

The following highlights some of the key differences between knee mill vises and the design of the One-Lok CNC Vise.





One-Lok Single Station CNC Vise
COL1520

Standard One-Lok CNC Vise includes:

- BoltFast hard jaw set
- Toe clamps, set of 4
- Swivel wrench
- T-wrench

Knee Mill Vise



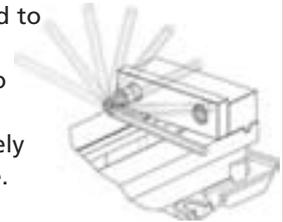
Push clamping results in jaw deflection.



It takes about 70 turns of the handle to fully open and close a knee mill vise.

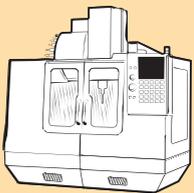


Cap screws need to be removed to change jaws. No way to accurately relocate.

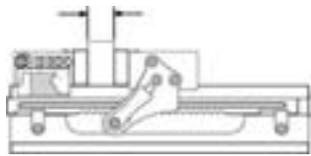


NEW TECHNOLOGY

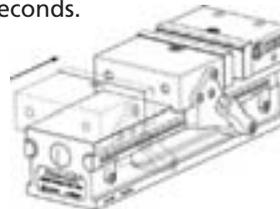
CNC Vise



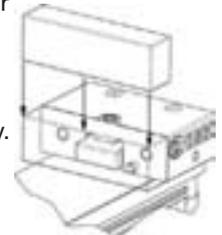
Squeeze clamping minimizes deflection.



The QwikSlide moveable jaw opens and closes in seconds.



BoltFast jaw system changes over in seconds with excellent repeatability.



One-Lok Results

Delivers consistent part placement across multiple users and a wide range of holding forces.

Saves valuable time on expensive CNC machines with the ability to make rapid workholding adjustments.

Makes more parts with less frustration—change jaws in seconds with better than 0.0008" repeatability.

One-Lok Single Station CNC Vise

The One-Lok's unique design offers speed, precision, and versatility.

1 New BoltFast Jaw System

No more knuckle scraping! With Chick's BoltFast jaw system, soft and hard jaws can be changed with a single turn of the locking screw—while providing repeatability of better than 0.0008" (0.02mm).

2 Fixed Jaw Deflection Virtually Eliminated

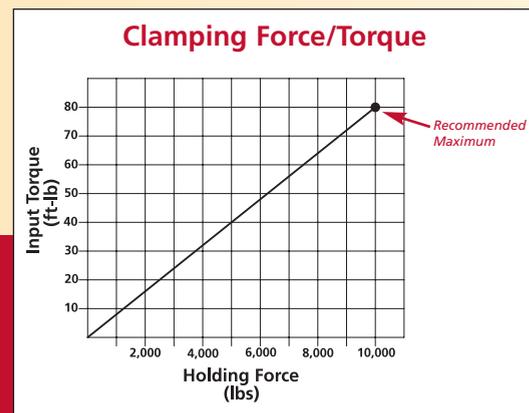
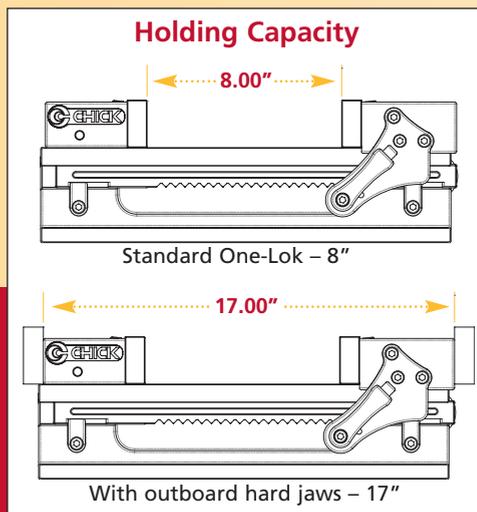
The CNC Vise is engineered to apply "squeeze clamping," which allows up to 10,000 lbs. of holding force.

3 No Chip Traps In the Base

Unique in the industry, the One-Lok's hardened, precision-ground, cast iron base is a solid working surface. No open ways means you'll never have to fish out small workpieces or clean chip build-up from inside the CNC Vise.

4 QwikSlide Moveable Jaw

The moveable jaw may be unlocked to slide forward or back for rapid set-up. No speed handles needed!





Time Is Money

Using a One-Lok (instead of a knee mill vise) will save a typical job shop at least three hours per week. Based on a \$60 hourly rate, each One-Lok in your shop will help you save \$180 a week—which adds up to \$9,360 a year.

One-Lok savings = \$9,360/year



The One-Lok's BoltFast Jaw System holds like a bolt—only better. We've designed a unique new way to change jaws quickly without sacrificing accuracy.

- 1 Slider interface pulls the jaw down into the base while squeezing the jaw plate and fixed jaw together.
- 2 The accurate locating pin repeats to within 0.0008."

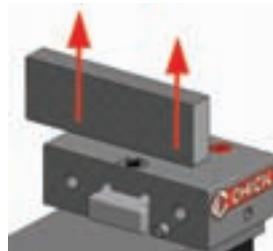
BoltFast Jaw System

BoltFast jaws can be changed out in seconds, saving time and money.

Use a T-wrench to loosen the BoltFast locking slider.



Remove the BoltFast jaw by sliding it upward.



Place a new jaw and tighten it down.



CNC Vise Accessories

BoltFast Accessories

BoltFast Stepped Hard Jaw Set
CBFST-150-06
0.25" step jaw eliminates the need for parallels.



BoltFast Soft Jaw Set
CBFSJ-150-50
Machinable for fast repeat setups and custom part applications.



BoltFast Bolt-On Jaw Spacer Set
CBFSP-150
Allows installation of knee mill vise jaw plates onto the BoltFast system.



Workstop
CWS1510



Locating Keys (5/8")
CLK0625



Locating Keys (blank)
CLKBLNK



Foundation Locating Stops
CLS0030



Outboard Hard Jaw Set
CHJ1506

Chick Workholding Solutions

Chick Workholding can help you improve productivity and profitability in your machining center. We work hand-in-hand with our customers and suppliers to pursue innovation and deliver quality workholding packages, products, and accessories for vertical and horizontal machining centers.

To order a One-Lok or discuss workholding challenges, give us a call at 724.772.1644.



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