

CHICK

Product



CHICK
WORKHOLDING
SOLUTIONS INC

MODERN WORKHOLDING FOR MODERN MACHINES

CHICK



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PRINCIPLES BEHIND THE PERFORMANCE



Chick Workholding Systems start with a base or column made from high strength aluminum alloy and hard coated for tremendous wear resistance. This

aluminum construction makes Chick Workholding Systems very lightweight, reducing the amount of wear on machine tool's ways and ballscrews. Chick Systems are easy to handle during set-ups and reduce the chance of work-related injuries.



The Chick slide assembly provides the clamping force for workpiece fixturing. This free-floating, self-contained assembly allows Chick Workholding to operate

with the same ease as an old fashioned vise and yet operate not one, but two moving jaws. This allows for fixturing of multiple workpieces. The patented third-hand mechanism is easily adjusted to fixture either similar or dissimilar workpieces.



A steel coverplate protects the base and column from shock loads and prevents chips from binding in the slide assembly. In fact, the coverplate

provides a completely smooth surface, free of any "chip traps," which allows the coolant wash system to flush chips away from the workpiece and workholding system. This reduces the amount of operator attention required when loading and unloading workpieces.



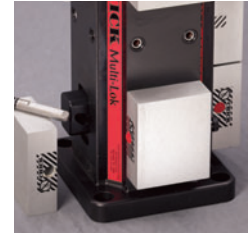
QwikChange Machinable Jaws can be designed and built to interface with virtually any workpiece. These jaws are made from a high strength aluminum

alloy that has the same tensile strength of mild steel. The jaws can be quickly manufactured into dedicated fixtures that can be installed in minutes during repeat set-ups.





The movable QwikChange Machinable Jaws are installed with QwikChange Pins, a patented design that provides the QwikChange flexibility of the Chick Workholding System. A flat on each pin interfaces with a



“D” shaped hole on the slide assembly and converts the forces generated during workpiece clamping into a downward pull on the jaw to eliminate any jaw lift and tilt. The symmetrical interface between the pin and the moveable jaw allows the jaw to be reversed and used for a second application.



The fixed center jaws are installed with two socket head cap screws. The two opposing movable jaws clamp workpieces against the center jaw to cancel out clamping forces and eliminate jaw deflection.



Once the jaw fixture is complete, the center jaw contains the locating points for all workpiece referencing. Since these locating features are integrated into a single solid piece, they cannot be disturbed and are always consistent.

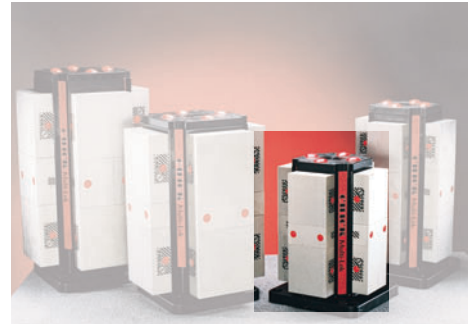


A round and diamond boss configuration on the bottom of the center jaw is sized with a die and interfaces with precision ground bushings in the base of the workholding system to provide the most accurate method of relocation available today.

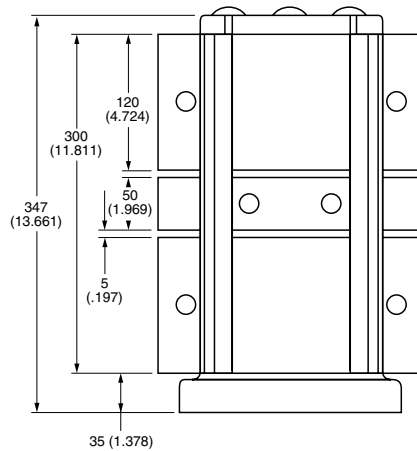
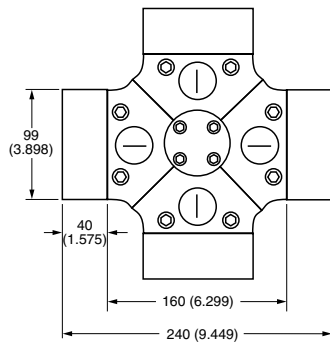
MML1030 MULTI-LOK WORKHOLDING SYSTEM



The **MML1030**'s compact 347mm (13.6") overall height gives CNC machines with limited Y-axis envelopes the flexibility to utilize Chick Workholding. The **MML1030** is also ideal for use with rotary tables and indexers to boost VMC productivity.



Dimensions

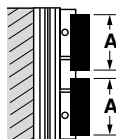


Dimensions in mm and (inches)

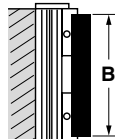
Baseplate Not Included

Specifications

Holding Capacities



A = 130 (5.1)
Dual Station



B = 280 (11.0)
*Single Station

*Required Use of **MHSML10-S**
Single Station End Plate &
MJQ10-100.40.120-MS Single Station Jaw

Torque/Clamping Force

<i>N•m</i>	<i>N</i>	<i>(ft. • lbs.)</i>	<i>(lbs.)</i>
10	4,000	5.0	600
20	8,000	15.0	1,800
30	12,000	25.0	3,000
40	16,000	35.0	4,200
◆ 50	20,000	◆ 40.0	4,800

◆ Recommended Operating Maximum

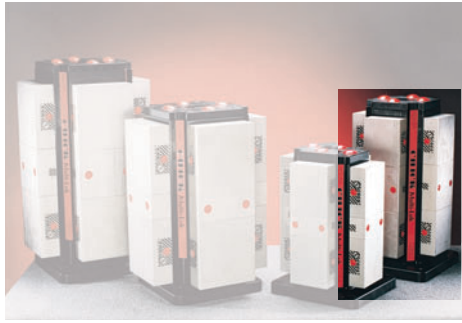
System Weight:

36 kg (80 lbs.)

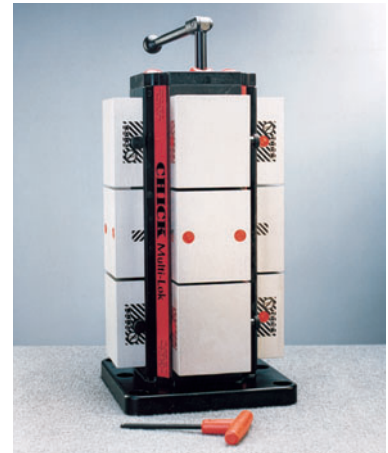
For More Information:

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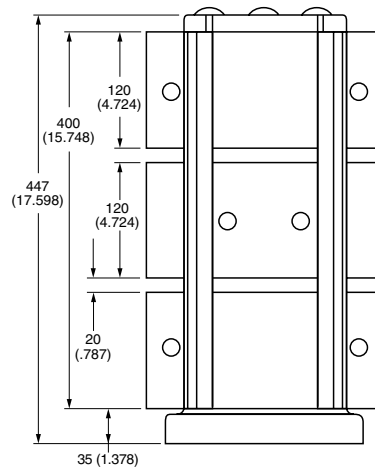
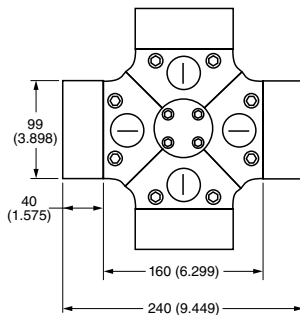
MML1040 MULTI-LOK WORKHOLDING SYSTEM



The **MML1040**'s maximum workholding capacity of 380mm (15"), combined with the short overall height of 447mm (17.6") provides tremendous machining envelope utilization. The **MML1040** is also ideal for use with indexers or rotary tables on VMCs.



Dimensions

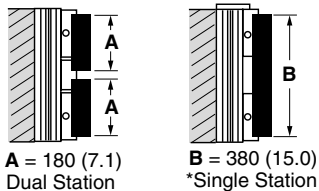


Dimensions in mm and (inches)

Baseplate Not Included

Specifications

Holding Capacities



*Required Use of **MHSM10-S** Single Station End Plate & **MJQ10-100.40.120-MS** Single Station Jaw

Torque/Clamping Force

<i>N•m</i>	<i>N</i>	<i>(ft. • lbs.)</i>	<i>(lbs.)</i>
10	4,000	5.0	600
20	8,000	15.0	1,800
30	12,000	25.0	3,000
40	16,000	35.0	4,200
◆50	20,000	◆40.0	4,800

◆ Recommended Operating Maximum

System Weight:

46 kg (101 lbs.)

For More Information:

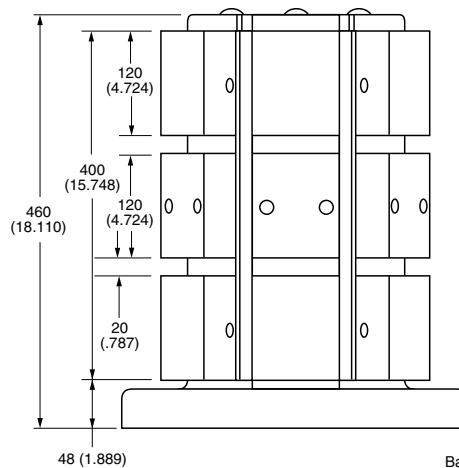
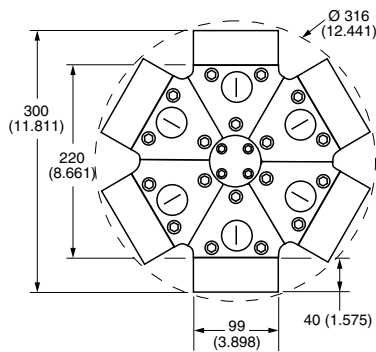
MML1040 AccessoriesPage 20
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MML1040-6 MULTI-LOK WORKHOLDING SYSTEM



Is your HMC required to run high volume jobs with minimal setup and spindle downtime? The **MML1040-6** offers the fixturing specifications of the MML1040 with one great advantage – 50% more parts at the spindle! The 6-sided unit allows for even greater uninterrupted cycle times, increasing both machine and operator efficiency.

Dimensions

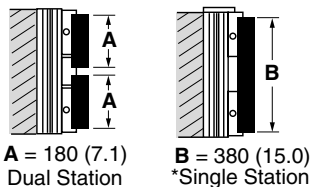


Dimensions in mm and (inches)

Baseplate Not Included

Specifications

Holding Capacities



*Required Use of **MHSML10-6-S** Single Station End Plate & **MJQ10-100.40.120-MS** Single Station Jaw

Torque/Clamping Force

<i>N•m</i>	<i>N</i>	<i>(ft. • lbs.)</i>	<i>(lbs.)</i>
10	4,000	5.0	600
20	8,000	15.0	1,800
30	12,000	25.0	3,000
40	16,000	35.0	4,200
◆50	20,000	◆40.0	4,800

◆ Recommended Operating Maximum

System Weight:

66 kg (146 lbs.)

For More Information:

MML1040-6 AccessoriesPage 20
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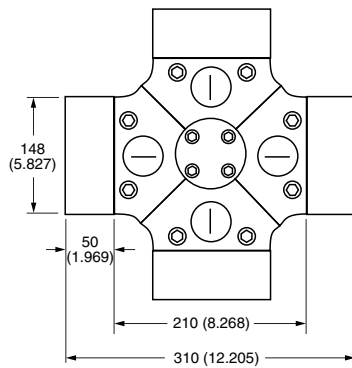
MML1540 MULTI-LOK WORKHOLDING SYSTEM



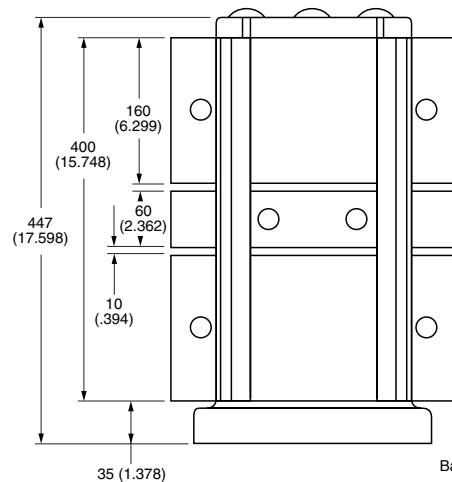
The **MML1540** has the same 447mm (17.6") overall height of the MML1040 Multi-Lok, yet offers a larger clamping station and nearly twice the clamping force!



Dimensions



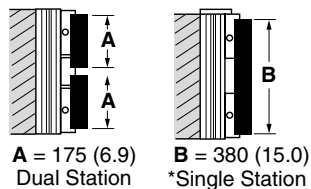
Dimensions in mm and (inches)



Baseplate Not Included

Specifications

Holding Capacities



*Required Use of **MHSML15-S** Single Station End Plate & **MJQ15-150.50.160-MS** Single Station Jaw

Torque/Clamping Force

<i>N•m</i>	<i>N</i>	<i>(ft. • lbs.)</i>	<i>(lbs.)</i>
20	7,000	15.0	1,700
50	18,000	25.0	2,800
70	25,500	40.0	4,500
90	33,000	60.0	6,800
◆110	40,000	◆80.0	9,000

◆ Recommended Operating Maximum

System Weight:

81 kg (180 lbs.)

For More Information:

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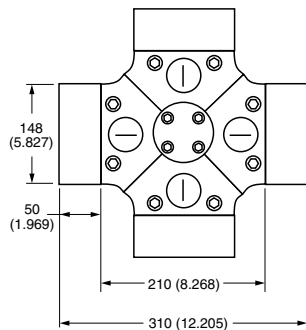
MML1550 MULTI-LOK WORKHOLDING SYSTEM



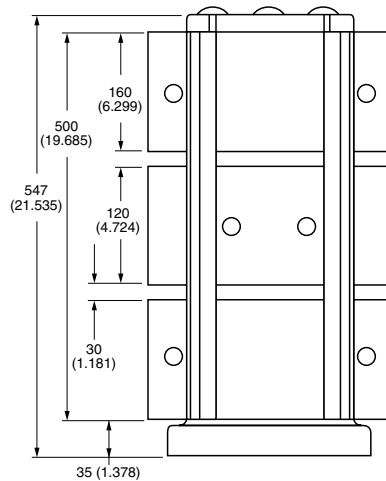
The **MML1550** Multi-Lok is the largest of the Chick horizontal workholding systems. The maximum workholding capacity of 480mm (18.9") and a clamping force maximum of 40 kN (9,000 lbs.) along with a wide range of available accessories, provides your HMC with the greatest amount of flexibility to meet all your production needs.



Dimensions



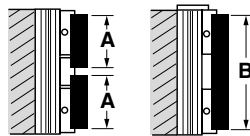
Dimensions in mm and (inches)



Baseplate Not Included

Specifications

Holding Capacities



A = 225 (8.9)
Dual Station

B = 480 (18.9)
*Single Station

*Required Use of **MHSM15-S**
Single Station End Plate &
MJQ15-150.50.160-MS Single Station Jaw

Torque/Clamping Force

<i>N•m</i>	<i>N</i>	<i>(ft. • lbs.)</i>	<i>(lbs.)</i>
20	7,000	15.0	1,700
50	18,000	25.0	2,800
70	25,500	40.0	4,500
90	33,000	60.0	6,800
◆110	40,000	◆80.0	9,000

◆ Recommended Operating Maximum

System Weight:

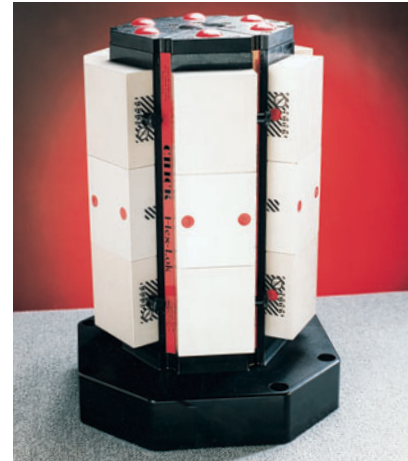
99 kg (218 lbs.)

For More Information:

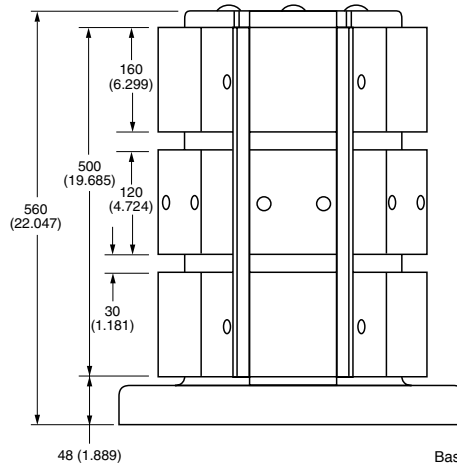
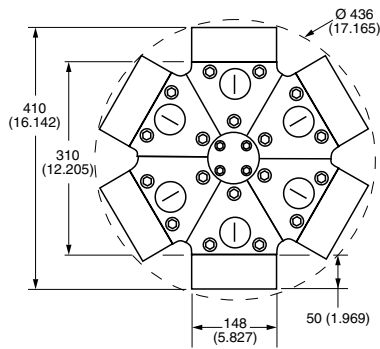
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MML1550-6 MULTI-LOK WORKHOLDING SYSTEM

Is your machine expected to run high volume jobs with minimal set-up and spindle downtime? The **MML1550-6** offers the fixturing specifications of the MML1550 with one great extra – 50% more parts at the spindle! The 6-sided unit allows for even greater uninterrupted cycle times, increasing both machine and operator efficiency.



Dimensions



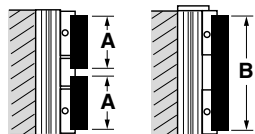
Dimensions in mm and (inches)

48 (1.889)

Baseplate Not Included

Specifications

Holding Capacities



A = 225 (8.9) Dual Station

B = 480 (18.9) *Single Station

*Required Use of **MHSML15-6-S** Single Station End Plate & **MJQ15-150.50.160-MS** Single Station Jaw

Torque/Clamping Force

<i>N•m</i>	<i>N</i>	<i>(ft. • lbs.)</i>	<i>(lbs.)</i>
20	7,000	15.0	1,700
50	18,000	25.0	2,800
70	25,500	40.0	4,500
90	33,000	60.0	6,800
◆110	40,000	80.0	9,000 ◆

◆ Recommended Operating Maximum

System Weight:

173 kg (380 lbs.)

For More Information:

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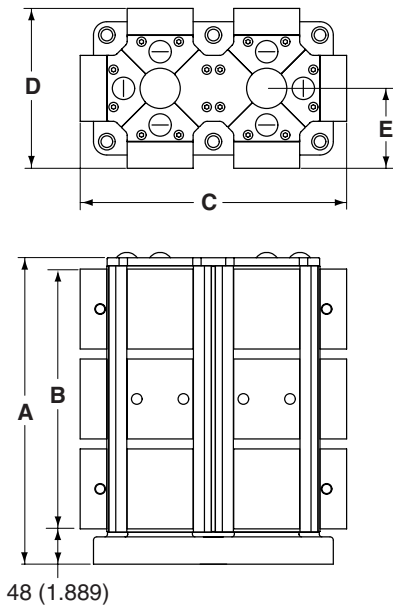
12 & 16 STATION MULTI-LOK



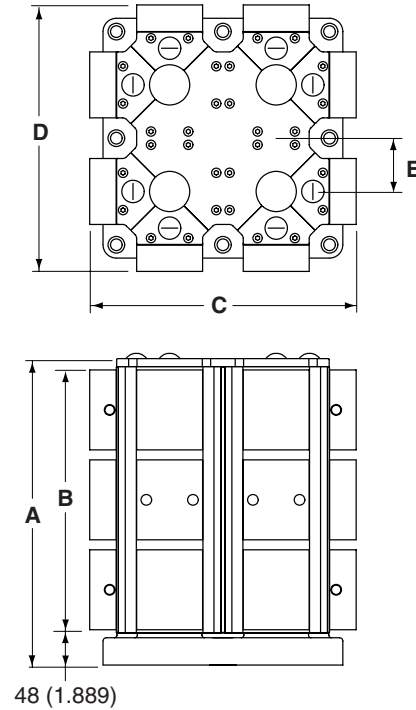
All Chick Multi-Loks are available in 12 and 16 workstation configurations. These larger Multi-Loks are ideally suited for regularly scheduled high volume production runs. The 12 and 16 station units can double the length of your unmanned machining cycles, thereby increasing machining efficiency and decreasing the manufacturing cost per part.

The 12 and 16 station units are also ideal for production of larger parts that exceed the holding capacity of standard 8 station units.

12 Station Dimensions



16 Station Dimensions

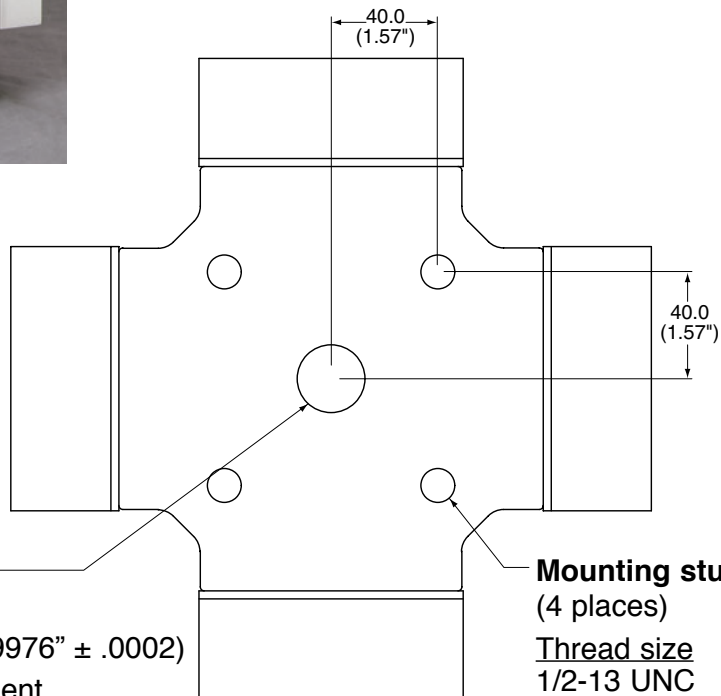
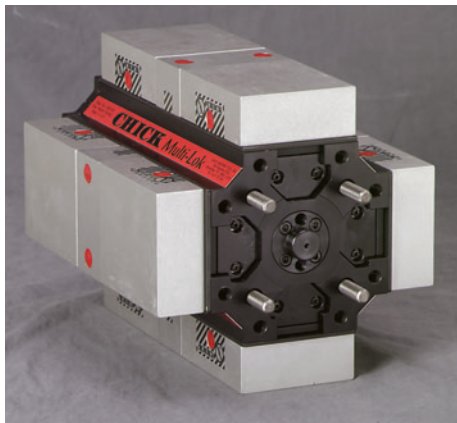


	A mm (inch)	B mm (inch)	C mm (inch)	D mm (inch)	E mm (inch)
MML1030-12	360 (14.17)	300 (11.81)	400 (15.75)	240 (9.45)	80 (3.15)
MML1040-12	460 (18.11)	400 (15.75)	400 (15.75)	240 (9.45)	80 (3.15)
MML1540-12	460 (18.11)	400 (15.75)	520 (20.47)	310 (12.20)	105 (4.13)
MML1550-12	560 (22.05)	500 (19.69)	520 (20.47)	310 (12.20)	105 (4.13)

	A mm (inch)	B mm (inch)	C mm (inch)	D mm (inch)	E mm (inch)
MML1030-16	360 (14.17)	300 (11.81)	400 (15.75)	400 (15.75)	80 (3.15)
MML1040-16	460 (18.11)	400 (15.75)	400 (15.75)	400 (15.75)	80 (3.15)
MML1540-16	460 (18.11)	400 (15.75)	520 (20.47)	520 (20.47)	105 (4.13)
MML1550-16	560 (22.05)	500 (19.69)	520 (20.47)	520 (20.47)	105 (4.13)

MML1030LP LOW PROFILE MULTI-LOK

The MML1030 Multi-Lok Workholding System is available in a low profile package, allowing Chick Workholding to be utilized on HMCs with smaller work envelopes. This Multi-Lok Workholding System consists of a standard 1030 Multi-Lok, low profile end hub and sealplates, and a special pilot plug. A through column mounting kit is then used to mount the Multi-Lok System directly to the pallet of an HMC, without the need for a baseplate. The overall height of 307mm (12.09") makes the **MML1030LP** the ideal workholding system for horizontal machining centers that utilize pallet carousels with limited Y-axis clearance.



Pilot Plug

Diameter

$\text{Ø}25.34 \pm 0.005$ (.9976" \pm .0002)

Depth of engagement

11.25 (.45")

Mounting studs

(4 places)

Thread size

1/2-13 UNC

Depth of engagement

19 (.75")

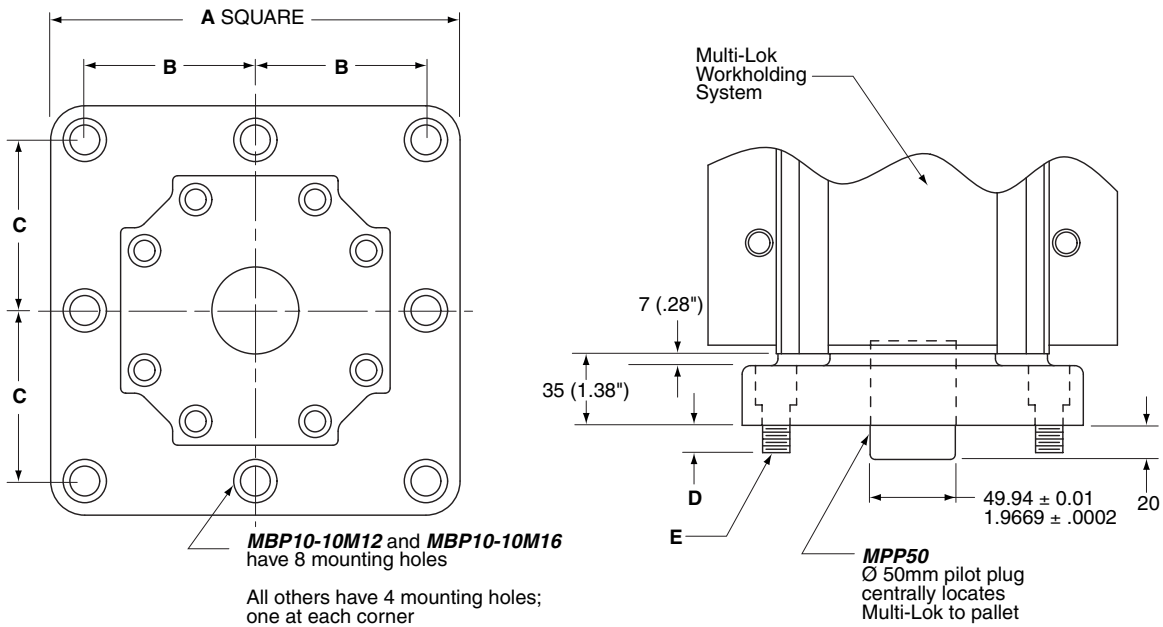
For more information, visit us at www.chick-workholding.com or call toll-free (800) 33-CHICK

STANDARD BASEPLATES

All Chick Multi-Lok Workholding Systems (except the **MML1030LP**) require the use of a baseplate for installation onto HMC pallets. The baseplate serves two important functions:

- First, the baseplate rigidly secures the Multi-Lok to the pallet
- Second, the baseplate may be used to position the Multi-Lok into the work envelope

Multi-Lok users have several options for choosing baseplates. Chick manufactures a number of standard size baseplates designed to interface with JIS and DIN standard HMC pallets.



For **MML1030** and **MML1040** Multi-Lok Workholding Systems

Catalog No.	A	B	C	D	E
MBP10-08M12	200 (7.87)	80 (3.15)	80 (3.15)	16 (.63)	M12 x 25
MBP10-08M16	200 (7.87)	80 (3.15)	80 (3.15)	23.5 (.93)	M16 x 35
MBP10-10M12	240 (9.45)	100 (3.94)	100 (3.94)	16 (.63)	M12 x 25
MBP10-10M16	240 (9.45)	100 (3.94)	100 (3.94)	23.5 (.93)	M16 x 35

For **MML1540** and **MML1550** Multi-Lok Workholding Systems

Catalog No.	A	B	C	D	E
MBP15-08M12	208 (8.19)	80 (3.15)	80 (3.15)	16 (.63)	M12 x 25
MBP15-08M16	208 (8.19)	80 (3.15)	80 (3.15)	23.5 (.93)	M16 x 35
MBP15-10M12	240 (9.45)	100 (3.94)	100 (3.94)	16 (.63)	M12 x 25
MBP15-10M16	240 (9.45)	100 (3.94)	100 (3.94)	23.5 (.93)	M16 x 35

CUSTOM BASEPLATES

Custom baseplates are available to match the needs of your machining applications and HMC pallet interface. Chick's application engineers will design a baseplate to your specifications, ensuring that the baseplate configuration is optimized for your manufacturing needs.

For further information regarding custom baseplates, contact your local Chick distributor. In order to expedite your request, please fill in the chart below:

Machining Center Make and Model: _____

Size of Pallet

A): _____

Mounting Hole Pattern

B): _____

C): _____

D): _____

E): _____

Mounting Hole Specifications
(thread size and depth)

F): _____

Edge Locator Pattern

G): _____

H): _____

I): _____

J): _____

Edge Locator Hole Specification
(Thru hole and C-Bore)

K): _____

Center Pilot Dimensions

L): _____

M): _____

Spindle Center to Pallet

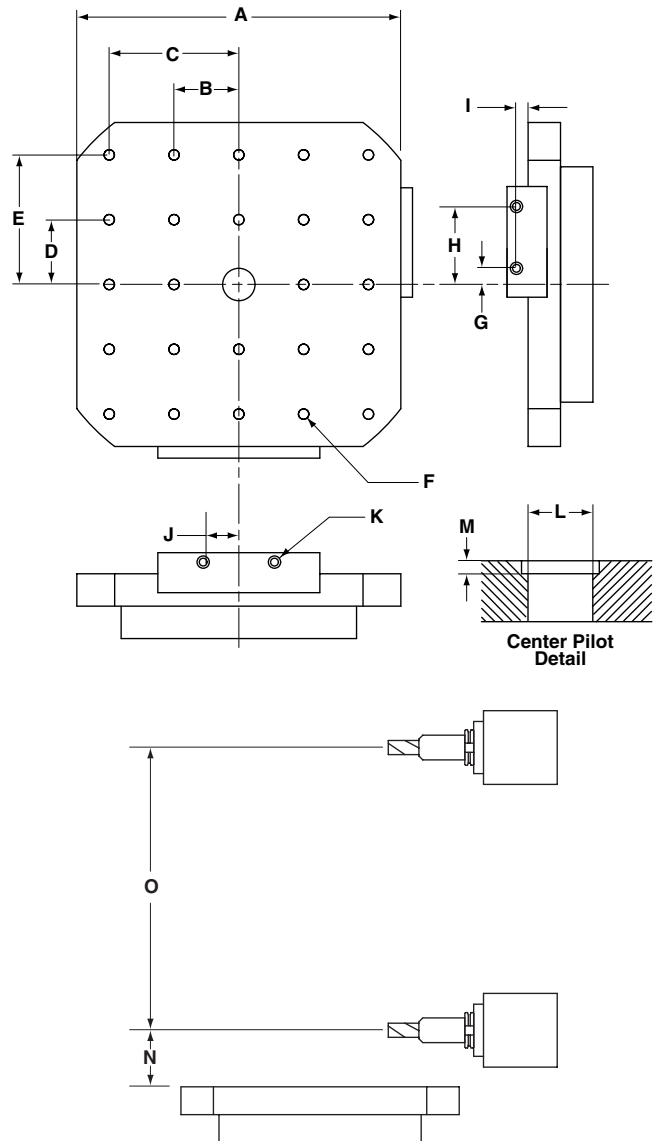
N): _____

Y-Axis Travel

O): _____

Additional Information

(i.e., full pallet coverage, extra tall, etc.) _____



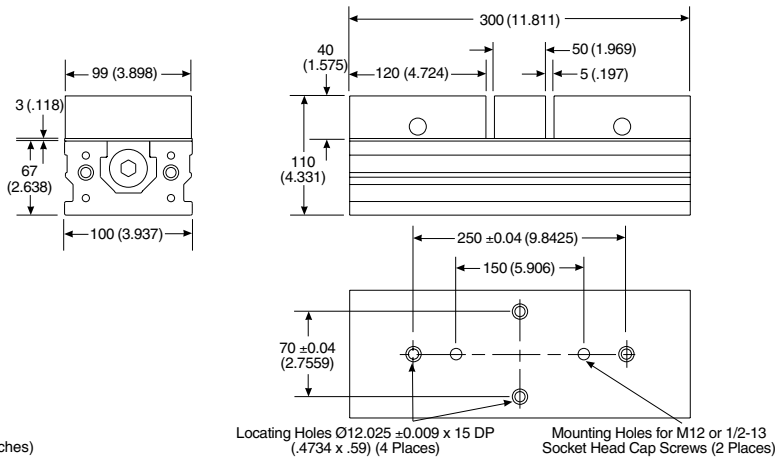
MQL1030 QWIK-LOK WORKHOLDING SYSTEM



The **MQL1030**, with it's 300mm (11.81") overall length offers a dual station workholding system with holding capacities over 130mm (5"). The **MQL1030** is ideal for use on pallet shuttles and any VMC's with no table overhang allowance.

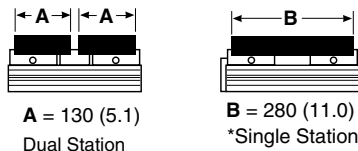


Dimensions



Specifications

Holding Capacities



*Required Use of **MHSQL10-S** Single Station End Plate & **MJQ10-100.40.120-MS** Single Station Jaw

Torque/Clamping Force

N•m	N	(ft. • lbs.)	(lbs.)
10	4,000	5.0	600
20	8,000	15.0	1,800
30	12,000	25.0	3,000
40	16,000	35.0	4,200
◆ 50	20,000	◆ 40.0	4,800

◆ Recommended Operating Maximum

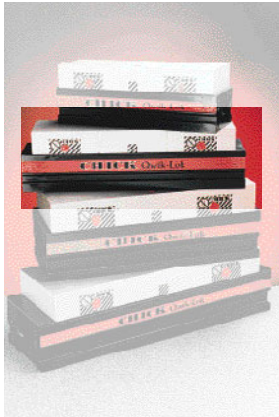
System Weight:

9 kg (20 lbs.)

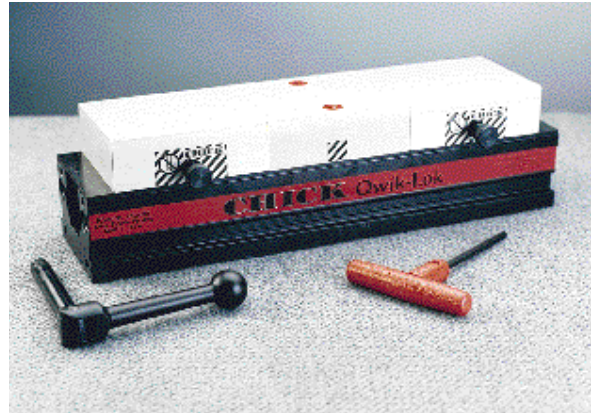
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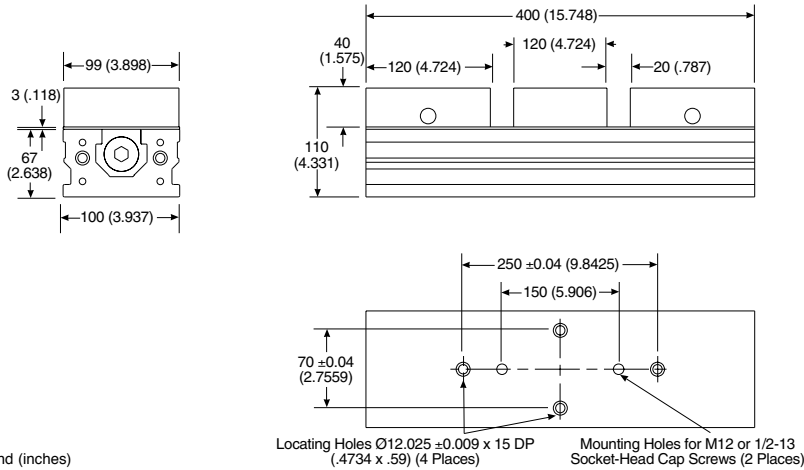
MQL1040 QWIK-LOK WORKHOLDING SYSTEM



The **MQL1040** offers dual station clamping capacities of over 180mm (7") and can be converted to single station clamping to fixture 380mm (15") workpieces. The **MQL1040** has a wide variety of available accessories to meet all your production needs.

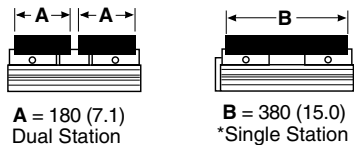


Dimensions



Specifications

Holding Capacities



*Required Use of **MHSQL10-S** Single Station End Plate & **MJQ10-100.40.120-MS** Single Station Jaw

Torque/Clamping Force

<i>N•m</i>	<i>N</i>	<i>(ft. • lbs.)</i>	<i>(lbs.)</i>
10	4,000	5.0	600
20	8,000	15.0	1,800
30	12,000	25.0	3,000
40	16,000	35.0	4,200
◆ 50	20,000	◆ 40.0	4,800

◆ Recommended Operating Maximum

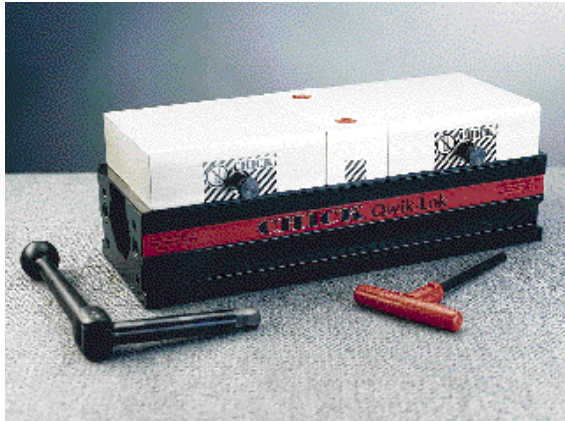
System Weight:

12 kg (27 lbs.)

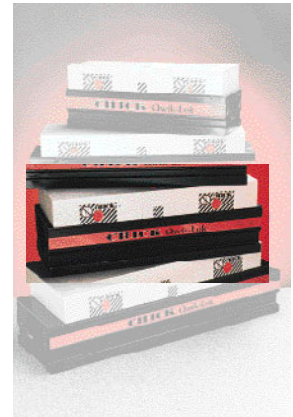
For More Information:

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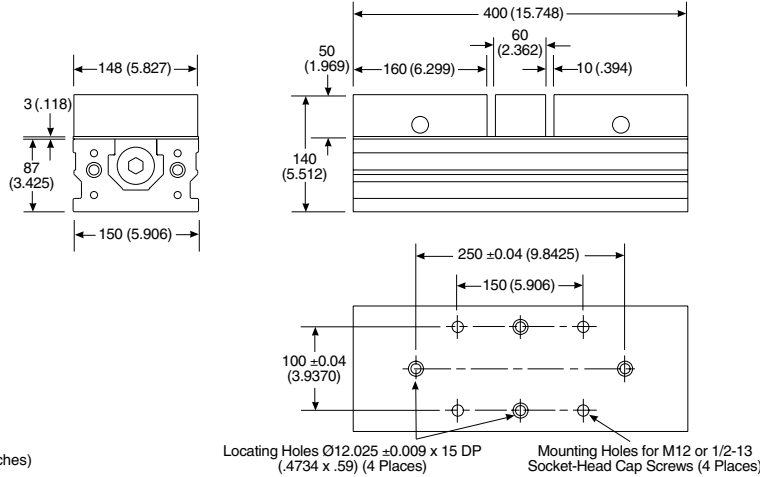
MQL1540 QWIK-LOK WORKHOLDING SYSTEM



The **MQL1540** offers 50% greater clamping capacity and nearly double the clamping force of an **MQL1040**, while maintaining the same overall 400mm (15.75") length. The MQL1540 is ideal for larger workpiece production on smaller VMC's with no table overhang allowance.

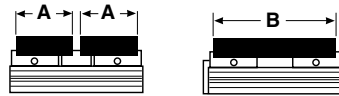


Dimensions



Specifications

Holding Capacities



A = 175 (6.9)
Dual Station

B = 380 (15.0)
*Single Station

*Required Use of **MHSQL15-S** Single Station End Plate & **MJQ15-150.50.160-MS** Single Station Jaw

Torque/Clamping Force

<i>N•m</i>	<i>N</i>	(ft. • lbs.)	(lbs.)
20	7,000	15.0	1,700
50	18,000	25.0	2,800
70	25,500	40.0	4,500
90	33,000	60.0	6,800
◆ 110	40,000	◆ 80.0	9,000

◆ Recommended Operating Maximum

System Weight:

23 kg (50 lbs.)

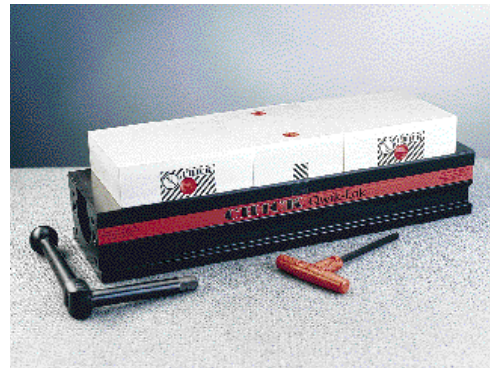
For More Information:

MQL1540 AccessoriesPage 22
Replacement PartsPage 28

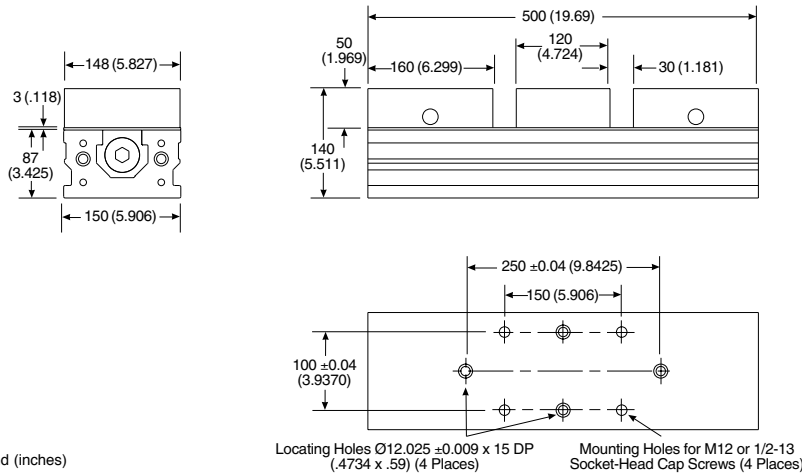
MQL1550 QWIK-LOK WORKHOLDING SYSTEM



The **MQL1550** is the largest of the Chick Qwik-Lok™ Workholding Systems. It offers dual station clamping capacities of 225mm (8.9") and can be converted to single station clamping to fixture workpieces as large as 480mm (18.9")! The **MQL1550** has a wide variety of available accessories to meet all your production needs.

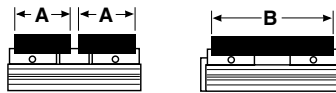


Dimensions



Specifications

Holding Capacities



A = 225 (8.9)
Dual Station

B = 480 (18.9)
*Single Station

*Required Use of **MHSQL15-S** Single Station End Plate & **MJQ15-150.50.160-MS** Single Station Jaw

Torque/Clamping Force

<i>N</i> •m	<i>N</i>	(ft. • lbs.)	(lbs.)
20	7,000	15.0	1,700
50	18,000	25.0	2,800
70	25,500	40.0	4,500
90	33,000	60.0	6,800
◆ 110	40,000	◆ 80.0	9,000

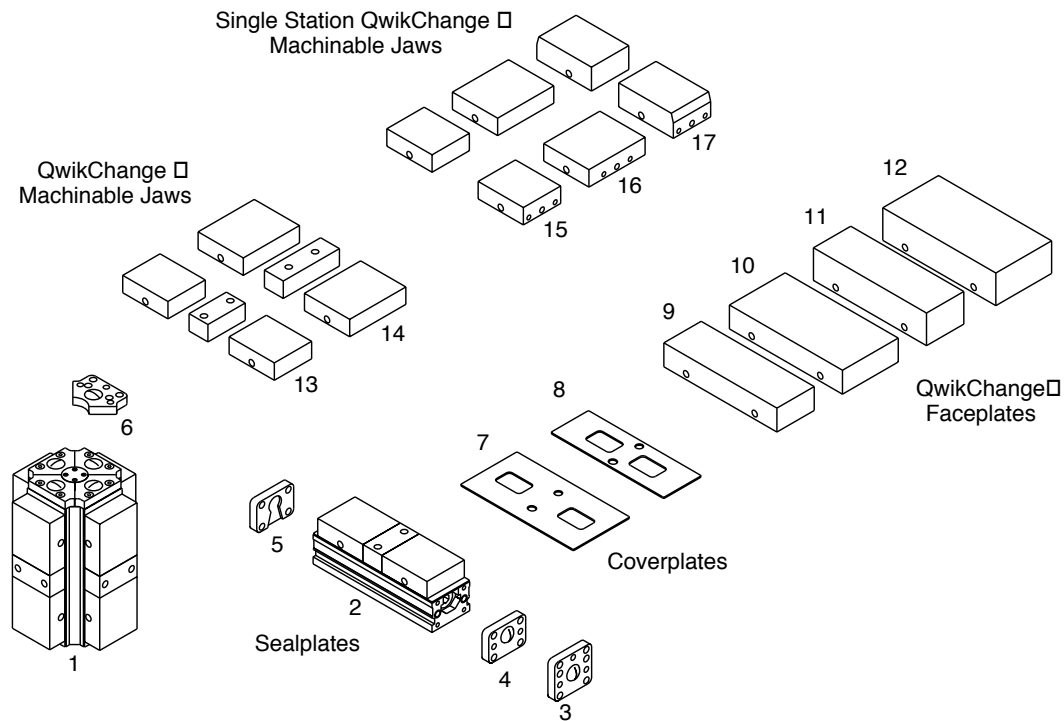
◆ Recommended Operating Maximum

System Weight:
27 kg (59 lbs.)

For More Information:

MQL1550 AccessoriesPage 24
Replacement PartsPage 28

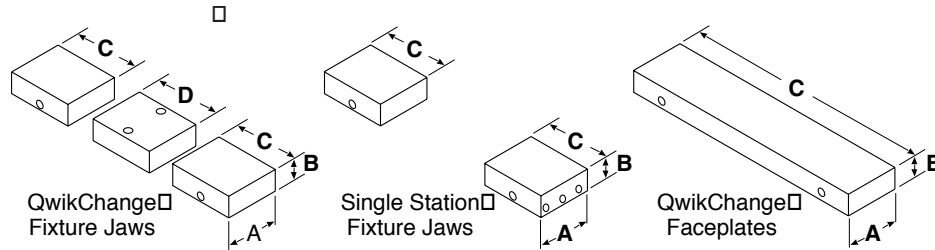
1030 ACCESSORIES



Item	Catalog No.	Description
1	MML1030	Multi-Lok 1030 Workholding System (pg. 4)
2	MQL1030	Qwik-Lok 1030 Workholding System (pg. 14)
3	MHSQL10-S	Single Station Sealplate for 100mm Qwik-Loks
4	MHSQL10	Handle Sealplate for 100mm Qwik-Loks
5	MRSQL10	Rear Sealplate for 100mm Qwik-Loks
6	MHSM10-S	Single Station Sealplate for 100mm Multi-Loks
7	MCPS10-150.300	Wide Coverplate for 1030 System
8	MCPH10-100.300	High Jaw Coverplate for 1030 Systems
9	MFP1030-100.55	QC Standard Faceplate for 1030 Systems; 100 wide x 55 tall
10	MFP1030-150.55	QC Wide Faceplate for 1030 Systems; 150 wide x 55 tall
11	MFP1030-100.75	QC High Faceplate for 1030 Systems; 100 wide x 75 tall
12	MFP1030-150.75	QC Oversized Faceplate for 1030 Systems; 150 wide x 75 tall
13	MJQ1030-100.40	QC Standard 1030 Machinable Jaw Set; 100 wide x 40 tall
14	MJQ1030-150.40	QC Wide 1030 Machinable Jaw Set; 150 wide x 40 tall
15	MJQ10-100.40.120-MS	QC Single Station Standard Machinable Jaw Set; 100 wide x 40 tall
16	MJQ10-150.40.120-MS	QC Single Station Wide Machinable Jaw Set; 150 wide x 40 tall
17	MJQ10-100.55.145-MS†	QC Single Station High Machinable Jaw Set; 100 wide x 55 tall

† - Must be used with **MCPH10-100.300** and **MHSQL10-S** (or **MHSM10-S** for Multi-Loks)
 All QC Faceplates require the use of an **MPIN12S** Round and Diamond Pin Set (Pg. 27)

JAWS AND FACEPLATES



Dimensions

QwikChange Machinable Jaw Sets

	A mm (inch)	B mm (inch)	C mm (inch)	D mm (inch)
MJQ1030-100.40	99 (3.94)	40 (1.57)	120 (4.72)	50 (1.97)
MJQ1030-150.40	148 (5.83)	40 (1.57)	120 (4.72)	50 (1.97)
CUSTOM*				

Single Station QwikChange Machinable Jaw Sets

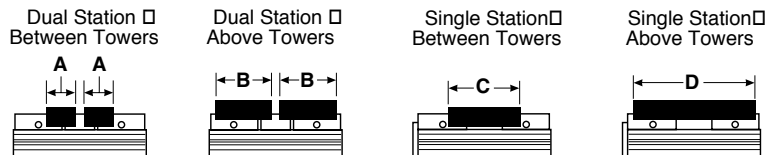
	A mm (inch)	B mm (inch)	C mm (inch)
MJQ10-100.40.120-MS	99 (3.94)	40 (1.57)	120 (4.72)
MJQ10-150.40.120-MS	148 (5.83)	40 (1.57)	120 (4.72)
MJQ10-100.55.145-MS	99 (3.94)	55 (2.17)	145 (5.71)
CUSTOM*			

QwikChange Faceplates

	A mm (inch)	B mm (inch)	C mm (inch)
MFP1030.100.55	99 (3.94)	55 (2.17)	298 (11.73)
MFP1030.150.55	148 (5.83)	55 (2.17)	298 (11.73)
MFP1030.100.75	99 (3.94)	75 (2.95)	298 (11.73)
MFP1030.150.75	148 (5.83)	75 (2.95)	298 (11.73)
CUSTOM*			

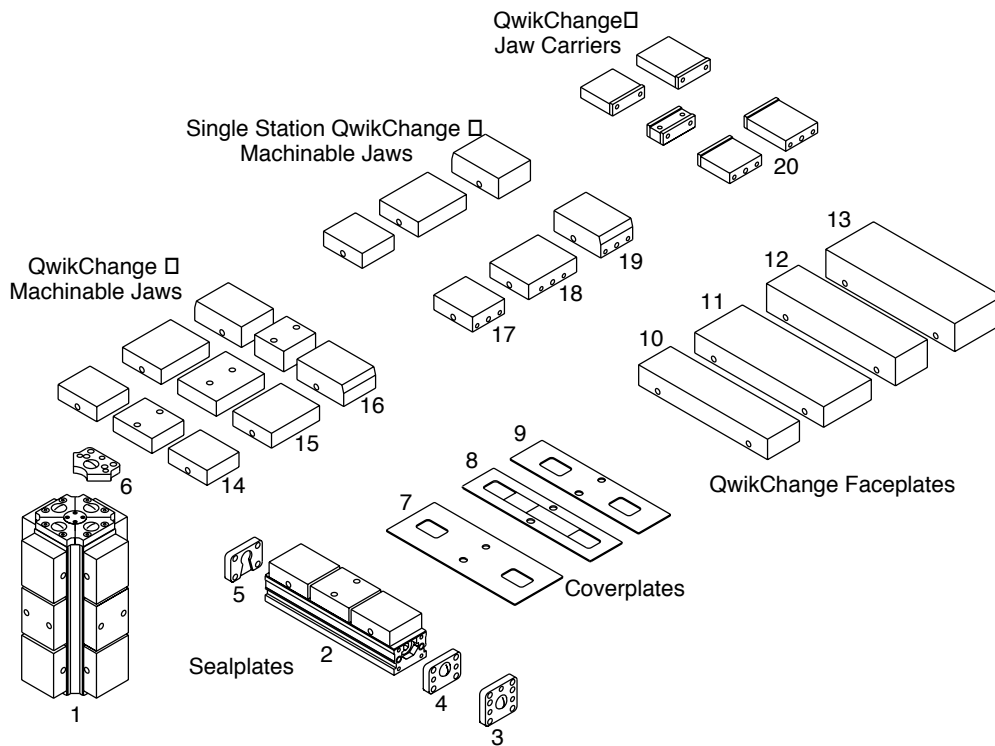
* QwikChange Machinable Jaws, Single Station QwikChange Machinable Jaws, and QwikChange Faceplates can be manufactured to any non-standard size to meet your special workholding applications. For a quotation, contact your local Chick distributor with specifications and quantity required.

Holding Capacities



	A mm (inch)	B mm (inch)	C mm (inch)	D mm (inch)
Standard & Wide Machinable Jaws	50 (1.97)	130 (5.12)	120 (4.72)	280 (11.02)
High Machinable Jaws	N/A	N/A	70 (2.76)	270 (10.63)

1040 ACCESSORIES



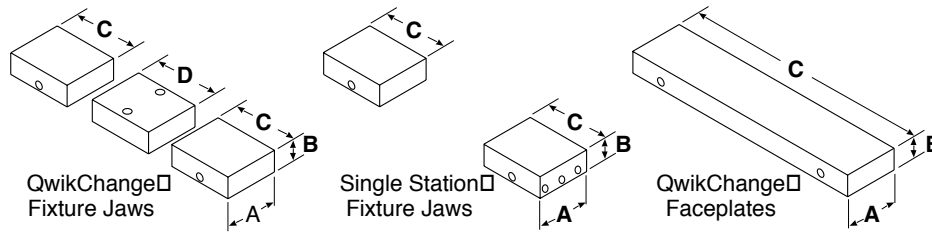
Item	Catalog No.	Description
1	MML1040	Multi-Lok 1040 Workholding System (pg. 5)
2	MQL1040	Qwik-Lok 1040 Workholding System (pg. 15)
3	MHSQL10-S	Single Station Sealplate for 100mm Qwik-Loks
4	MHSQL10	Handle Sealplate for 100mm Qwik-Loks
5	MRSQL10	Rear Sealplate for 100mm Qwik-Loks
6	MHSML10-S	Single Station Sealplate for 100mm Multi-Loks
7	MCPS10-150.400	Wide Coverplate for 1040 Systems
8	MCPX10-100.400	Extended Travel Coverplate for 1040 Systems
9	MCPH1040-100.400	High Jaw Coverplate for 1040 Systems
10	MFP1040-100.55	QC Standard Faceplate for 1040 Systems; 100 wide x 55 tall
11	MFP1040-150.55	QC Wide Faceplate for 1040 Systems; 150 wide x 55 tall
12	MFP1040-100.75	QC High Faceplate for 1040 Systems; 100 wide x 75 tall
13	MFP1040-150.75	QC Oversized Faceplate for 1040 Systems; 150 wide x 75 tall
14	MJQ1040-100.40	QC Standard 1040 Machinable Jaw Set; 100 wide x 40 tall
15	MJQ1040-150.40	QC Wide 1040 Machinable Jaw Set; 150 wide x 40 tall
16	MJQ1040-100.55†	QC High 1040 Machinable Jaw Set; 100 wide x 55 tall
17	MJQ10-100.40.120-MS	QC Single Station Standard Machinable Jaw Set; 100 wide x 40 tall
18	MJQ10-150.40.120-MS	QC Single Station Wide Machinable Jaw Set; 150 wide x 40 tall
19	MJQ10-100.55.145-MS††	QC Single Station High Machinable Jaw Set; 100 wide x 55 tall
20	MJCI1040-10	QC Jaw Carriers for 1040 Systems (pg.26)

† - Must be used with **MCPH10-100.400**

†† - Must be used with **MCPH10-100.400** and **MHSQL10-S** (or **MHSML10-S** for Multi-Loks™)

All QC Faceplates require the use of an **MPIN12S** Round and Diamond Pin Set (Pg. 27)

JAWS AND FACEPLATES



Dimensions

QwikChange Machinable Jaw Sets

	A mm (inch)	B mm (inch)	C mm (inch)	D mm (inch)
<i>MJQ1040-100.40</i>	99 (3.94)	40 (1.57)	120 (4.72)	120 (4.72)
<i>MJQ1040-150.40</i>	148 (5.83)	40 (1.57)	120 (4.72)	120 (4.72)
<i>MJQ1040-100.55</i>	99 (3.94)	55 (2.17)	145 (5.71)	90 (3.54)
CUSTOM*				

Single Station QwikChange Machinable Jaw Sets

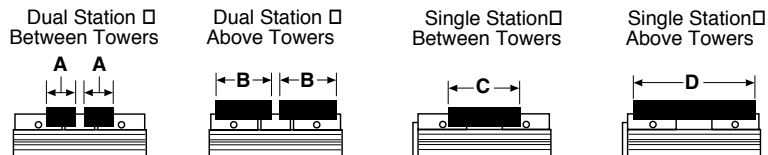
	A mm (inch)	B mm (inch)	C mm (inch)
<i>MJQ10-100.40.120-MS</i>	99 (3.94)	40 (1.57)	120 (4.72)
<i>MJQ10-150.40.120-MS</i>	148 (5.83)	40 (1.57)	120 (4.72)
<i>MJQ10-100.55.145-MS</i>	99 (3.94)	55 (2.17)	145 (5.71)
CUSTOM*			

QwikChange Faceplates

	A mm (inch)	B mm (inch)	C mm (inch)
<i>MFP1040.100.55</i>	99 (3.94)	55 (2.17)	398 (15.67)
<i>MFP1040.150.55</i>	148 (5.83)	55 (2.17)	398 (15.67)
<i>MFP1040.100.75</i>	99 (3.94)	75 (2.95)	398 (15.67)
<i>MFP1040.150.75</i>	148 (5.83)	75 (2.95)	398 (15.67)
CUSTOM*			

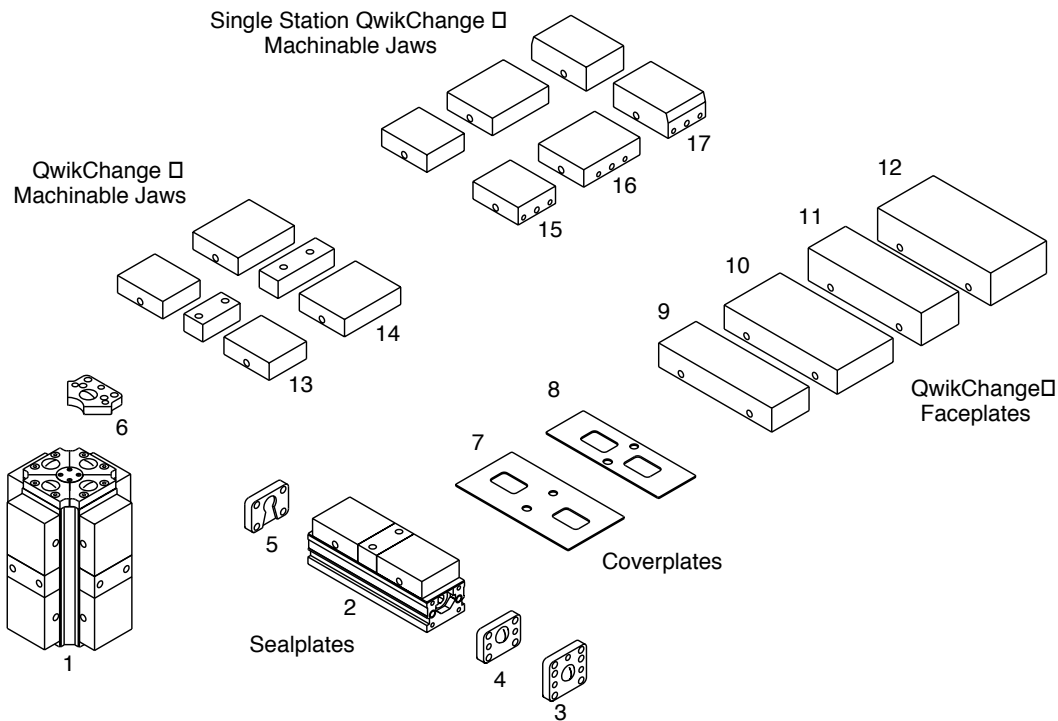
* QwikChange Machinable Jaws, Single Station QwikChange Machinable Jaws, and QwikChange Faceplates can be manufactured to any non-standard size to meet your special workholding applications. For a quotation, contact your local Chick distributor with specifications and quantity required.

Holding Capacities



	A mm (inch)	B mm (inch)	C mm (inch)	D mm (inch)
Standard & Wide Machinable Jaws	100 (3.94)	180 (7.09)	220 (8.66)	380 (14.96)
High Machinable Jaws	50 (1.97)	180 (7.09)	170 (6.69)	370 (14.57)

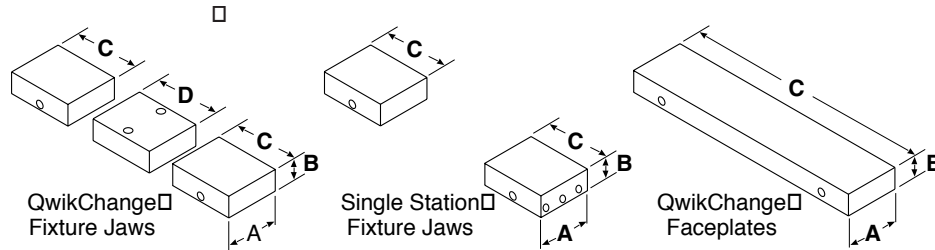
1540 ACCESSORIES



Item	Catalog No.	Description
1	MML1540	Multi-Lok 1540 Workholding System (pg. 7)
2	MQL1540	Qwik-Lok 1540 Workholding System (pg. 16)
3	MHSQL15-S	Single Station Sealplate for 100mm Qwik-Loks
4	MHSQL15	Handle Sealplate for 150mm Qwik-Loks
5	MRSQL15	Rear Sealplate for 150mm Qwik-Loks
6	MHSML15-S	Single Station Sealplate for 150mm Multi-Loks
7	MCPS15-200.400	Wide Coverplate for 1540 Systems
8	MCPH15-150.400	High Jaw Coverplate for 1540 Systems
9	MFP1540-150.55	QC Standard Faceplate for 1540 Systems; 150 wide x 55 tall
10	MFP1540-200.55	QC Wide Faceplate for 1540 Systems; 200 wide x 55 tall
11	MFP1540-150.75	QC High Faceplate for 1540 Systems; 150 wide x 75 tall
12	MFP1540-200.75	QC Oversized Faceplate for 1540 Systems; 200 wide x 75 tall
13	MJQ1540-150.50	QC Standard 1540 Machinable Jaw Set; 150 wide x 50 tall
14	MJQ1540-200.50	QC Wide 1540 Machinable Jaw Set; 200 wide x 50 tall
15	MJQ15-150.50.160-MS	QC Single Station Standard Machinable Jaw Set; 150 wide x 50 tall
16	MJQ15-200.50.160-MS	QC Single Station Wide Machinable Jaw Set; 200 wide x 50 tall
17	MJQ15-150.70.190-MS†	QC Single Station High Machinable Jaw Set; 150 wide x 70 tall

† - Must be used with **MCPH15-150.400** and **MHSQL15-S** (or **MHSML15-S** for Multi-Loks)
 All QC Faceplates require the use of an **MPIN12S** Round and Diamond Pin Set (Pg. 27)

JAWS AND FACEPLATES



Dimensions

QwikChange Machinable Jaw Sets

	A mm (inch)	B mm (inch)	C mm (inch)	D mm (inch)
<i>MJQ1540-150.50</i>	148 (5.83)	50 (1.97)	160 (6.3)	60 (2.54)
<i>MJQ1540-200.50</i>	198 (7.79)	50 (1.97)	160 (6.3)	60 (2.54)
CUSTOM*				

Single Station QwikChange Machinable Jaw Sets

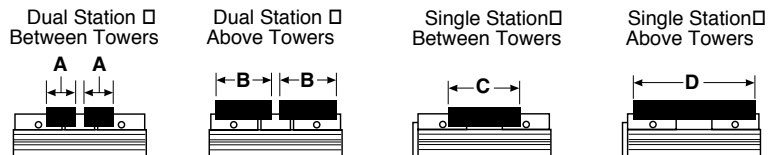
	A mm (inch)	B mm (inch)	C mm (inch)
<i>MJQ15-150.50.160-MS</i>	148 (5.83)	50 (1.97)	160 (6.3)
<i>MJQ15-200.50-160-MS</i>	198 (7.79)	50 (1.97)	160 (6.3)
<i>MJQ15-150.70.190-MS</i>	148 (5.83)	70 (2.76)	190 (7.48)
CUSTOM*			

QwikChange Faceplates

	A mm (inch)	B mm (inch)	C mm (inch)
<i>MFP1540.150.55</i>	148 (5.83)	55 (2.17)	398 (15.67)
<i>MFP1540.200.55</i>	198 (7.79)	55 (2.17)	398 (15.67)
<i>MFP1540.150.75</i>	148 (5.83)	75 (2.95)	398 (15.67)
<i>MFP1540.200.75</i>	198 (7.79)	75 (2.95)	398 (15.67)
CUSTOM*			

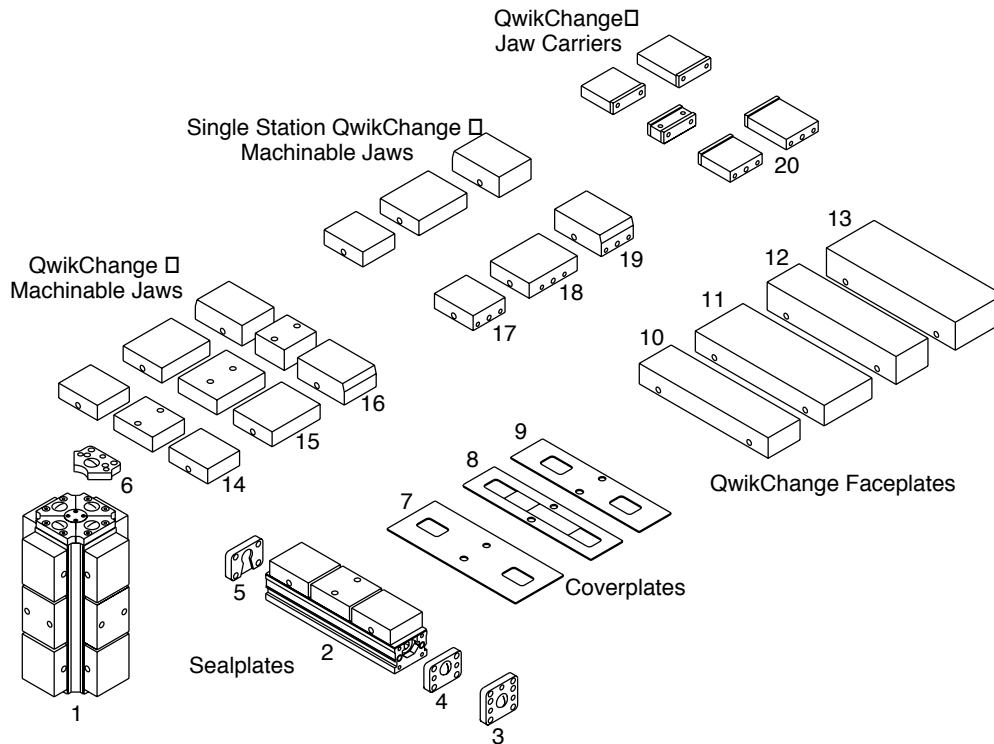
* QwikChange Machinable Jaws, Single Station QwikChange Machinable Jaws, and QwikChange Faceplates can be manufactured to any non-standard size to meet your special workholding applications. For a quotation, contact your local Chick distributor with specifications and quantity required.

Holding Capacities



	A mm (inch)	B mm (inch)	C mm (inch)	D mm (inch)
Standard & Wide Machinable Jaws	75 (2.95)	175 (6.90)	160 (6.30)	380 (14.96)
High Machinable Jaws	N/A	N/A	110 (4.33)	365 (14.37)

1550 ACCESSORIES



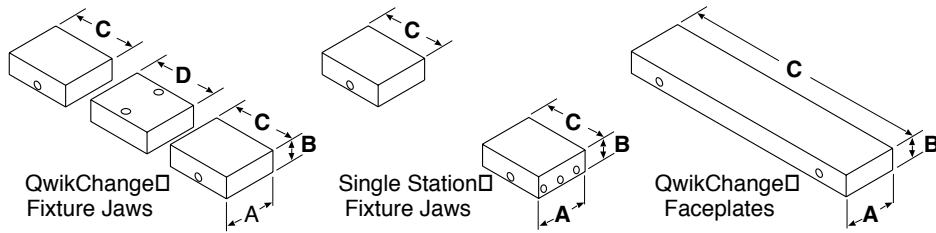
Item	Catalog No.	Description
1	MML1550	Multi-Lok 1550 Workholding System (pg. 8)
2	MQL1550	Qwik-Lok 1550 Workholding System (pg. 17)
3	MHSQL15-S	Single Station Sealplate for 150mm Qwik-Loks
4	MHSQL15	Handle Sealplate for 150mm Qwik-Loks
5	MRSQL15	Rear Sealplate for 150mm Qwik-Loks
6	MHSML15-S	Single Station Sealplate for 150mm Multi-Loks
7	MCPS15-200.500	Wide Coverplate for 1550 Systems
8	MCPX15-150.500	Extended Travel Coverplate for 1550 Systems
9	MCPH15-150.500	High Jaw Coverplate for 1550 Systems
10	MFP1550-150.55	QC Standard Faceplate for 1550 Systems; 150 wide x 55 tall
11	MFP1550-200.55	QC Wide Faceplate for 1550 Systems; 200 wide x 55 tall
12	MFP1550-150.75	QC High Faceplate for 1550 Systems; 150 wide x 75 tall
13	MFP1550-200.75	QC Oversized Faceplate for 1550 Systems; 200 wide x 75 tall
14	MJQ1550-150.50	QC Standard 1550 Machinable Jaw Set; 150 wide x 50 tall
15	MJQ1550-200.50	QC Wide 1550 Machinable Jaw Set; 200 wide x 50 tall
16	MJQ1550-150.70†	QC High 1550 Machinable Jaw Set; 150 wide x 70 tall
17	MJQ15-150.50.160-MS	QC Single Station Standard Machinable Jaw Set; 150 wide x 50 tall
18	MJQ15-200.50.160-MS	QC Single Station Wide Machinable Jaw Set; 200 wide x 50 tall
19	MJQ15-150.70.190-MS††	QC Single Station High Machinable Jaw Set; 150 wide x 70 tall
20	MJCI1550-15	QC Jaw Carriers for 1550 Systems (pg. 26)

† - Must be used with **MCPH15-150.500**

†† - Must be used with **MCPH15-150.500** and **MHSQL15-S** (or **MHSML15-S** for Multi-Loks)

All QC Faceplates require the use of an **MPIN12S** Round and Diamond Pin Set (Pg. 27)

JAWS AND FACEPLATES



Dimensions

QwikChange Machinable Jaw Sets

	A mm (inch)	B mm (inch)	C mm (inch)	D mm (inch)
<i>MJQ1550-150.50</i>	148 (5.83)	50 (1.97)	160 (6.3)	120 (4.72)
<i>MJQ1550-200.50</i>	198 (7.79)	50 (1.97)	160 (6.3)	120 (4.72)
<i>MJQ1550-150.70</i>	148 (5.83)	70 (2.76)	190 (7.48)	100 (3.94)
CUSTOM*				

Single Station QwikChange Machinable Jaw Sets

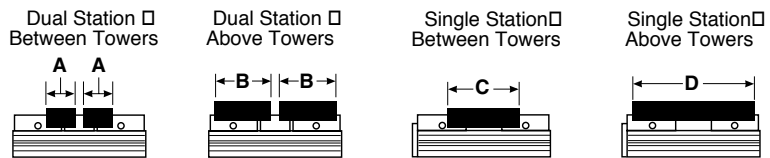
	A mm (inch)	B mm (inch)	C mm (inch)
<i>MJQ15-150.50.160-MS</i>	148 (5.83)	50 (1.97)	160 (6.3)
<i>MJQ15-200.50.160-MS</i>	198 (7.79)	50 (1.97)	160 (6.3)
<i>MJQ15-150.70.190-MS</i>	148 (5.83)	70 (2.76)	190 (7.48)
CUSTOM*			

QwikChange Faceplates

	A mm (inch)	B mm (inch)	C mm (inch)
<i>MFP1550.150.55</i>	148 (5.83)	55 (2.17)	498 (19.61)
<i>MFP1550.200.55</i>	198 (7.79)	55 (2.17)	498 (19.61)
<i>MFP1550.150.75</i>	148 (5.83)	75 (2.95)	498 (19.61)
<i>MFP1550.200.75</i>	198 (7.79)	75 (2.95)	498 (19.61)
CUSTOM*			

* QwikChange Machinable Jaws, Single Station QwikChange Machinable Jaws, and QwikChange Faceplates can be manufactured to any non-standard size to meet your special workholding applications. For a quotation, contact your local Chick distributor with specifications and quantity required.

Holding Capacities



	A mm (inch)	B mm (inch)	C mm (inch)	D mm (inch)
Standard & Wide Machinable Jaws	125 (4.92)	225 (8.86)	260 (10.24)	480 (18.90)
High Machinable Jaws	75 (2.95)	225 (8.86)	210 (8.27)	465 (18.31)

For more information, visit us at www.chick-workholding.com or call toll-free (800) 33-CHICK

JAW CARRIER SOLUTIONS

Jaw Carriers for 1040 Systems

MJCI1040-10

A complete **MJCI1040-10** Jaw Carrier Set consists of:

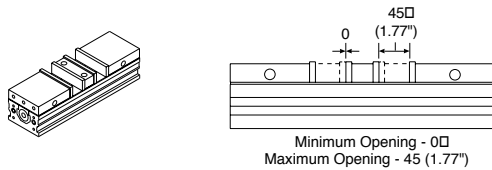
- (2) **MJCI1040-10ML** Long Moveables
- (2) **MJCI1040-10MS** Short Moveables
- (1) **MJCI1040-10F** Fixed Center

4" Hard Jaws are sold separately

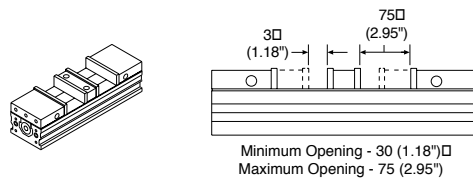
This jaw carrier set must be used with **MCPX10-100.400** Extended Travel Coverplate

Jaw carriers for metric jaw plates available

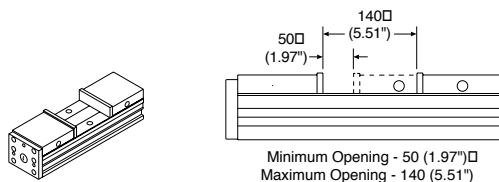
1040 Dual Station - Long Moveables



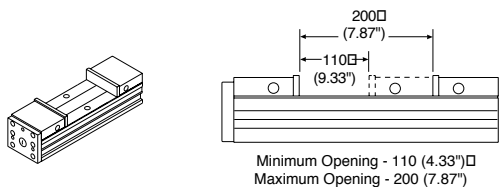
1040 Dual Station - Short Moveables



1040 Single Station - Long Moveables



1040 Single Station - Short Moveables



Jaw Carriers for 1550 Systems

MJCI1550-15

A complete **MJCI1550-15** Jaw Carrier Set consists of:

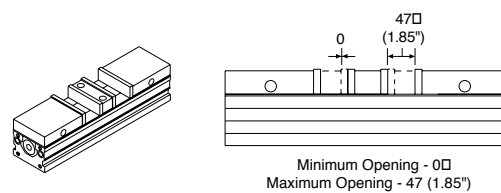
- (2) **MJCI1550-15ML** Long Moveables
- (2) **MJCI1550-15MS** Short Moveables
- (1) **MJCI1550-15F** Fixed Center

6" Hard Jaws are sold separately

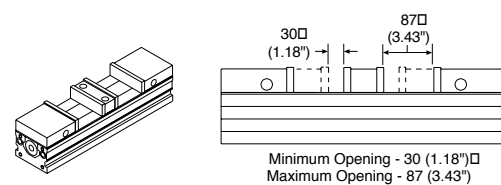
This jaw carrier set must be used with **MCPX15-150.500** Extended Travel Coverplate

Jaw carriers for metric jaw plates available

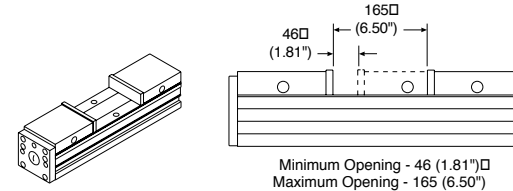
1550 Dual Station - Long Moveables



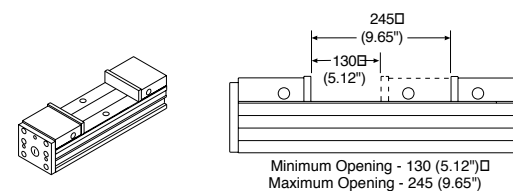
1550 Dual Station - Short Moveables



1550 Single Station - Long Moveables



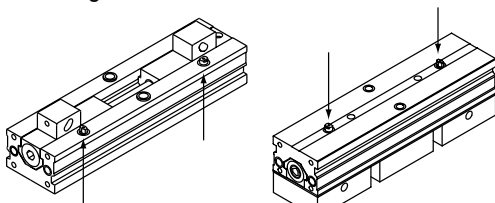
1550 Single Station - Short Moveables



ACCESSORIES

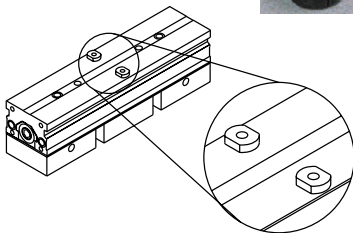
ROUND & DIAMOND PIN MPIN12S

Round and Diamond Pin Sets are used to provide positive location for all QwikChange Machinable Faceplate applications. They also may be used to locate Qwik-Lok Systems quickly and accurately. These Ø 12mm pins utilize an expanding ball lock mechanism for fastening.



LOCATING KEYS MKE-XX

Locating Keys (two keys per set) are used to provide positive location when mounting Qwik-Loks to T-slotted VMC tables. These keys utilize a ball lock mechanism to fasten into the underside of all Qwik-Lok bases.



MKE-XX

* Locating keys are available in the following sizes:

(Inch Size):	(Metric Size):
MKE-500 (1/2")	MKE10 (10mm)
MKE-562 (9/16")	MKE12 (12mm)
MKE-625 (5/8")	MKE14 (14mm)
MKE-688 (11/16")	MKE16 (16mm)
MKE-750 (3/4")	MKE18 (18mm)
MKE-812 (13/16")	MKE20 (20mm)
	MKE14X18 (14 and 18mm)

*Specify size when ordering

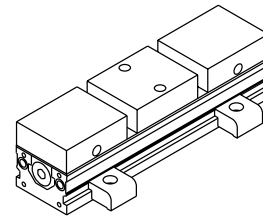
PIN EXTRACTOR PE-15

Pin Extractors complete your workholding system. The slide hammer handle provides the necessary pull to simplify jaw pin removal, and the long, threaded stud gets into tight configurations.



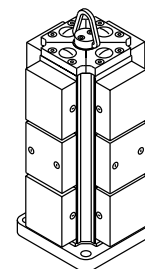
TOE CLAMP 005-0254

Chick Toe Clamps (four clamps per set) provide the quickest and most secure means of mounting an M-System Qwik-Lok to a T-slotted VMC table. Toe Clamps are designed to be used with either 1/2-13 or M12 socket head cap screws.



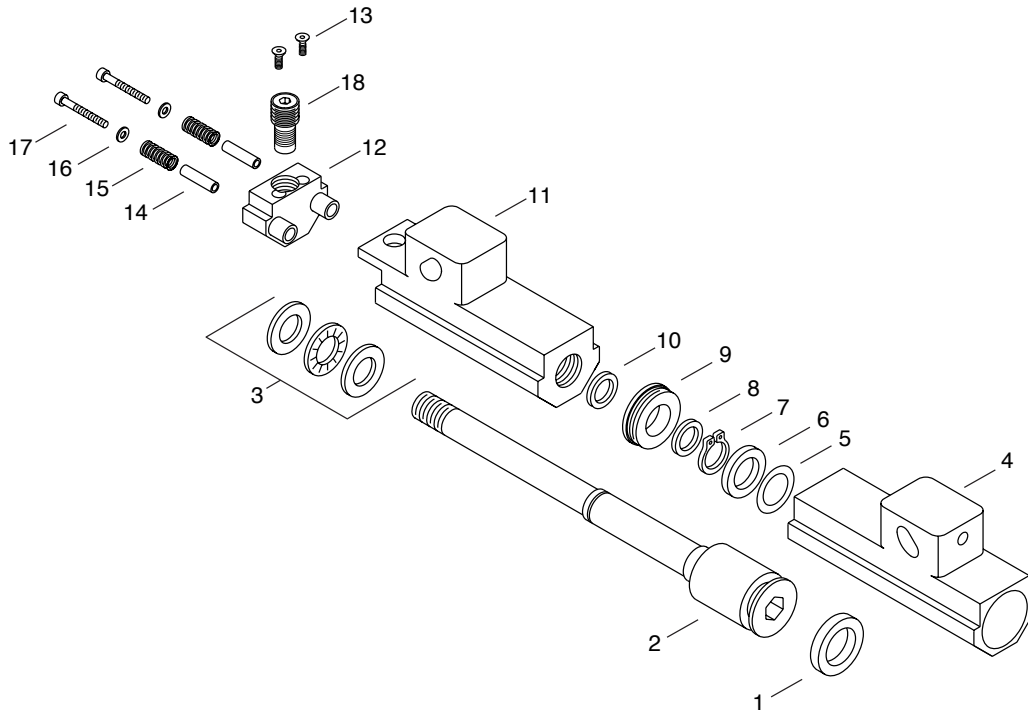
HOIST RING 027-0600

Easily lift Multi-Lok™ Workholding Systems by installing Chick's Hoist Ring. The hoist ring is bolted to the Multi-Lok's End-Hub (MMLEH) with two socket head cap screws (included). The Hoist Ring does not interfere with regular operations and may be installed as an integral component of your Multi-Lok™ Workholding System.



Note: Multi-Loks purchased prior to May 1997 will also require an MMLEH End Hub.

PARTS BREAKDOWN



Slide Assembly Component Breakdown

1 Screw Seal	7 Retaining Ring	13 Flat Head Screw
2 Screw	8 Collar Seal	14 Sleeve
3 Thrust Bearing Kit	9 Collar	15 Compression Spring
4 Slide	10 Slide Nut Seal	16 Washer
5 Wave Spring	11 Slide Nut	17 Cap Screw
6 Retaining Collar	12 Clamping Block	18 Third Hand Screw

Catalog No.

Replacement Parts*	1030 Systems	1040 Systems	1540 Systems	1550 Systems
Slide Assembly (1-18)	MSAS1030	MSAS1040	MSAS1540	MSAS1550
Slide (4)	MSLD1030	MSLD1040	MSLD1540	MSLD1550
Slide Nut (11)	MSNT1030	MSNT1040	MSNT1540	MSNT1550
Screw (2)	MSCR1030	MSCR1040	MSCR1540	MSCR1550
Collar Seal (9)	MSSC10	MSSC10	MSSC15	MSSC15
Slide Rebuilt Kit (1,3,5-8,10)	MSRK10	MSRK10	MSRK15	MSRK15
Third Hand Hardware (14-17)	MTHH10	MTHH10	MTHH15	MTHH15
Third Hand Screw (18)	MTHS10	MTHS10	MTHS15	MTHS15
Clamping Block (12-13)	MCLB10	MCLB10	MCLB15	MCLB15

*Replacement Parts are only available in kits listed above.

CHICK
WORKHOLDING
SOLUTIONS INC

500 Keystone Drive • Warrendale, PA 15086
Tel: (724) 772-1644 • Fax: (724) 772-1633 • Toll Free: (800) 33-CHICK
www.chick-workholding.com