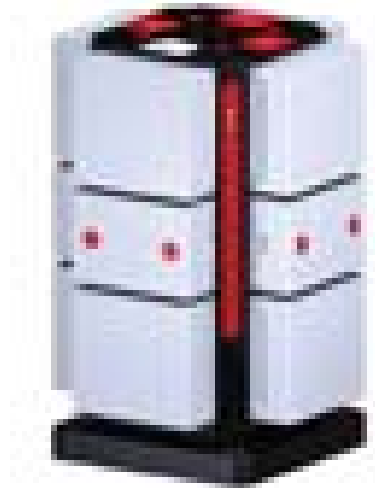


5AP-MAZA-00264

This workholding package is designed for your MAZAK Variaxis 630 APC (Inch) machining center.

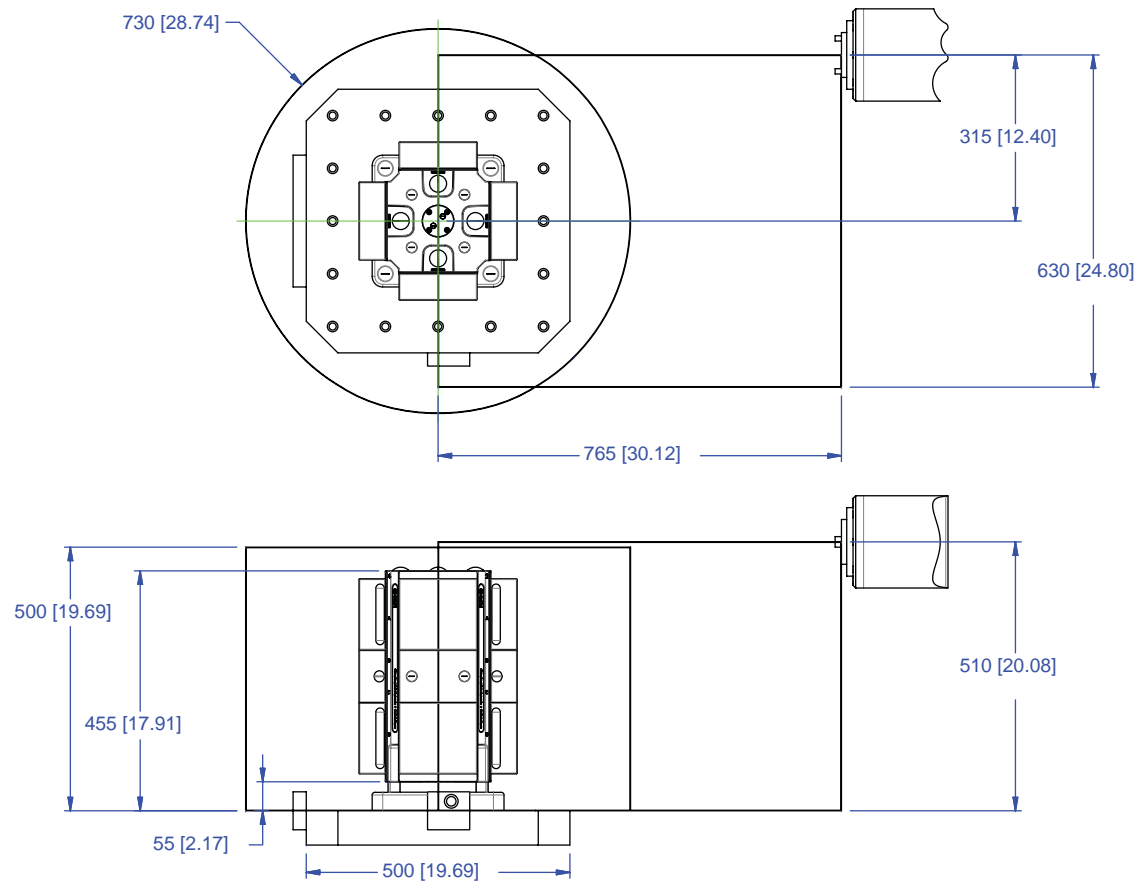


Notes

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www.ChickWorkholding.com

5AP-MAZA-00264

This workholding package is designed for your MAZAK Variaxis 630 APC (Inch) machining center.



Notes

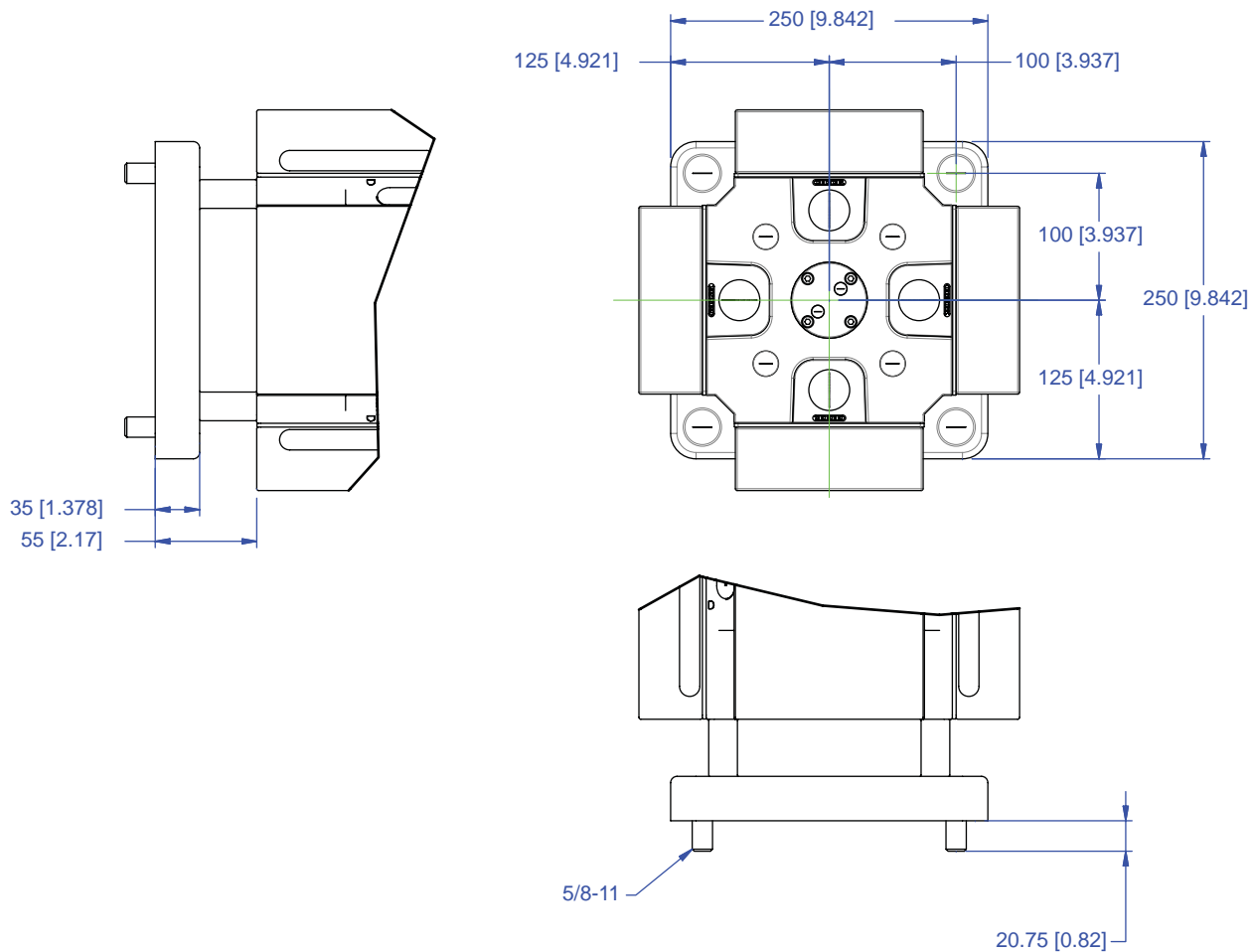
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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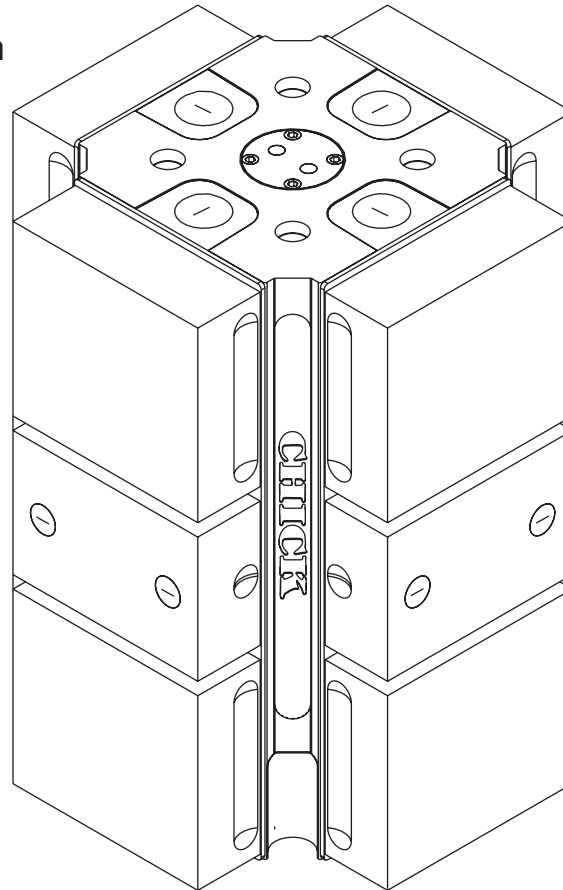
Notes
All dimensions are MM [IN]

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⑤ 5ML1540-41

SYSTEM 5

1540 Multi-Lok Product Information

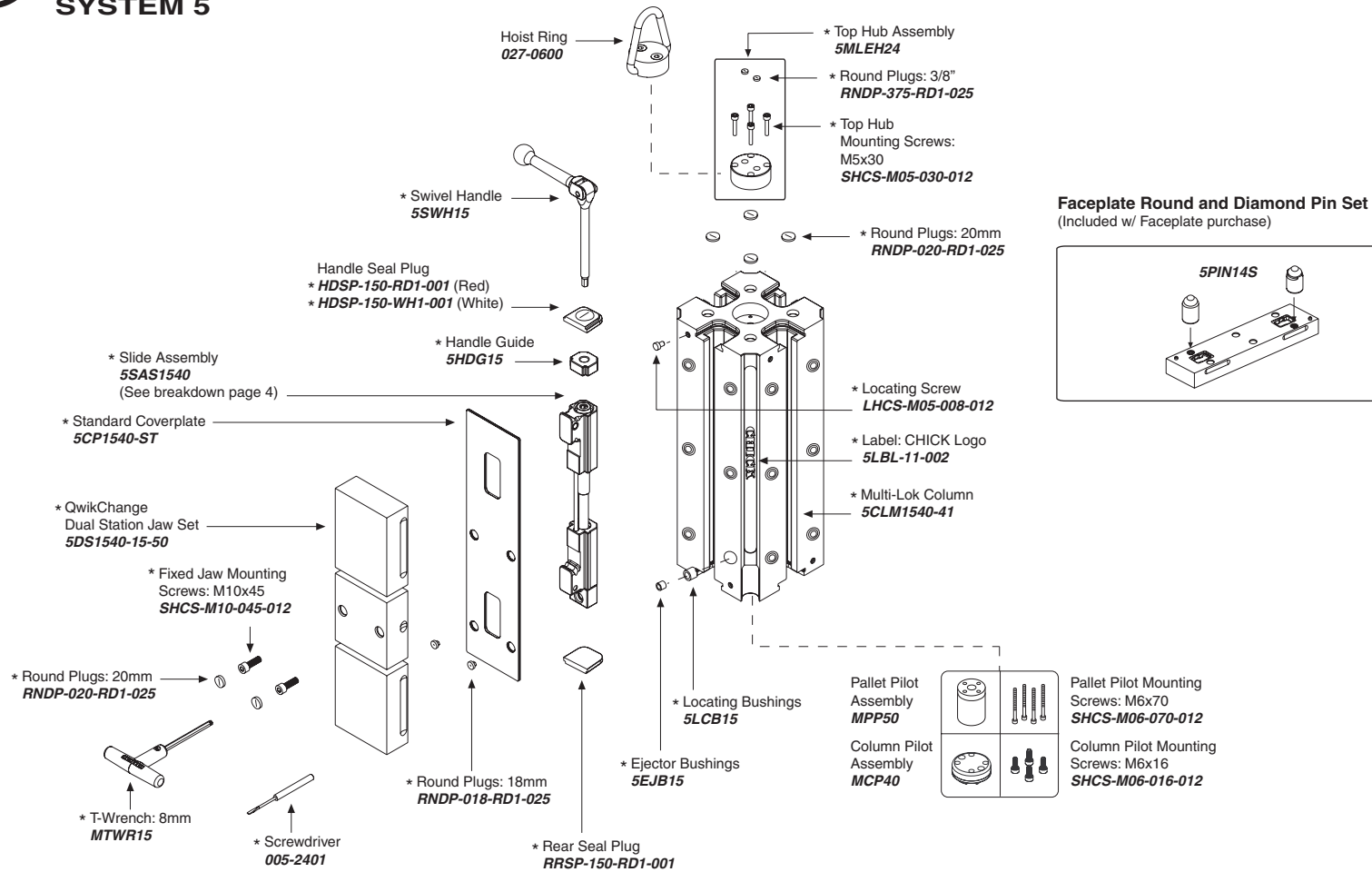


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SYSTEM 5



Notes

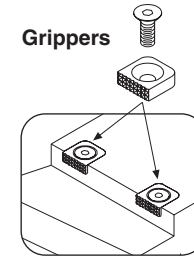
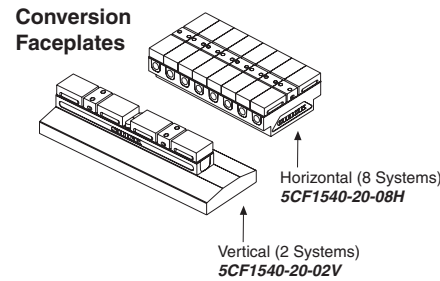
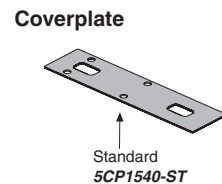
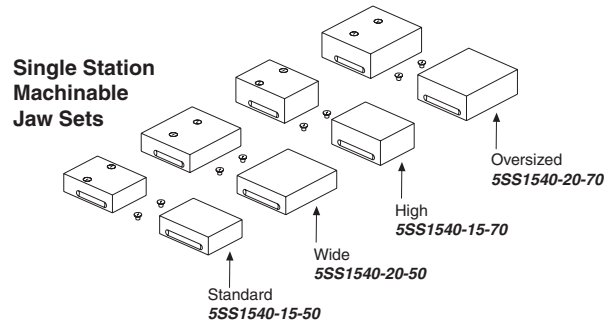
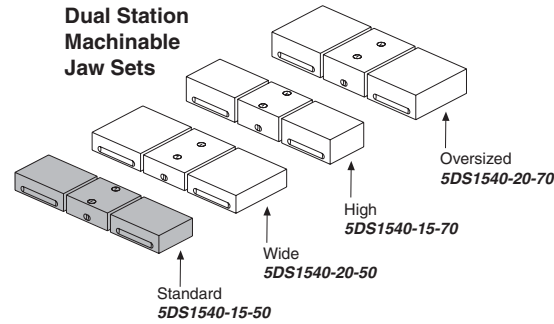
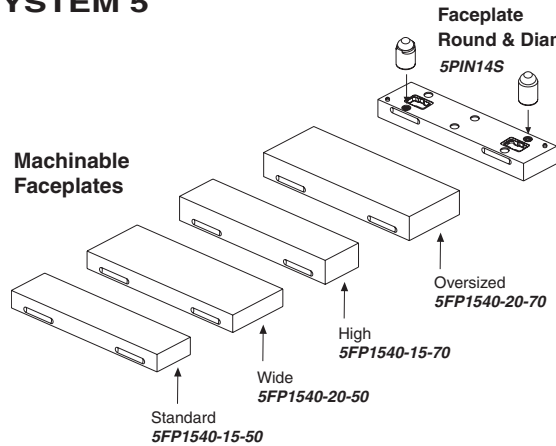
For QwikChange Jaw accessories, see pages 2-3

* Included in a standard 1540 Multi-Lok

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SYSTEM 5



Gripper #3
 Plain 005-2531
 Serrated 005-2532
 (L-9mm x W-9mm x T-8mm)

Gripper #4
 Plain 005-2541
 Serrated 005-2542
 (L-12mm x W-12mm x T-4.6mm)

Gripper #5
 Plain 005-2551
 Serrated 005-2552
 (L-15mm x W-15mm x T-5mm)

Gripper #6
 Plain 005-2561
 Serrated 005-2562
 (L-19mm x W-19mm x T-6mm)

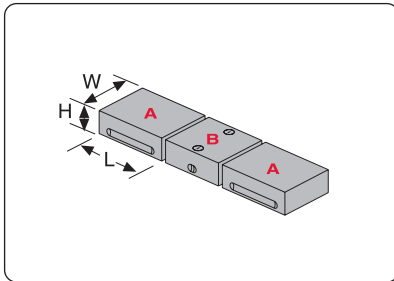
Notes
 Grey item is included with a standard system

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SYSTEM 5

QwikChange Machinable Dual Station Jaws



Individual Dual Station Jaws

Standard

- A** Moveable Jaw **5MJ1540-15-50**
(W148mm, H50mm, L135mm)
- B** Fixed Jaw **5FJ1540-15-50**
(W148mm, H50mm, L100mm)

Wide

- A** Moveable Jaw **5MJ1540-20-50**
(W198mm, H50mm, L135mm)
- B** Fixed Jaw **5FJ1540-20-50**
(W198mm, H50mm, L100mm)

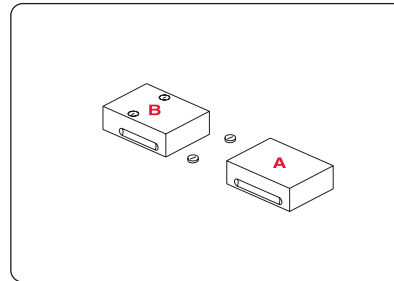
High

- A** Moveable Jaw **5MJ1540-15-70**
(W148mm, H70mm, L135mm)
- B** Fixed Jaw **5FJ1540-15-70**
(W148mm, H70mm, L100mm)

Oversized

- A** Moveable Jaw **5MJ1540-20-70**
(W198mm, H70mm, L135mm)
- B** Fixed Jaw **5FJ1540-20-70**
(W198mm, H70mm, L100mm)

QwikChange Machinable Single Station Jaws



Individual Single Station Jaws

Standard

- A** Moveable Jaw **5MJ1540-15-50**
(W148mm, H50mm, L135mm)
- B** Fixed Jaw **5SJ1540-15-50**
(W148mm, H50mm, L135mm)

Wide

- A** Moveable Jaw **5MJ1540-20-50**
(W198mm, H50mm, L135mm)
- B** Fixed Jaw **5SJ1540-20-50**
(W198mm, H50mm, L135mm)

High

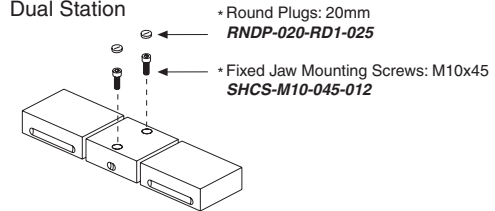
- A** Moveable Jaw **5MJ1540-15-70**
(W148mm, H70mm, L135mm)
- B** Fixed Jaw **5SJ1540-15-70**
(W148mm, H70mm, L135mm)

Oversized

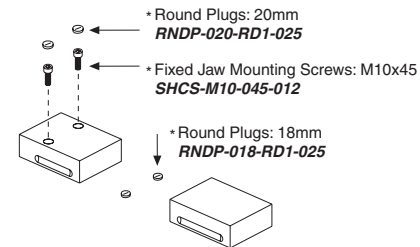
- A** Moveable Jaw **5MJ1540-20-70**
(W198mm, H70mm, L135mm)
- B** Fixed Jaw **5SJ1540-20-70**
(W198mm, H70mm, L135mm)

Screws and Plugs

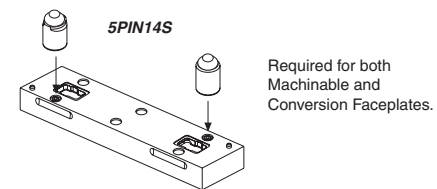
Dual Station



Single Station



Faceplate Round & Diamond Pin Set (Included w/ Faceplate purchase)



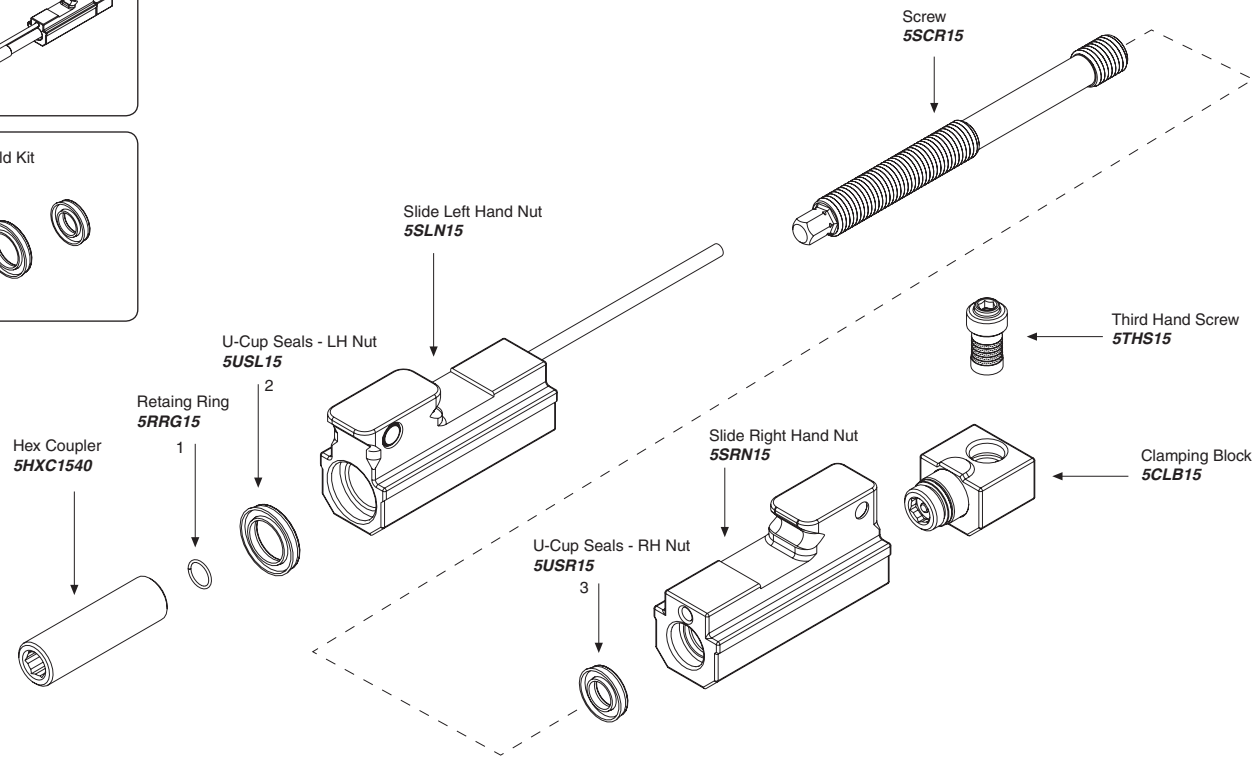
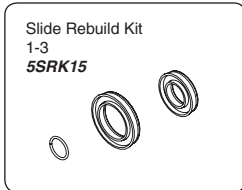
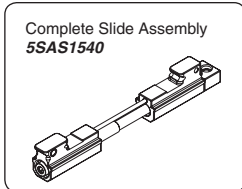
Notes

Grey item is included with a standard system

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5 5ML1540-41

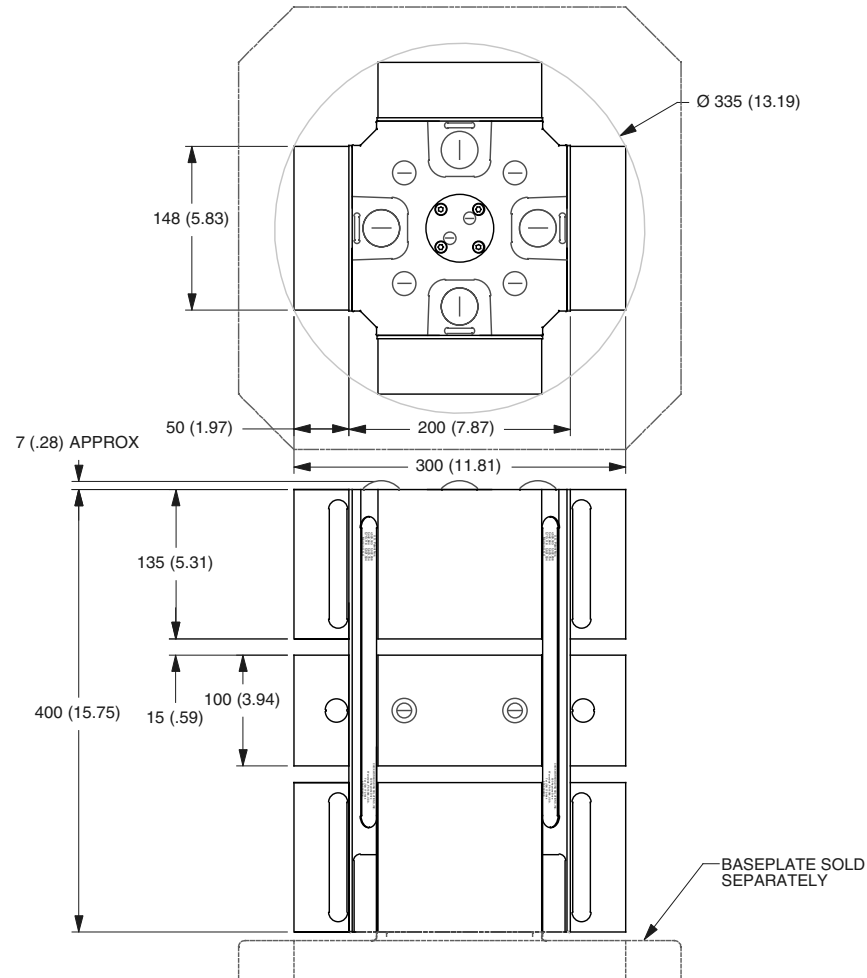
SYSTEM 5



Notes

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5 **5ML1540-41**
SYSTEM 5



Notes

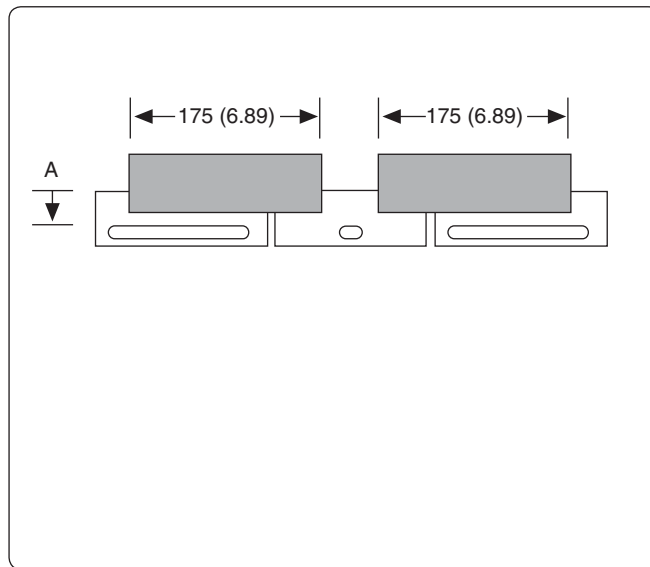
Dimensions are in mm (inches)
 Dimensions include standard Dual Station Machinable Jaw Sets.
 System weight: 80kg. (177lbs.)

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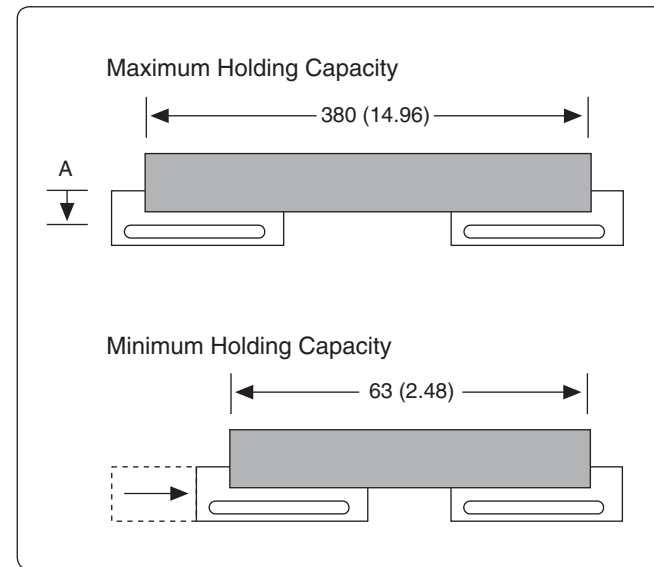
SYSTEM 5

Dual Station



Item Number	Description	A	Jaw Width
5DS1540-15-50	Standard	32 (1.26)	148 (5.83)
5DS1540-15-70	High	52 (2.05)	148 (5.83)
5DS1540-20-50	Wide	32 (1.26)	198 (7.80)
5DS1540-20-70	Oversized	52 (2.05)	198 (7.80)

Single Station



Item Number	Description	A	Jaw Width
5DS1540-15-50	Standard	32 (1.26)	148 (5.83)
5DS1540-15-70	High	52 (2.05)	148 (5.83)
5DS1540-20-50	Wide	32 (1.26)	198 (7.80)
5DS1540-20-70	Oversized	52 (2.05)	198 (7.80)

Notes

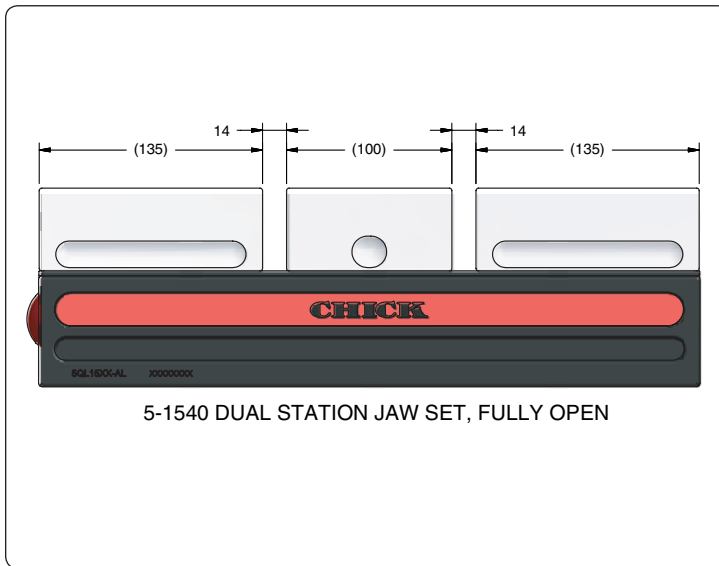
All dimensions are MM [IN]

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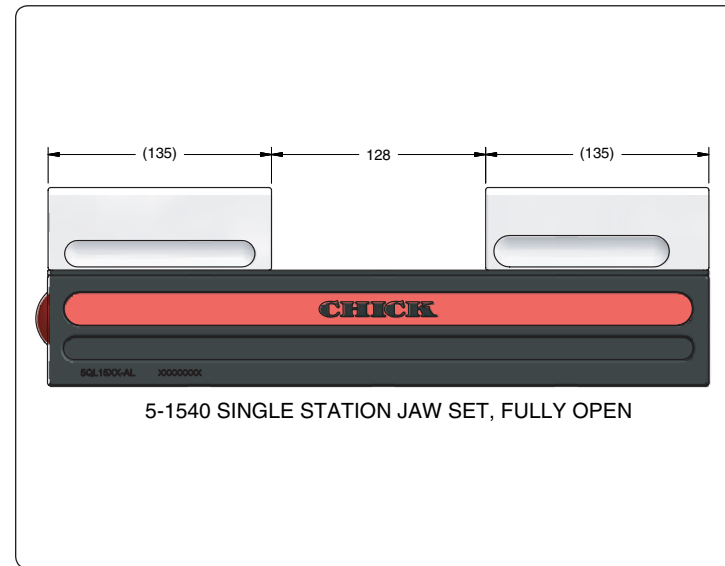
5 5ML1540-41

SYSTEM 5

Dual Station



Single Station



Notes

All dimensions are MM [IN]

* Additional closure is available with an Extended Travel Coverplate.

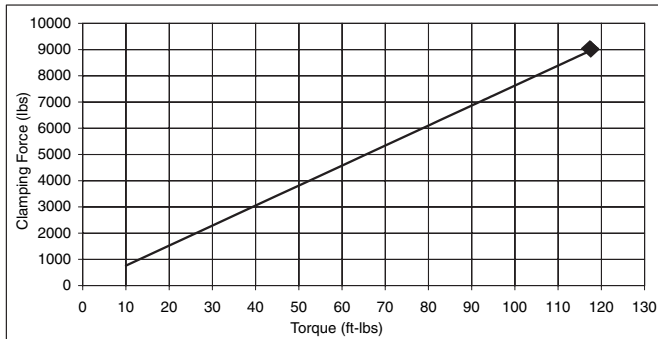
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5 5ML1540-41 SYSTEM 5

Pounds (lbs)

Force	=	Torque	X	Slope
lbs	=	in-lb	x	6.4
lbs	=	ft-lbs	x	76.3

Torque (ft-lb)	Force (lbs)
0	0
10	763
20	1525
30	2288
40	3051
50	3814
60	4576
70	5339
80	6102
90	6864
95	7246
100	7627
105	8008
110	8390
115	8771
118	9000

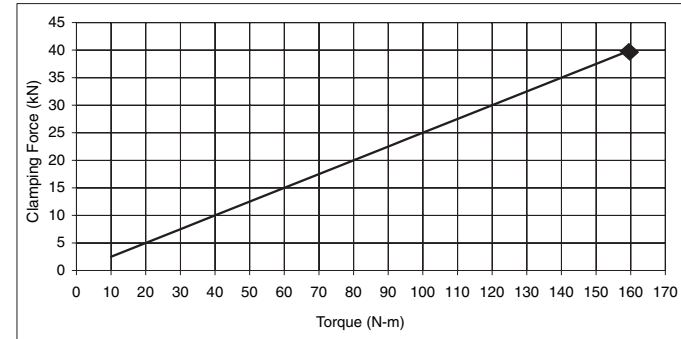


Note: ◆ Maximum Recommended Torque. Actual results may vary.

Kilo Newtons (kN)

Force	=	Torque	X	Slope
N	=	N-m	x	250
kN	=	N-m	x	0.25

Torque (N-m)	Force (kN)
0	0.0
10	2.5
20	5.0
30	7.5
40	10.0
50	12.5
60	15.0
70	17.5
80	20.0
90	22.5
100	25.0
110	27.5
120	30.0
130	32.5
140	35.0
150	37.5
160	40.0



Note: ◆ Maximum Recommended Torque. Actual results may vary.

Notes

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