

5HP-HAAS-00078

This workholding package is designed for your HAAS EC-300 (Metric) machining center.



Workholding package



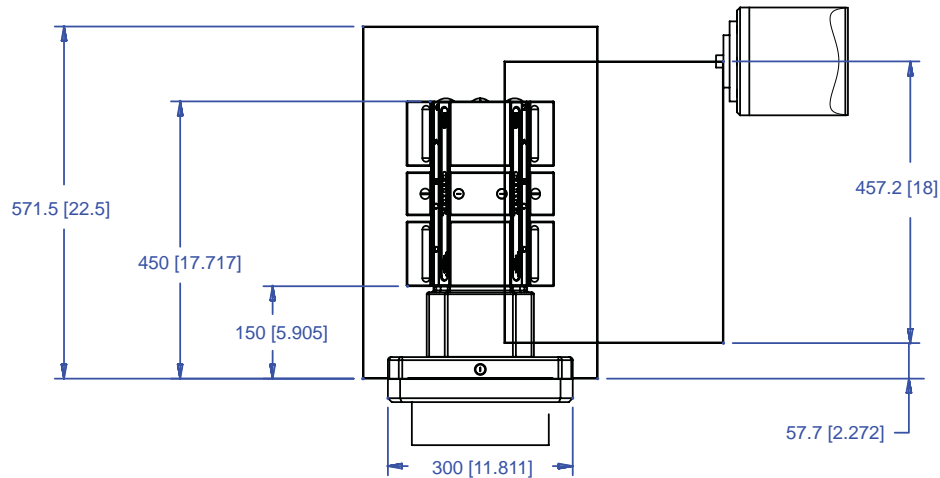
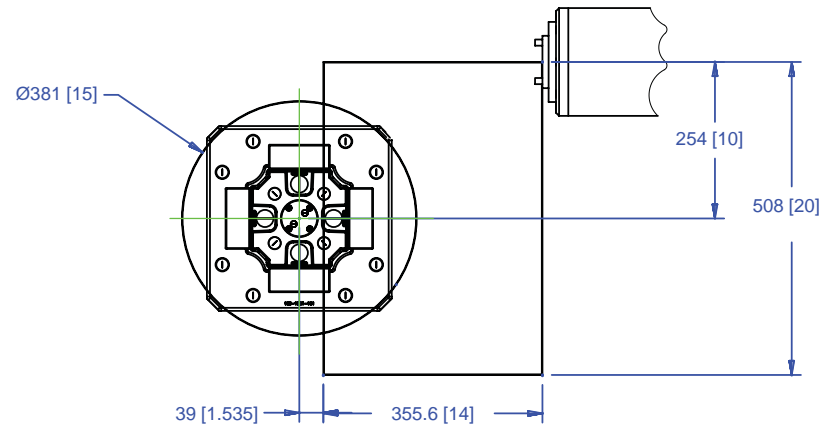
Workholding package
in machine envelope

Notes

CHICK WORKHOLDING SOLUTIONS, INC.
500 Keystone Drive • Warrendale, PA 15086 USA
Phone: (724) 772-1644 • Fax: (724) 772-1633
www.ChickWorkholding.com

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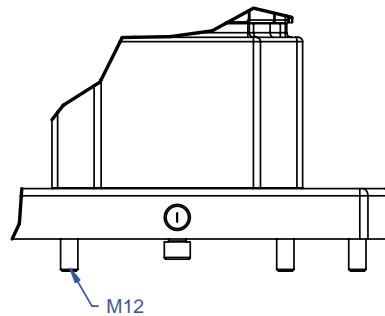
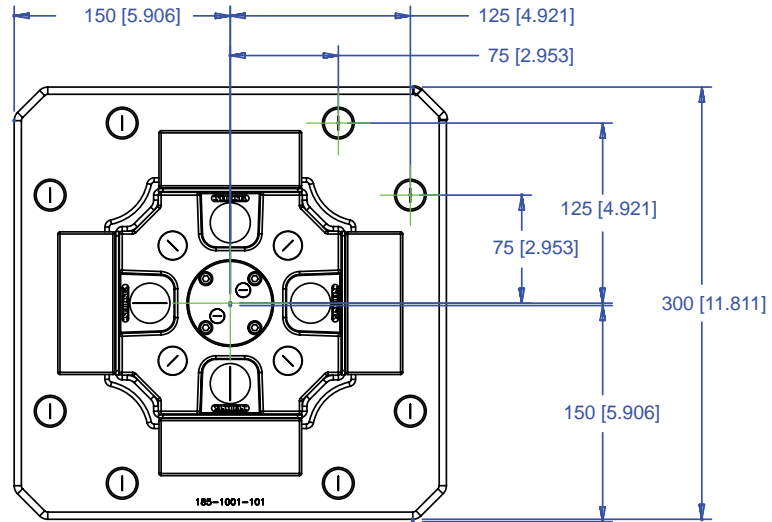
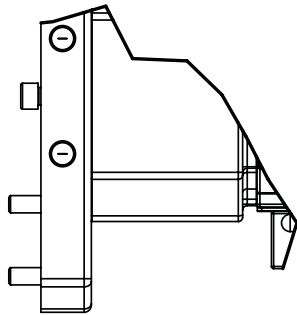
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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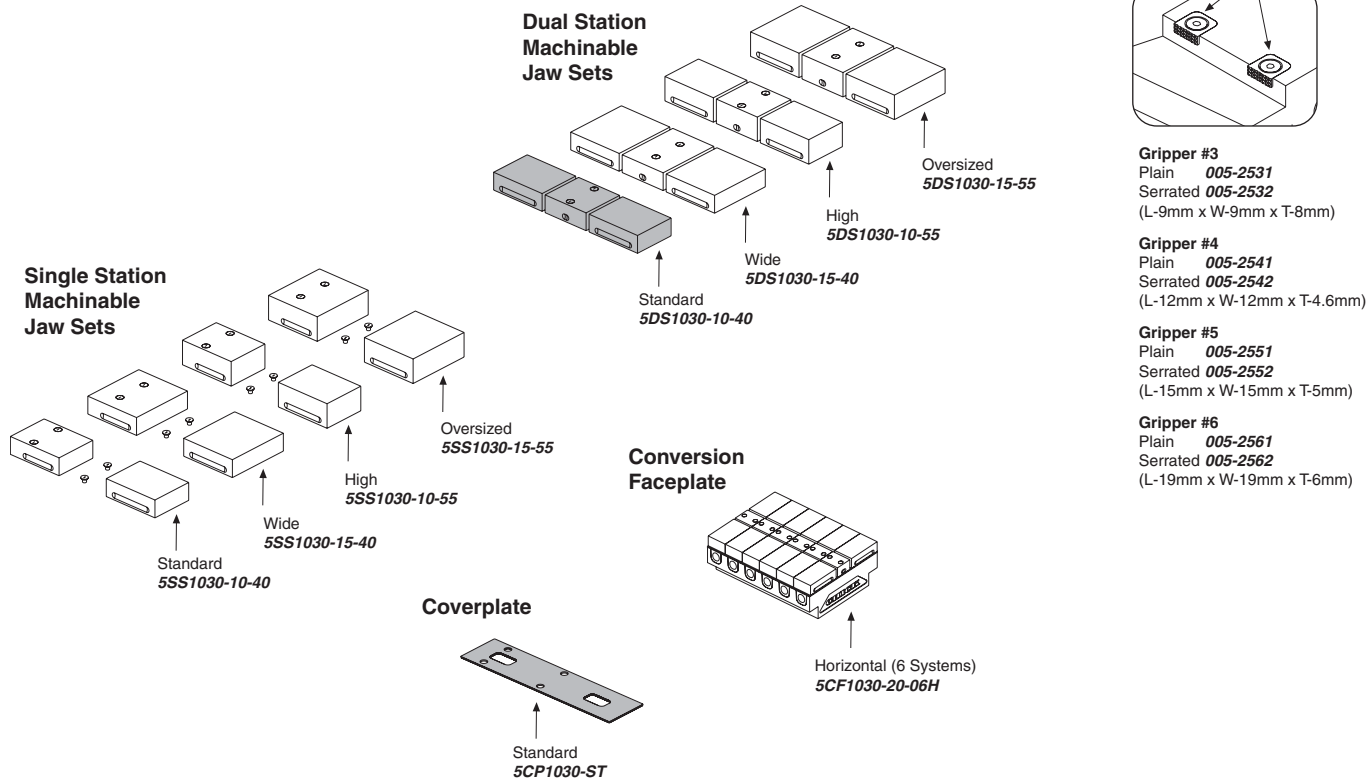


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Batch Production

Machinable accessories are the optimal solution for batch production. They offer QwikChange™ and accurate repeat set ups to optimize the productivity of the machine center.



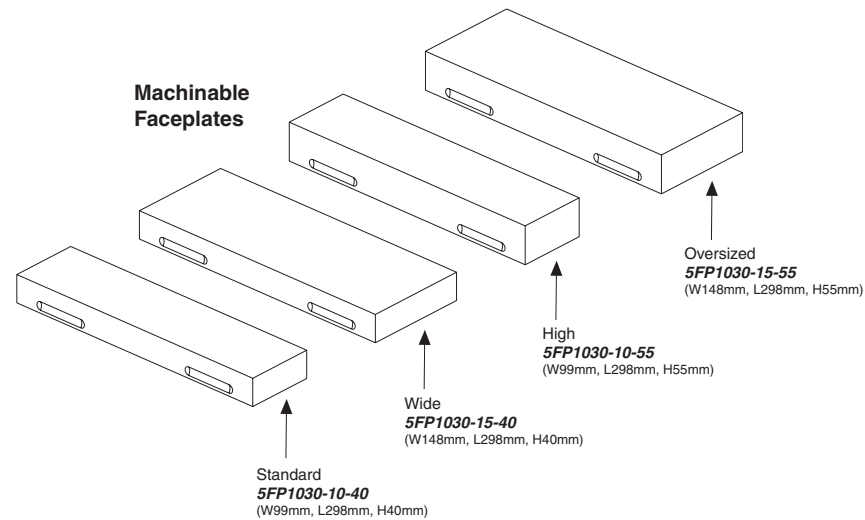
Notes

Grey item is included with a standard system

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Dedicated Fixturing

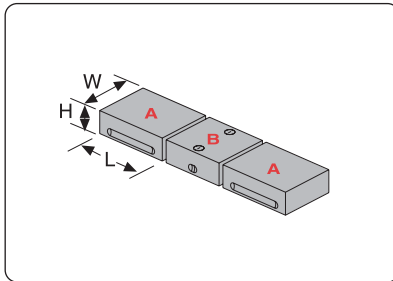
Machinable Faceplates provide QwikChange™ dedicated fixturing and are optimal for awkward or hard to hold parts. A mini pallet changer can be created by utilizing two Faceplates in tandem.



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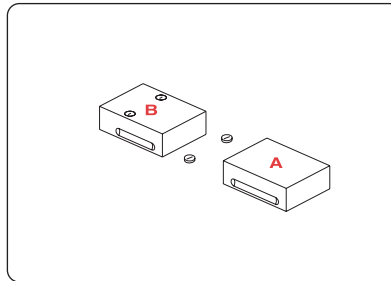
**QwikChange Machinable
Dual Station Jaws**



Individual Dual Station Jaws

Standard	
A Moveable Jaw	5MJ1030-10-40 (W99mm, H40mm, L105mm)
B Fixed Jaw	5FJ1030-10-40 (W99mm, H40mm, L70mm)
Wide	
A Moveable Jaw	5MJ1030-15-40 (W148mm, H40mm, L105mm)
B Fixed Jaw	5FJ1030-15-40 (W148mm, H40mm, L70mm)
High	
A Moveable Jaw	5MJ1030-10-55 (W99mm, H55mm, L105mm)
B Fixed Jaw	5FJ1030-10-55 (W99mm, H55mm, L70mm)
Oversized	
A Moveable Jaw	5MJ1030-15-55 (W148mm, H55mm, L105mm)
B Fixed Jaw	5FJ1030-15-55 (W148mm, H55mm, L70mm)

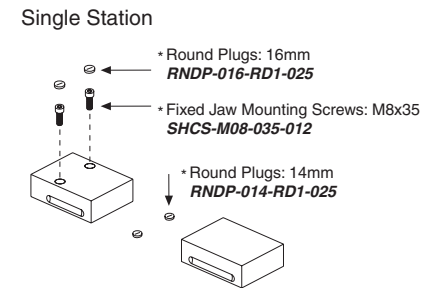
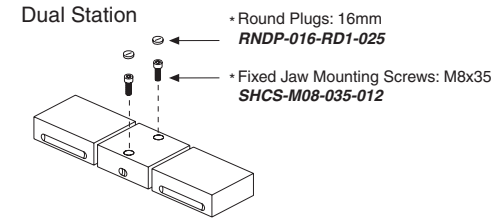
**QwikChange Machinable
Single Station Jaws**



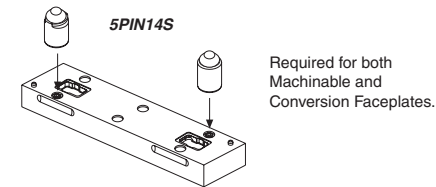
Individual Single Station Jaws

Standard	
A Moveable Jaw	5MJ1030-10-40 (W99mm, H40mm, L105mm)
B Fixed Jaw	5SJ1030-10-40 (W99mm, H40mm, L105mm)
Wide	
A Moveable Jaw	5MJ1030-15-40 (W148mm, H40mm, L105mm)
B Fixed Jaw	5SJ1030-15-40 (W148mm, H40mm, L105mm)
High	
A Moveable Jaw	5MJ1030-10-55 (W99mm, H55mm, L105mm)
B Fixed Jaw	5SJ1030-10-55 (W99mm, H55mm, L105mm)
Oversized	
A Moveable Jaw	5MJ1030-15-55 (W148mm, H55mm, L105mm)
B Fixed Jaw	5SJ1030-15-55 (W148mm, H55mm, L105mm)

Screws and Plugs



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

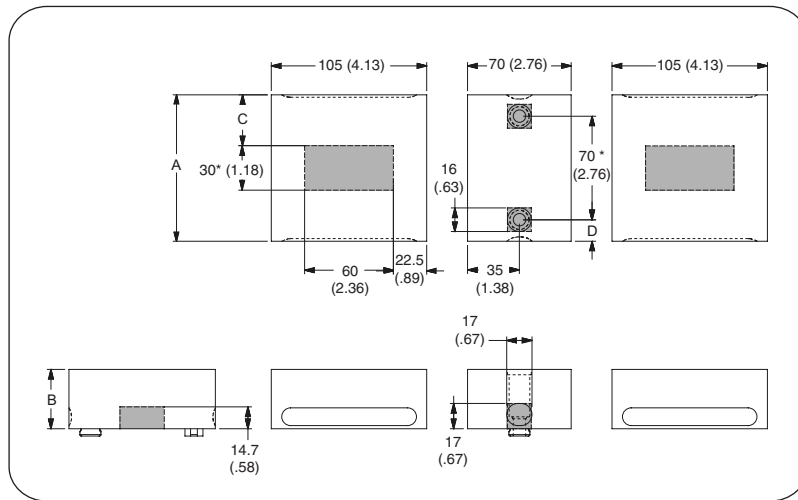


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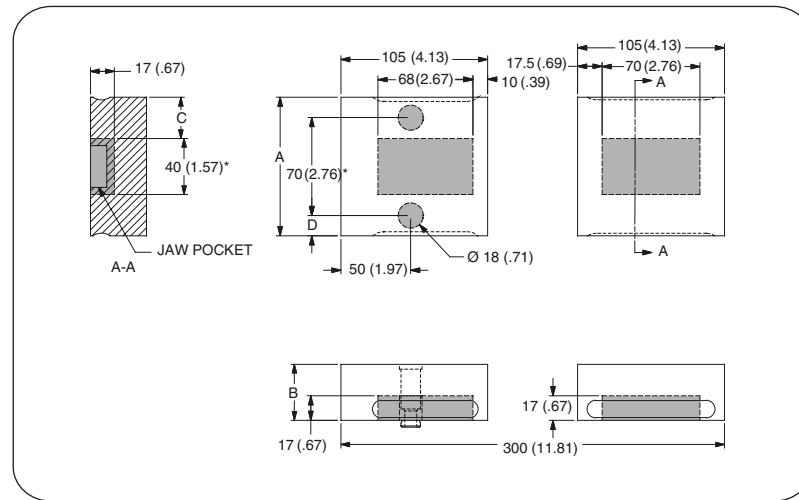
Grey or * item is included with a standard system

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Dual Station



Single Station



Item Number	Description	A	B	C	D
5DS1030-10-40	Standard	99 [3.90]	40 [1.57]	34.5 [1.36]	14.5 [.57]
5DS1030-10-55	High	99 [3.90]	55 [2.17]	34.5 [1.36]	14.5 [.57]
5DS1030-15-40	Wide	148 [5.83]	40 [1.57]	59 [2.32]	39 [1.54]
5DS1030-15-55	Oversized	148 [5.83]	55 [2.17]	59 [2.32]	39 [1.54]

Item Number	Description	A	B	C	D
5SS1030-10-40	Standard	99 [3.90]	40 [1.57]	29.5 [1.16]	14.5 [.57]
5SS1030-10-55	High	99 [3.90]	55 [2.17]	29.5 [1.16]	14.5 [.57]
5SS1030-15-40	Wide	148 [5.83]	40 [1.57]	54 [2.13]	39 [1.54]
5SS1030-15-55	Oversized	148 [5.83]	55 [2.17]	54 [2.13]	39 [1.54]

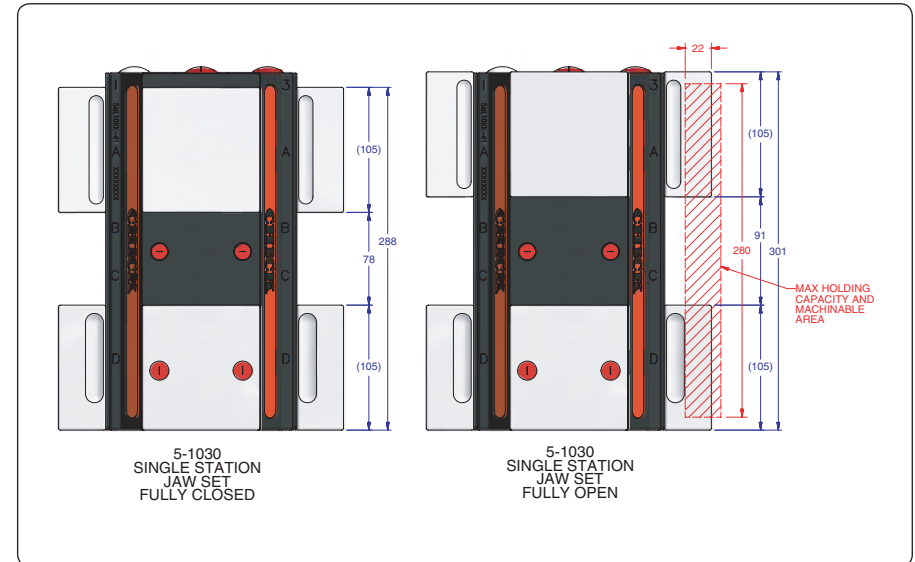
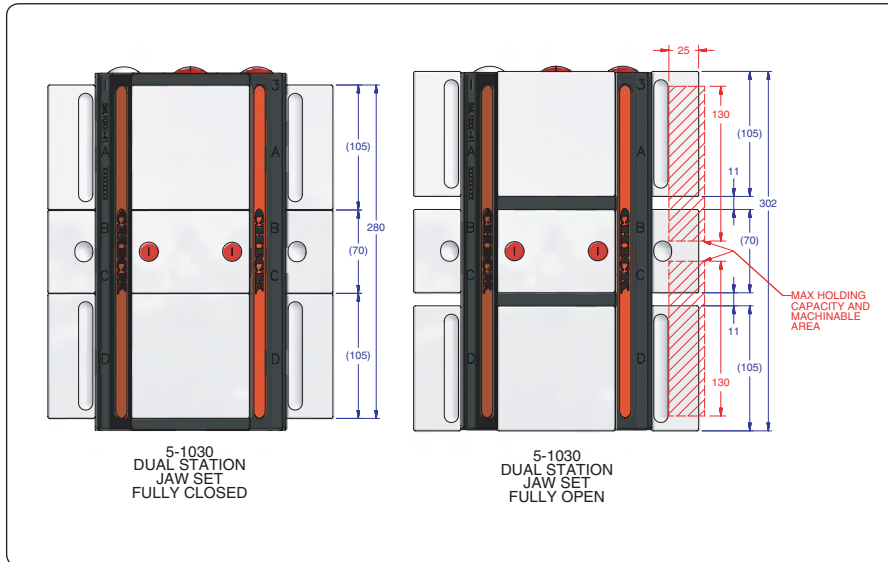
Notes

Grey area indicates no cut zone
 All dimensions are MM [IN]
 Dimensions centered on the "A" dimension.

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Dual Station

Single Station



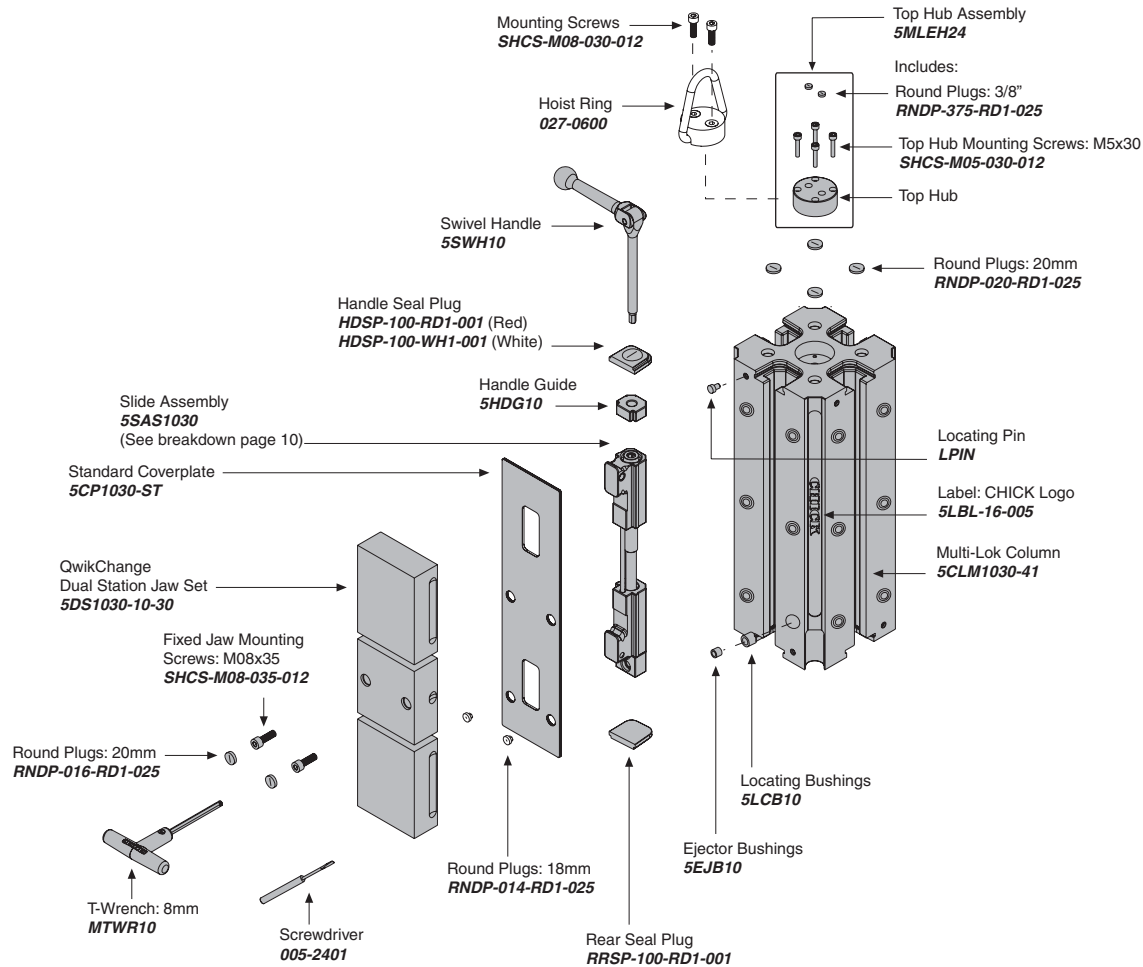
Item Number	Description	A	Jaw Width
5DS1030-10-40	Standard	26 [1.02]	99 [3.90]
5DS1030-10-55	High	41 [1.61]	99 [3.90]
5DS1030-15-40	Wide	26 [1.02]	148 [5.83]
5DS1030-15-55	Oversized	41 [1.61]	148 [5.83]

Item Number	Description	A	Jaw Width
5SS1030-10-40	Standard	26 [1.02]	99 [3.90]
5SS1030-10-55	High	41 [1.61]	99 [3.90]
5SS1030-15-40	Wide	26 [1.02]	148 [5.83]
5SS1030-15-55	Oversized	41 [1.61]	148 [5.83]

Notes

All dimensions are MM [IN]
 Additional closure is available with an Extended Travel Coverplate.
 Contact CHICK for details.

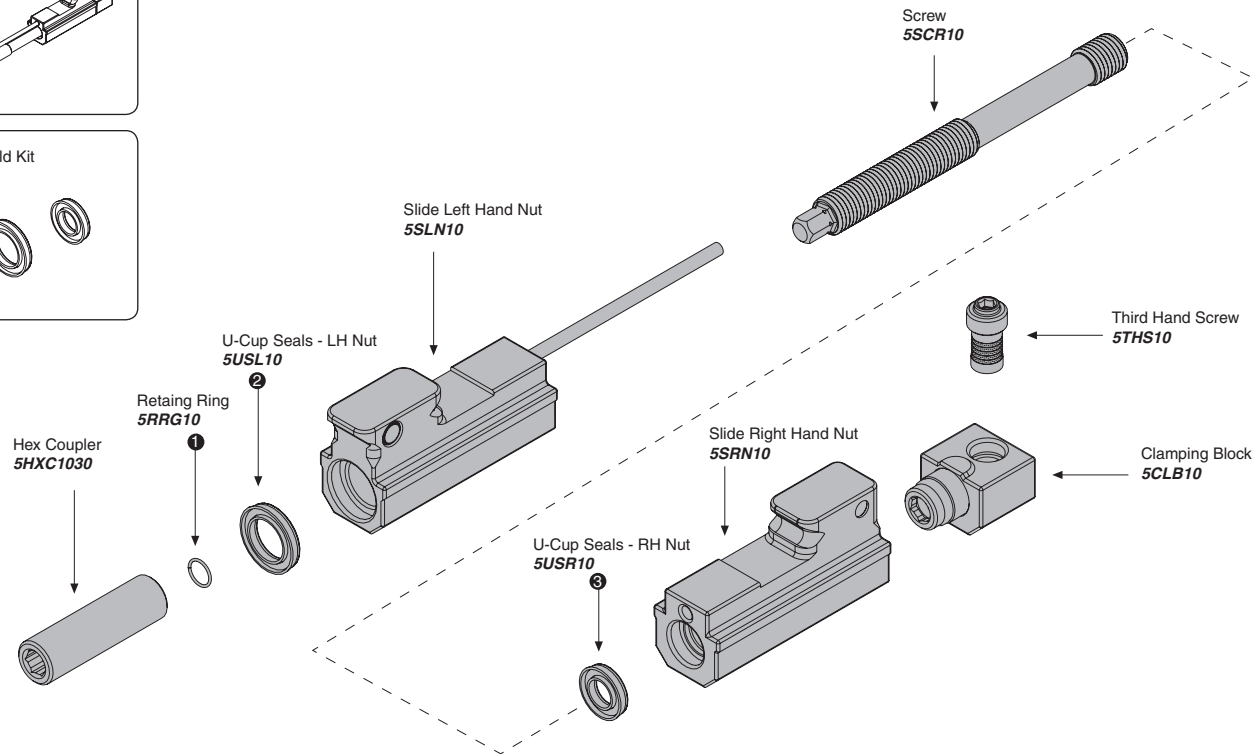
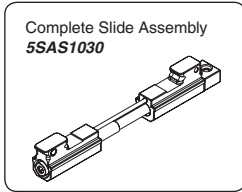
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Notes

Grey items are included with a standard system
 For QwikChange™ Jaw accessories, see pages 4-7

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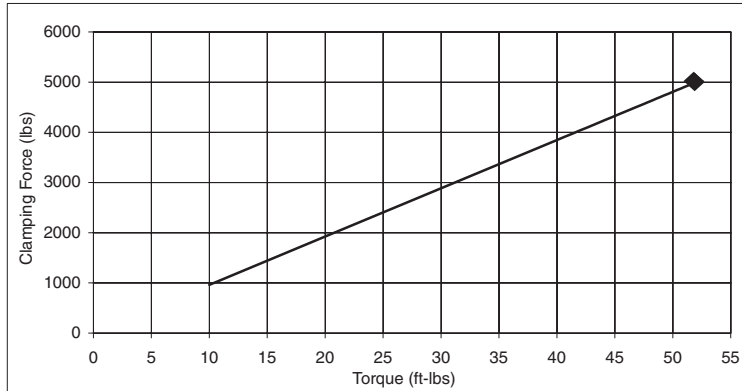
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Pounds (lbs)

Force	=	Torque	X	Slope
lbs	=	in-lb	x	8.0
lbs	=	ft-lbs	x	96

Torque (ft-lb)	Force (lbs)
0	0
10	962
20	1923
30	2885
40	3846
50	4808
52	5000

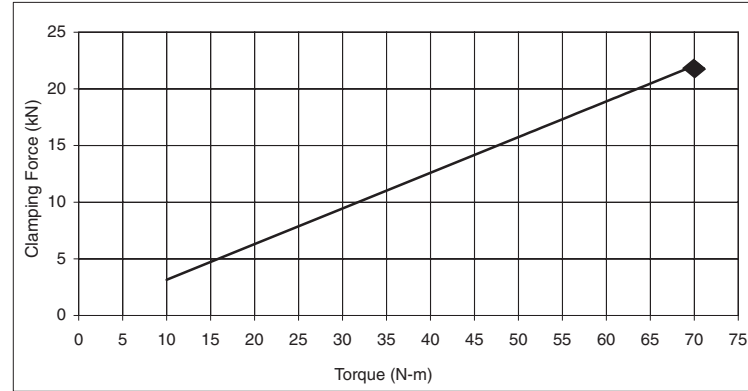


Note: ◆ Maximum Recommended Torque. Actual results may vary.

Kilonewtons (kN)

Force	=	Torque	X	Slope
N	=	N-m	x	315
kN	=	N-m	x	0.315

Torque (N-m)	Force (kN)
0	0.0
10	3.1
20	6.3
30	9.4
40	12.6
50	15.7
60	18.9
65	20.5
70	22.0



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

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