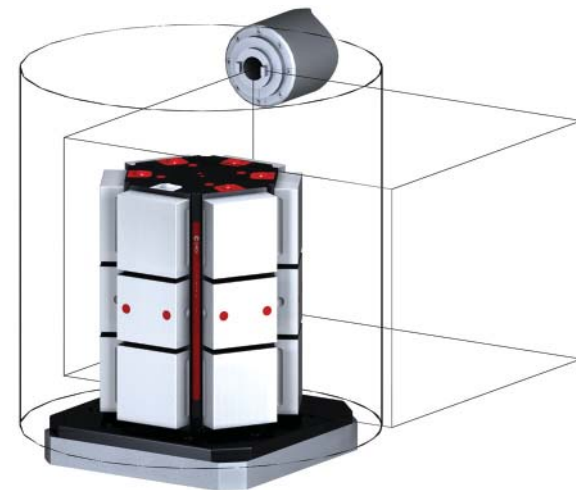


## 5HP-HAAS-00299

This workholding package is designed for your HAAS EC-500 machining center.



Workholding package



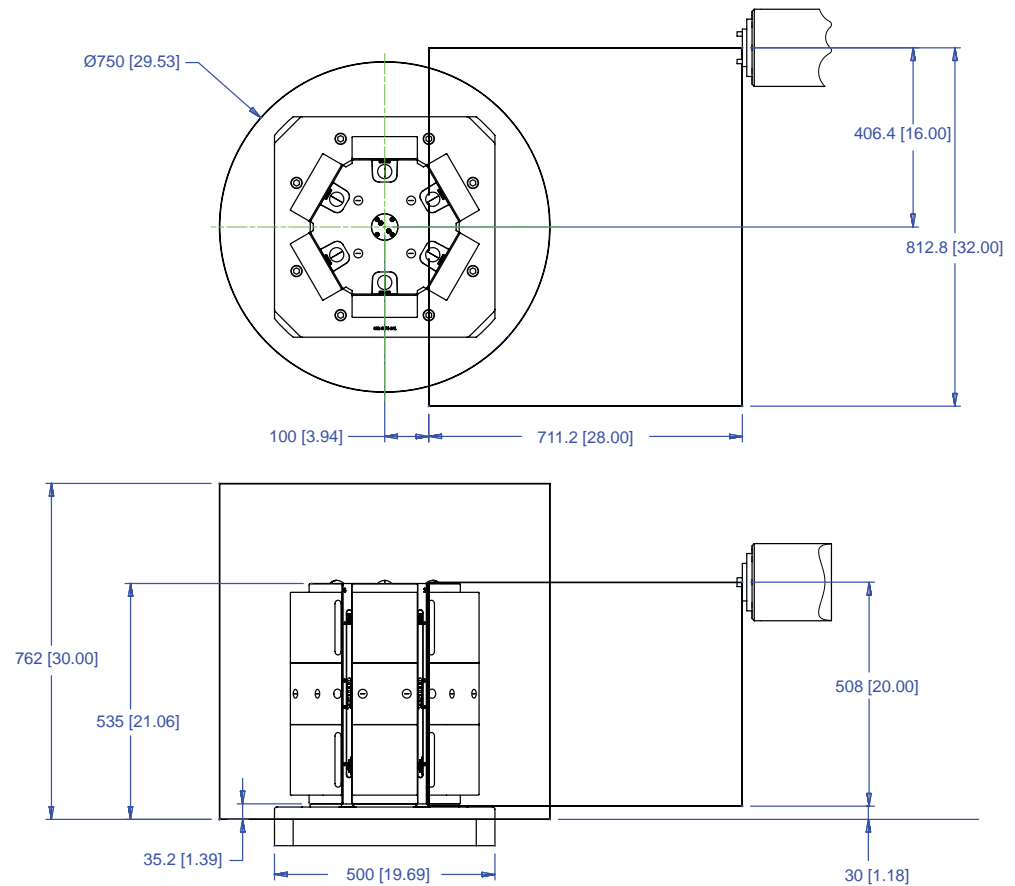
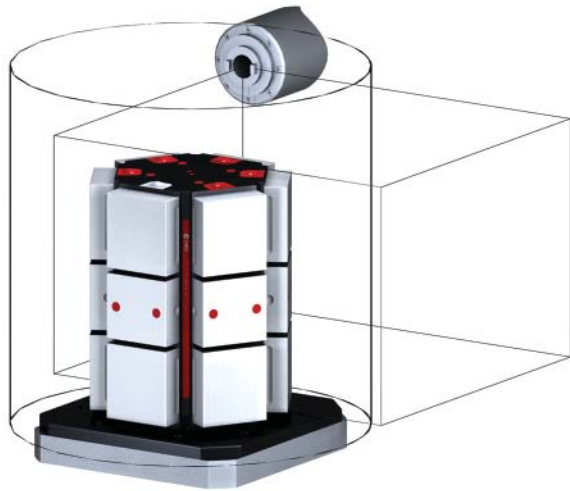
Workholding package  
in machine envelope

Notes

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# 5HP-HAAS-00299

This workholding package is designed for your HAAS EC-500 machining center.



**Notes**

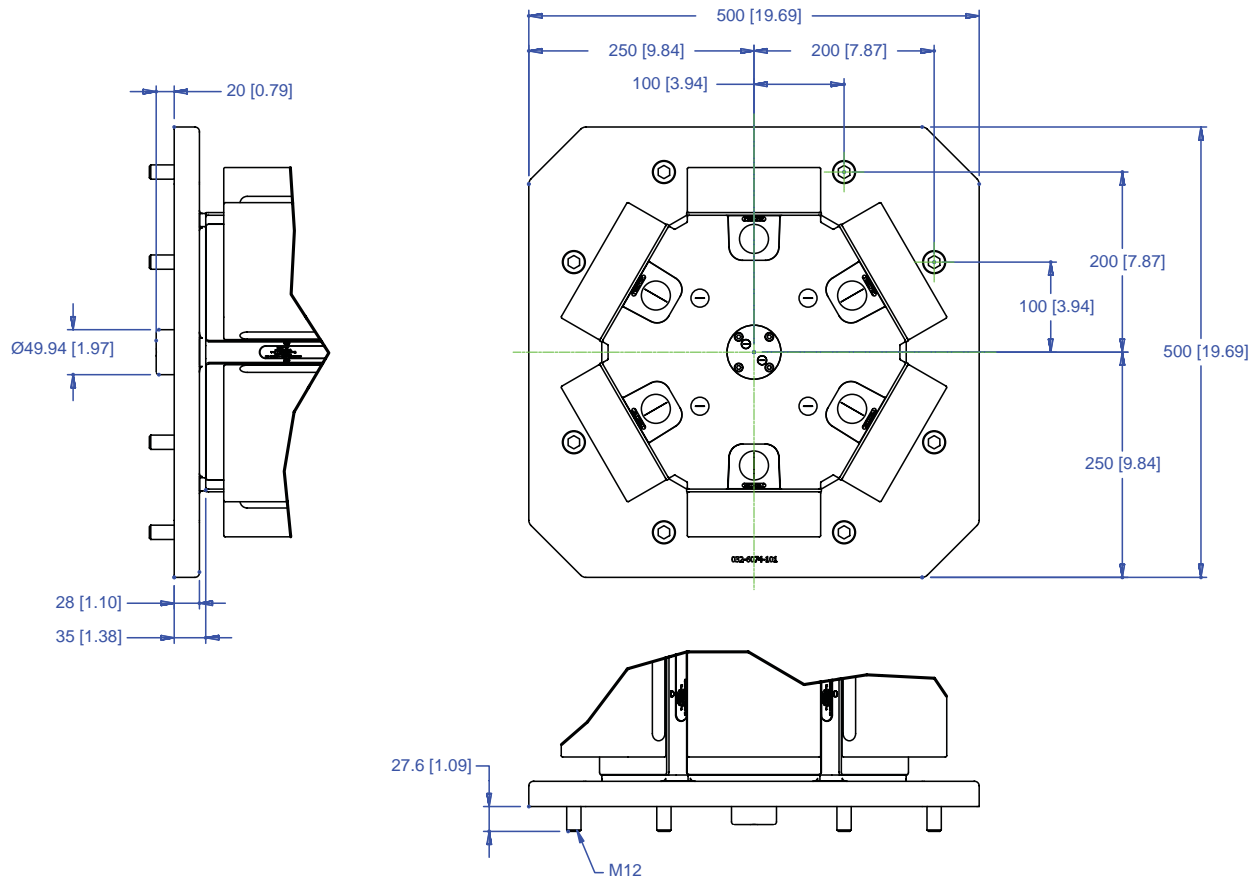
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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# 5HP-HAAS-00299

This workholding package is designed for your HAAS EC-500 machining center.



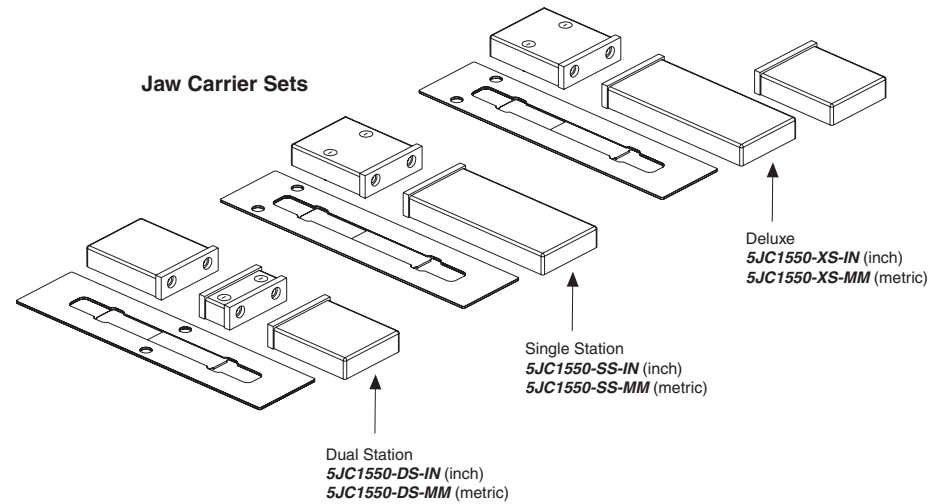
Notes  
All dimensions are MM [IN]

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## One-Off Workholding

Jaw carriers broaden your modern workholding flexibility by offering vise-like fixturing.

Simply QwikChange™ the jaws and your modern workholding is ready for one-off workholding needs.

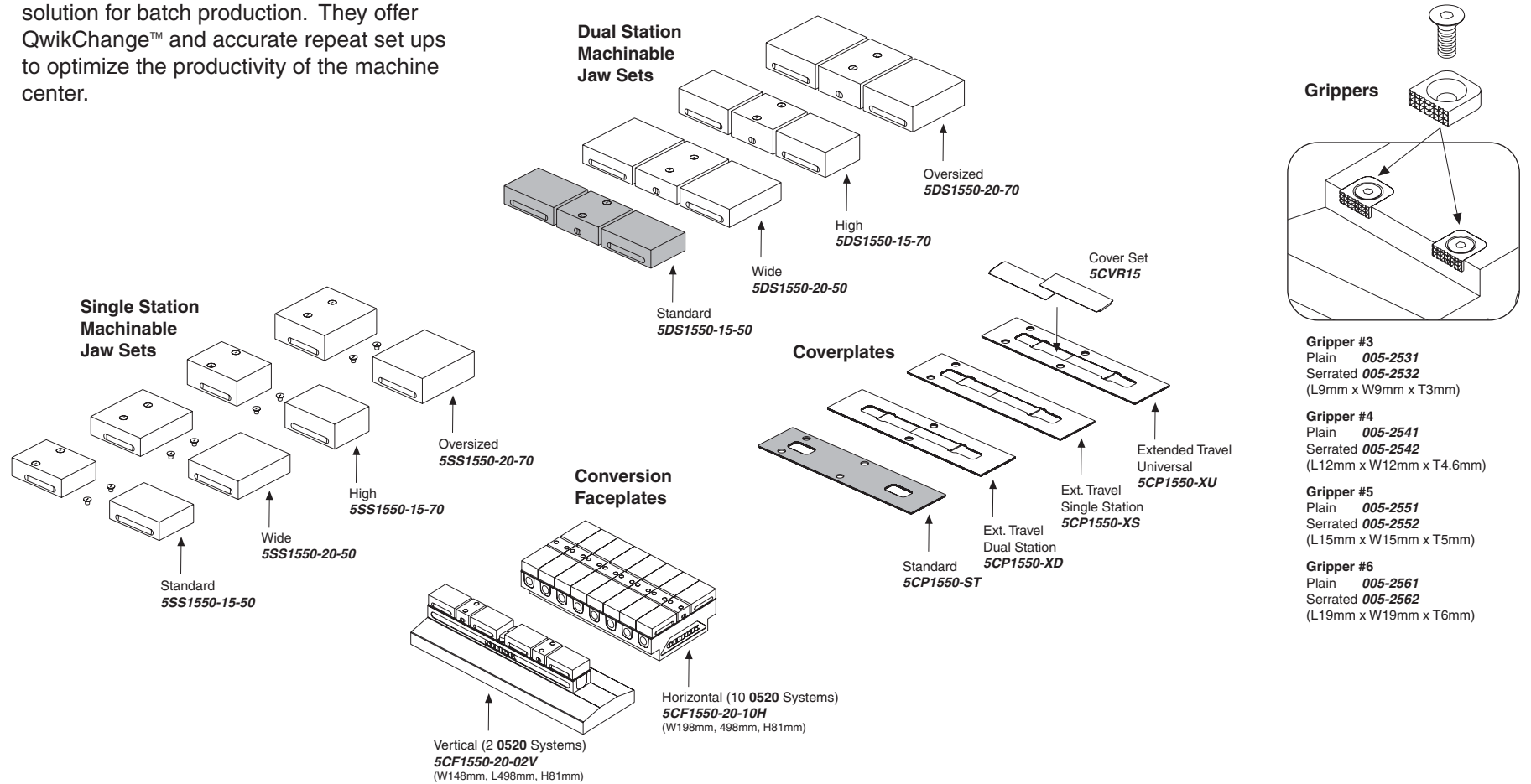


Notes

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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

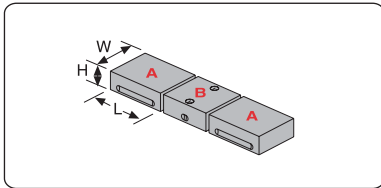
Machinable Faceplates provide QwikChange™ dedicated fixturing and are optimal for awkward or hard to hold parts. A mini pallet changer can be created by utilizing two Faceplates in tandem.



Notes

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## QwikChange Machinable Dual Station Jaws



### Individual Dual Station Jaws

Standard

- A** Moveable Jaw ..... **5MJ1550-15-50**  
(W148mm, H50mm, L160mm)
- B** Fixed Jaw ..... **5FJ1550-15-50**  
(W148mm, H50mm, L120mm)

Wide

- A** Moveable Jaw ..... **5MJ1550-20-50**  
(W198mm, H50mm, L160mm)
- B** Fixed Jaw ..... **5FJ1550-20-50**  
(W198mm, H50mm, L120mm)

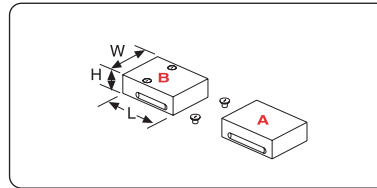
High

- A** Moveable Jaw ..... **5MJ1550-15-70**  
(W148mm, H70mm, L160mm)
- B** Fixed Jaw ..... **5FJ1550-15-70**  
(W148mm, H70mm, L120mm)

Oversized

- A** Moveable Jaw ..... **5MJ1550-20-70**  
(W198mm, H70mm, L160mm)
- B** Fixed Jaw ..... **5FJ1550-20-70**  
(W198mm, H70mm, L120mm)

## QwikChange Machinable Single Station Jaws



### Individual Single Station Jaws

Standard

- A** Moveable Jaw ..... **5MJ1550-15-50**  
(W148mm, H50mm, L160mm)
- B** Fixed Jaw ..... **5SJ1550-15-50**  
(W148mm, H50mm, L160mm)

Wide

- A** Moveable Jaw ..... **5MJ1550-20-50**  
(W198mm, H50mm, L160mm)
- B** Fixed Jaw ..... **5SJ1550-20-50**  
(W198mm, H50mm, L160mm)

High

- A** Moveable Jaw ..... **5MJ1550-15-70**  
(W148mm, H70mm, L160mm)
- B** Fixed Jaw ..... **5SJ1550-15-70**  
(W148mm, H70mm, L160mm)

Oversized

- A** Moveable Jaw ..... **5MJ1550-20-70**  
(W198mm, H70mm, L160mm)
- B** Fixed Jaw ..... **5SJ1550-20-70**  
(W198mm, H70mm, L160mm)

## QwikChange Jaw Carriers



Jaw Carriers (Inch)

- A** **5JC1550-FC-IN**
- B** **5JC1550-MC-IN**
- C** **5JC1550-SC-IN**
- D** **5JC1550-LM-IN**
- E** **5JC1550-SM-IN**

Jaw Carriers (Metric)

- A** **5JC1550-FC-MM**
- B** **5JC1550-MC-MM**
- C** **5JC1550-SC-MM**
- D** **5JC1550-LM-MM**
- E** **5JC1550-SM-MM**

- A** Dual Station Fixed
- B** Dual Station Moveable

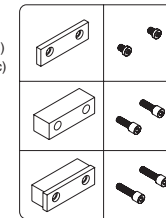
- C** Single Station Fixed
- D** Single Station Long Moveable

- E** Single Station Short Moveable

## Jaw Plates

- Standard (Set of 4)  
**JH6STD** (Inch)  
**MJH15** (Metric)

### HARD JAW PLATES



- Standard Mounting Screws: 1/2-13x5/8"  
**LHCS-500-063-008** (Inch)  
**LHCS-M10-012-008** (Metric)

- Thick (Set of 2)  
**JH6THK**

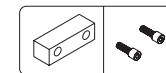
- Thick Mounting Screws: 1/2-13x1.25"  
**SHCS-500-125-008**

- Both Sizes  
**JH6STD** &  
**JH6THK**

- Both Sizes Mounting Screws: 1/2-13x1.75"  
**SHCS-500-175-008**

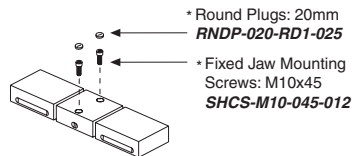
- Standard (Set of 4)  
**JS6AL**

### SOFT JAW PLATES

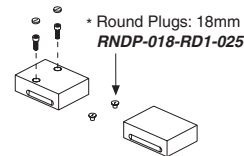


- Soft Mounting Screws: 1/2-13x1.25"  
**SHCS-500-125-012**

## Screws and Plugs



- \* Round Plugs: 20mm  
**RNDP-020-RD1-025**
- \* Fixed Jaw Mounting Screws: M10x45  
**SHCS-M10-045-012**



- \* Round Plugs: 18mm  
**RNDP-018-RD1-025**

## Notes

Grey or \* item is included with a standard system

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**Dual Station**



**Single Station**



| Item Number          | Description | A          | B         | C         | D         |
|----------------------|-------------|------------|-----------|-----------|-----------|
| <b>5DS1550-15-50</b> | Standard    | 148 [5.83] | 50 [1.97] | 51 [2.01] | 24 [.94]  |
| <b>5DS1550-15-70</b> | High        | 148 [5.83] | 70 [2.76] | 51 [2.01] | 24 [.94]  |
| <b>5DS1550-20-50</b> | Wide        | 198 [7.80] | 50 [1.97] | 76 [2.99] | 49 [1.93] |
| <b>5DS1550-20-70</b> | Oversized   | 198 [7.80] | 70 [2.76] | 76 [2.99] | 49 [1.93] |

| Item Number   | Description | A          | B         | C         | D         |
|---------------|-------------|------------|-----------|-----------|-----------|
| 5SS1550-15-50 | Standard    | 148 [5.83] | 50 [1.97] | 49 [1.93] | 24 [.94]  |
| 5SS1550-15-70 | High        | 148 [5.83] | 70 [2.76] | 49 [1.93] | 24 [.94]  |
| 5SS1550-20-50 | Wide        | 198 [7.80] | 50 [1.97] | 74 [2.91] | 49 [1.93] |
| 5SS1550-20-70 | Oversized   | 198 [7.80] | 70 [2.76] | 74 [2.91] | 49 [1.93] |

**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**



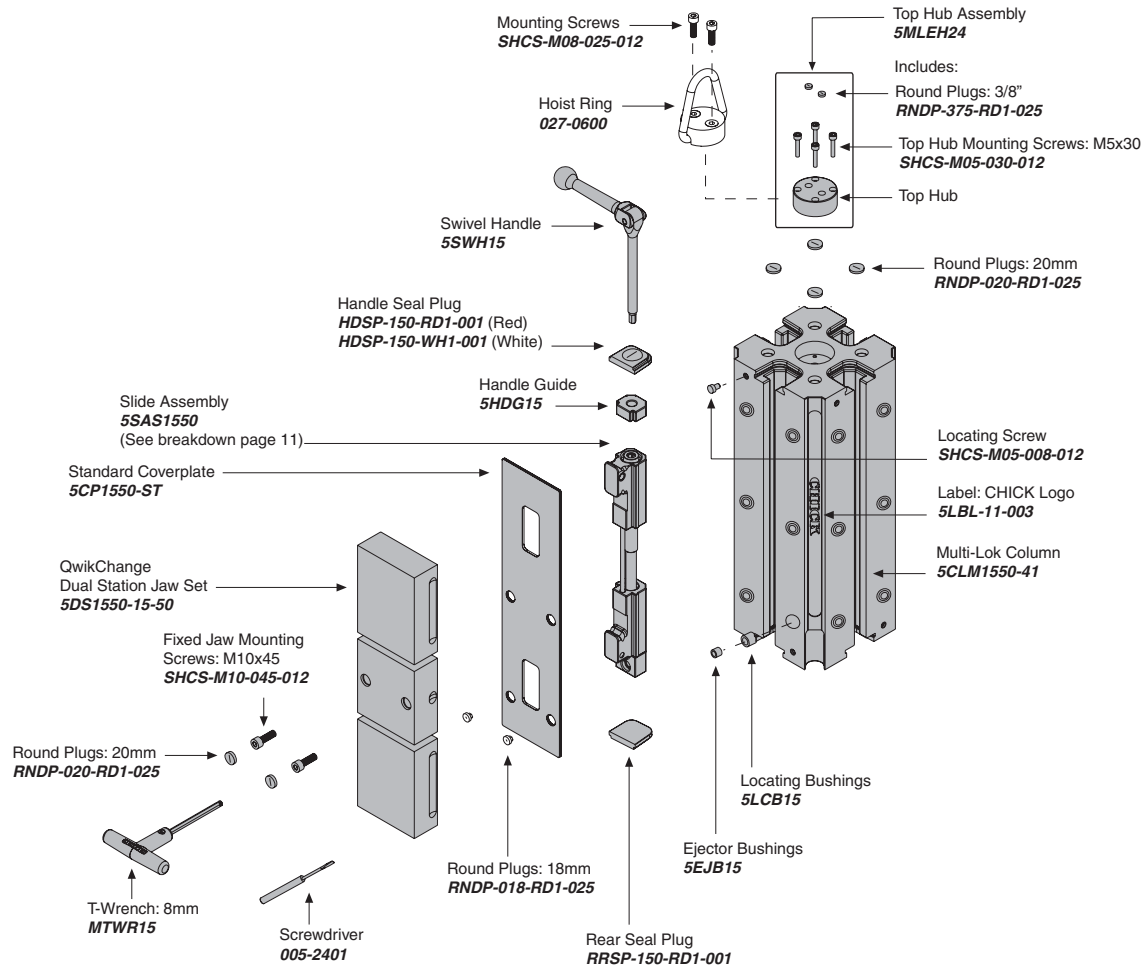
| Item Number   | Description | A         | Jaw Width  |
|---------------|-------------|-----------|------------|
| 5DS1550-15-50 | Standard    | 32 [1.26] | 148 [5.83] |
| 5DS1550-15-70 | High        | 52 [2.05] | 148 [5.83] |
| 5DS1550-20-50 | Wide        | 32 [1.26] | 198 [7.80] |
| 5DS1550-20-70 | Oversized   | 52 [2.05] | 198 [7.80] |

| Item Number   | Description | A         | Jaw Width  |
|---------------|-------------|-----------|------------|
| 5SS1550-15-50 | Standard    | 29 [1.14] | 148 [5.83] |
| 5SS1550-15-70 | High        | 49 [1.93] | 148 [5.83] |
| 5SS1550-20-50 | Wide        | 29 [1.14] | 198 [7.80] |
| 5SS1550-20-70 | Oversized   | 49 [1.93] | 198 [7.80] |

**Notes**

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

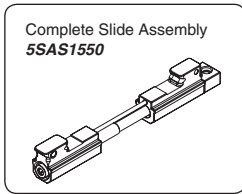
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**Notes**

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

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**Notes**

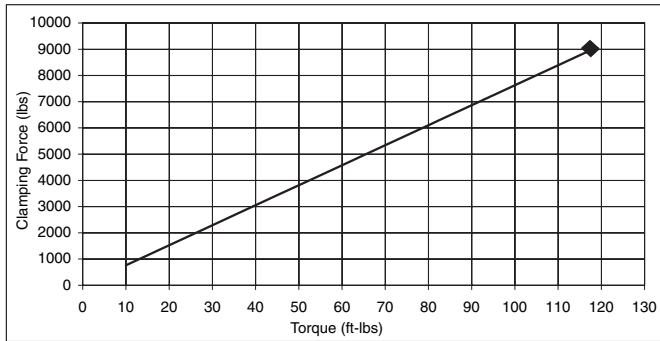
Grey items are included with a standard system

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**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        |

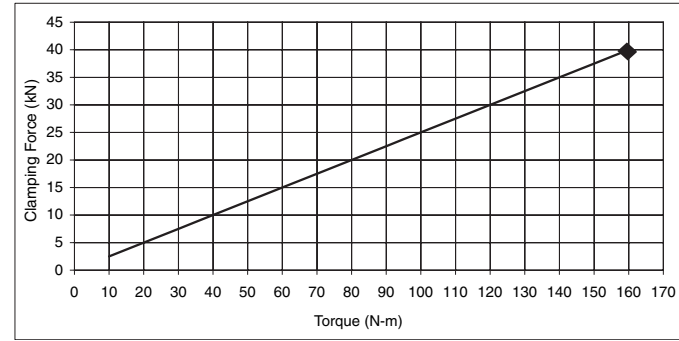


Note: ◆ Maximum Recommended Torque. Actual results may vary.

**Kilonewtons (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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