

5HP-HAAS-00300

This workholding package is designed for your HAAS EC-400 (Metric) machining center.



Workholding package



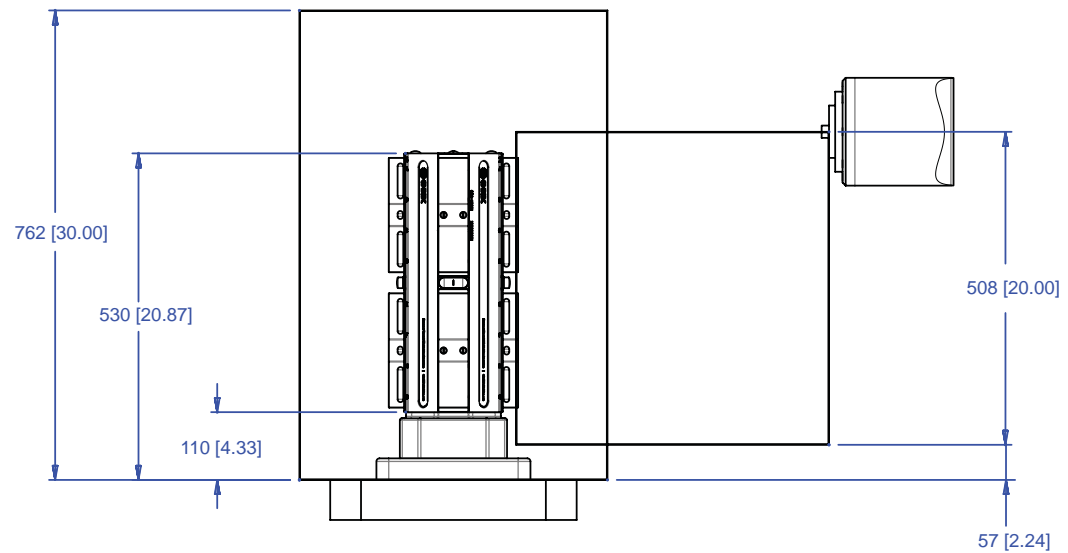
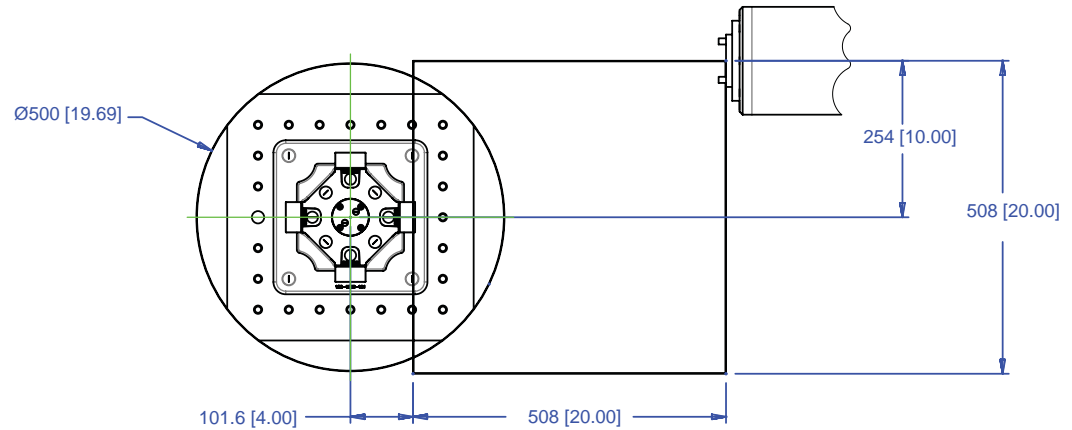
Workholding package
in machine envelope

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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Notes

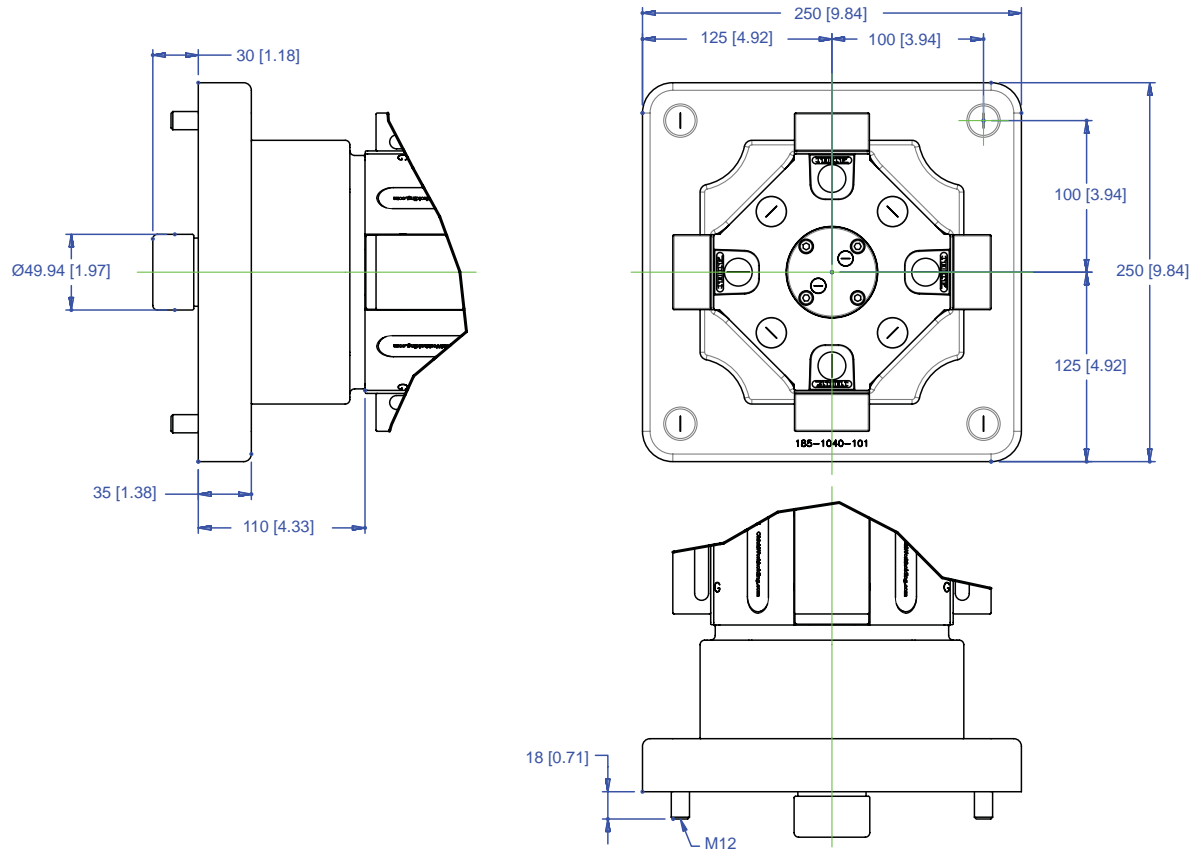
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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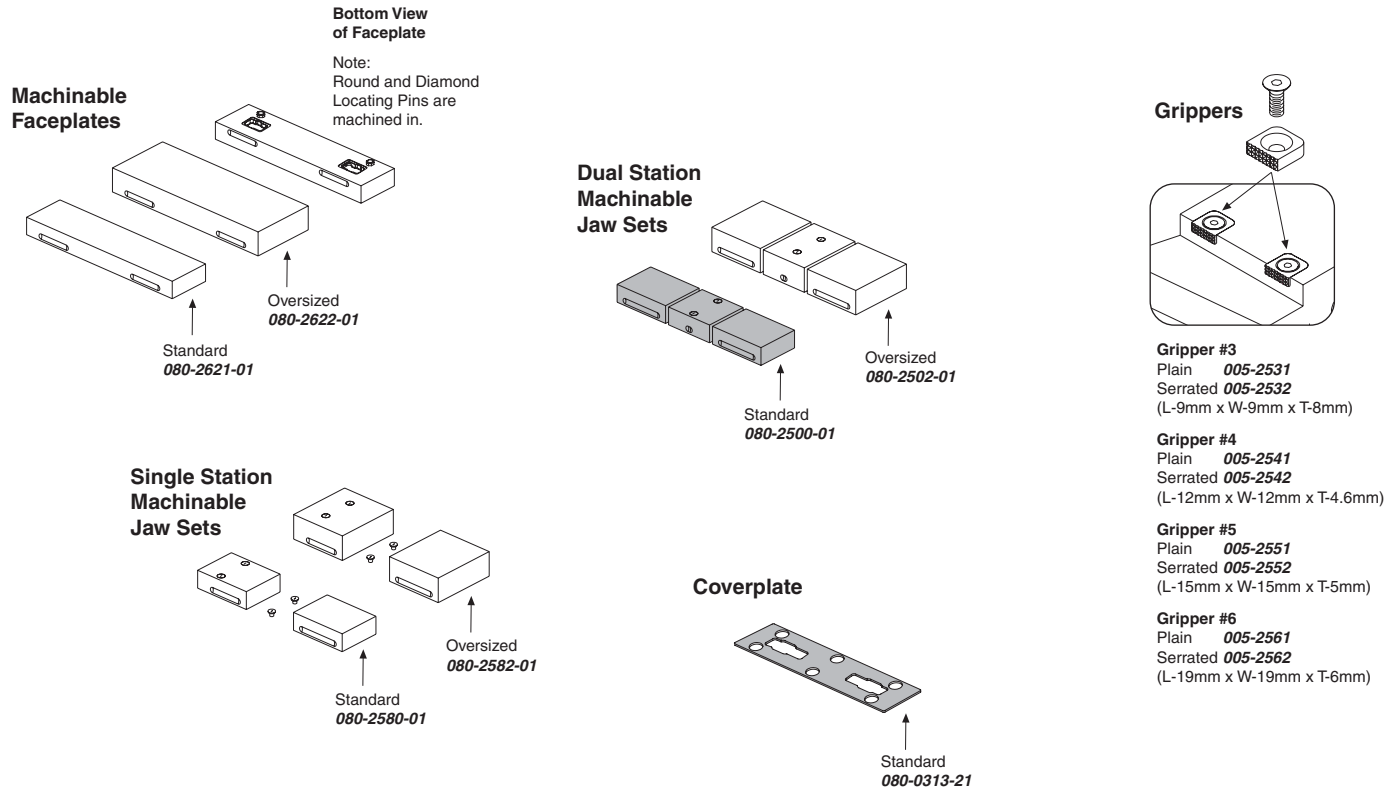
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All dimensions are MM [IN]

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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

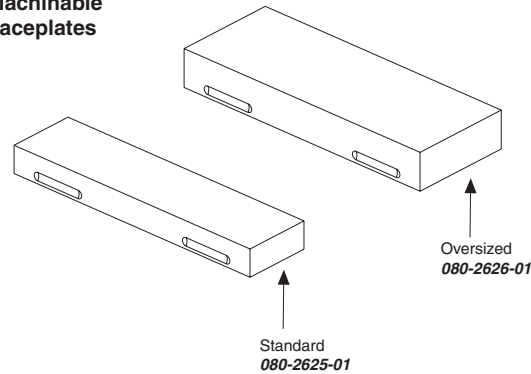
Grey item is included with a standard system

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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.

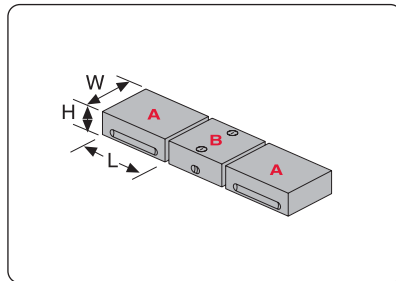
Machinable Faceplates



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**QwikChange Machinable
Dual Station Jaws**



Individual Dual Station Jaws

Standard

A Moveable Jaw **080-2511-01**
(W49mm, H25mm, L75mm)

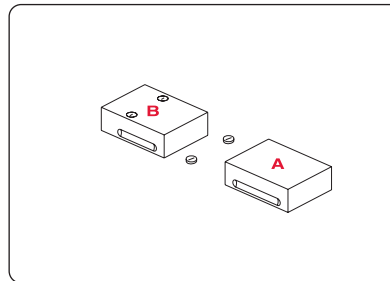
B Fixed Jaw **080-2551-01**
(W49mm, H25mm, L36mm)

Oversized

A Moveable Jaw **080-2512-01**
(W80mm, H35mm, L75mm)

B Fixed Jaw **080-2522-01**
(W80mm, H35mm, L36mm)

**QwikChange Machinable
Single Station Jaws**



Individual Single Station Jaws

Standard

A Moveable Jaw **080-2511-01**
(W49mm, H25mm, L75mm)

B Fixed Jaw **080-2571-01**
(W49mm, H25mm, L75mm)

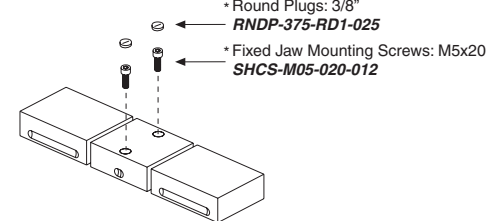
Oversized

A Moveable Jaw **080-2512-01**
(W80mm, H35mm, L75mm)

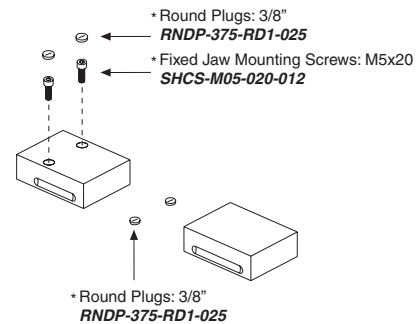
B Fixed Jaw **080-2575-01**
(W80mm, H35mm, L75mm)

Screws and Plugs

Dual Station



Single Station

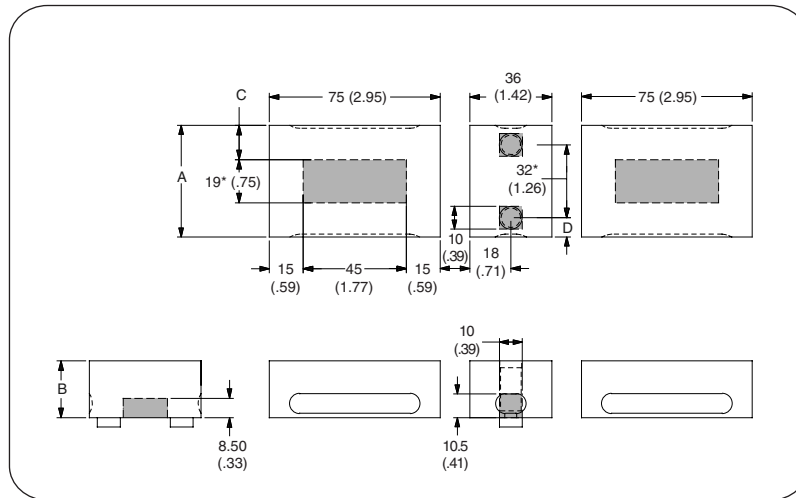


Notes

Grey or * item is included with a standard system

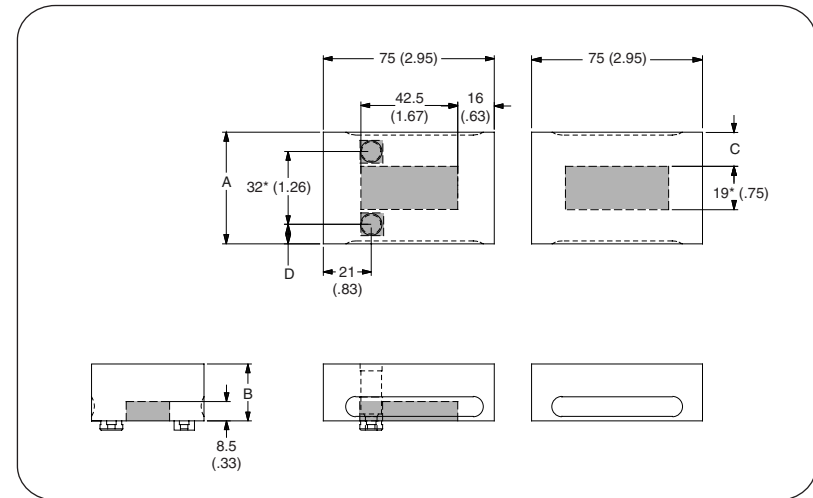
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Dual Station



Item Number	Description	A	B	C	D
080-2500	Standard	49 (1.93)	25 (.98)	15 (.59)	8.5 (.33)
080-2502	Oversized	80 (3.15)	35 (1.38)	30.5 (1.20)	24 (.94)

Single Station



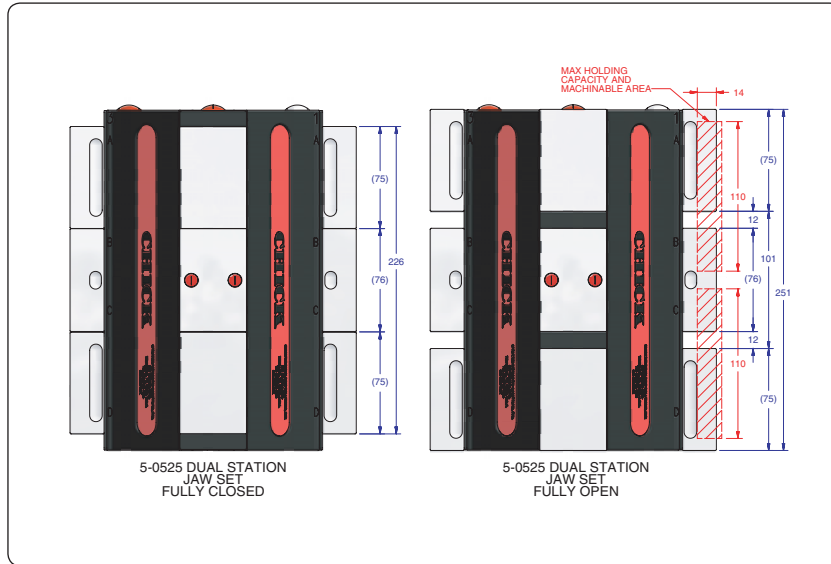
Item Number	Description	A	B	C	D
080-2580	Standard	49 (1.93)	25 (.98)	15 (.59)	8.5 (.33)
080-2582	Oversized	80 (3.15)	35 (1.38)	30.5 (1.20)	24 (.94)

Notes

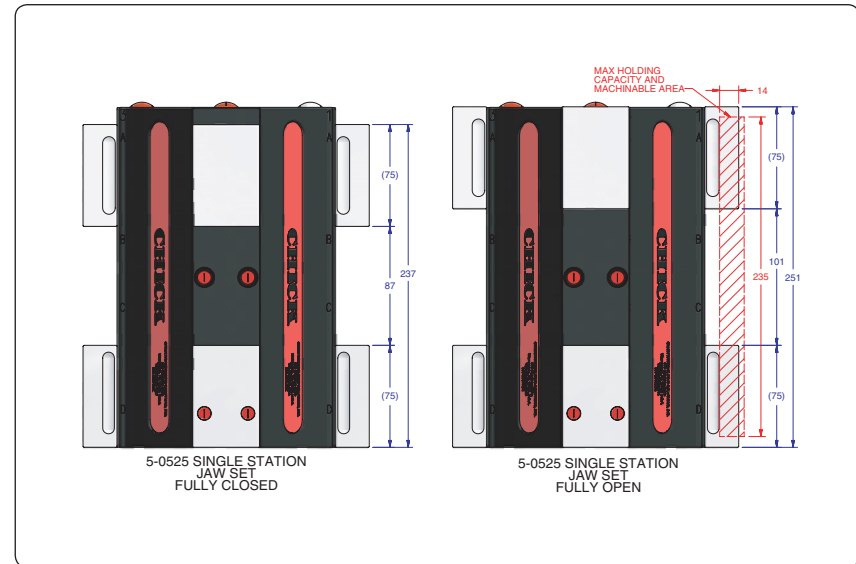
Grey area indicates no cut zone
 All dimensions are MM [IN]
 Dimensions centered on the "A" dimension.

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Dual Station



Single Station



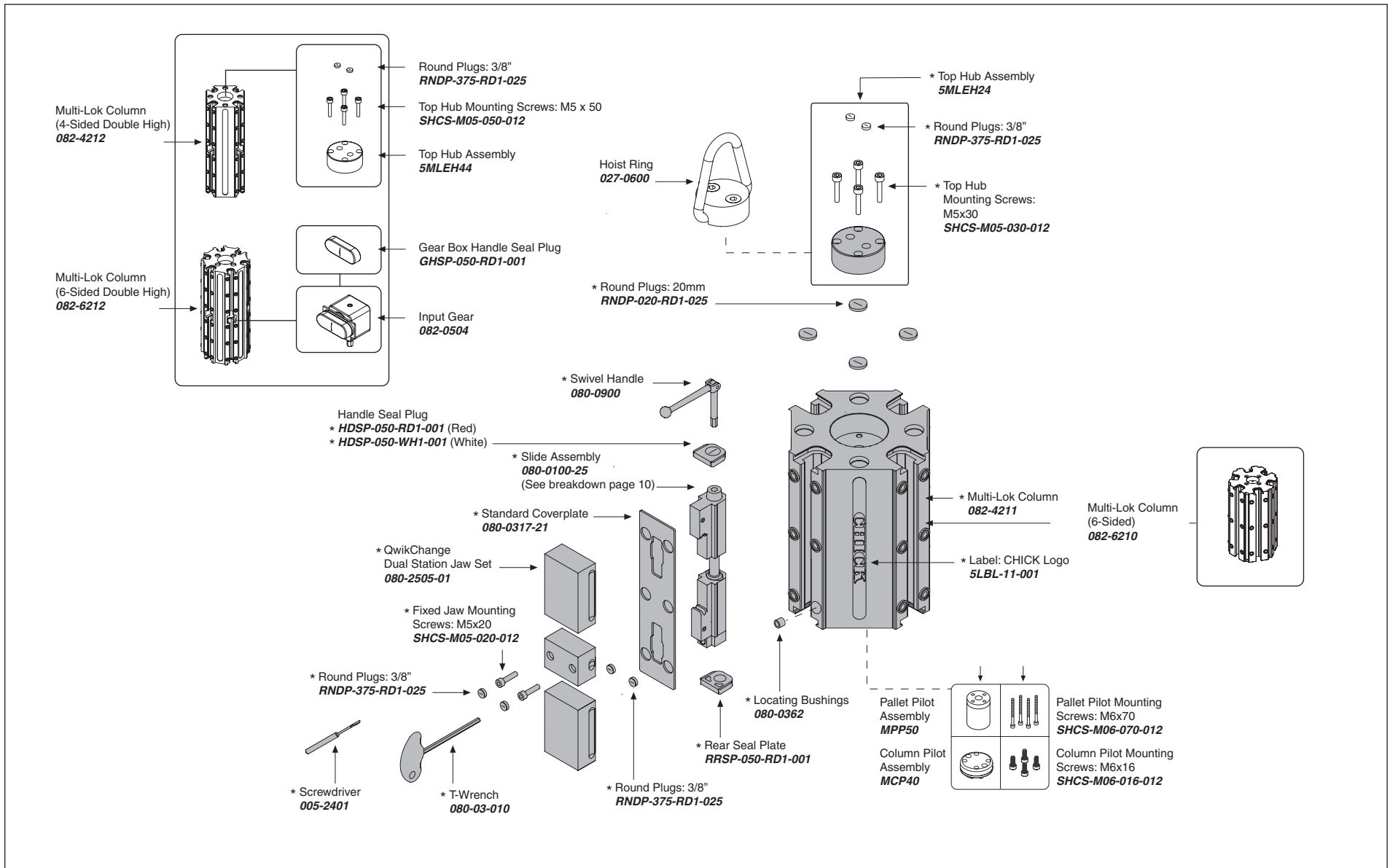
Item Number	Description	A	Jaw Width
080-2500	Standard	14 [0.57]	49 [1.93]
080-2506	Oversized	24 [0.96]	80 [3.15]

Item Number	Description	A	Jaw Width
080-2580	Standard	14 [0.57]	49 [1.93]
080-2582	Oversized	24 [0.96]	80 [3.15]

Notes

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

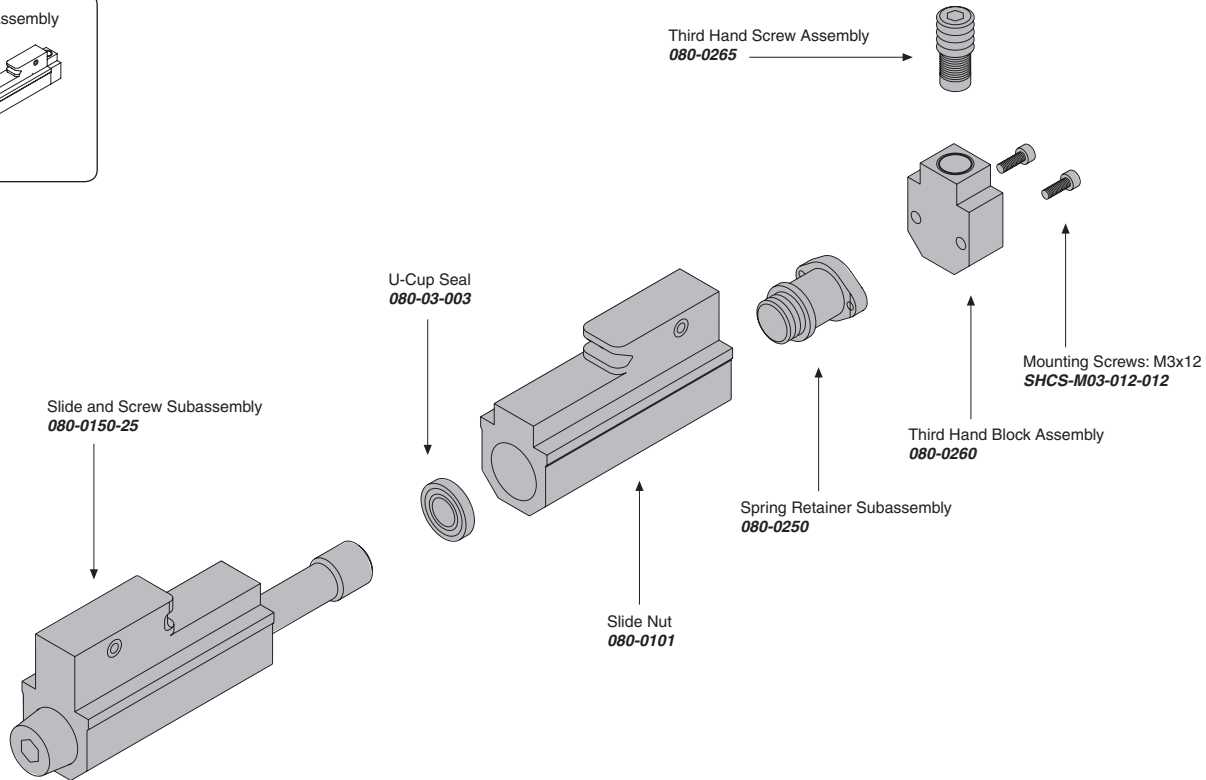
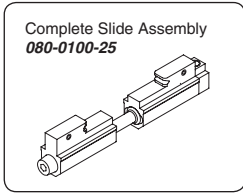
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Notes

Grey items are included with a standard system
 For QwikChange™ Jaw accessories, see pages 4-6

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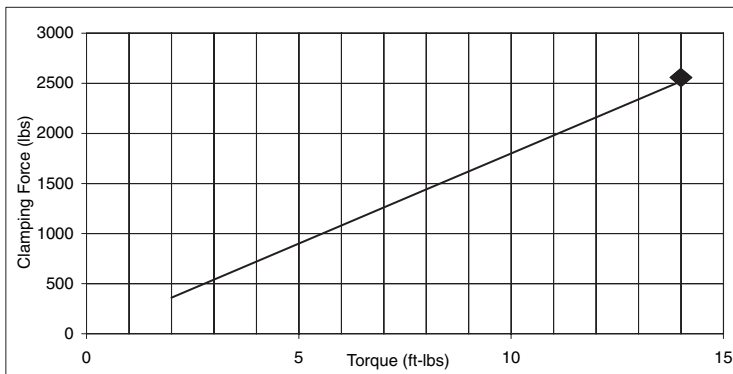
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Pounds (lbs)

Force	=	Torque	X	Slope
lbs	=	in-lb	x	15
lbs	=	ft-lbs	x	180

Torque (ft-lb)	Force (lbs)
0	0
2	360
4	720
6	1080
8	1440
10	1800
12	2160
14	2520

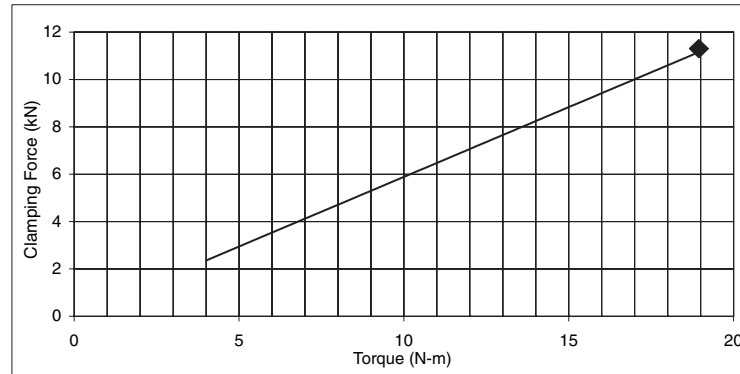


Note: ◆ Maximum Recommended Torque. Actual results may vary.

Kilo Newtons (kN)

Force	=	Torque	X	Slope
N	=	N-m	x	590
kN	=	N-m	x	0.59

Torque (N-m)	Force (kN)
0	0.0
4	2.4
8	4.7
12	7.1
14	8.2
18	10.6
19	11.2



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

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