

5HP-KITA-00031

This workholding package is designed for your KITAMURA HX-250iF machining center.

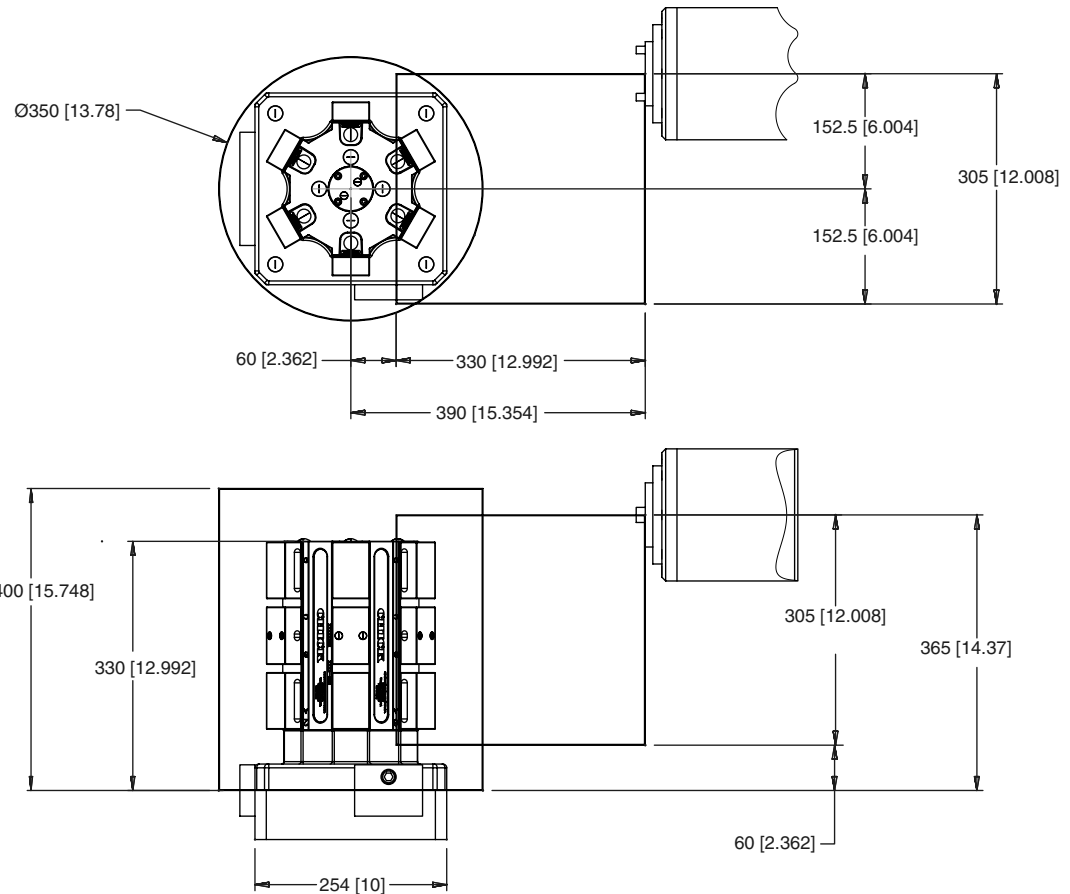


Notes

CHICK WORKHOLDING SOLUTIONS, INC
500 Keystone Drive • Warrendale, PA 15086 USA
Phone: (724) 772-1644 • Fax: (724) 772-1633
Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com

5HP-KITA-00031

This workholding package is designed for your KITAMURA HX-250iF machining center.



Notes

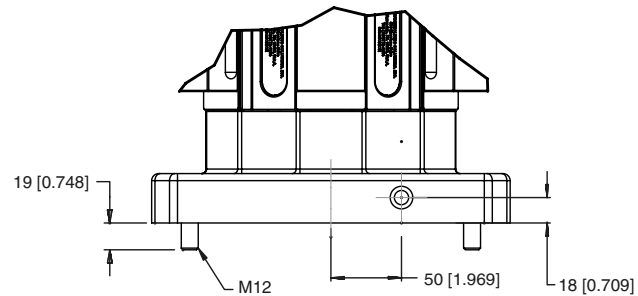
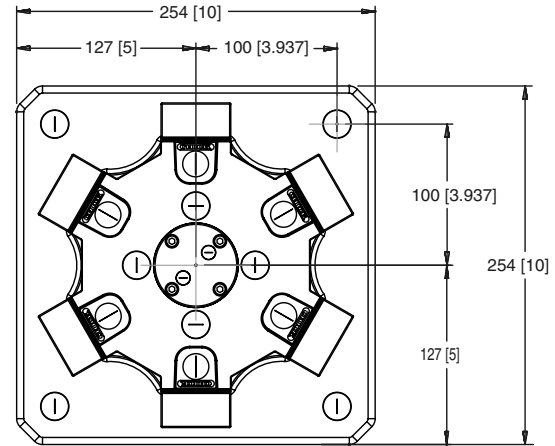
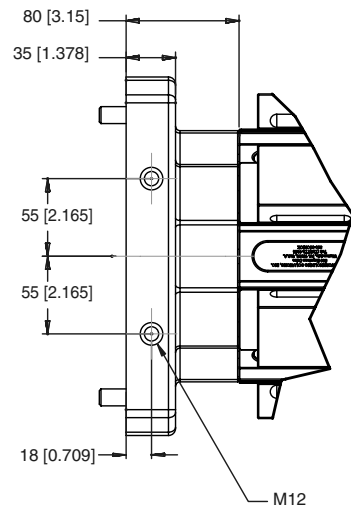
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

CHICK WORKHOLDING SOLUTIONS, INC
 500 Keystone Drive • Warrendale, PA 15086 USA
 Phone: (724) 772-1644 • Fax: (724) 772-1633
 Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com

5HP-KITA-00031

This workholding package is designed for your KITAMURA HX-250iF machining center.

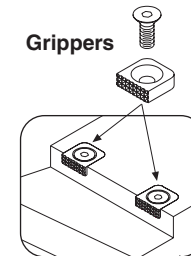
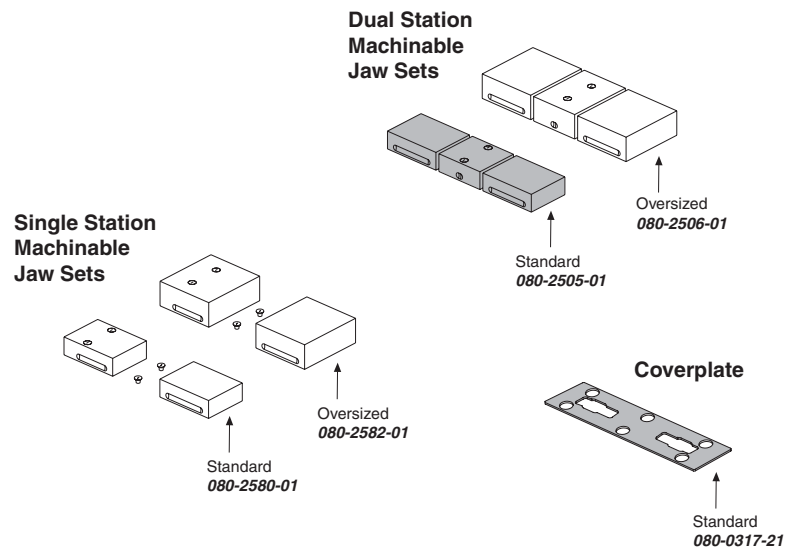


Notes
All dimensions are MM [IN]

CHICK WORKHOLDING SOLUTIONS, INC
500 Keystone Drive • Warrendale, PA 15086 USA
Phone: (724) 772-1644 • Fax: (724) 772-1633
Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com

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.



Grippers

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

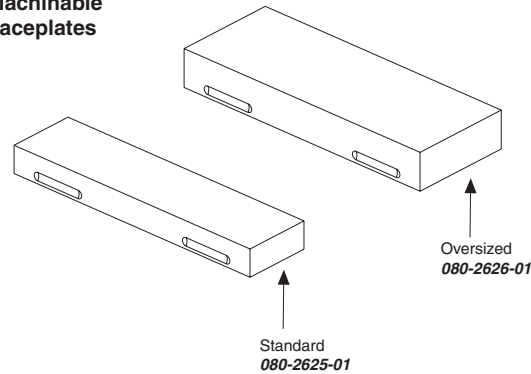
Grey item is included with a standard system

CHICK WORKHOLDING SOLUTIONS, INC
 500 Keystone Drive • Warrendale, PA 15086 USA
 Phone: (724) 772-1644 • Fax: (724) 772-1633
 Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com

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.

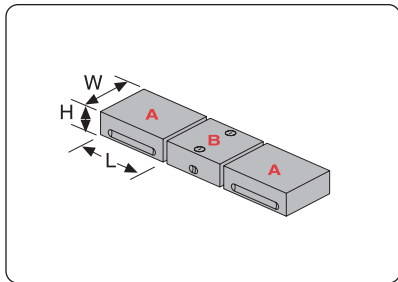
Machinable Faceplates



Notes

CHICK WORKHOLDING SOLUTIONS, INC
500 Keystone Drive • Warrendale, PA 15086 USA
Phone: (724) 772-1644 • Fax: (724) 772-1633
Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com

**QwikChange Machinable
Dual Station Jaws**



Individual Dual Station Jaws

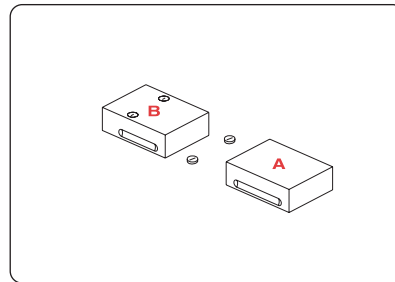
Standard

- A** Moveable Jaw **080-2511-01**
(W49mm, H25mm, L75mm)
- B** Fixed Jaw **080-2553-01**
(W49mm, H25mm, L76mm)

Oversized

- A** Moveable Jaw **080-2512-01**
(W80mm, H35mm, L75mm)
- B** Fixed Jaw **080-2554-01**
(W80mm, H35mm, L76mm)

**QwikChange Machinable
Single Station Jaws**



Individual Single Station Jaws

Standard

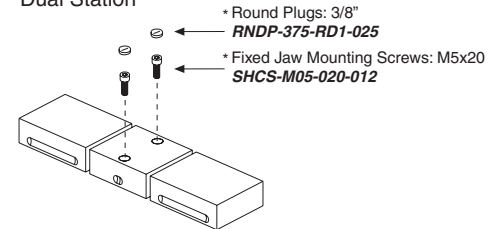
- A** Moveable Jaw **080-2511-01**
(W49mm, H25mm, L75mm)
- B** Fixed Jaw **080-2571-01**
(W49mm, H25mm, L75mm)

Oversized

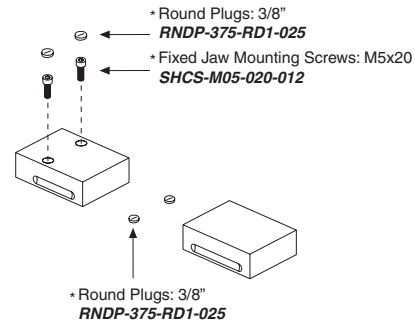
- A** Moveable Jaw **080-2512-01**
(W80mm, H35mm, L75mm)
- B** Fixed Jaw **080-2572-01**
(W80mm, H35mm, L75mm)

Screws and Plugs

Dual Station



Single Station

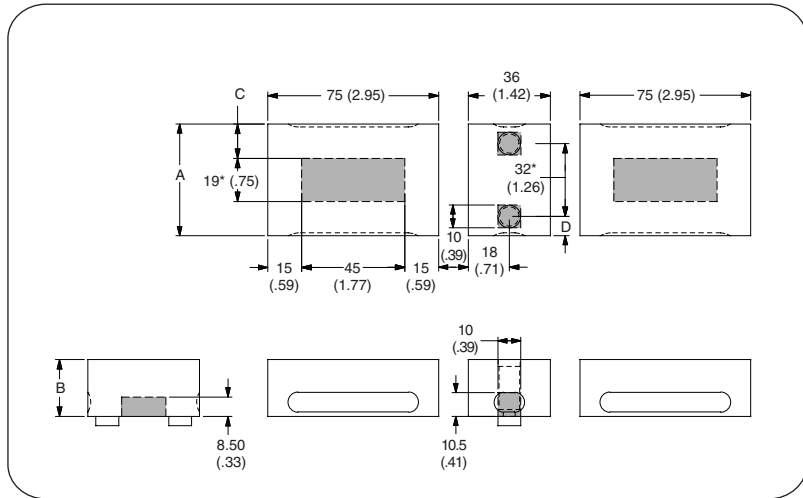


Notes

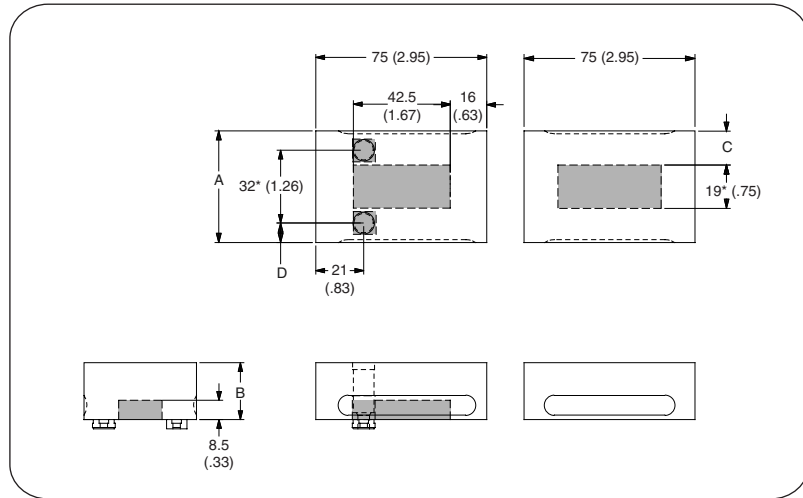
Grey or * item is included with a standard system

CHICK WORKHOLDING SOLUTIONS, INC
 500 Keystone Drive • Warrendale, PA 15086 USA
 Phone: (724) 772-1644 • Fax: (724) 772-1633
 Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com

Dual Station



Single Station



| Item Number | Description | A | B | C | D |
|-----------------|-------------|-----------|-----------|-------------|-----------|
| 080-2500 | Standard | 49 [1.93] | 25 [.98] | 15 [.59] | 8.5 [.33] |
| 080-2506 | Oversized | 80 [3.15] | 35 [1.38] | 30.5 [1.20] | 24 [.94] |
| | | | | | |
| | | | | | |

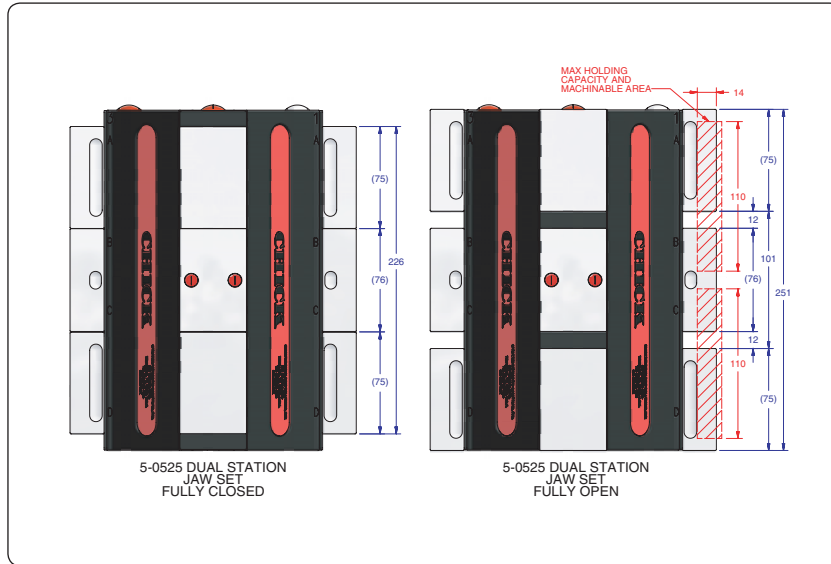
| Item Number | Description | A | B | C | D |
|-----------------|-------------|-----------|-----------|-------------|-----------|
| 080-2580 | Standard | 49 [1.93] | 25 [.98] | 15 [.59] | 8.5 [.33] |
| 080-2582 | Oversized | 80 [3.15] | 35 [1.38] | 30.5 [1.20] | 24 [.94] |
| | | | | | |
| | | | | | |

Notes

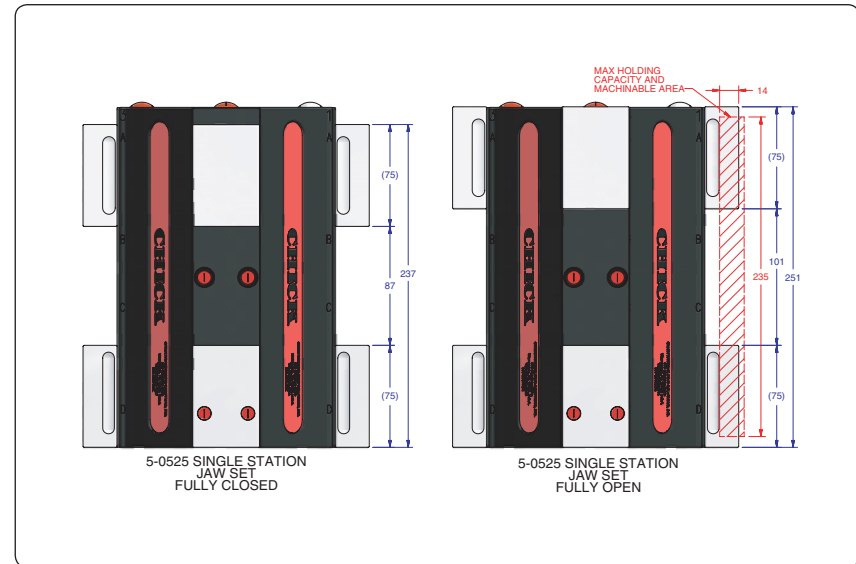
Grey area indicates no cut zone
 All dimensions are MM [IN]
 Dimensions centered on the "A" dimension.

CHICK WORKHOLDING SOLUTIONS, INC
 500 Keystone Drive • Warrendale, PA 15086 USA
 Phone: (724) 772-1644 • Fax: (724) 772-1633
 Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com

Dual Station



Single Station



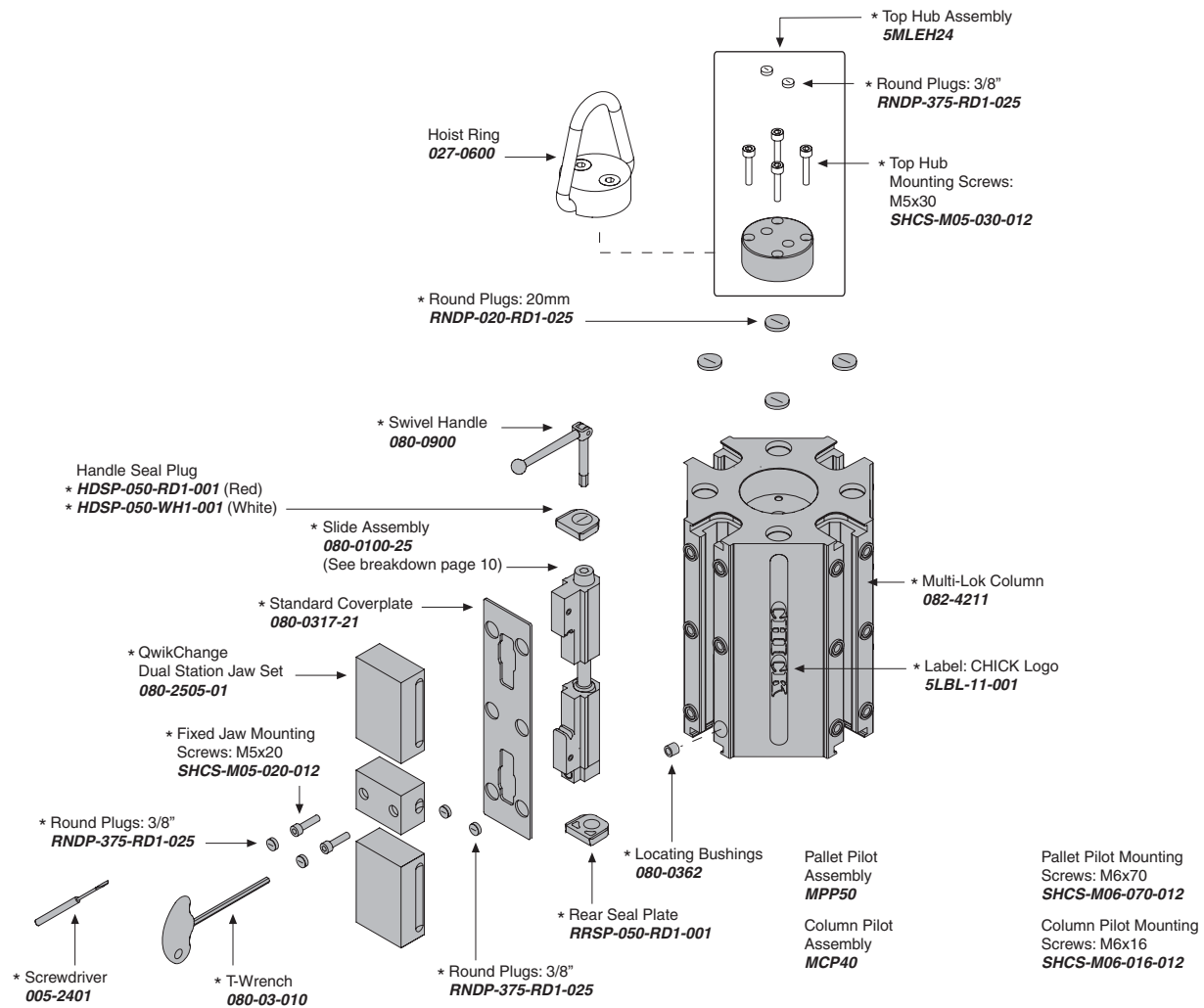
| Item Number | Description | A | Jaw Width |
|-----------------|-------------|-----------|-----------|
| 080-2500 | Standard | 14 [0.57] | 49 [1.93] |
| 080-2506 | Oversized | 24 [0.96] | 80 [3.15] |
| | | | |
| | | | |

| 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.

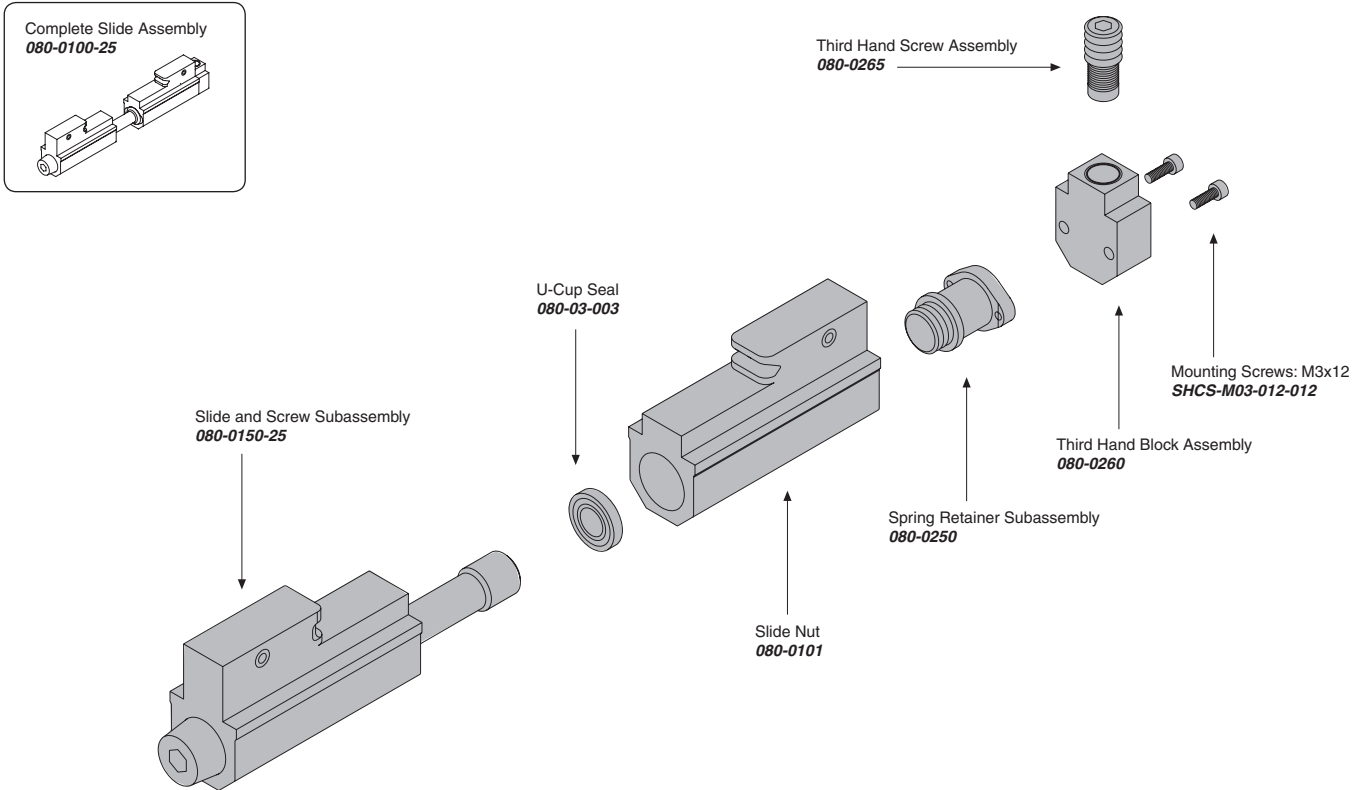
CHICK WORKHOLDING SOLUTIONS, INC
 500 Keystone Drive • Warrendale, PA 15086 USA
 Phone: (724) 772-1644 • Fax: (724) 772-1633
 Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com



Notes

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

CHICK WORKHOLDING SOLUTIONS, INC
500 Keystone Drive • Warrendale, PA 15086 USA
Phone: (724) 772-1644 • Fax: (724) 772-1633
Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com



Notes

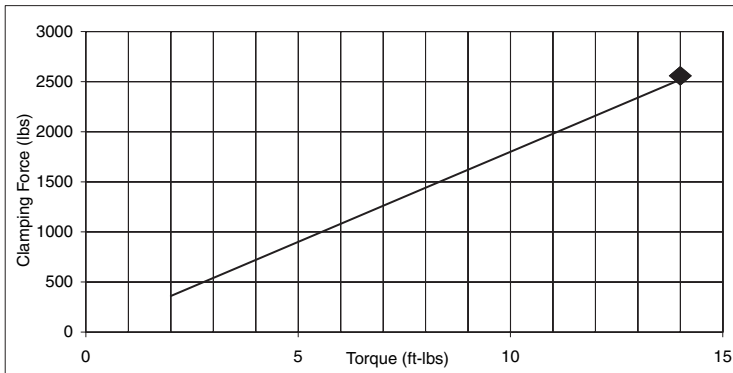
Grey items are included with a standard system

CHICK WORKHOLDING SOLUTIONS, INC
 500 Keystone Drive • Warrendale, PA 15086 USA
 Phone: (724) 772-1644 • Fax: (724) 772-1633
 Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com

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 |

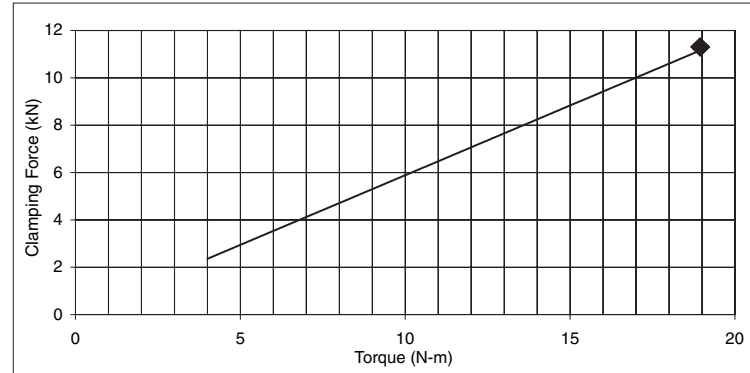


Note: ◆ Maximum Recommended Torque. Actual results may vary.

Kilonewtons (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.

Notes

CHICK WORKHOLDING SOLUTIONS, INC
 500 Keystone Drive • Warrendale, PA 15086 USA
 Phone: (724) 772-1644 • Fax: (724) 772-1633
 Toll Free: (800) 33-CHICK • (800) 332-4425
www.ChickWorkholding.com