

5HP-MAZA-00257

This workholding package is designed for your NEXUS HCN4000-II machining center.

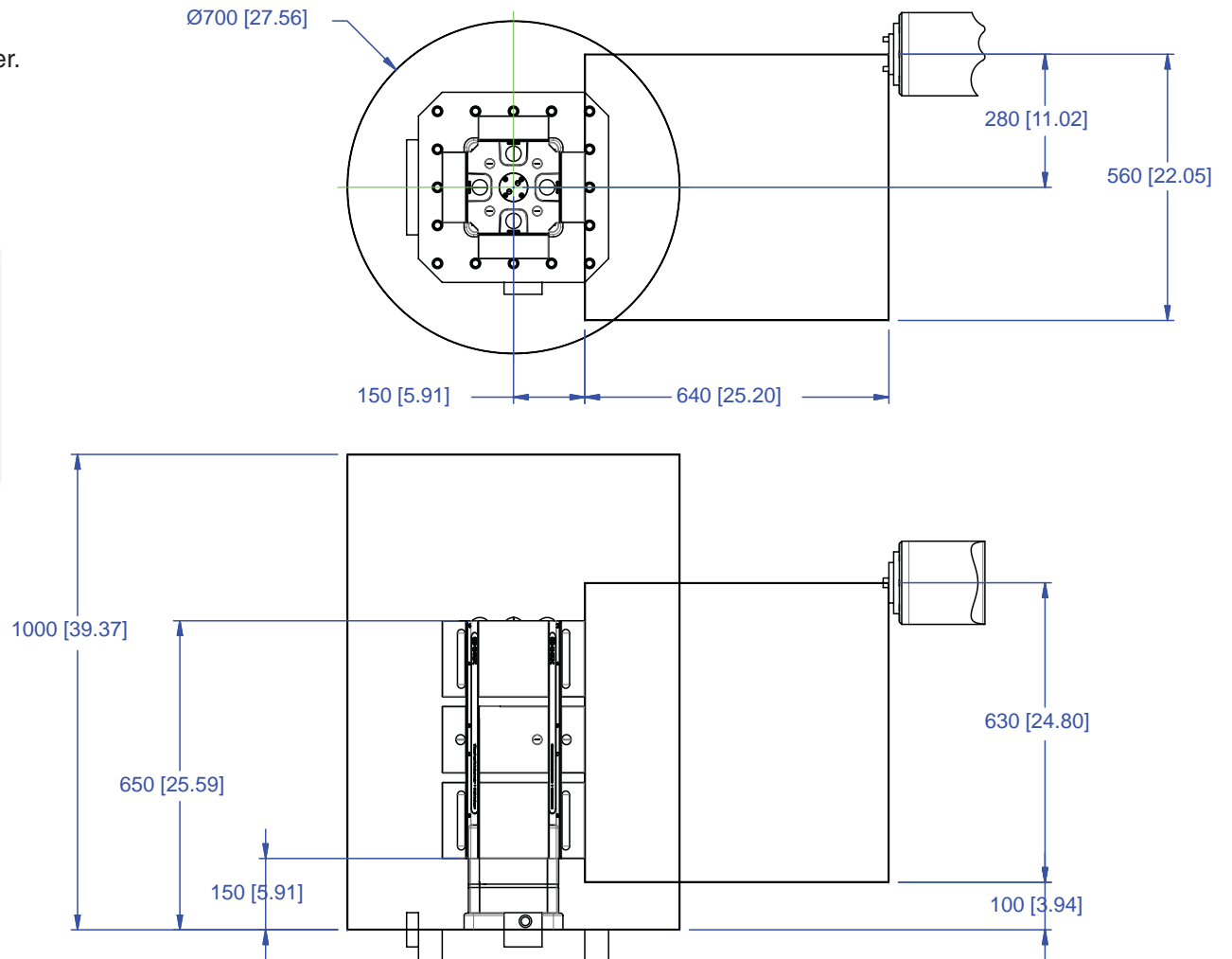


Notes

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

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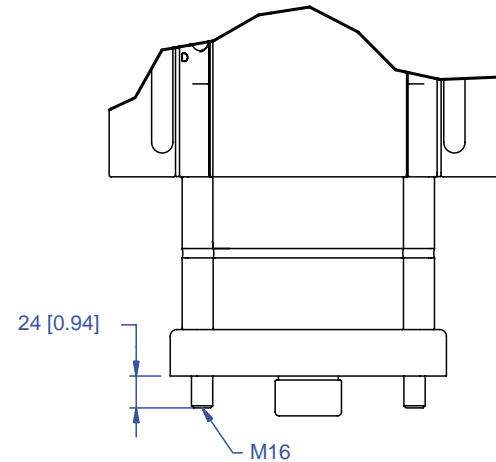
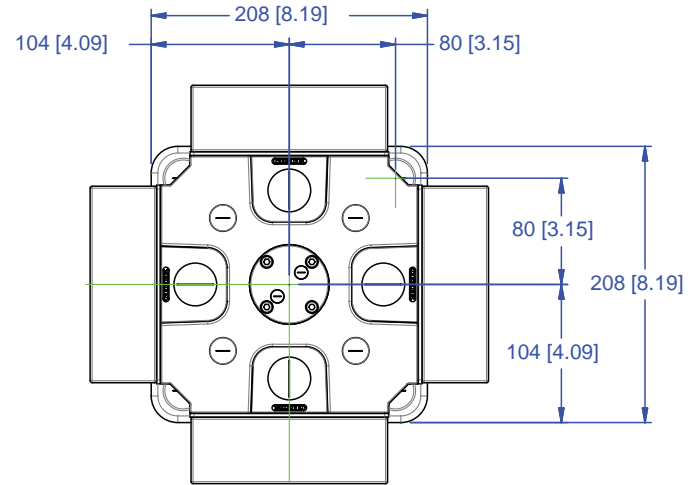
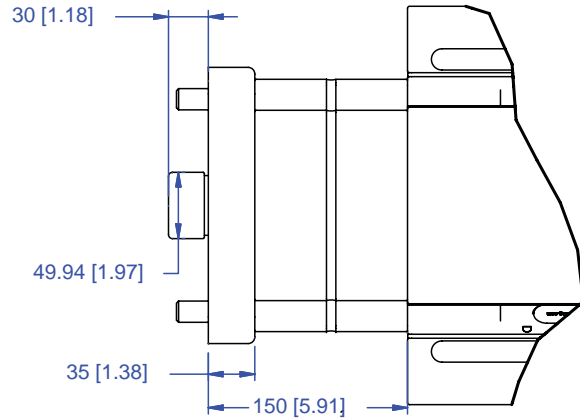
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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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.



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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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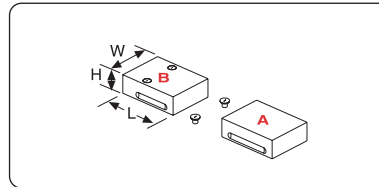
QwikChange Machinable Dual Station Jaws



Individual Dual Station Jaws

- Standard
A Moveable Jaw **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)

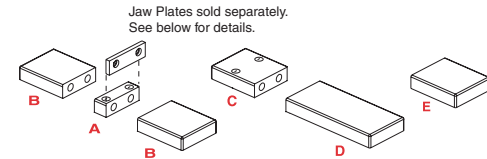
QwikChange Machinable Single Station Jaws



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)

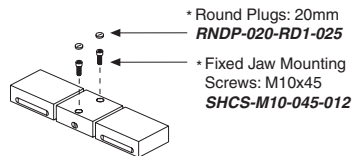
QwikChange Jaw Carriers



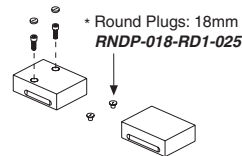
- Jaw Carriers (Inch) Jaw Carriers (Metric)
- A** **5JC1550-FC-IN** **A** **5JC1550-FC-MM**
B **5JC1550-MC-IN** **B** **5JC1550-MC-MM**
C **5JC1550-SC-IN** **C** **5JC1550-SC-MM**
D **5JC1550-LM-IN** **D** **5JC1550-LM-MM**
E **5JC1550-SM-IN** **E** **5JC1550-SM-MM**

- A** Dual Station Fixed **C** Single Station Fixed **E** Single Station Short
B Dual Station Moveable **D** Single Station Long Moveable

Screws and Plugs



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

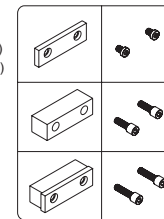


- * Round Plugs: 18mm **RNDP-018-RD1-025**

Jaw Plates

- Standard (Set of 4) **JH6STD** (Inch) **MJH15** (Metric)
- Thick (Set of 2) **JH6THK**
- Both Sizes **JH6STD** & **JH6THK**

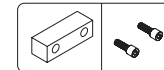
HARD JAW PLATES



- Standard Mounting Screws: 1/2-13x5/8" **LHCS-500-063-008** (Inch) **LHCS-M10-012-008** (Metric)
- Thick Mounting Screws: 1/2-13x1.25" **SHCS-500-125-008**
- Both Sizes Mounting Screws: 1/2-13x1.75" **SHCS-500-175-008**

SOFT JAW PLATES

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



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

Notes

Grey or * item is included with a standard system

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Dual Station

Single Station



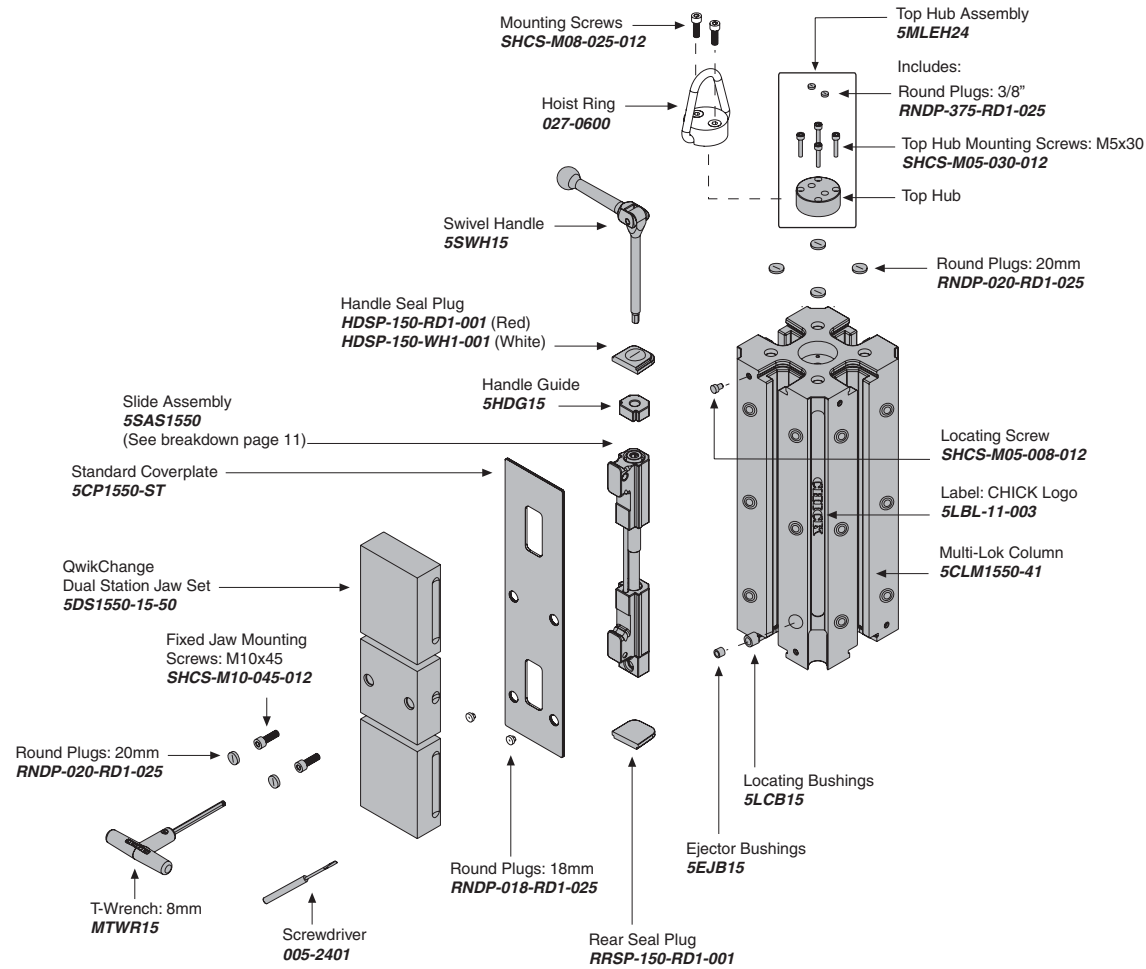
Item Number	Description	A	Jaw Width
5DS1550-15-50	Standard	32 [1.26]	148 [5.83]
5DS1550-15-70	High	52 [2.05]	148 [5.83]
5DS1550-20-50	Wide	32 [1.26]	198 [7.80]
5DS1550-20-70	Oversized	52 [2.05]	198 [7.80]

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

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 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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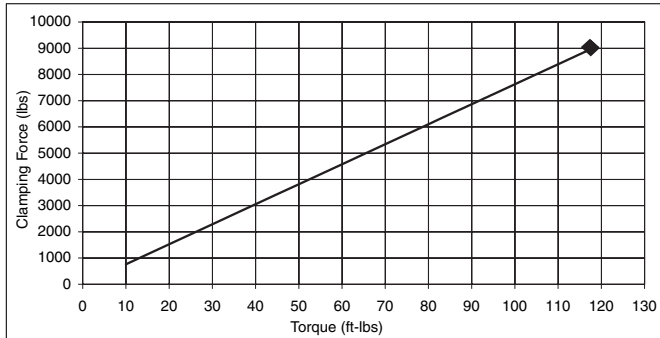
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Pounds (lbs)

Force	=	Torque	X	Slope
lbs	=	in-lb	x	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

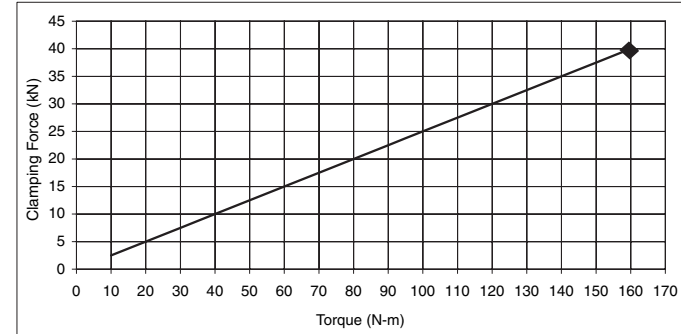


Note: ◆ Maximum Recommended Torque. Actual results may vary.

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.

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