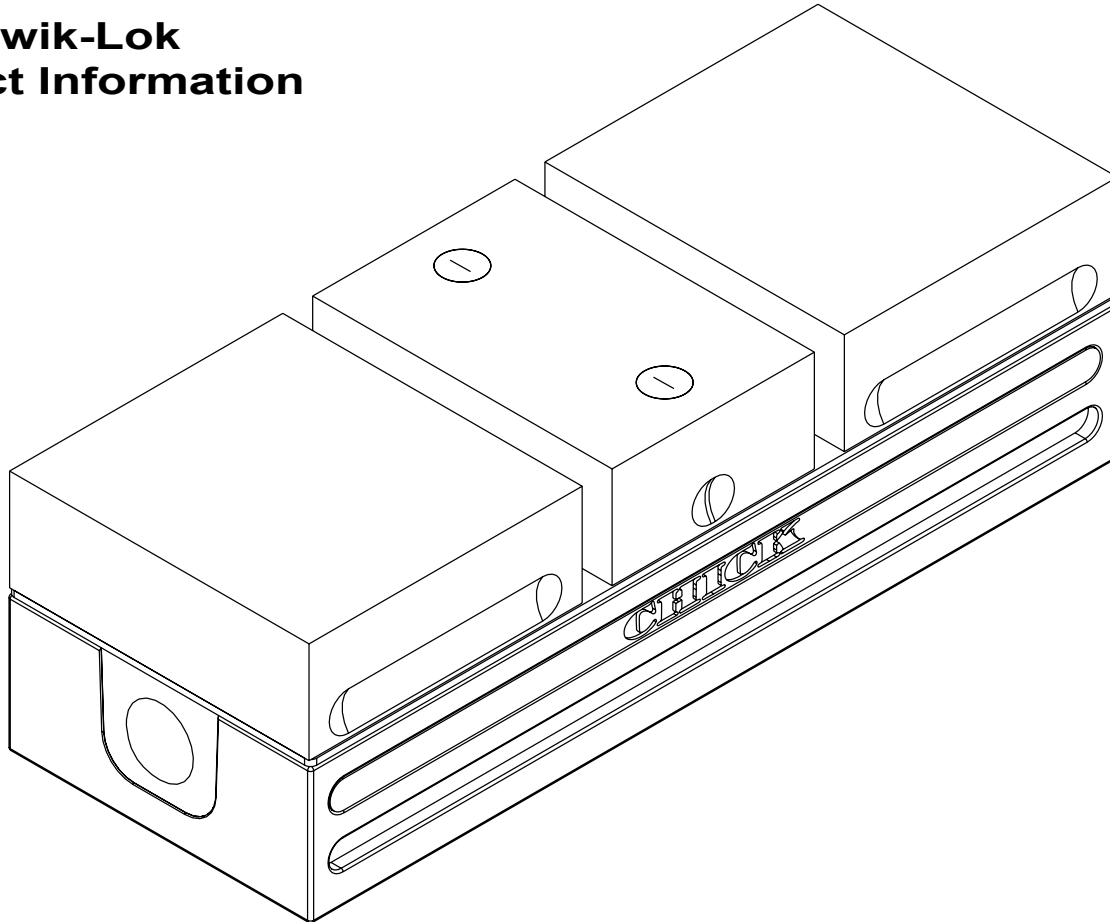


PRODUCT INFO

⑤ 5QL1540-AL

1540 Qwik-Lok Product Information



SPARE PARTS

5 5QL1540-AL SYSTEM 5

NOTES

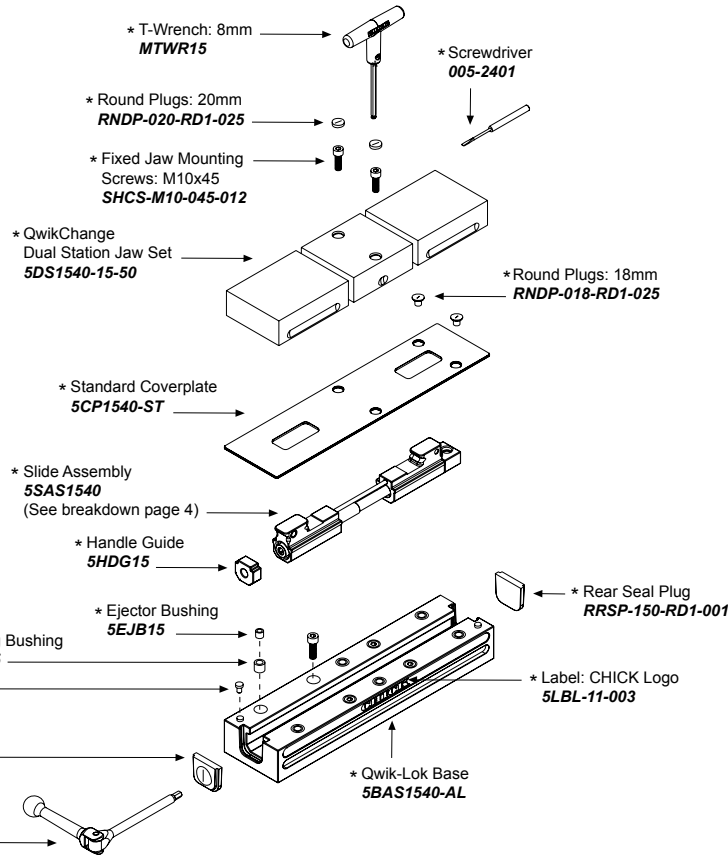
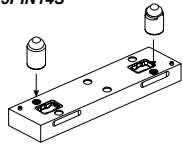
For QwikChange Jaw accessories, see pages 2-3

- * Included in a standard 1540 Qwik-Lok

Faceplate Round & Diamond Pins

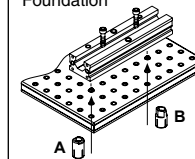
(Included w/ Faceplate purchase)

5PIN14S



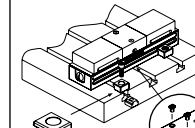
MOUNTING

Foundation



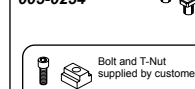
- A Round Pin..... **MPIN12R**
- B Diamond Pin... **MPIN12D**
- A & B Set **MPIN12S**

T-Slotted Table



Toe Clamps

005-0254



Bolt and T-Nut
supplied by customer

Locating Keys

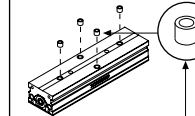
Inch Size

- MKE500** (1/2")
- MKE562** (9/16")
- MKE625** (5/8")
- MKE688** (11/16")
- MKE750** (3/4")
- MKE812** (13/16")

Metric Size

- MKE10** (10mm)
- MKE12** (12mm)
- MKE14X18** (14mm)
- MKE16** (16mm)
- MKE20** (20mm)

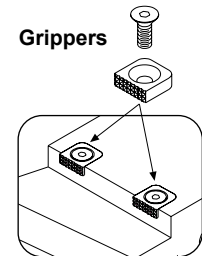
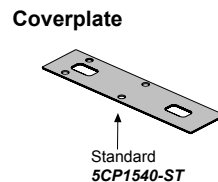
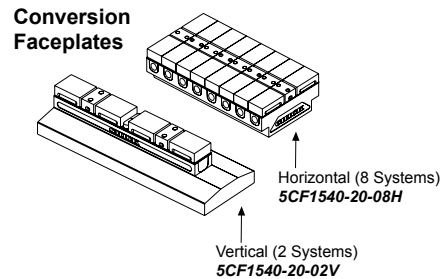
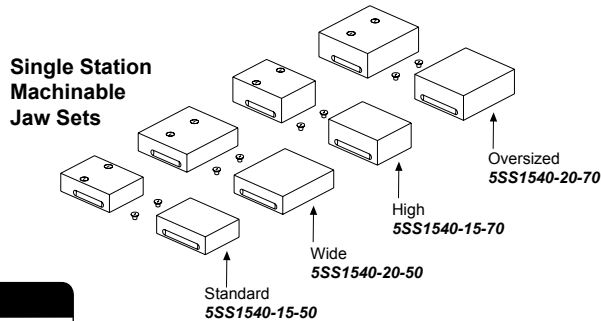
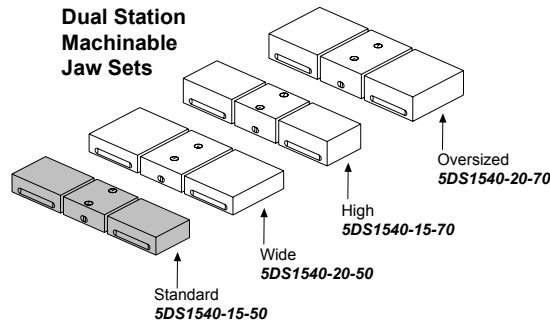
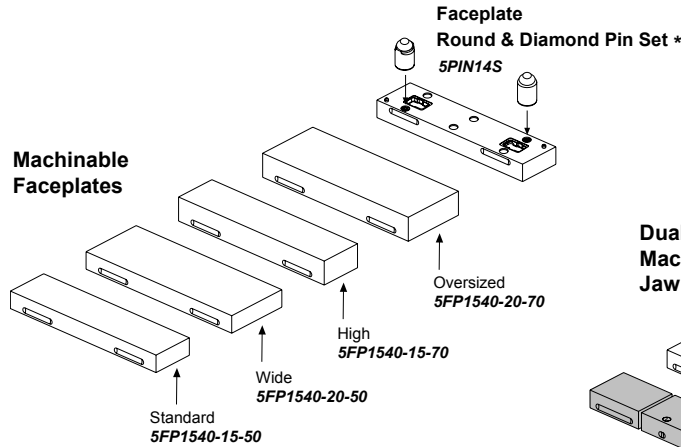
Bottom of Base



- * Locating Bushing:
12mmx18mmx12mm
025-0370

ACCESSORY SETS

5 5QL1540-AL SYSTEM 5



Gripper #3
Plain 005-2531
Serrated 005-2532
(L-9mm x W-9mm x T-3mm)

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

■ Included with a standard system

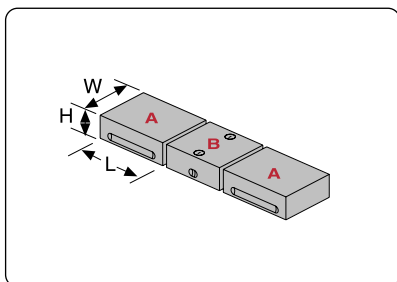
* Required for both Machinable and Conversion Faceplates. (Included with Faceplate purchase)

INDIVIDUAL ACC.

5 5QL1540-AL SYSTEM 5

* or Included with a standard system

QwikChange Machinable Dual Station Jaws



Individual Dual Station Jaws

Standard

A Moveable Jaw **5MJ1540-15-50**
(W148mm, H50mm, L135mm)

B Fixed Jaw **5FJ1540-15-50**
(W148mm, H50mm, L100mm)

Wide

A Moveable Jaw **5MJ1540-20-50**
(W198mm, H50mm, L135mm)

B Fixed Jaw **5FJ1540-20-50**
(W198mm, H50mm, L100mm)

High

A Moveable Jaw **5MJ1540-15-70**
(W148mm, H70mm, L135mm)

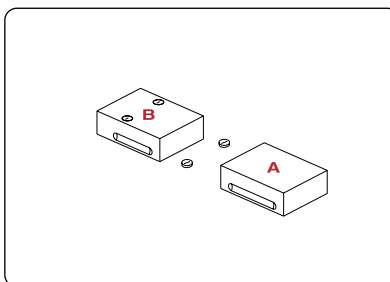
B Fixed Jaw **5FJ1540-15-70**
(W148mm, H70mm, L100mm)

Oversized

A Moveable Jaw **5MJ1540-20-70**
(W198mm, H70mm, L135mm)

B Fixed Jaw **5FJ1540-20-70**
(W198mm, H70mm, L100mm)

QwikChange Machinable Single Station Jaws



Individual Single Station Jaws

Standard

A Moveable Jaw **5MJ1540-15-50**
(W148mm, H50mm, L135mm)

B Fixed Jaw **5SJ1540-15-50**
(W148mm, H50mm, L135mm)

Wide

A Moveable Jaw **5MJ1540-20-50**
(W198mm, H50mm, L135mm)

B Fixed Jaw **5SJ1540-20-50**
(W198mm, H50mm, L135mm)

High

A Moveable Jaw **5MJ1540-15-70**
(W148mm, H70mm, L135mm)

B Fixed Jaw **5SJ1540-15-70**
(W148mm, H70mm, L135mm)

Oversized

A Moveable Jaw **5MJ1540-20-70**
(W198mm, H70mm, L135mm)

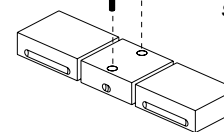
B Fixed Jaw **5SJ1540-20-70**
(W198mm, H70mm, L135mm)

Screws and Plugs

Dual Station

* Round Plugs: 20mm
RNDP-020-RD1-025

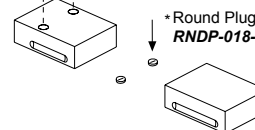
* Fixed Jaw Mounting Screws: M10x45
SHCS-M10-045-012



Single Station

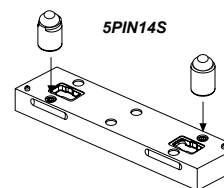
* Round Plugs: 20mm
RNDP-020-RD1-025

* Fixed Jaw Mounting Screws: M10x45
SHCS-M10-045-012



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

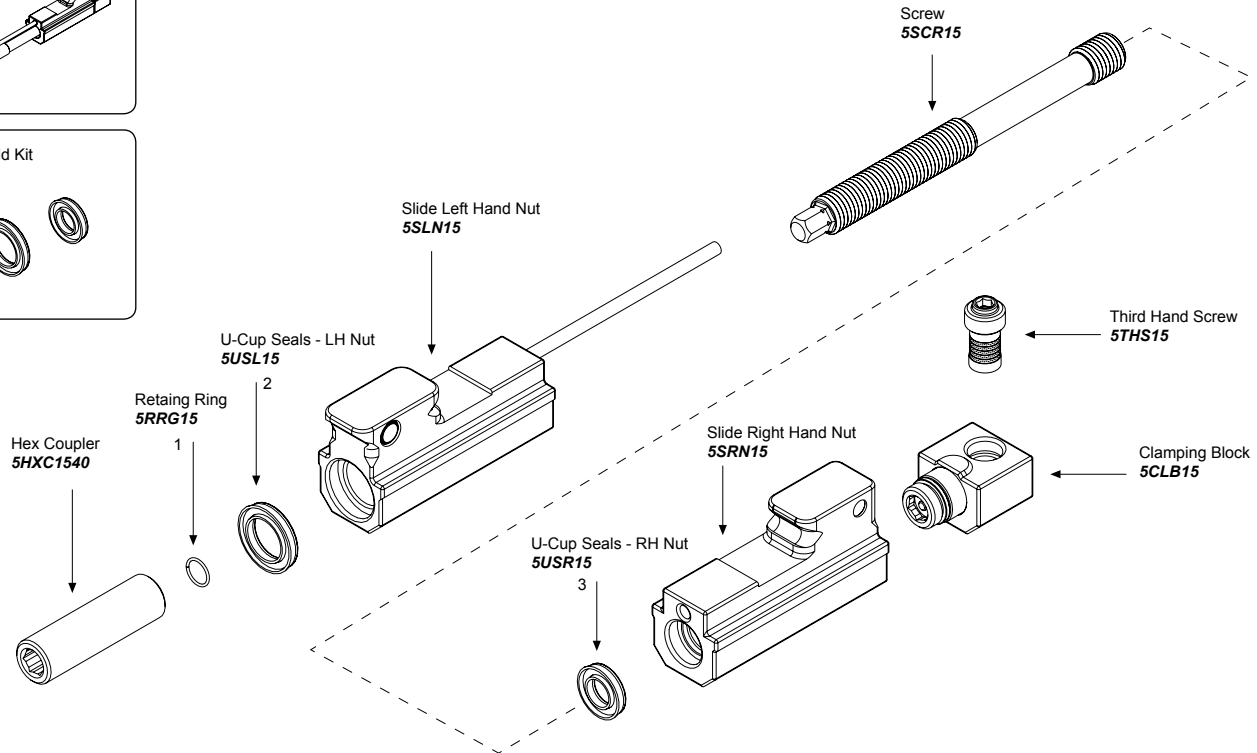
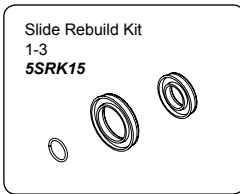
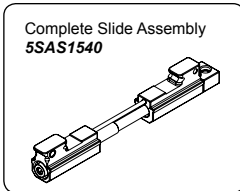
Faceplate Round & Diamond Pin Set (Included w/ Faceplate purchase)



Required for both
Machinable and
Conversion Faceplates.

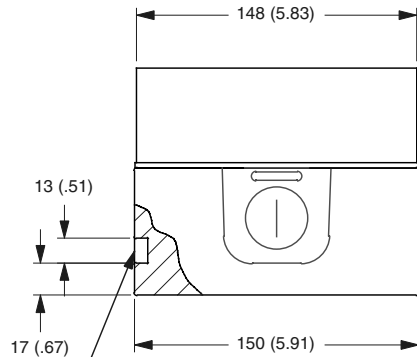
SLIDE ASSEMBLY

5 5QL1540-AL SYSTEM 5

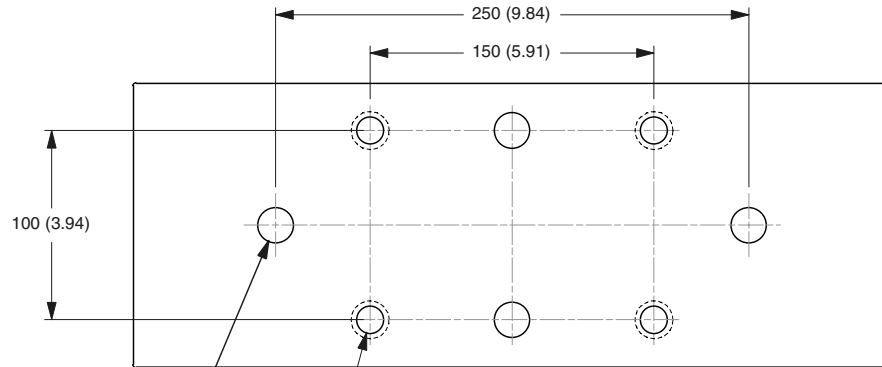
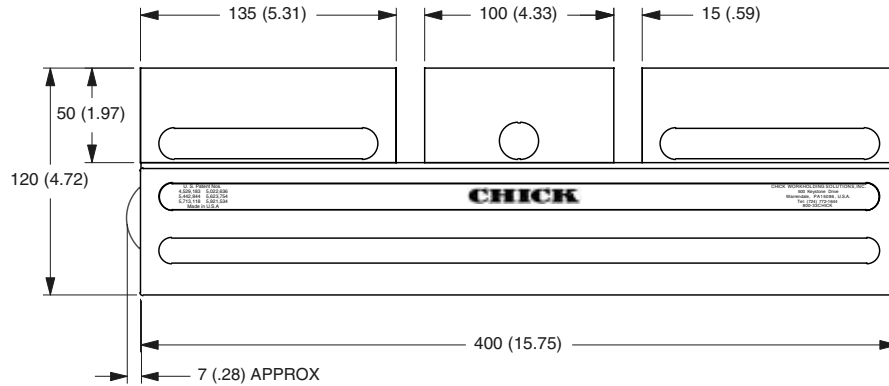


DIMENSIONS

5 5QL1540-AL SYSTEM 5



TOE CLAMP RAIL FOR USE WITH
CHICK TOE CLAMPS
ORDER NUMBER 005-0254



LOCATING HOLES
Ø 12.007 (.4727)X 15 (.039)DP
2 PLACES

MOUNTING HOLES FOR
M12 SOCKET-HEAD CAP
SCREWS
4 PLACES

NOTES

Dimensions are in mm (inches)

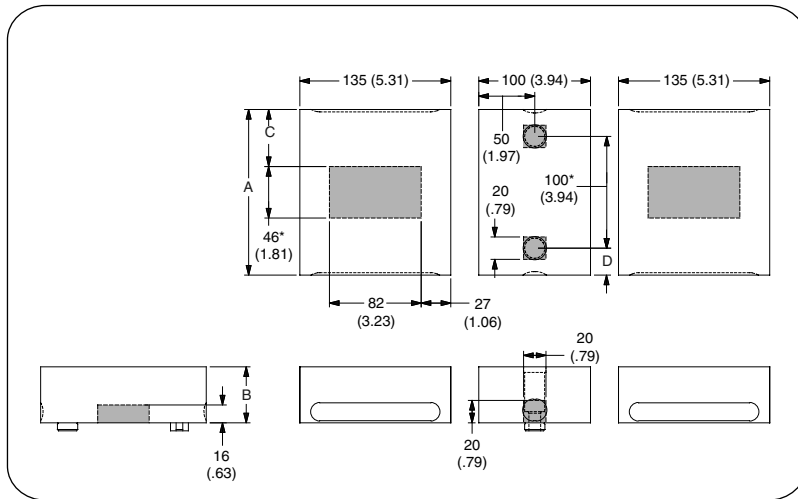
Dimensions include standard Dual
Station Machinable Jaw Sets.

System weight: 21 kg. (46 lbs.)

5 5QL1540-AL

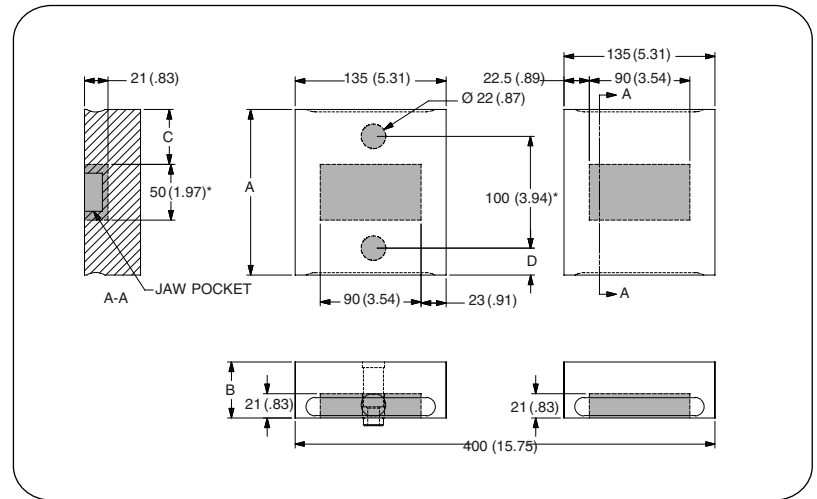
SYSTEM 5

Dual Station



Item Number	Description	A	B	C	D
5DS1540-15-50	Standard	148 (5.83)	50 (1.97)	51 (2.01)	24 (.94)
5DS1540-15-70	High	148 (5.83)	70 (2.76)	51 (2.01)	24 (.94)
5DS1540-20-50	Wide	198 (7.80)	50 (1.97)	76 (2.99)	49 (1.93)
5DS1540-20-70	Oversized	198 (7.80)	70 (2.76)	76 (2.99)	49 (1.93)

Single Station



Item Number	Description	A	B	C	D
5SS1540-15-50	Standard	148 (5.83)	50 (1.97)	49 (1.93)	24 (.94)
5SS1540-15-70	High	148 (5.83)	70 (2.76)	49 (1.93)	24 (.94)
5SS1540-20-50	Wide	198 (7.80)	50 (1.97)	74 (2.91)	49 (1.93)
5SS1540-20-70	Oversized	198 (7.80)	70 (2.76)	74 (2.91)	49 (1.93)

NOTES

■ No cut zone

Dimensions are in mm (inches)

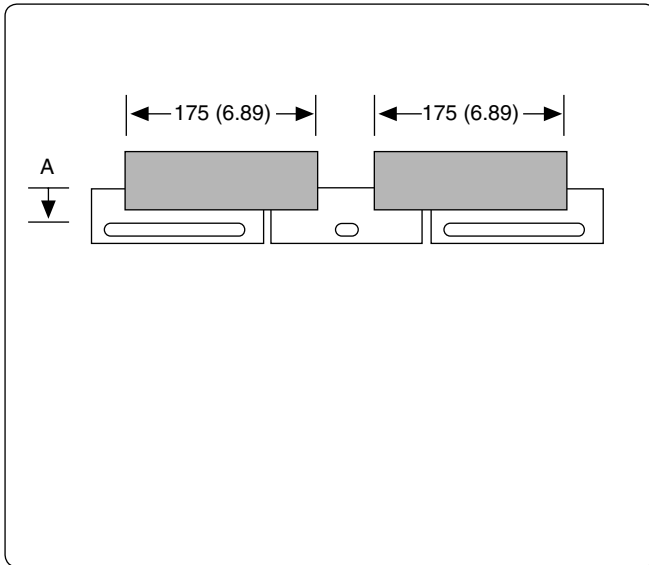
* Dimensions centered on the "A" dimension.

HOLDING CAPACITY

5 5QL1540-AL

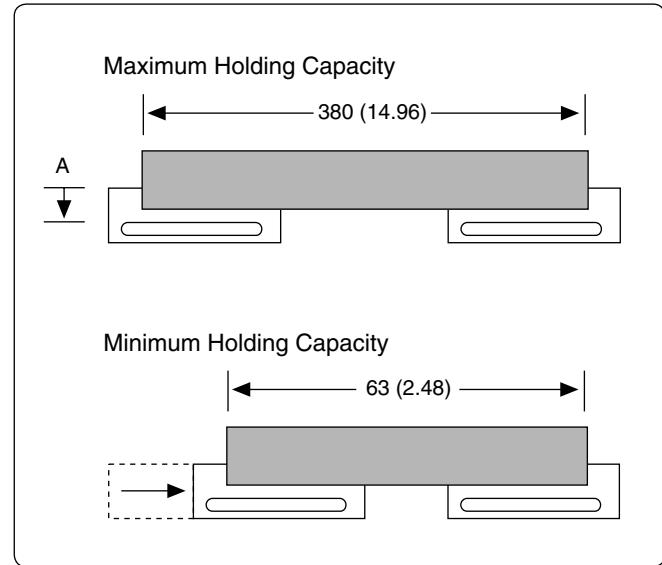
SYSTEM 5

Dual Station



Item Number	Description	A	Jaw Width
5DS1540-15-50	Standard	32 (1.26)	148 (5.83)
5DS1540-15-70	High	52 (2.05)	148 (5.83)
5DS1540-20-50	Wide	32 (1.26)	198 (7.80)
5DS1540-20-70	Oversized	52 (2.05)	198 (7.80)

Single Station



Item Number	Description	A	Jaw Width
5SS1540-15-50	Standard	32 (1.26)	148 (5.83)
5SS1540-15-70	High	52 (2.05)	148 (5.83)
5SS1540-20-50	Wide	32 (1.26)	198 (7.80)
5SS1540-20-70	Oversized	52 (2.05)	198 (7.80)

NOTES

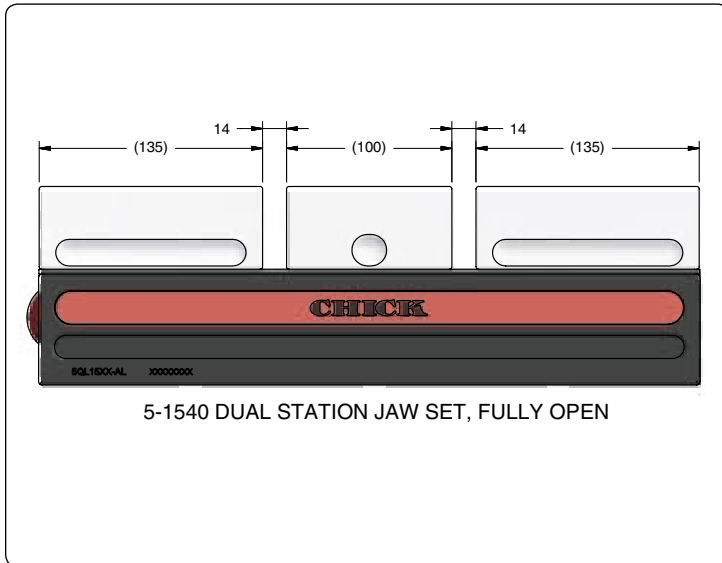
Dimensions are in mm (inches)

JAW TRAVEL

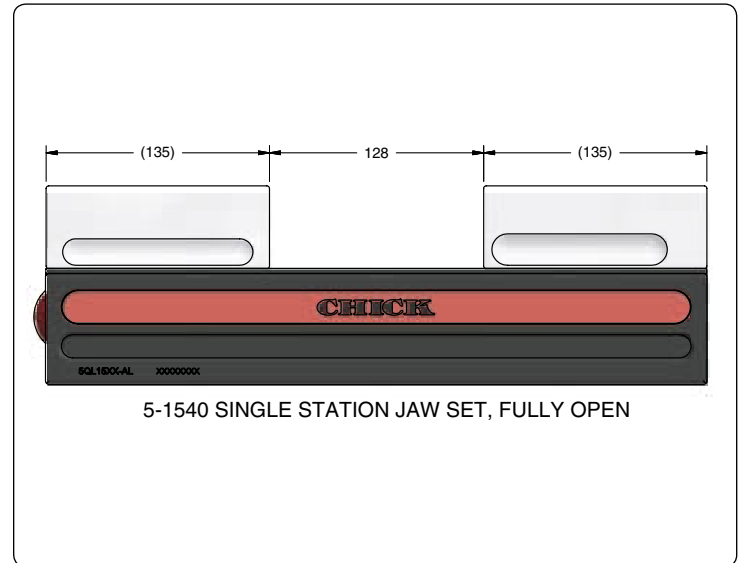
5 5QL1540-AL

SYSTEM 5

Dual Station



Single Station



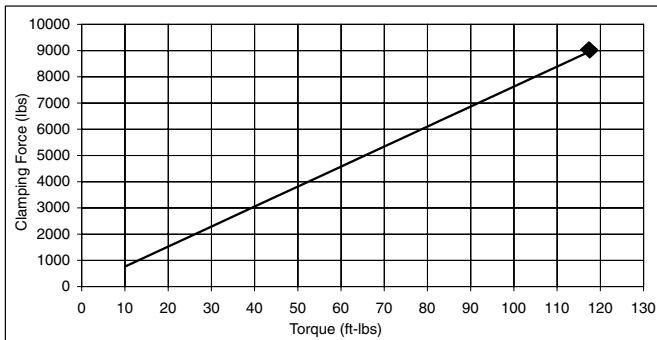
CLAMPING FORCE

5 5QL1540-AL SYSTEM 5

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

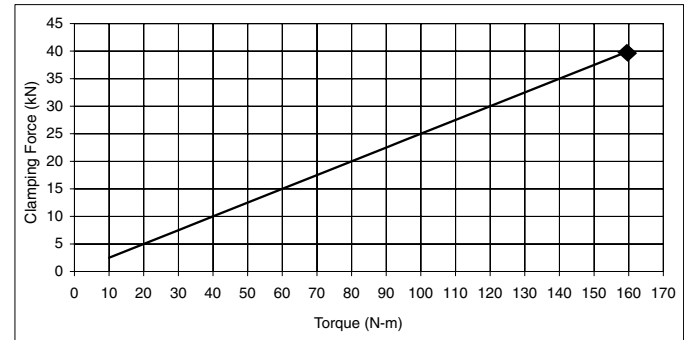


Note: ♦ Maximum Recommended Torque. Actual results may vary.

Kilo Newtons (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.