

## 5RP-HAAS-00302

This workholding package is designed for your HAAS Rotary HRT-210 machining center.



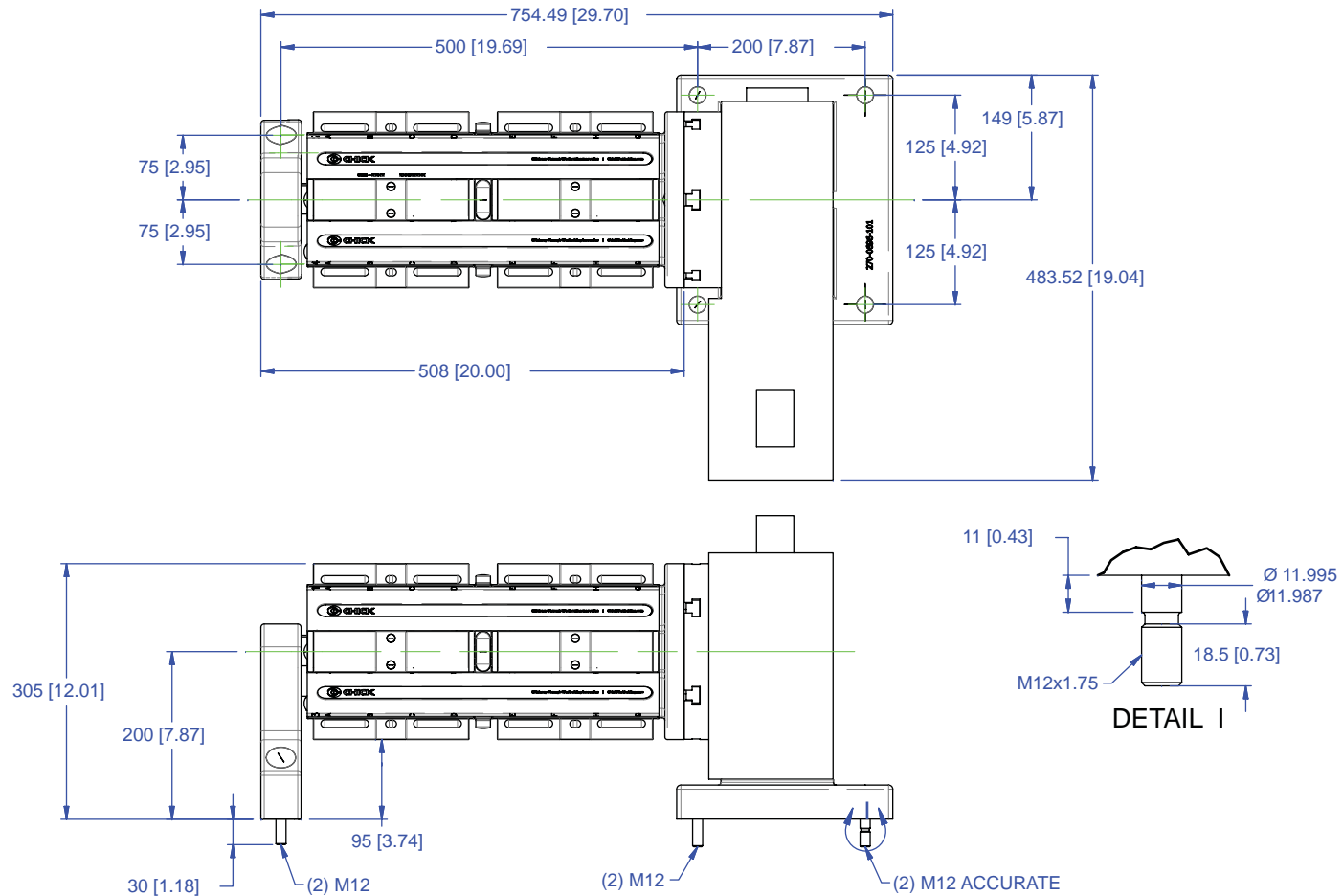
Workholding package includes all necessary mounting hardware. Must be coupled with a Chick Foundation that corresponds to your machine.

Notes

**CHICK WORKHOLDING SOLUTIONS, INC.**  
500 Keystone Drive • Warrendale, PA 15086 USA  
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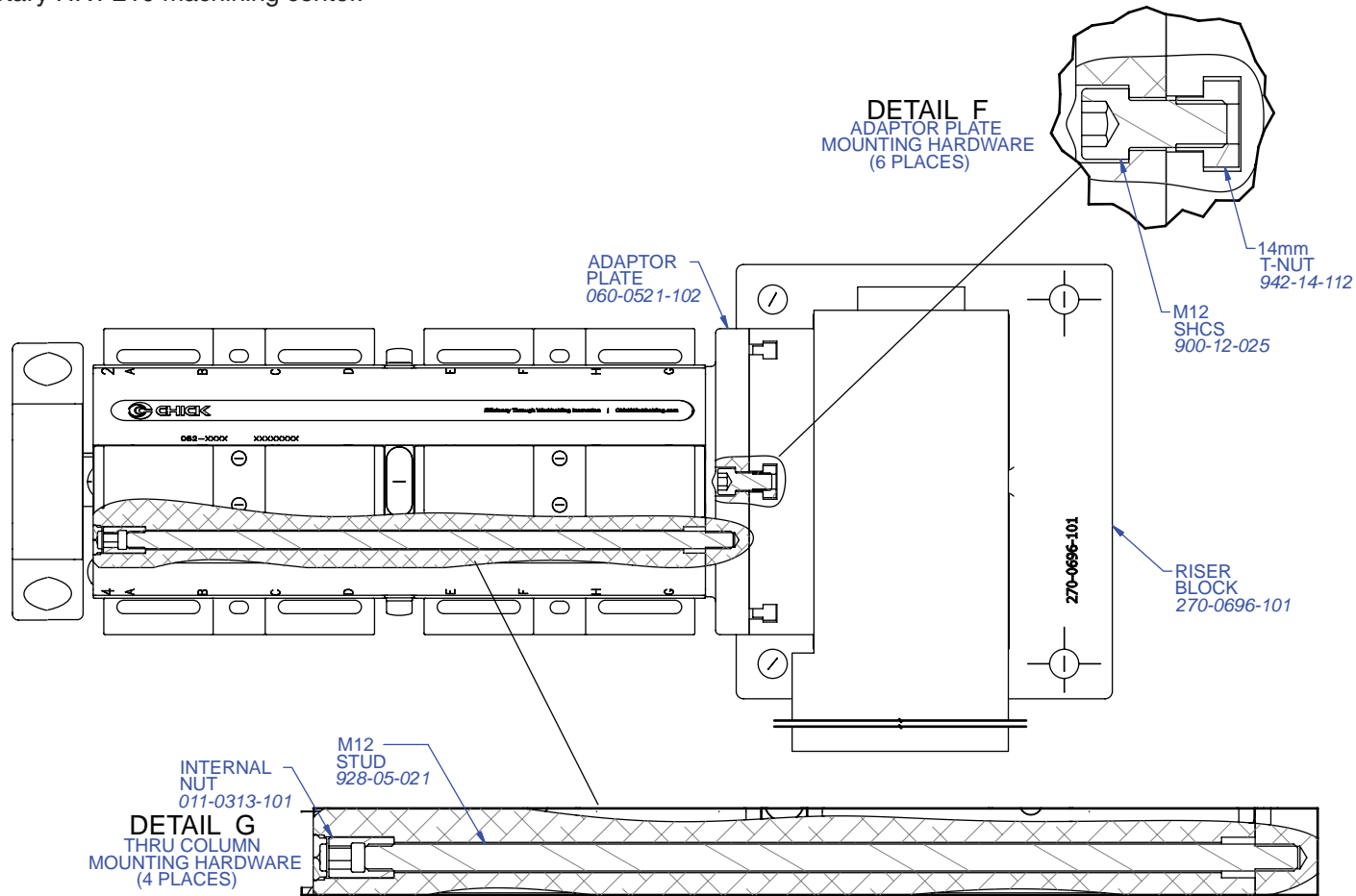
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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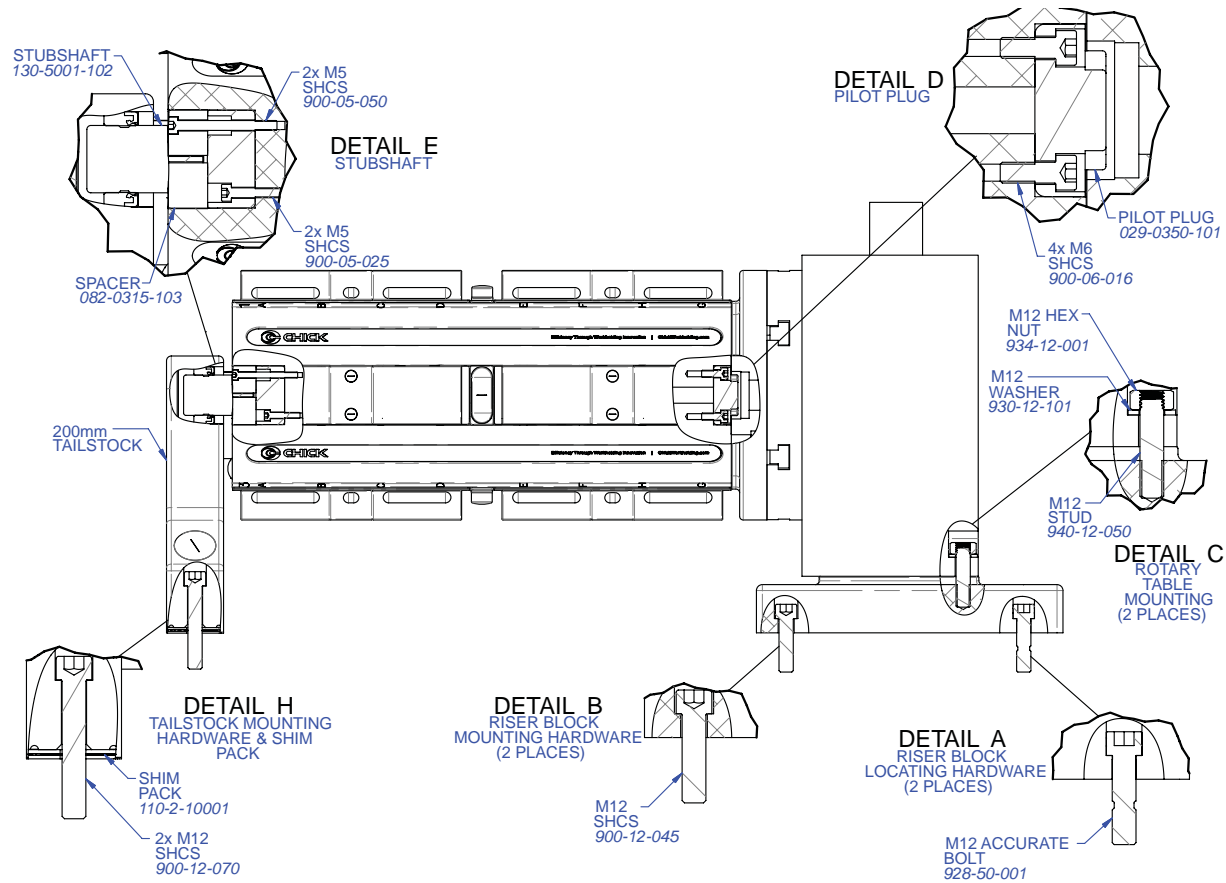


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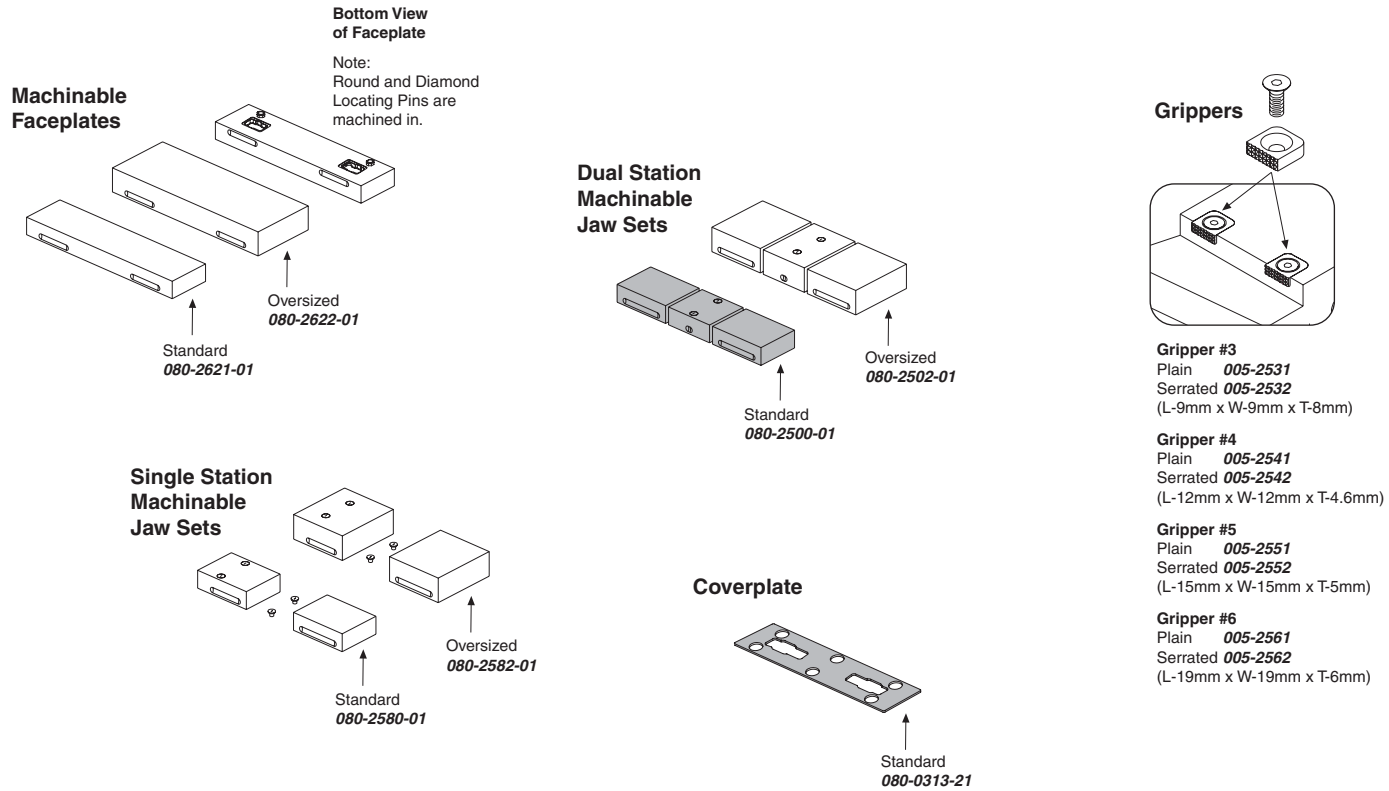


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## Batch Production

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**

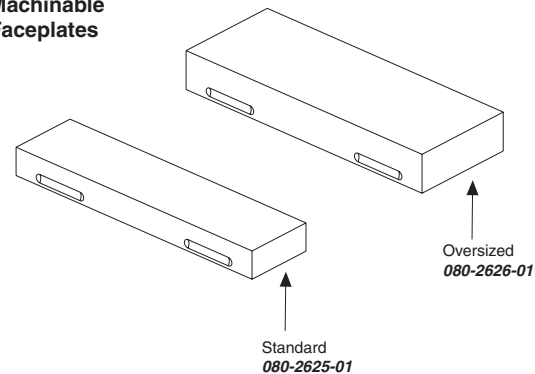
Grey item is included with a standard system

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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.

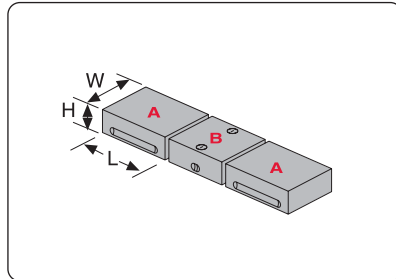
### Machinable Faceplates



Notes

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**QwikChange Machinable  
Dual Station Jaws**



**Individual Dual Station Jaws**

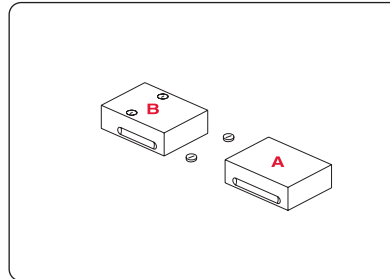
Standard

- 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

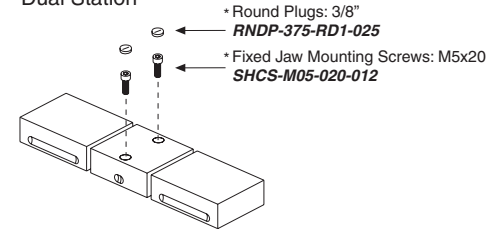
- A** Moveable Jaw ..... **080-2511-01**  
(W49mm, H25mm, L75mm)
- B** Fixed Jaw ..... **080-2571-01**  
(W49mm, H25mm, L75mm)

Oversized

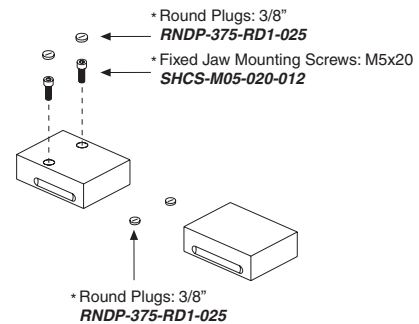
- A** Moveable Jaw ..... **080-2512-01**  
(W80mm, H35mm, L75mm)
- B** Fixed Jaw ..... **080-2575-01**  
(W80mm, H35mm, L75mm)

**Screws and Plugs**

**Dual Station**



**Single Station**

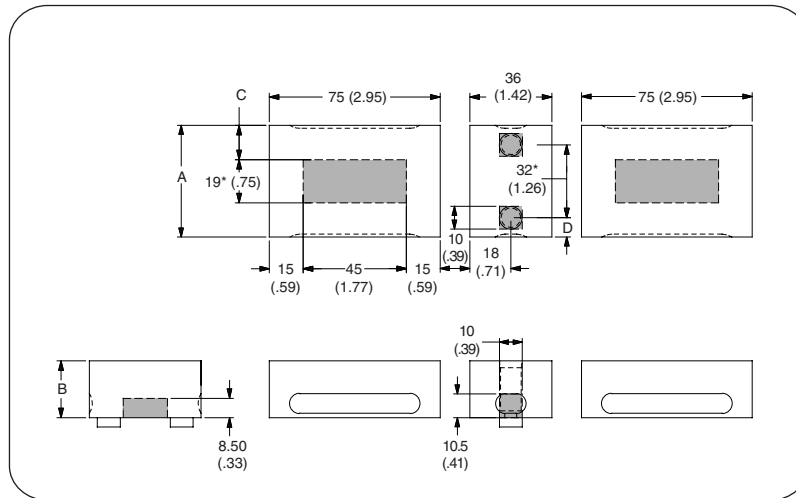


**Notes**

Grey or \* item is included with a standard system

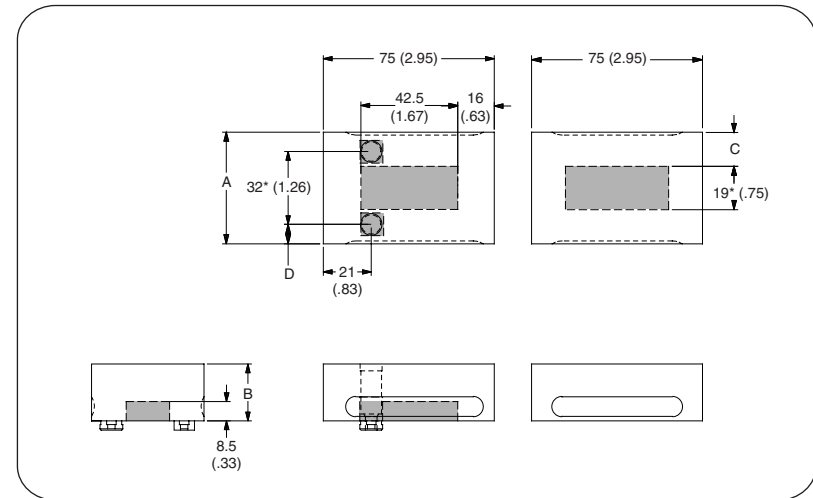
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Dual Station



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)

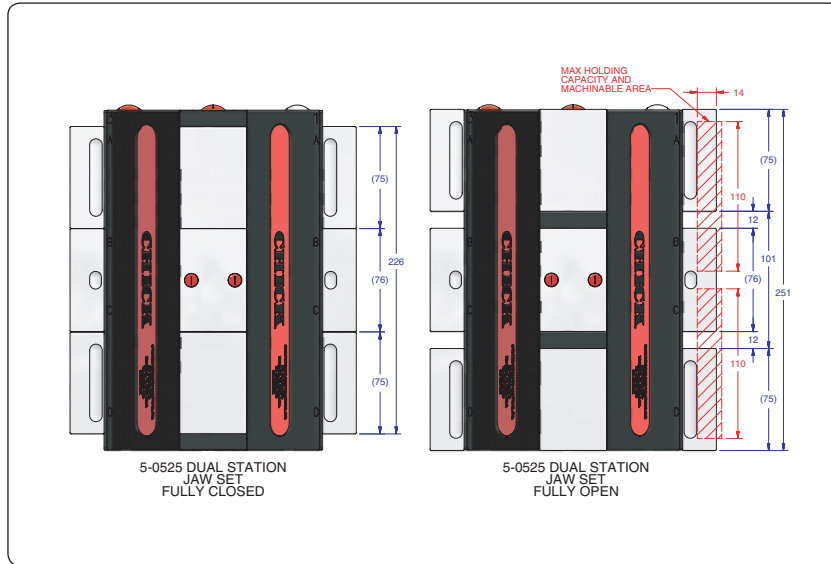
Notes

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

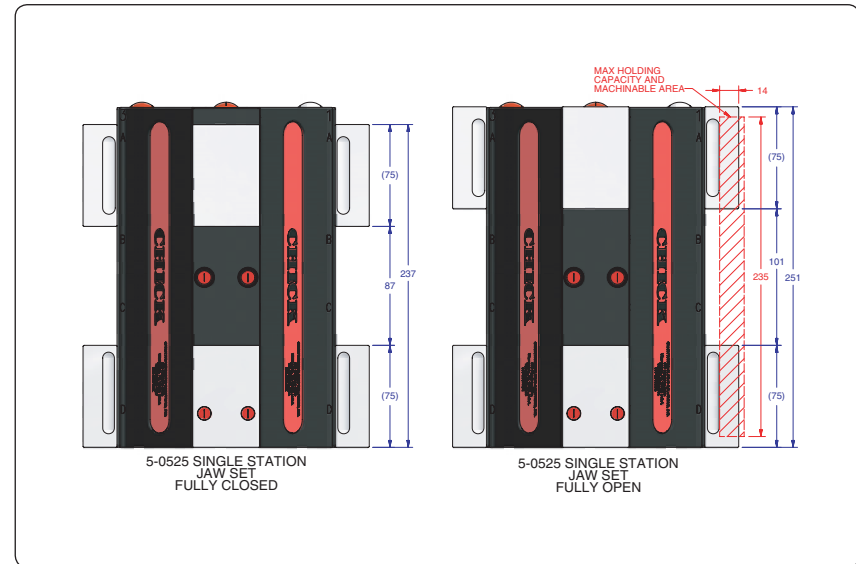
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**Dual Station**



**Single Station**



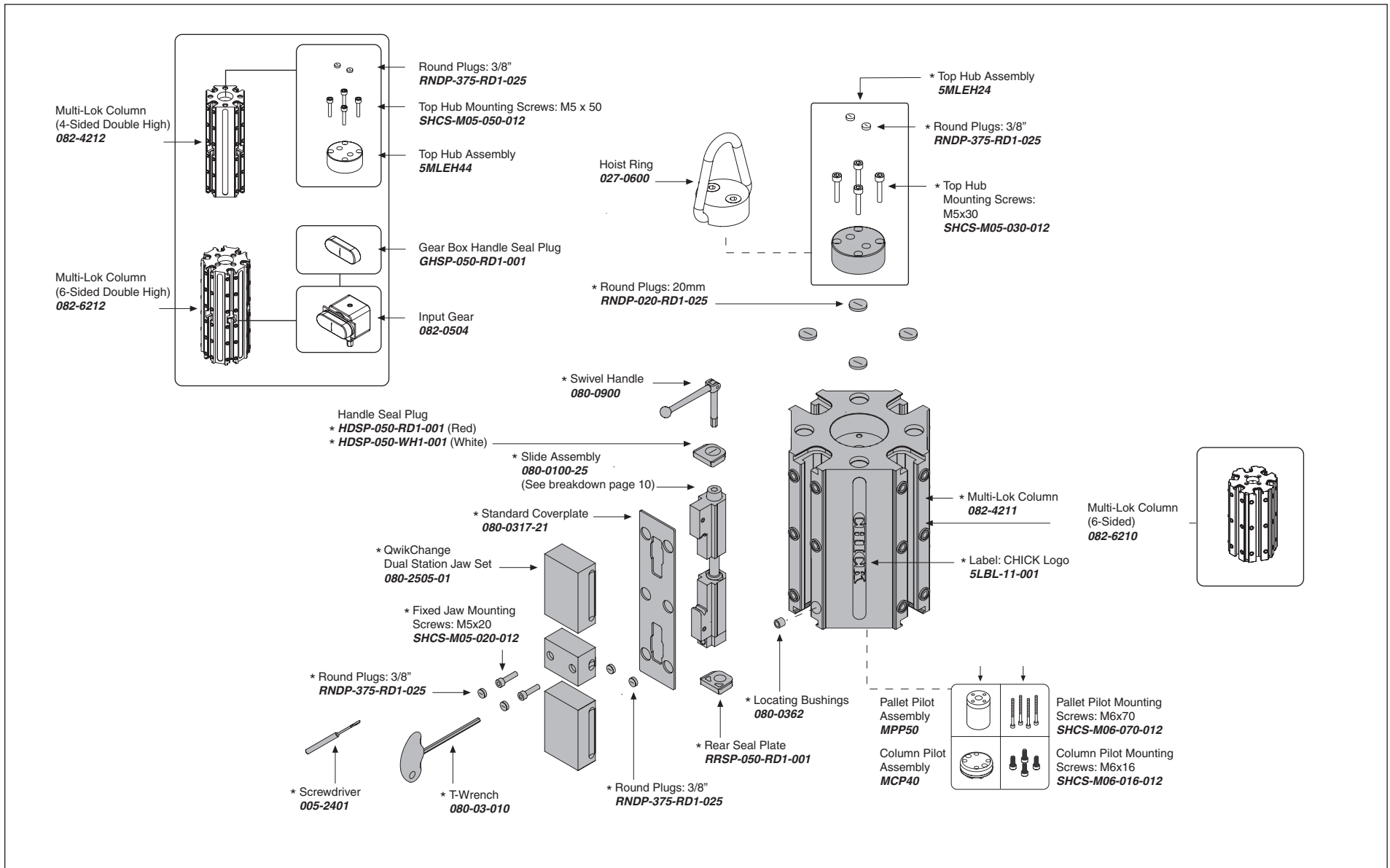
Item Number	Description	A	Jaw Width
<b>080-2500</b>	Standard	14 [0.57]	49 [1.93]
<b>080-2506</b>	Oversized	24 [0.96]	80 [3.15]

Item Number	Description	A	Jaw Width
<b>080-2580</b>	Standard	14 [0.57]	49 [1.93]
<b>080-2582</b>	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.

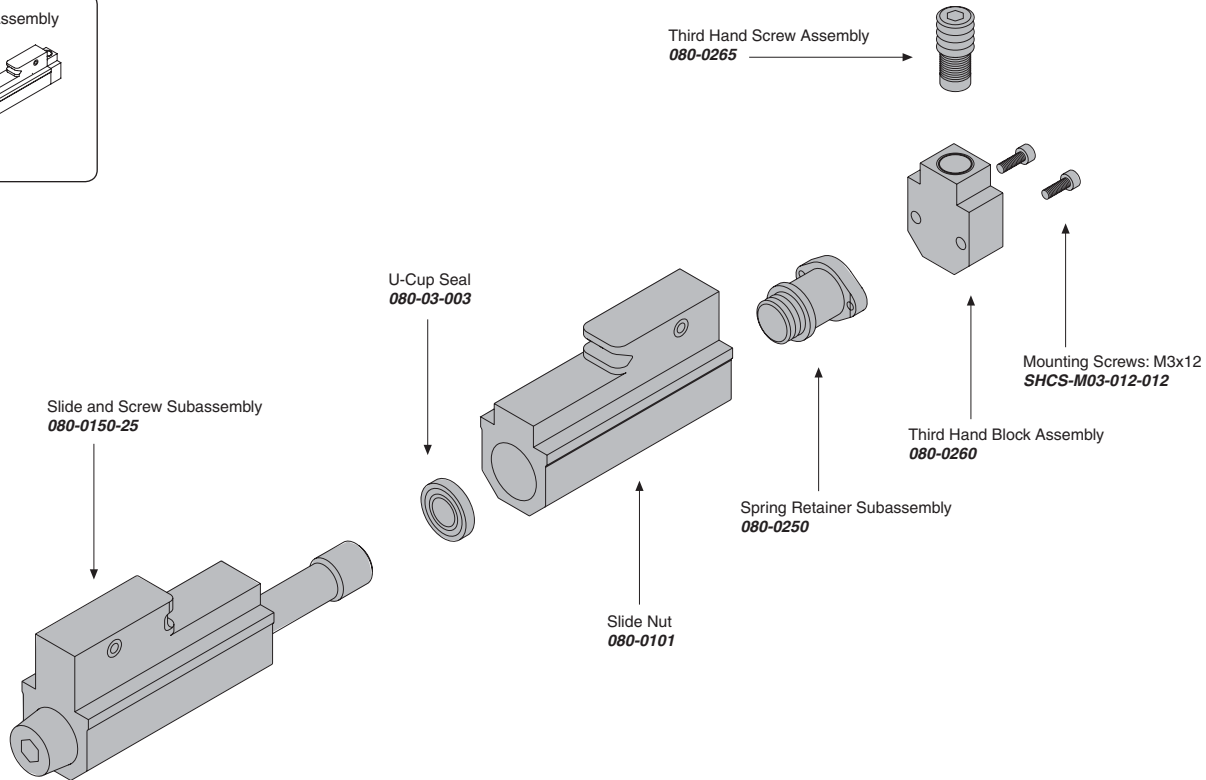
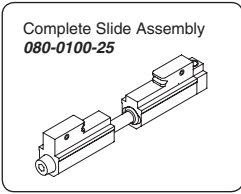
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### Notes

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

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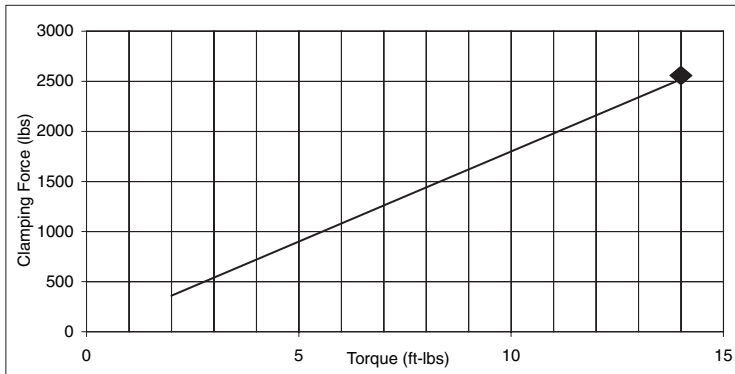
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**Pounds (lbs)**

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

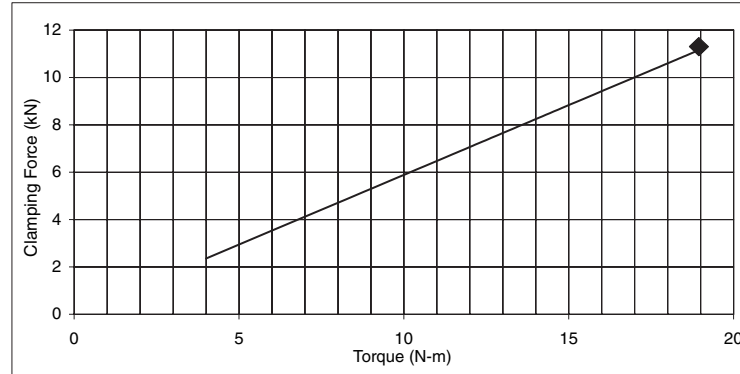


Note: ◆ Maximum Recommended Torque. Actual results may vary.

**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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