

THIS WORKHOLDING PACKAGE IS DESIGNED
FOR HAAS HRT160 & HRT160SP ROTARY TABLES

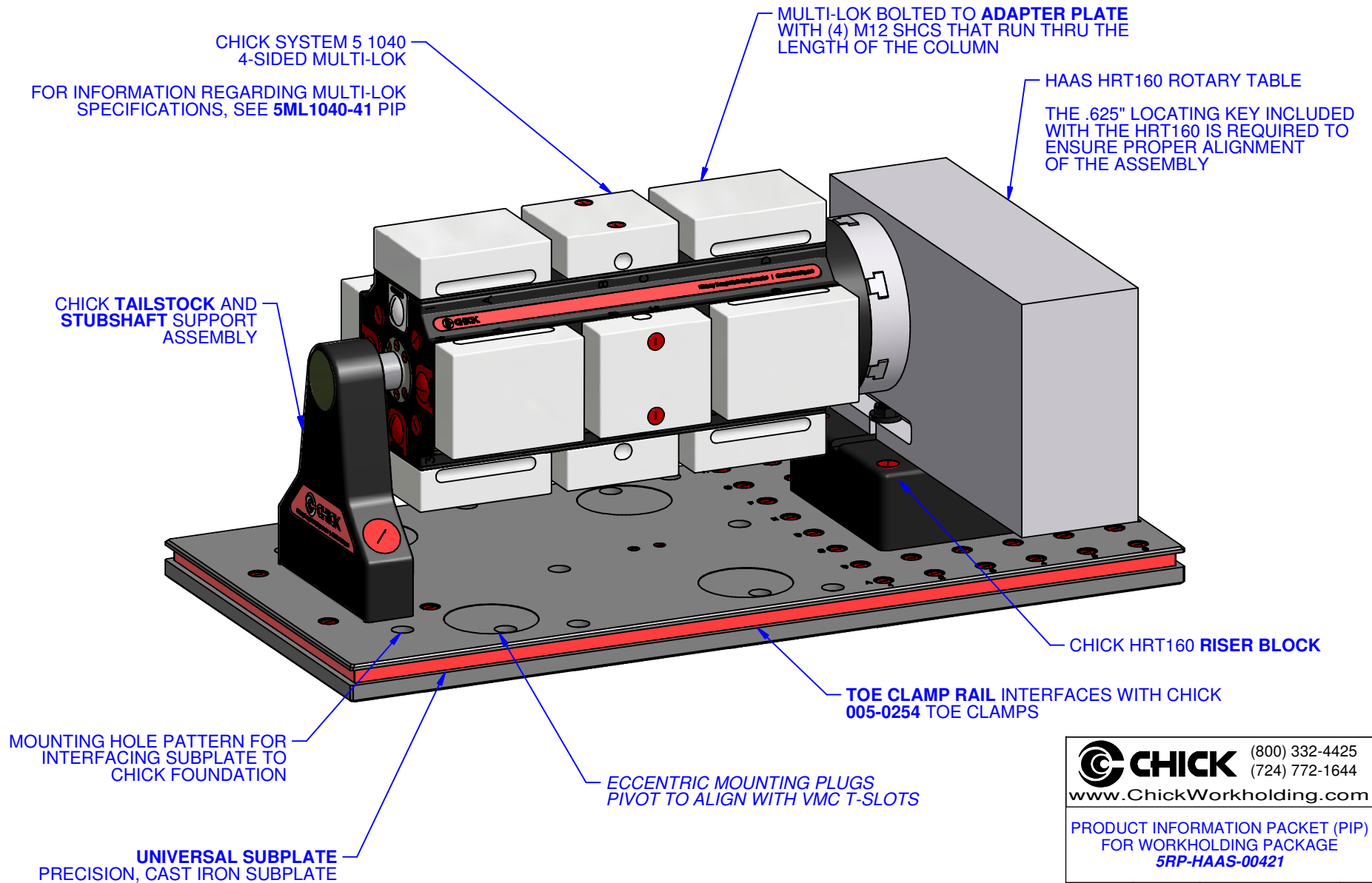
(ROTARY TABLE NOT INCLUDED WITH PACKAGE)

 **CHICK** (800) 332-4425
(724) 772-1644
www.ChickWorkholding.com

PRODUCT INFORMATION PACKET (PIP)
FOR WORKHOLDING PACKAGE
5RP-HAAS-00421

	1 OF 7	5RP-HAAS-00421	REV
2/12/2009		PIP	A

ALL COMPONENTS (EXCLUDING THE ROTARY TABLE)
REQUIRED FOR COMPLETE ASSEMBLY ARE INCLUDED
WITH THIS WORKHOLDING PACKAGE.

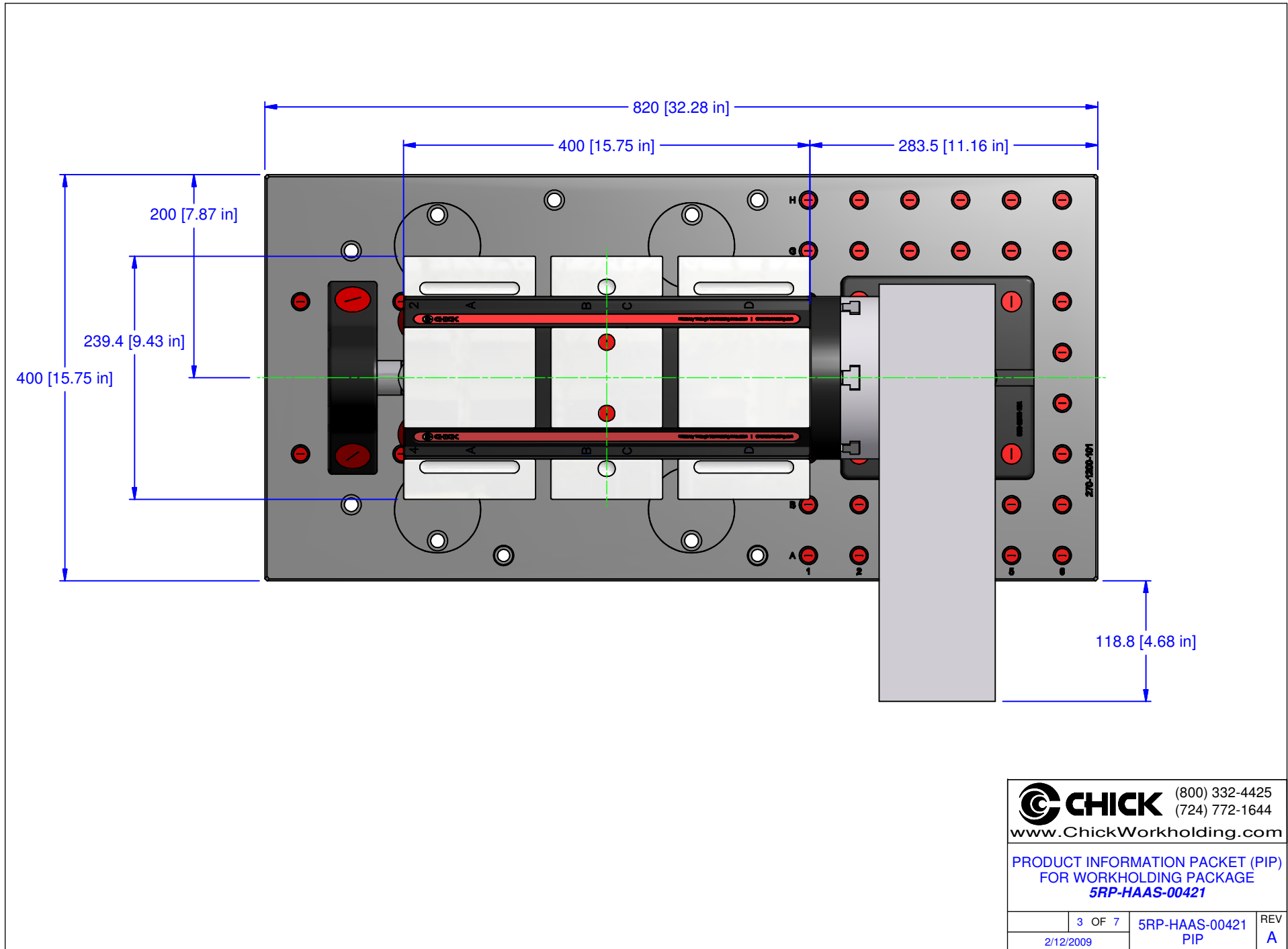


CHICK (800) 332-4425
(724) 772-1644
www.ChickWorkholding.com

PRODUCT INFORMATION PACKET (PIP)
FOR WORKHOLDING PACKAGE
5RP-HAAS-00421

	2 OF 7	5RP-HAAS-00421	REV
2/12/2009		PIP	A

DIMENSIONAL INFORMATION (TOP VIEW)

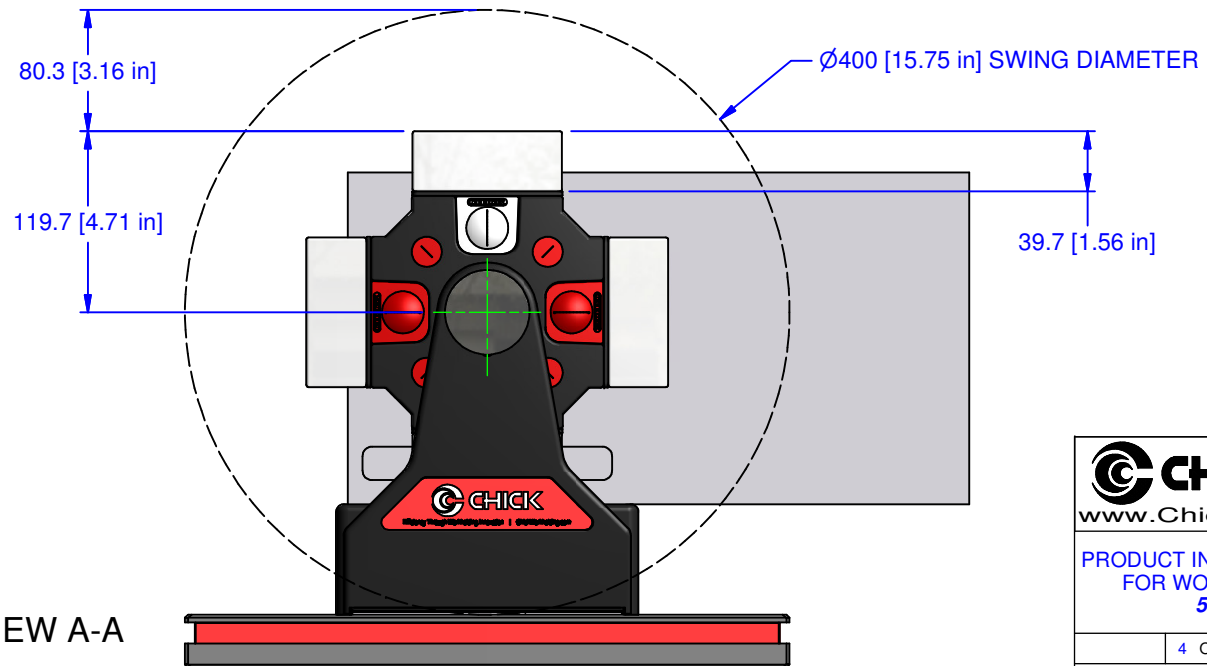
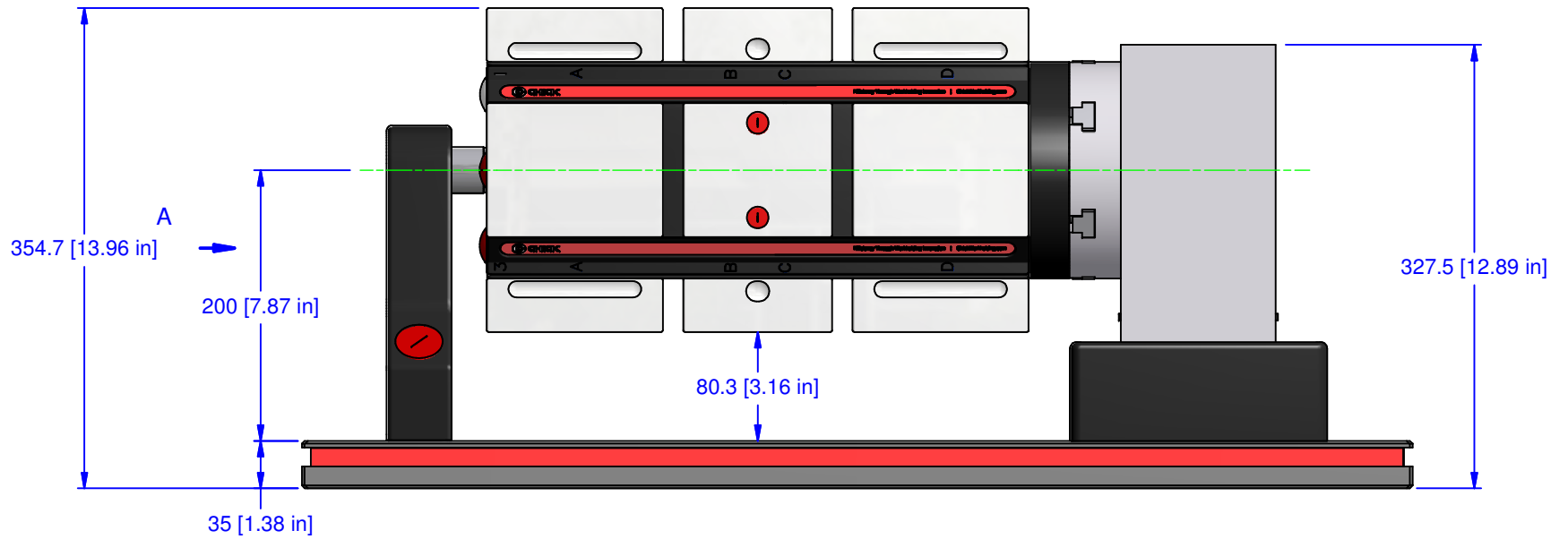



CHICK (800) 332-4425
 (724) 772-1644
www.ChickWorkholding.com

PRODUCT INFORMATION PACKET (PIP)
 FOR WORKHOLDING PACKAGE
5RP-HAAS-00421

3 OF 7	5RP-HAAS-00421	REV
2/12/2009	PIP	A

DIMENSIONAL INFORMATION (FRONT AND SIDE VIEW)



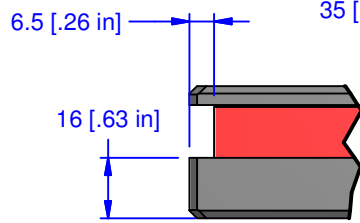
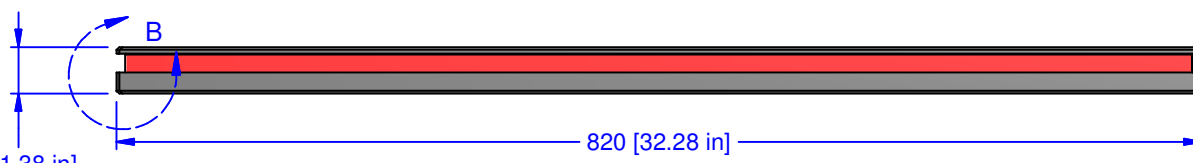
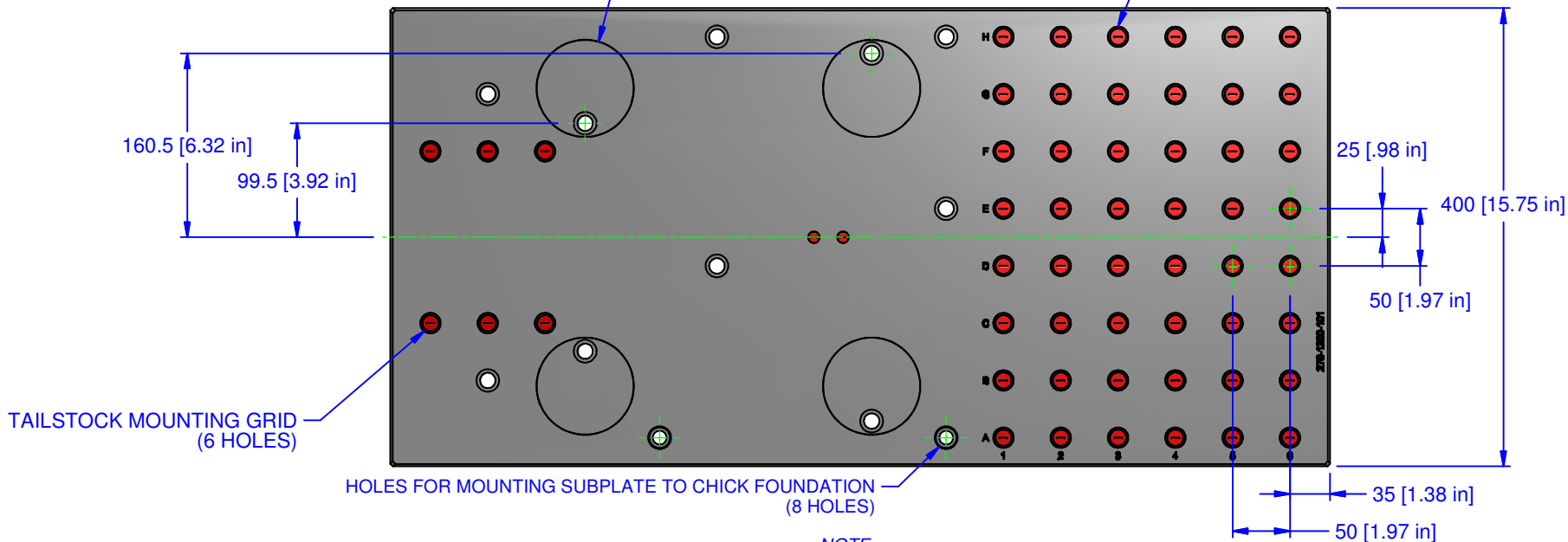
 CHICK (800) 332-4425 (724) 772-1644 www.ChickWorkholding.com		REV
PRODUCT INFORMATION PACKET (PIP) FOR WORKHOLDING PACKAGE 5RP-HAAS-00421		
2/12/2009	4 OF 7 5RP-HAAS-00421 PIP	

ECCENTRIC MOUNTING PLUGS (4 PLACES) PIVOT 360 DEGREES TO ALIGN WITH VMC TABLE'S T-SLOTS

1/2-13 OR M12 SHCS MAY BE USED

ROTARY TABLE MOUNTING GRID (48 HOLES)

FOR GRID INFORMATION, SEE CHICK FOUNDATION SPECS

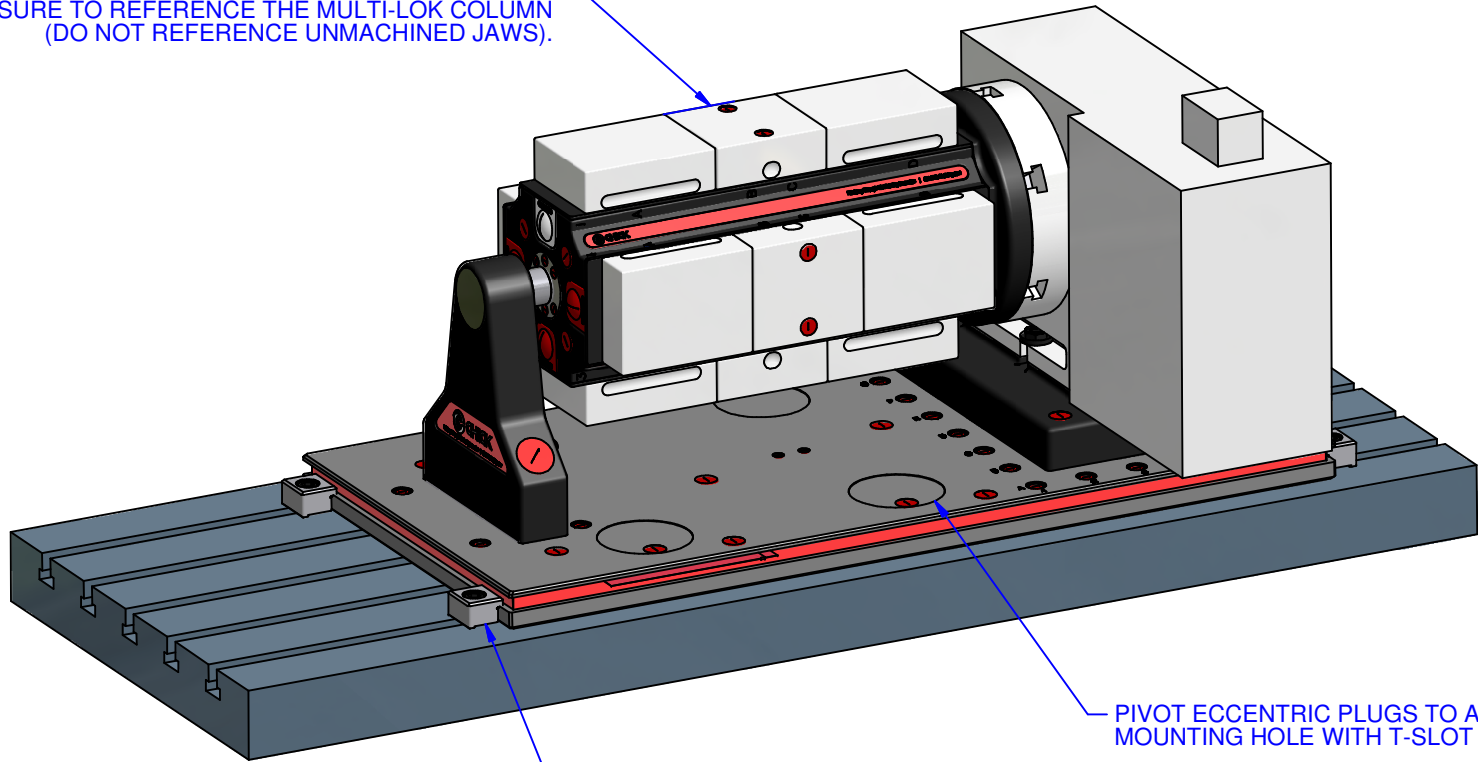


SUBPLATE MAY BE TOE CLAMPED WITH CHICK 005-0254 TOE CLAMPS WHEN INSTALLING ON EITHER T-SLOTTED TABLES OR CHICK FOUNDATIONS

		(800) 332-4425 (724) 772-1644
www.ChickWorkholding.com		
PRODUCT INFORMATION PACKET (PIP) FOR WORKHOLDING PACKAGE 5RP-HAAS-00421		
2/12/2009	5 OF 7 5RP-HAAS-00421 PIP	REV A

MOUNTING BOLTS AND T-NUTS REQUIRED FOR INSTALLATION TO A VMC TABLE ARE NOT INCLUDED WITH THE KIT.

WHEN ALIGNING THE SET-UP TO THE MACHINE AXES, BE SURE TO REFERENCE THE MULTI-LOK COLUMN (DO NOT REFERENCE UNMACHINED JAWS).



TOE CLAMP OUTSIDE EDGES

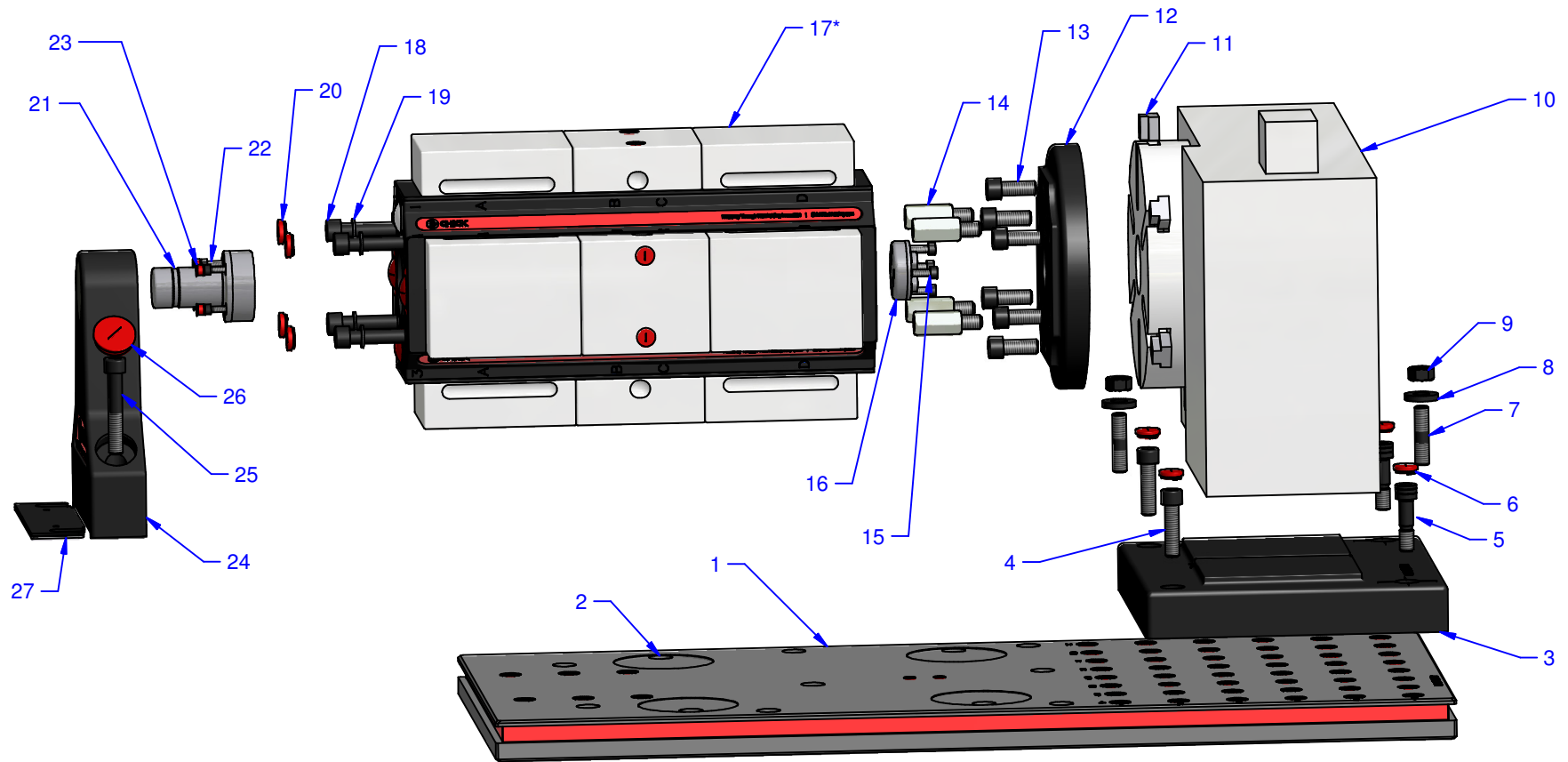
PIVOT ECCENTRIC PLUGS TO ALIGN MOUNTING HOLE WITH T-SLOT

THE SUBPLATE MAY BE MODIFIED WITH THE ADDITION OF A NEW MOUNTING HOLE PATTERN FOR UNIQUE INSTALLATION REQUIREMENTS

CHICK (800) 332-4425
(724) 772-1644
www.ChickWorkholding.com

PRODUCT INFORMATION PACKET (PIP)
FOR WORKHOLDING PACKAGE
5RP-HAAS-00421

	6 OF 7	5RP-HAAS-00421	REV
2/12/2009		PIP	



Parts ID			
Item	Part	Item	Part
1	Universal Subplate - 270-1200	15	SHCS - M6 X 16
2	Eccentric Mounting Plug	16	Column Pilot - 40mm
3	Riser Block - 060-0512-101	17	Multi-Lok - System 5 1040
4	SHCS - M12 X 45	18	SHCS - M12 X 200
5	Shoulder Bolt - M12 X 45	19	Washer - M12
6	Seal Plug - 18mm	20	Seal Plug - 18mm
7	Threaded Stud - M12 X 50	21	Stubshaft - 85mm Length
8	Washer - Hardened M12	22	SHCS - M5 X 35
9	Hex Nut - M12	23	Seal Plug - 9.5mm
10	Rotary Table - Haas HRT160	24	Tailstock - 200mm Center Height
11	T-Nut - Modified M12	25	SHCS - M12 X 70
12	Adapter Plate - 060-0123-102	26	Seal Plug - 35mm
13	SHCS - M12 X 30	27	Shim Pack
14	Coupler Nut - M12		

* For information on Multi-Lok, see 5ML1040-41 PIP

Order Numbers	
Parts	Item Number
1 - 2	270-1200
3 - 9	060-0512-101
11 - 13	060-0123-102
14, 18 - 19	102-4035
15 - 16	MCP40
17 - 20	5ML1040-41
21 - 23	SBSFT
24 - 27	110-0080-200

CHICK (800) 332-4425
 (724) 772-1644
www.ChickWorkholding.com

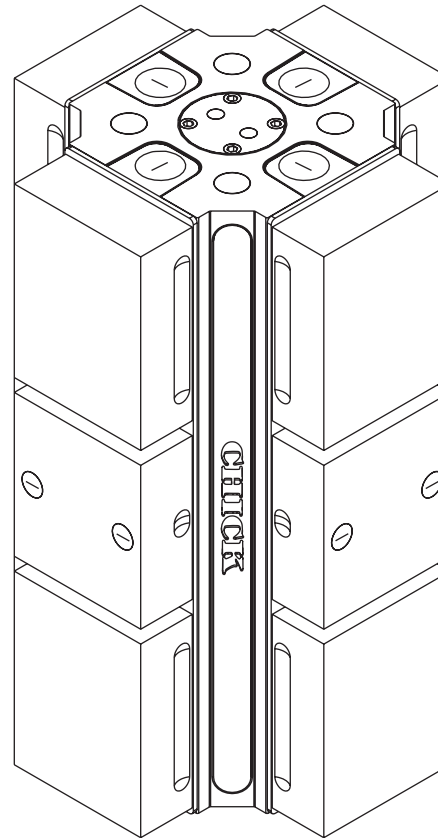
PRODUCT INFORMATION PACKET (PIP)
 FOR WORKHOLDING PACKAGE
5RP-HAAS-00421

7 OF 7	5RP-HAAS-00421	REV
2/12/2009	PIP	A

⑤ 5ML1040-41

SYSTEM 5

1040 Multi-Lok Product Information

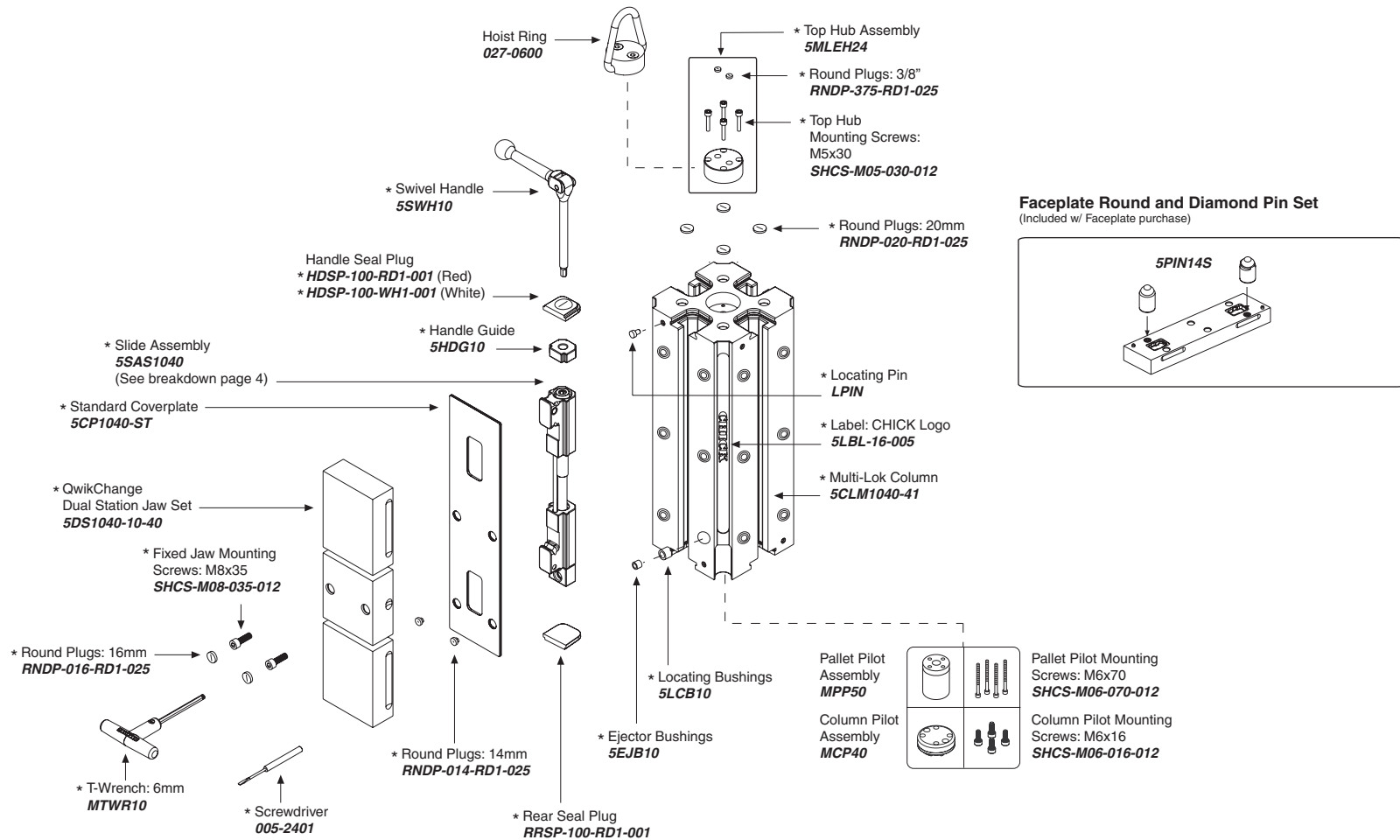


Notes

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

5 5ML1040-41

SYSTEM 5



Notes

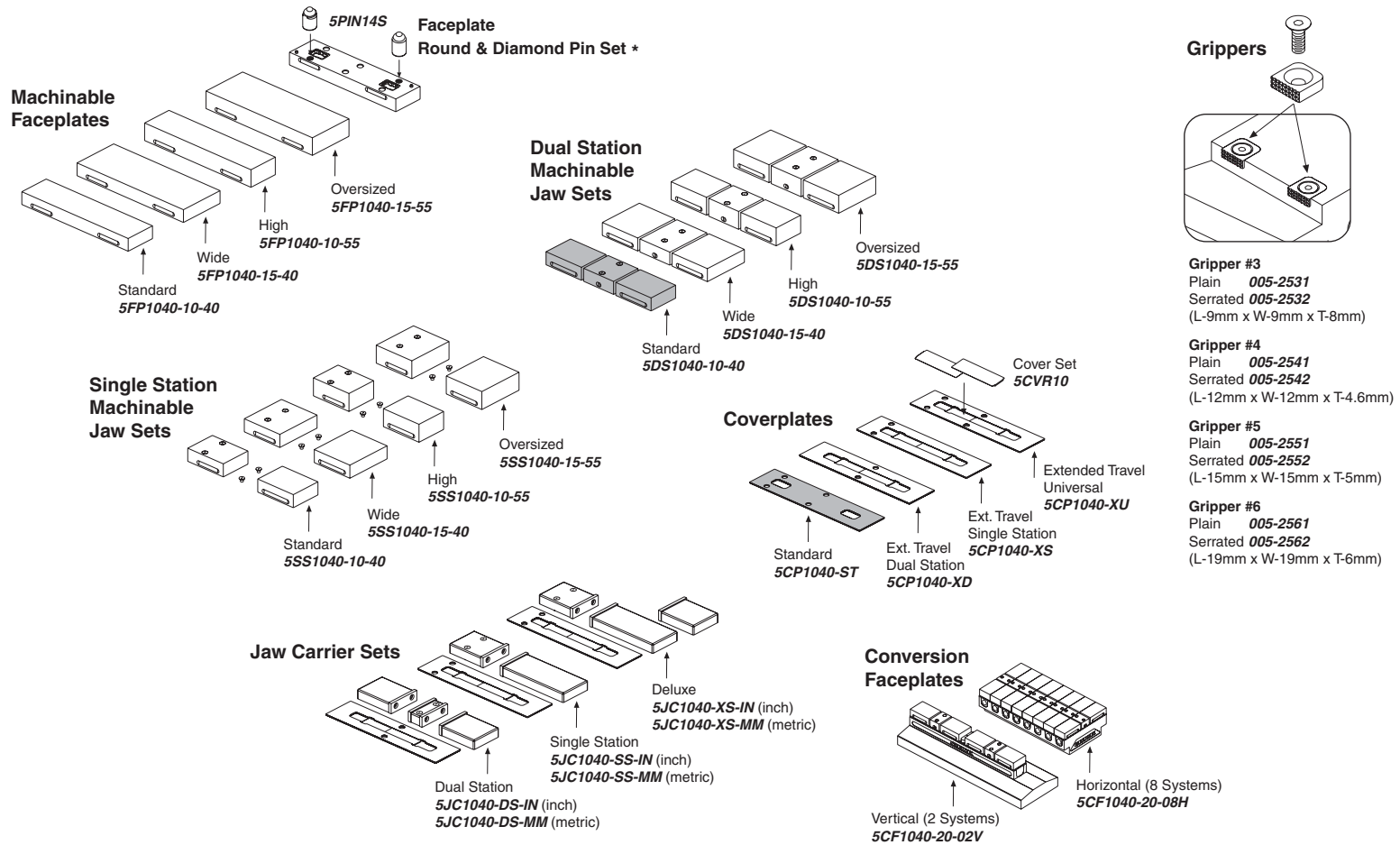
For QwikChange Jaw accessories, see pages 2-3

* Included in a standard 1040 Multi-Lok

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

5 5ML1040-41

SYSTEM 5



Notes

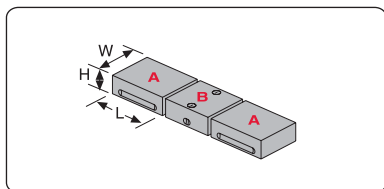
Grey item is included with a standard system

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

5 5ML1040-41

SYSTEM 5

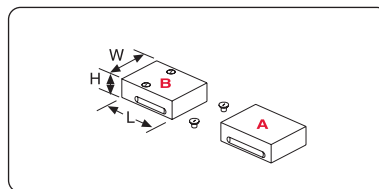
QwikChange Machinable Dual Station Jaws



Individual Dual Station Jaws

- Standard
A Moveable Jaw **5MJ1040-10-40**
 (W99mm, H40mm, L130mm)
B Fixed Jaw **5FJ1040-10-40**
 (W99mm, H40mm, L110mm)
- Wide
A Moveable Jaw **5MJ1040-15-40**
 (W148mm, H40mm, L130mm)
B Fixed Jaw **5FJ1040-15-40**
 (W148mm, H40mm, L110mm)
- High
A Moveable Jaw **5MJ1040-10-55**
 (W99mm, H55mm, L130mm)
B Fixed Jaw **5FJ1040-10-55**
 (W99mm, H55mm, L110mm)
- Oversized
A Moveable Jaw **5MJ1040-15-55**
 (W148mm, H55mm, L130mm)
B Fixed Jaw **5FJ1040-15-55**
 (W148mm, H55mm, L110mm)

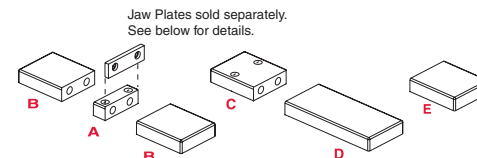
QwikChange Machinable Single Station Jaws



Individual Single Station Jaws

- Standard
A Moveable Jaw **5MJ1040-10-40**
 (W99mm, H40mm, L130mm)
B Fixed Jaw **5SJ1040-10-40**
 (W99mm, H40mm, L130mm)
- Wide
A Moveable Jaw **5MJ1040-15-40**
 (W148mm, H40mm, L130mm)
B Fixed Jaw **5SJ1040-15-40**
 (W148mm, H40mm, L130mm)
- High
A Moveable Jaw **5MJ1040-10-55**
 (W99mm, H40mm, L130mm)
B Fixed Jaw **5SJ1040-10-55**
 (W99mm, H40mm, L130mm)
- Oversized
A Moveable Jaw **5MJ1040-15-55**
 (W148mm, H40mm, L130mm)
B Fixed Jaw **5SJ1040-15-55**
 (W148mm, H40mm, L130mm)

QwikChange Jaw Carriers



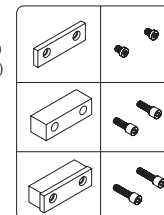
- | Jaw Carriers (Inch) | Jaw Carriers (Metric) |
|------------------------|------------------------|
| A 5JC1040-FC-IN | A 5JC1040-FC-MM |
| B 5JC1040-MC-IN | B 5JC1040-MC-MM |
| C 5JC1040-SC-IN | C 5JC1040-SC-MM |
| D 5JC1040-LM-IN | D 5JC1040-LM-MM |
| E 5JC1040-SM-IN | E 5JC1040-SM-MM |

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

Jaw Plates

- Standard (Set of 4)
JH4STD (Inch)
MJH10 (Metric)

HARD JAW PLATES



- Standard Mounting Screws:
 3/8-16x1/2"
LHCS-375-050-008 (Inch)
LHCS-M08-016-008 (Metric)

- Thick (Set of 2)
JH4THK

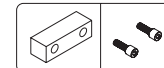
- Thick Mounting Screws:
 3/8-16x1"
SHCS-375-100-012

- Both Sizes
JH4STD &
JH4THK

- Both Sizes Mounting Screws:
 3/8-16x1.25"
SHCS-375-125-008

- Standard (Set of 4)
JS4AL

SOFT JAW PLATES

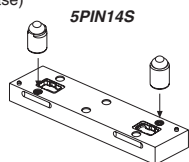


- Soft Mounting Screws:
 3/8-16x1"
SHCS-375-100-012

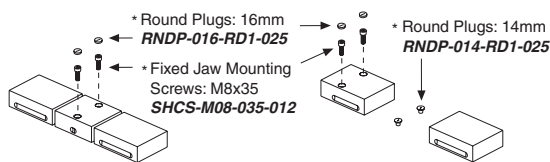
Faceplate Round & Diamond Pin Set

(Included w/ Faceplate purchase)

Required for both Machinable and Conversion Faceplates.



Screws and Plugs



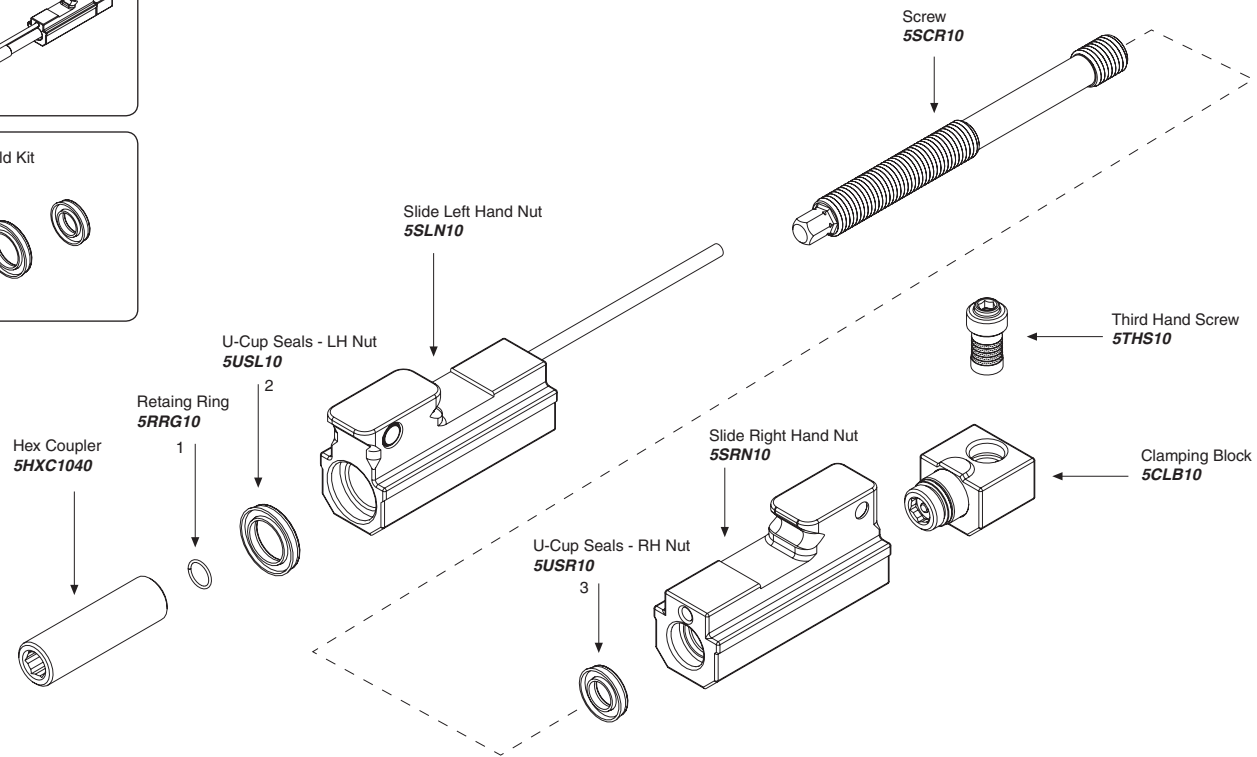
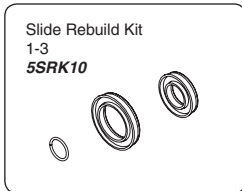
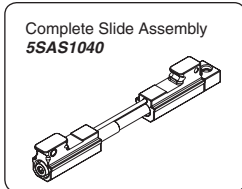
Notes

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

5 5ML1040-41

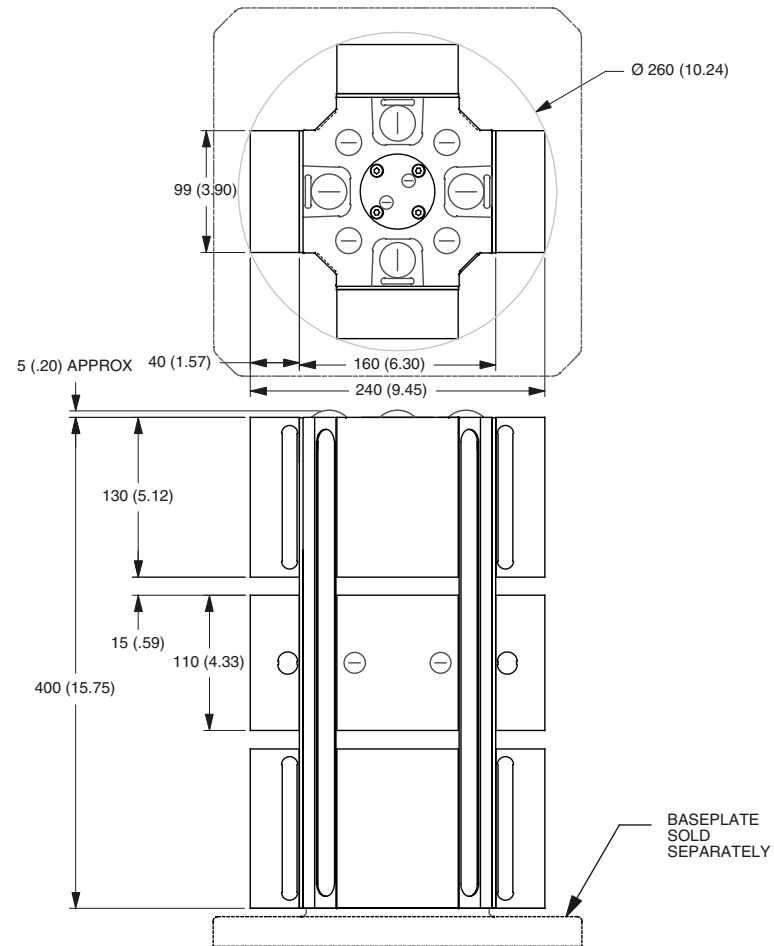
SYSTEM 5



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

5 5ML1040-41
SYSTEM 5



Notes

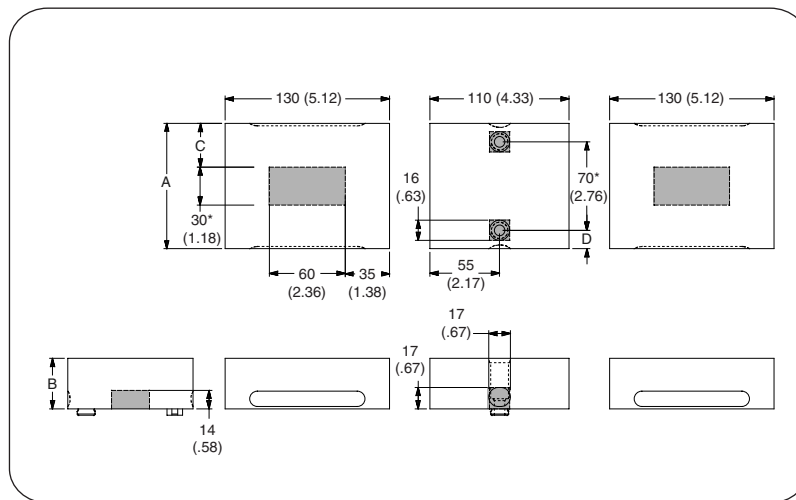
Dimensions are in mm (inches)
 Dimensions include standard Dual Station Machinable Jaw Sets.
 System weight: 47kg. (103lbs.)

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

5 5ML1040-41

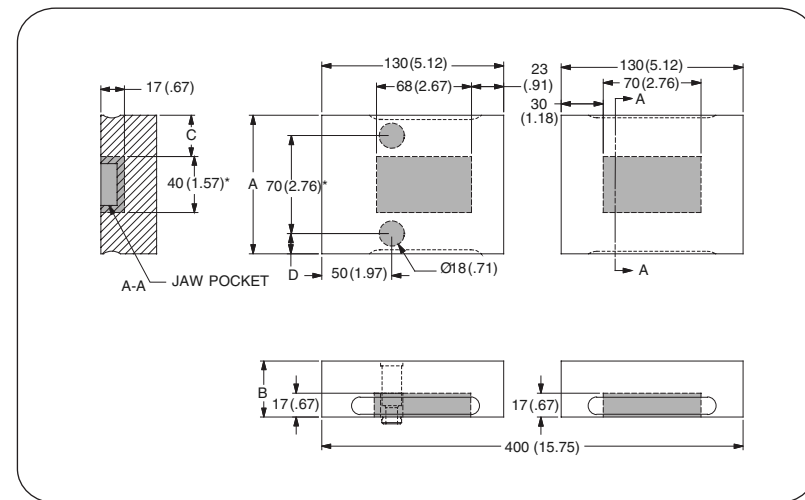
SYSTEM 5

Dual Station



Item Number	Description	A	B	C	D
5DS1040-10-40	Standard	99 (3.90)	40 (1.57)	34.5 (1.36)	14.5 (.57)
5DS1040-10-55	High	99 (3.90)	55 (2.17)	34.5 (1.36)	14.5 (.57)
5DS1040-15-40	Wide	148 (5.83)	40 (1.57)	59 (2.32)	39 (1.54)
5DS1040-15-55	Oversized	148 (5.83)	55 (2.17)	59 (2.32)	39 (1.54)

Single Station



Item Number	Description	A	B	C	D
5SS1040-10-40	Standard	99 (3.90)	40 (1.57)	29.5 (1.16)	14.5 (.57)
5SS1040-10-55	High	99 (3.90)	55 (2.17)	29.5 (1.16)	14.5 (.57)
5SS1040-15-40	Wide	148 (5.83)	40 (1.57)	54 (2.13)	39 (1.54)
5SS1040-15-55	Oversized	148 (5.83)	55 (2.17)	54 (2.13)	39 (1.54)

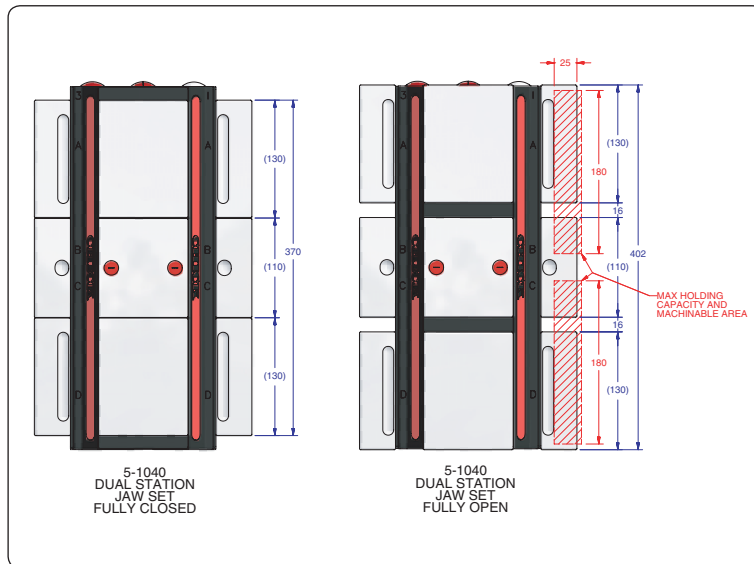
Notes

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

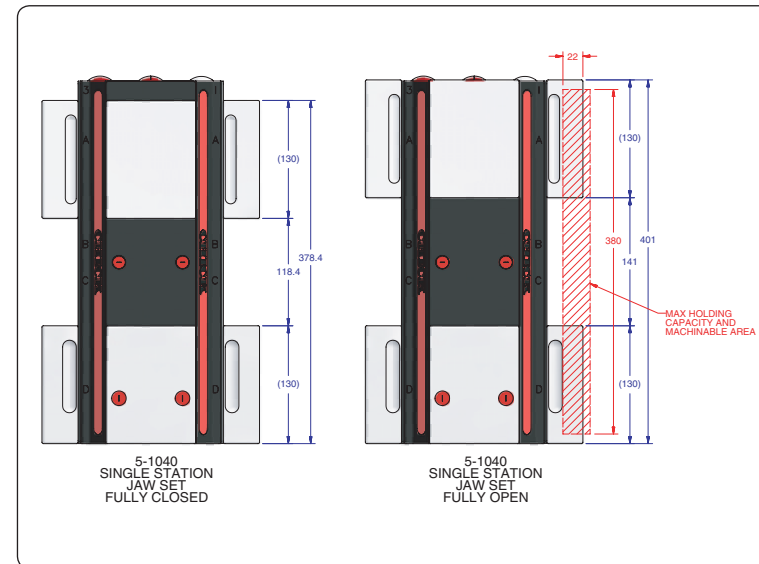
5 5ML1040-41 SYSTEM 5

Dual Station



Item Number	Description	A	Jaw Width
5DS1040-10-40	Standard	26 (1.02)	99 (3.90)
5DS1040-10-55	High	41 (1.61)	99 (3.90)
5DS1040-15-40	Wide	26 (1.02)	148 (5.83)
5DS1040-15-55	Oversized	41 (1.61)	148 (5.83)

Single Station



Item Number	Description	A	Jaw Width
5DS1040-10-40	Standard	26 (1.02)	99 (3.90)
5DS1040-10-55	High	41 (1.61)	99 (3.90)
5DS1040-15-40	Wide	26 (1.02)	148 (5.83)
5DS1040-15-55	Oversized	41 (1.61)	148 (5.83)

Notes

All dimensions are MM [IN]
 * Additional closure is available with an Extended Travel Coverplate.

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

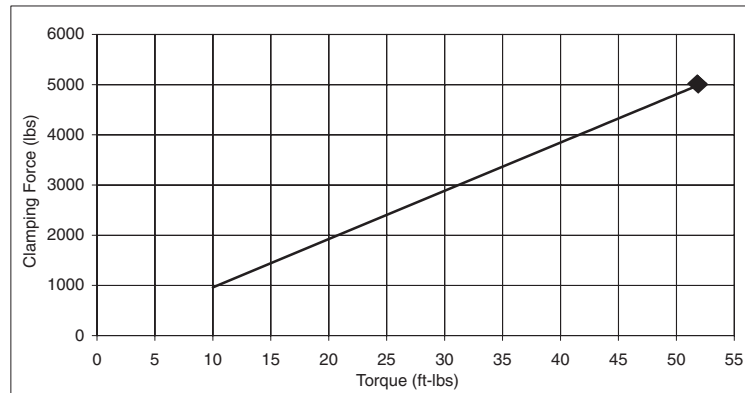
5 5ML1040-41

SYSTEM 5

Pounds (lbs)

Force	=	Torque	X	Slope
lbs	=	in-lb	x	8.0
lbs	=	ft-lbs	x	96

Torque (ft-lb)	Force (lbs)
0	0
10	962
20	1923
30	2885
40	3846
50	4808
52	5000

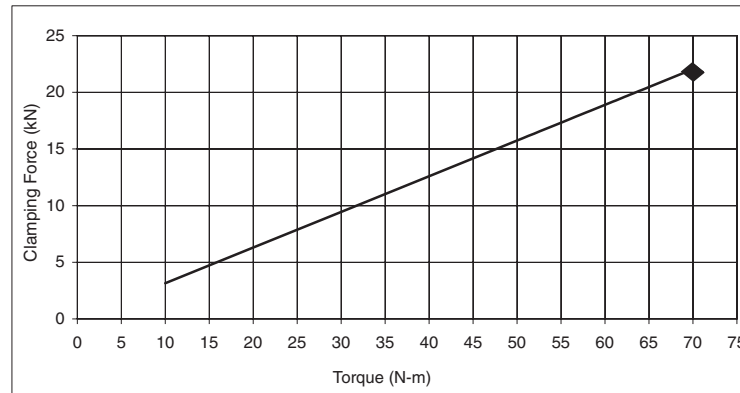


Note:  Maximum Recommended Torque. Actual results may vary.

Kilo Newtons (kN)

Force	=	Torque	X	Slope
N	=	N-m	x	315
kN	=	N-m	x	0.315

Torque (N-m)	Force (kN)
0	0.0
10	3.1
20	6.3
30	9.4
40	12.6
50	15.7
60	18.9
65	20.5
70	22.0



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