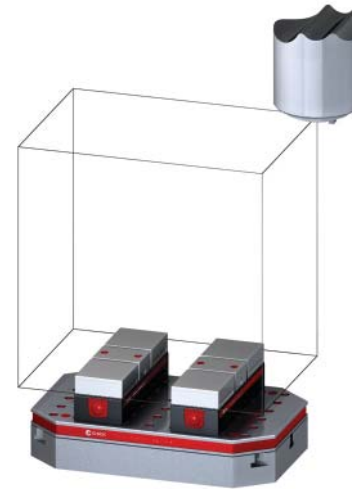


## 5VP-HAAS-00015

This workholding package is designed for your HAAS MDC-500 machining center.



Workholding package



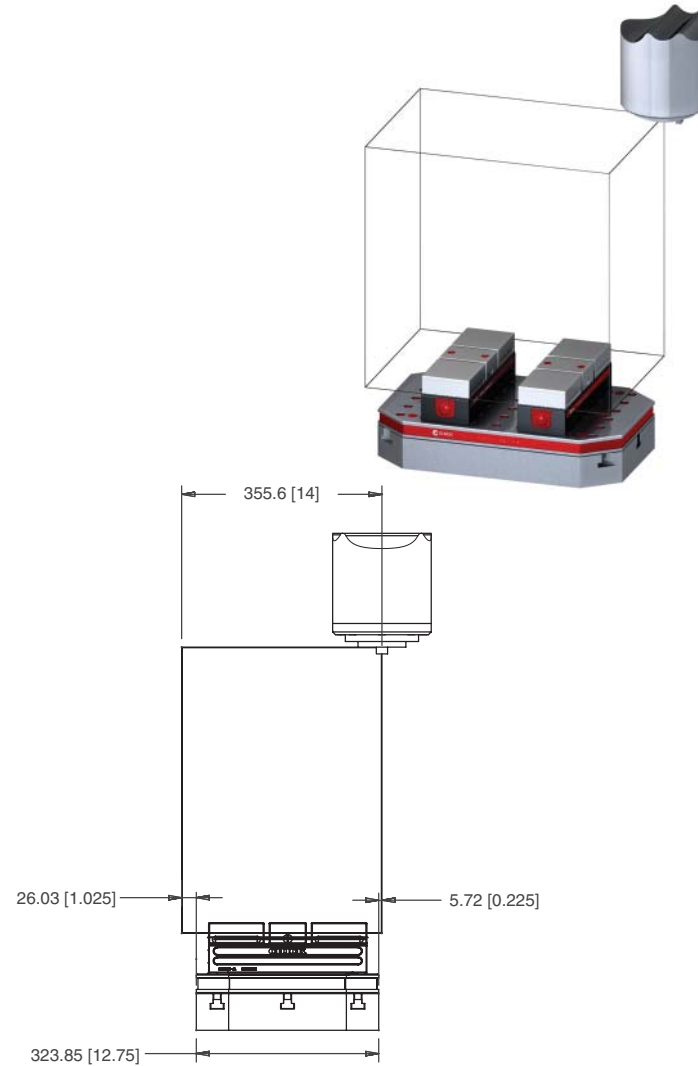
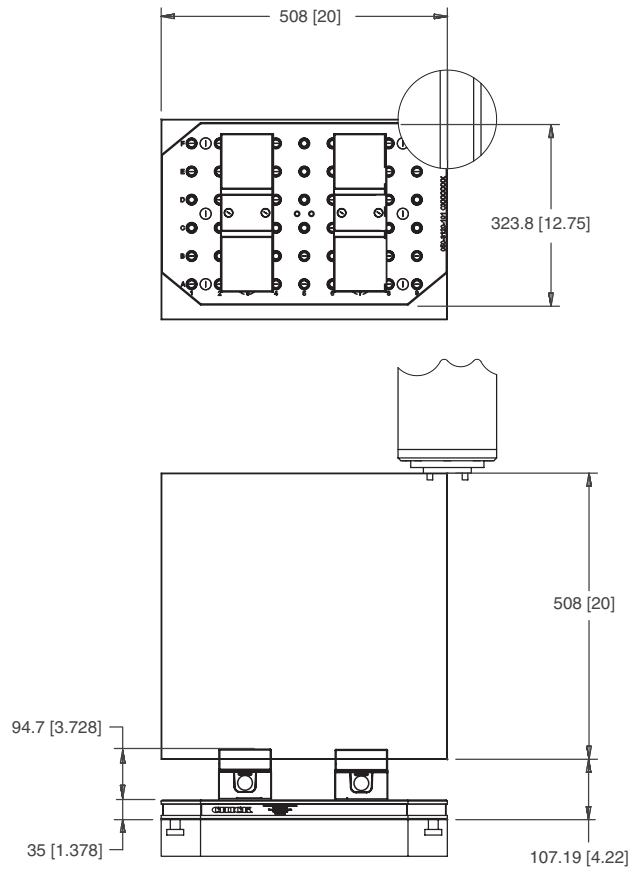
Workholding package  
in machine envelope

Notes

**CHICK WORKHOLDING SOLUTIONS, INC.**  
500 Keystone Drive • Warrendale, PA 15086 USA  
Phone: (724) 772-1644 • Fax: (724) 772-1633  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

# 5VP-HAAS-00015

This workholding package is designed for your HAAS MDC-500 machining center.



**Notes**

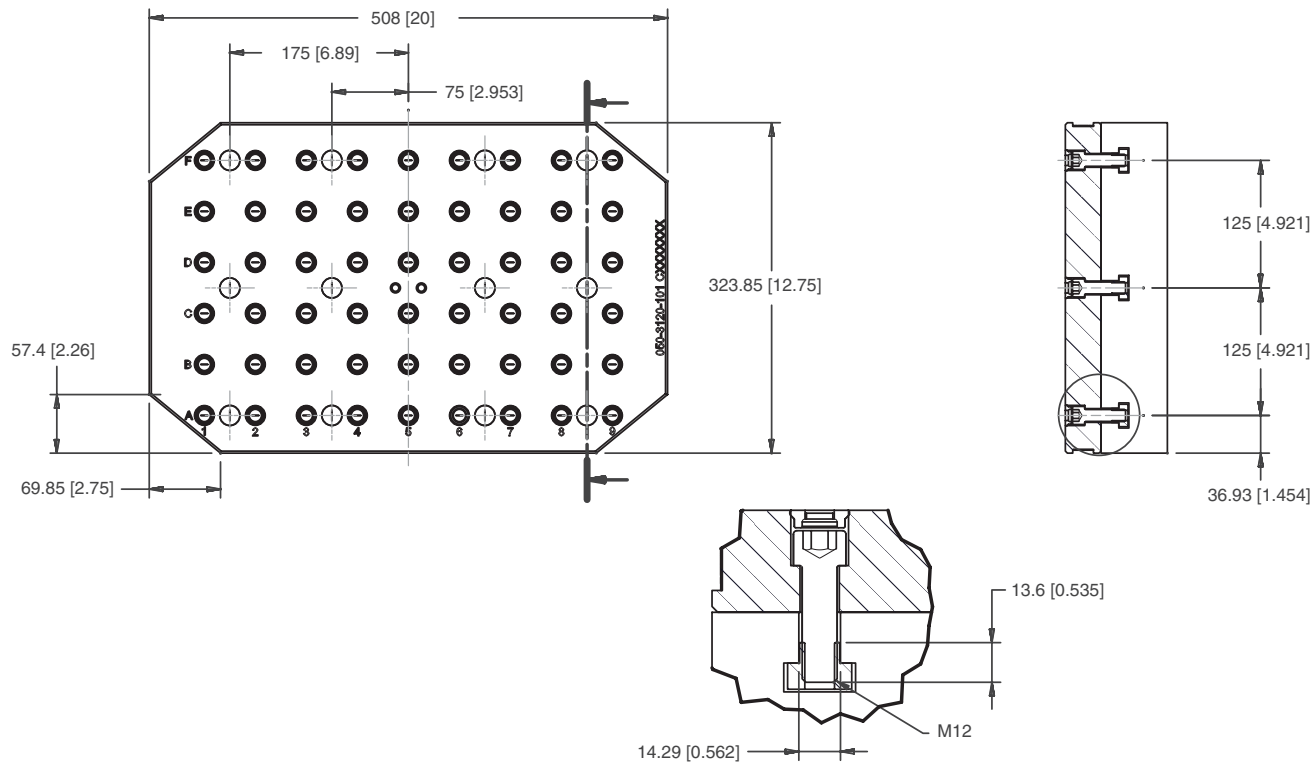
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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# 5VP-HAAS-00015

This workholding package is designed for your HAAS MDC-500 machining center.



Notes  
All dimensions are MM [IN]

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# 5VP-HAAS-00015

This workholding package is designed for your HAAS MDC-500 machining center.

FOUNDATION LENGTH, DEPTH, AND MOUNTING HOLE CONFIGURATION DESIGNED ACCORDING TO MACHINE TOOL SPECIFICATION



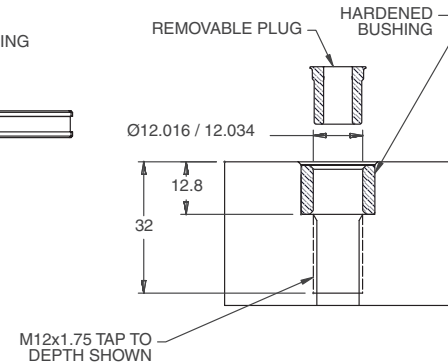
FOUNDATION MAT'L: CAST IRON  
FOUNDATION INCLUDES INSTALLATION HARDWARE

**DETAIL A**



HOLE SPACING TOLERANCE  
±0.02 TO 500mm  
±0.03 TO 1200mm

**SECTION B-B**

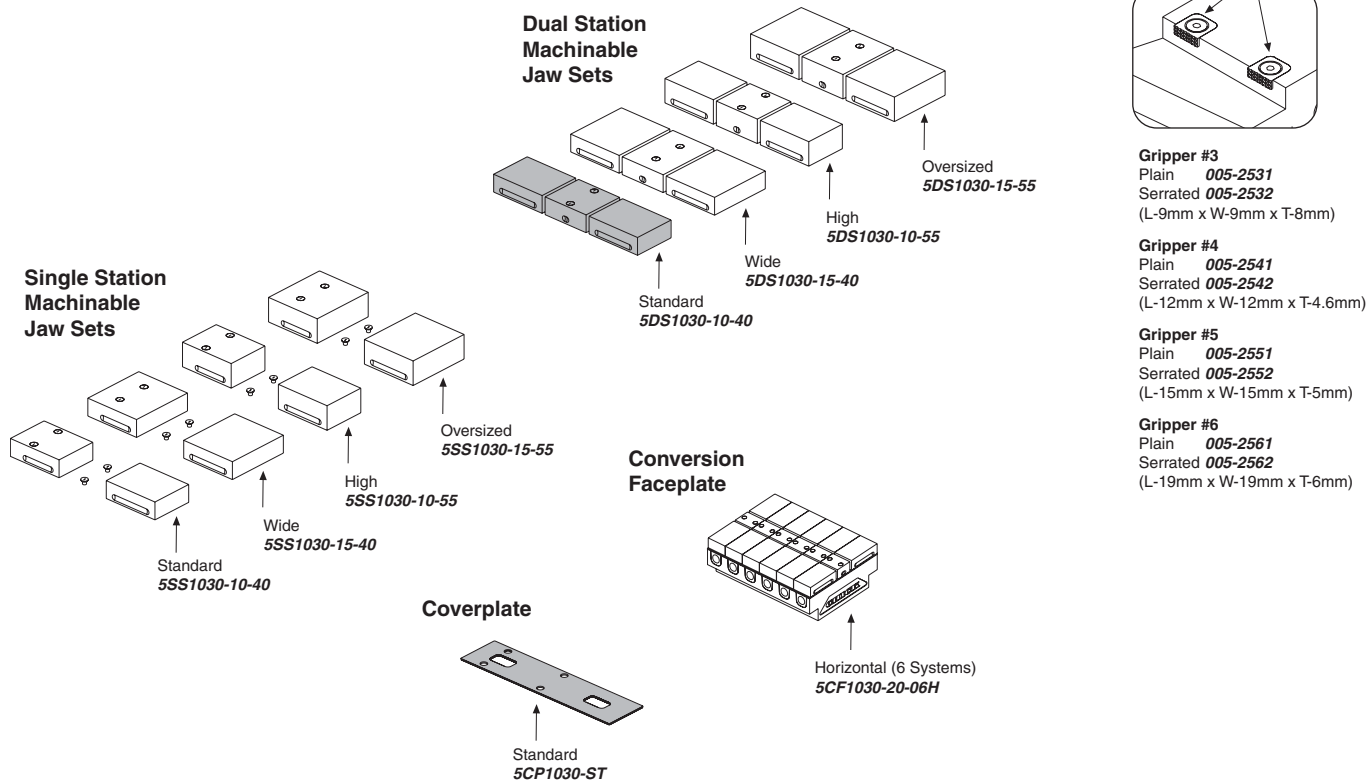


Notes  
All dimensions are MM [IN]

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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.



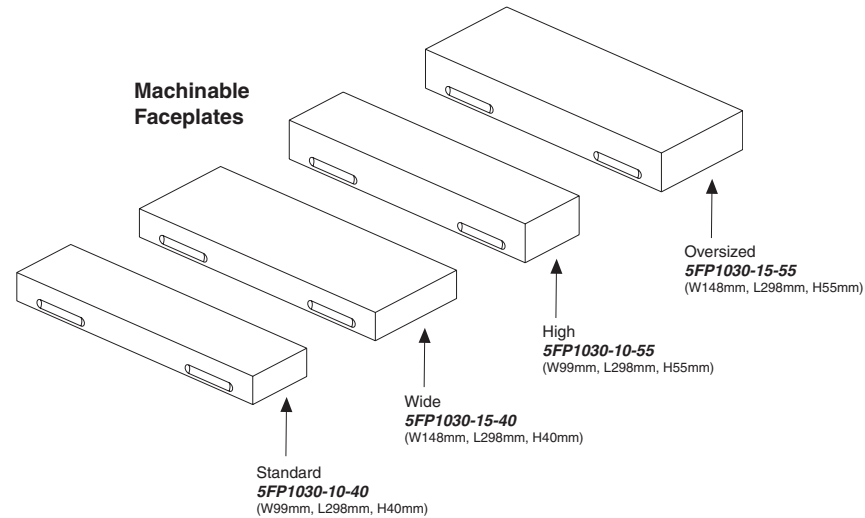
**Notes**

Grey item is included with a standard system

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## Dedicated Fixturing

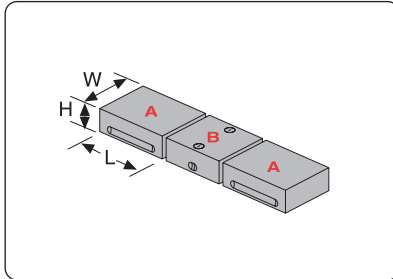
Machinable Faceplates provide QwikChange™ dedicated fixturing and are optimal for awkward or hard to hold parts. A mini pallet changer can be created by utilizing two Faceplates in tandem.



Notes

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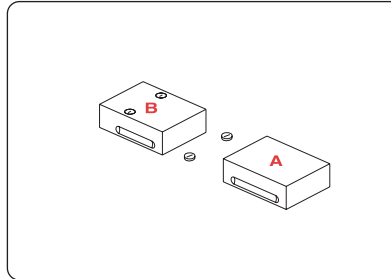
**QwikChange Machinable  
Dual Station Jaws**



**Individual Dual Station Jaws**

- Standard  
**A** Moveable Jaw ..... **5MJ1030-10-40**  
 (W99mm, H40mm, L105mm)  
**B** Fixed Jaw ..... **5FJ1030-10-40**  
 (W99mm, H40mm, L70mm)
- Wide  
**A** Moveable Jaw ..... **5MJ1030-15-40**  
 (W148mm, H40mm, L105mm)  
**B** Fixed Jaw ..... **5FJ1030-15-40**  
 (W148mm, H40mm, L70mm)
- High  
**A** Moveable Jaw ..... **5MJ1030-10-55**  
 (W99mm, H55mm, L105mm)  
**B** Fixed Jaw ..... **5FJ1030-10-55**  
 (W99mm, H55mm, L70mm)
- Oversized  
**A** Moveable Jaw ..... **5MJ1030-15-55**  
 (W148mm, H55mm, L105mm)  
**B** Fixed Jaw ..... **5FJ1030-15-55**  
 (W148mm, H55mm, L70mm)

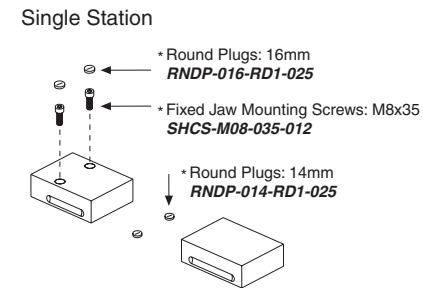
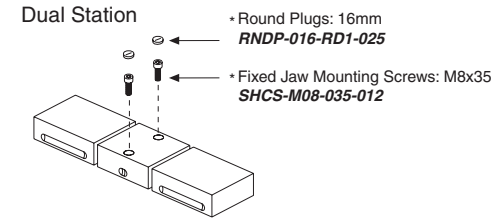
**QwikChange Machinable  
Single Station Jaws**



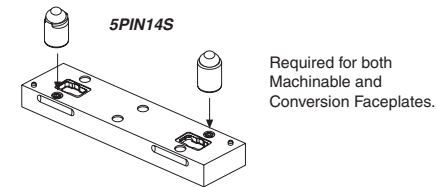
**Individual Single Station Jaws**

- Standard  
**A** Moveable Jaw ..... **5MJ1030-10-40**  
 (W99mm, H40mm, L105mm)  
**B** Fixed Jaw ..... **5SJ1030-10-40**  
 (W99mm, H40mm, L105mm)
- Wide  
**A** Moveable Jaw ..... **5MJ1030-15-40**  
 (W148mm, H40mm, L105mm)  
**B** Fixed Jaw ..... **5SJ1030-15-40**  
 (W148mm, H40mm, L105mm)
- High  
**A** Moveable Jaw ..... **5MJ1030-10-55**  
 (W99mm, H55mm, L105mm)  
**B** Fixed Jaw ..... **5SJ1030-10-55**  
 (W99mm, H55mm, L105mm)
- Oversized  
**A** Moveable Jaw ..... **5MJ1030-15-55**  
 (W148mm, H55mm, L105mm)  
**B** Fixed Jaw ..... **5SJ1030-15-55**  
 (W148mm, H55mm, L105mm)

**Screws and Plugs**



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

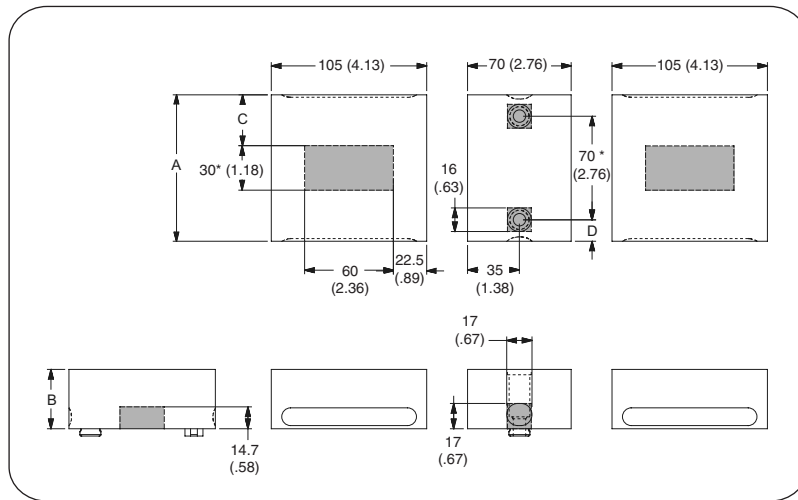


**Notes**

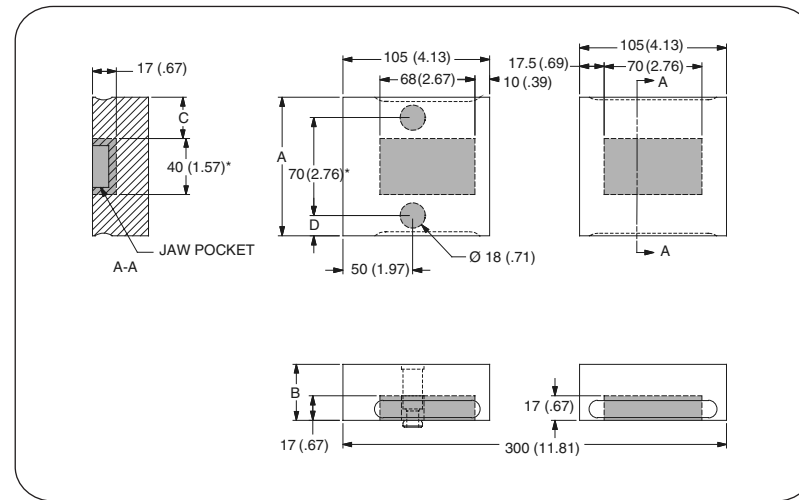
Grey or \* item is included with a standard system

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Dual Station



Single Station



| Item Number          | Description | A          | B         | C           | D          |
|----------------------|-------------|------------|-----------|-------------|------------|
| <b>5DS1030-10-40</b> | Standard    | 99 [3.90]  | 40 [1.57] | 34.5 [1.36] | 14.5 [.57] |
| <b>5DS1030-10-55</b> | High        | 99 [3.90]  | 55 [2.17] | 34.5 [1.36] | 14.5 [.57] |
| <b>5DS1030-15-40</b> | Wide        | 148 [5.83] | 40 [1.57] | 59 [2.32]   | 39 [1.54]  |
| <b>5DS1030-15-55</b> | Oversized   | 148 [5.83] | 55 [2.17] | 59 [2.32]   | 39 [1.54]  |

| Item Number          | Description | A          | B         | C           | D          |
|----------------------|-------------|------------|-----------|-------------|------------|
| <b>5SS1030-10-40</b> | Standard    | 99 [3.90]  | 40 [1.57] | 29.5 [1.16] | 14.5 [.57] |
| <b>5SS1030-10-55</b> | High        | 99 [3.90]  | 55 [2.17] | 29.5 [1.16] | 14.5 [.57] |
| <b>5SS1030-15-40</b> | Wide        | 148 [5.83] | 40 [1.57] | 54 [2.13]   | 39 [1.54]  |
| <b>5SS1030-15-55</b> | Oversized   | 148 [5.83] | 55 [2.17] | 54 [2.13]   | 39 [1.54]  |

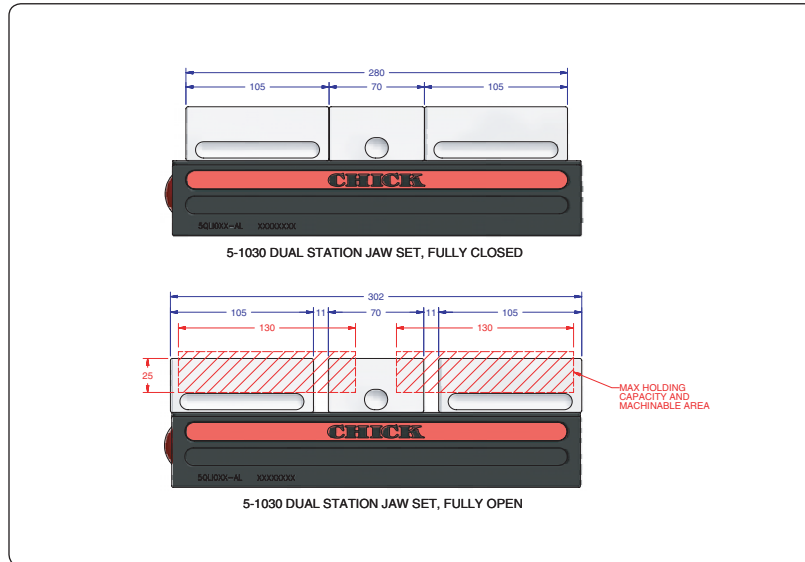
Notes

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

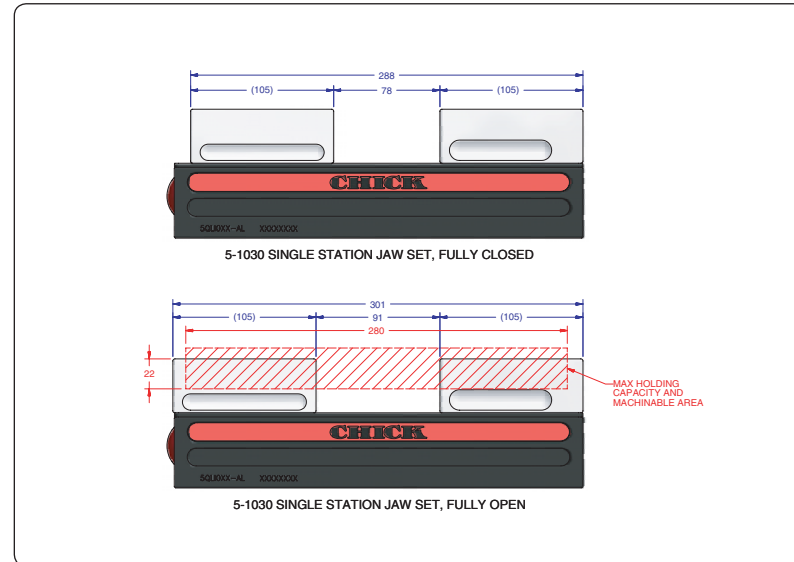
**CHICK WORKHOLDING SOLUTIONS, INC.**  
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 Phone: (724) 772-1644 • Fax: (724) 772-1633  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)



**Dual Station**



**Single Station**



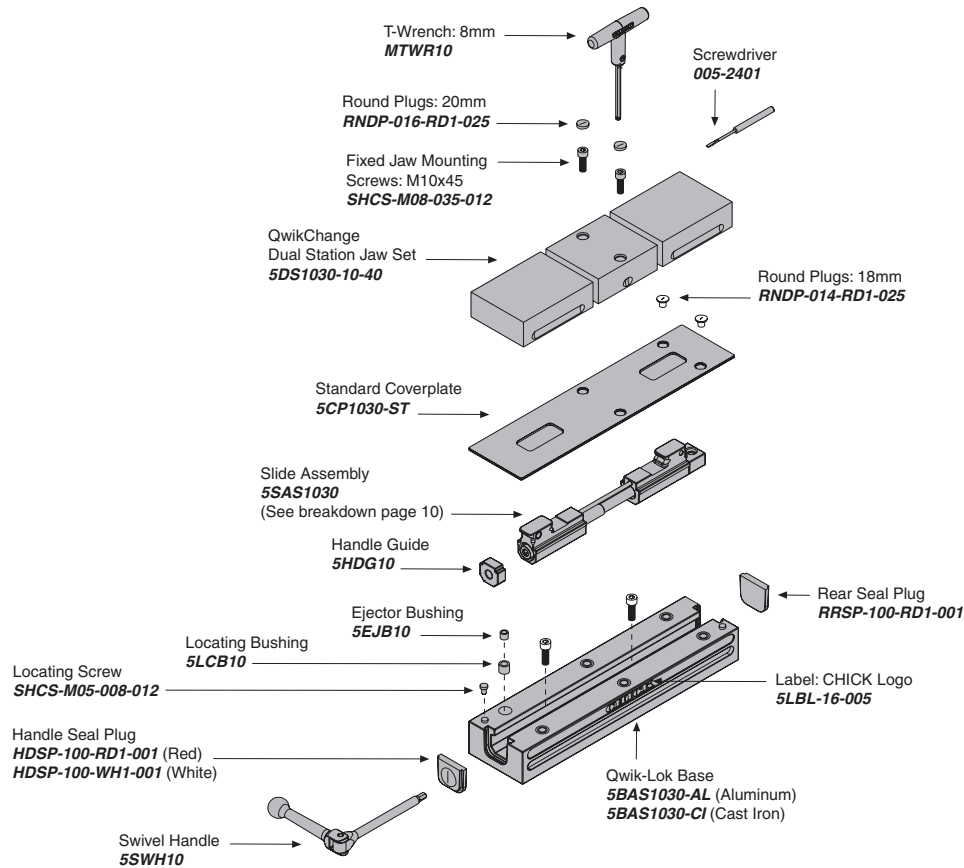
| Item Number          | Description | A         | Jaw Width  |
|----------------------|-------------|-----------|------------|
| <b>5DS1030-10-40</b> | Standard    | 26 [1.02] | 99 [3.90]  |
| <b>5DS1030-10-55</b> | High        | 41 [1.61] | 99 [3.90]  |
| <b>5DS1030-15-40</b> | Wide        | 26 [1.02] | 148 [5.83] |
| <b>5DS1030-15-55</b> | Oversized   | 41 [1.61] | 148 [5.83] |

| Item Number          | Description | A         | Jaw Width  |
|----------------------|-------------|-----------|------------|
| <b>5SS1030-10-40</b> | Standard    | 26 [1.02] | 99 [3.90]  |
| <b>5SS1030-10-55</b> | High        | 41 [1.61] | 99 [3.90]  |
| <b>5SS1030-15-40</b> | Wide        | 26 [1.02] | 148 [5.83] |
| <b>5SS1030-15-55</b> | Oversized   | 41 [1.61] | 148 [5.83] |

**Notes**

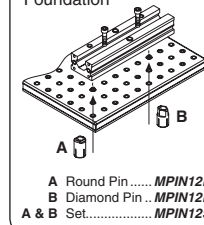
All dimensions are MM [IN]  
 Additional closure is available with an Extended Travel Coverplate.  
 Contact CHICK for details.

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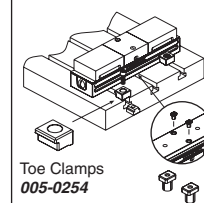


**MOUNTING**

**Foundation**

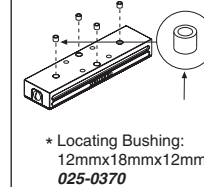


**T-Slotted Table**



Bolt and T-Nut supplied by customer

**Bottom of Base**



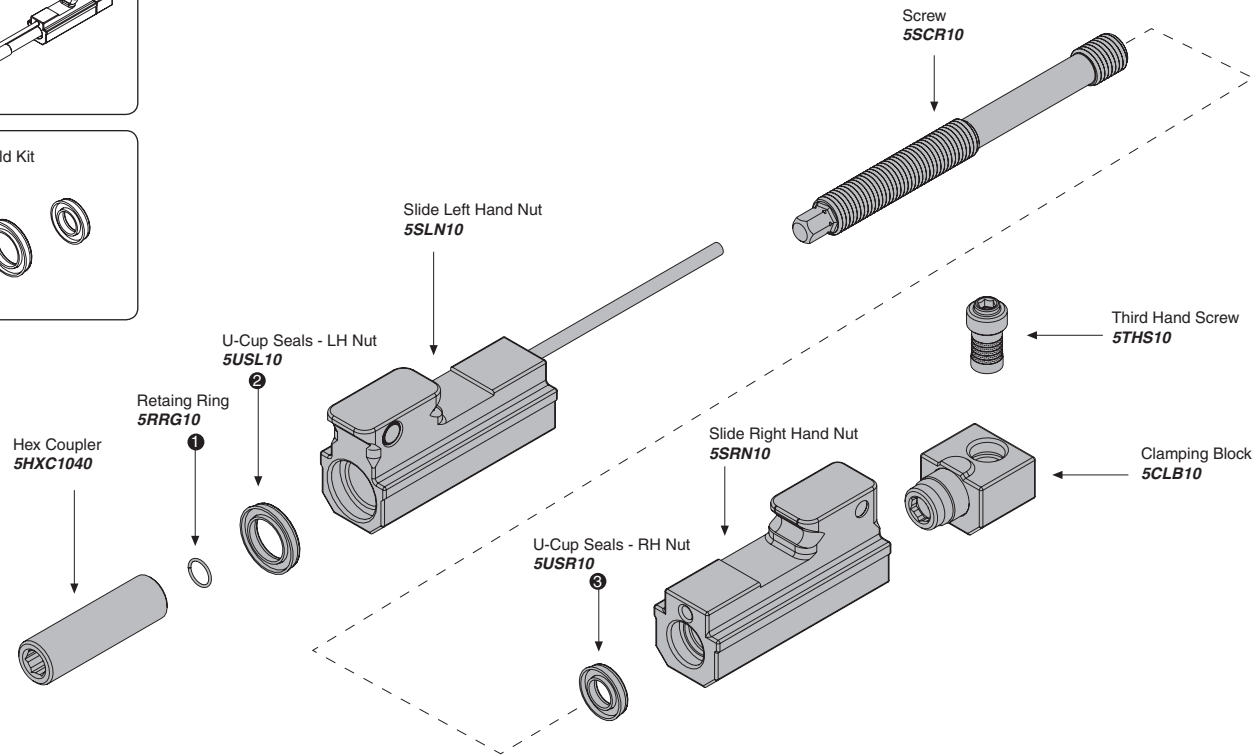
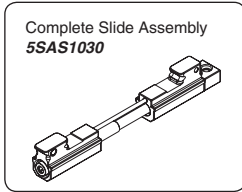
**Locating Keys**

| 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)    |

**Notes**

Grey items are included with a standard system  
 For QwikChange™ Jaw accessories, see pages 4-7

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**Notes**

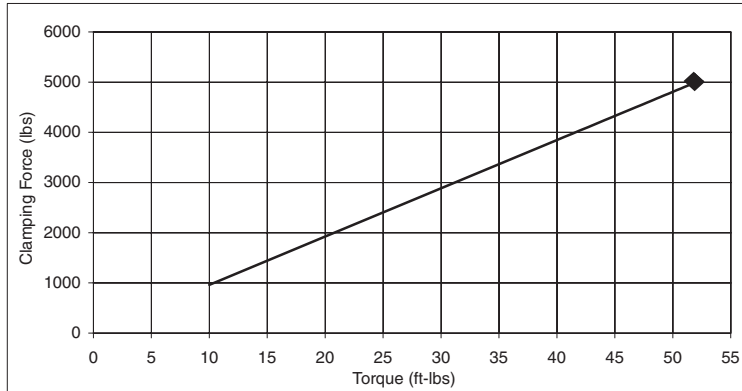
Grey items are included with a standard system

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**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        |

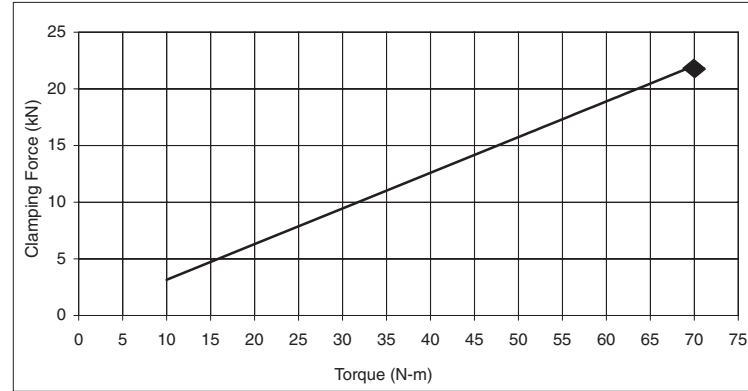


Note: ◆ Maximum Recommended Torque. Actual results may vary.

**Kilonewtons (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

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