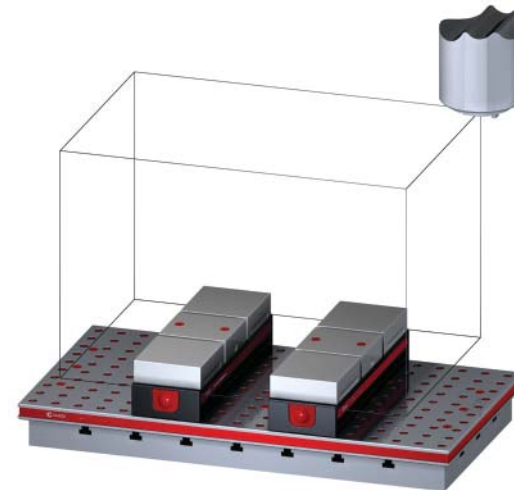


5VP-HAAS-00115

This workholding package is designed for your HAAS VM-2 machining center.



Workholding package



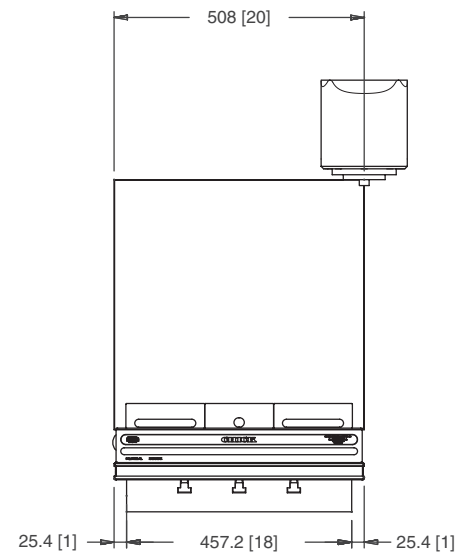
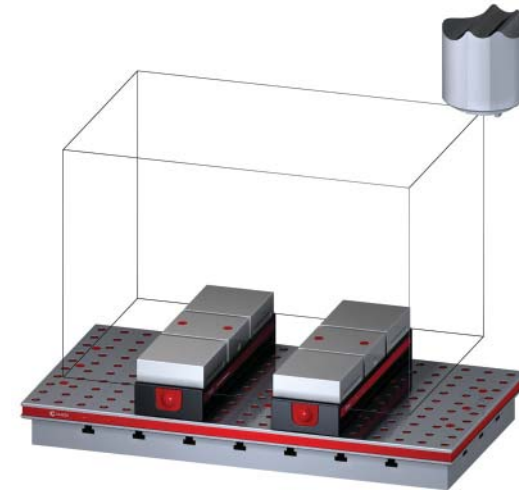
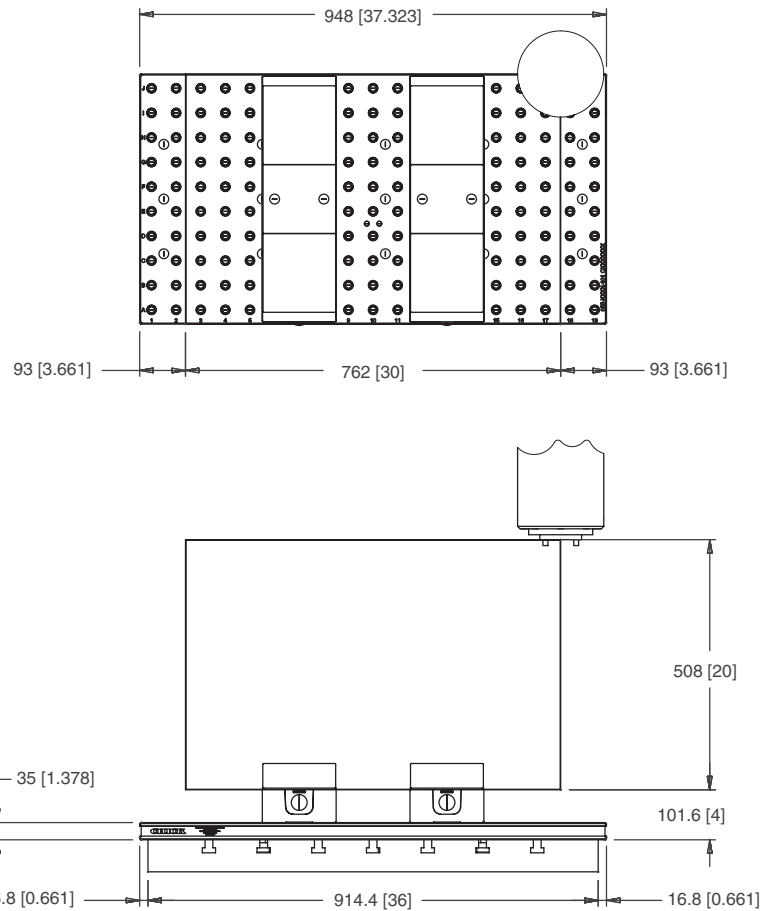
Workholding package
in machine envelope

Notes

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Phone: (724) 772-1644 • Fax: (724) 772-1633
www.ChickWorkholding.com

5VP-HAAS-00115

This workholding package is designed for your HAAS VM-2 machining center.



Notes

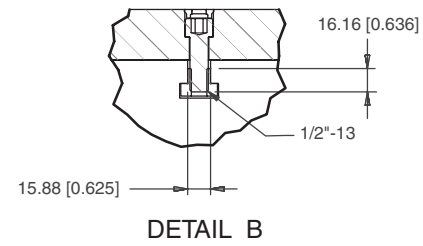
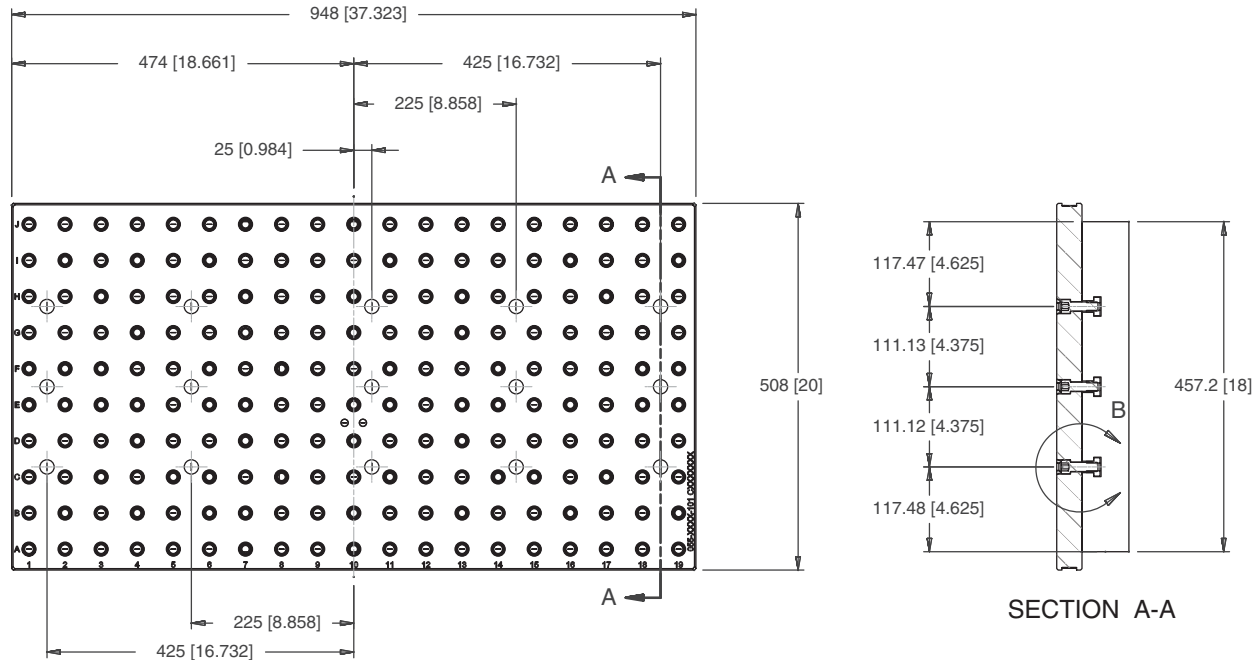
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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5VP-HAAS-00115

This workholding package is designed for your HAAS VM-2 machining center.



Notes
All dimensions are MM [IN]

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5VP-HAAS-00115

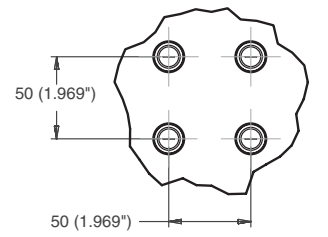
This workholding package is designed for your HAAS VM-2 machining center.

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



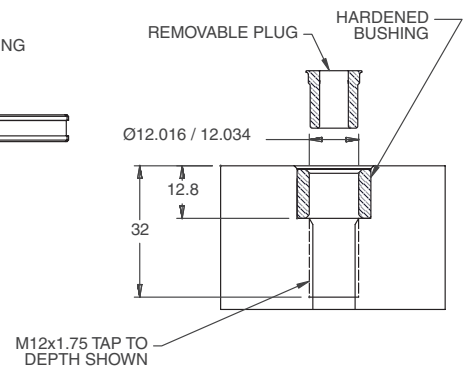
FOUNDATION MAT'L: CAST IRON
FOUNDATION INCLUDES INSTALLATION HARDWARE

DETAIL A



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

SECTION B-B



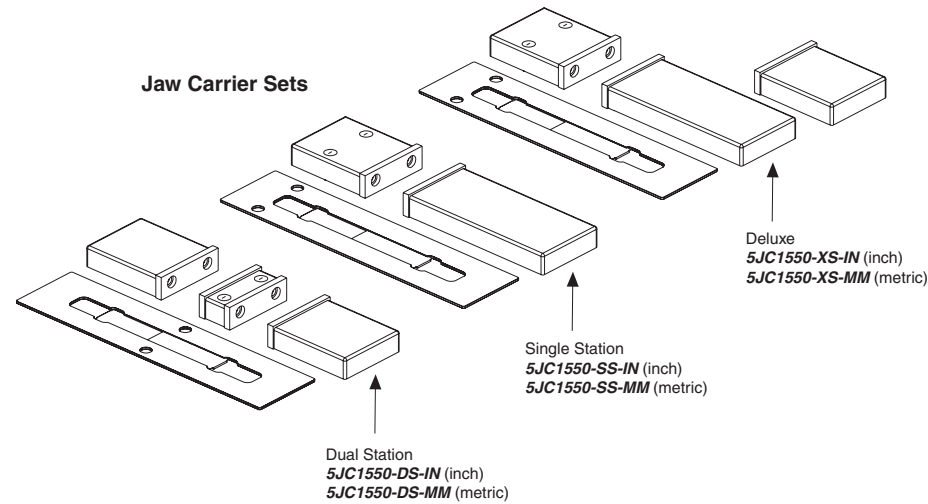
Notes
All dimensions are MM [IN]

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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.

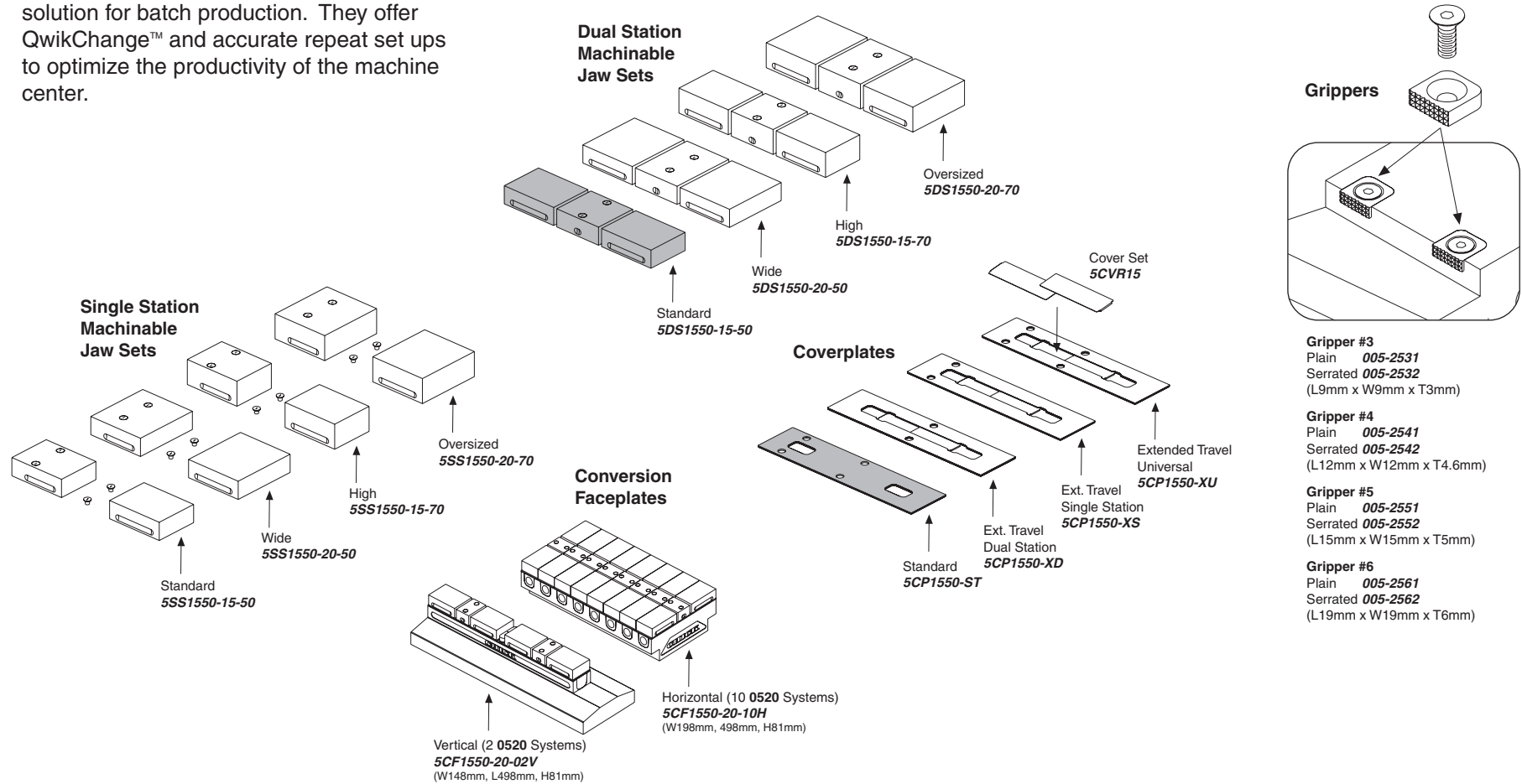


Notes

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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.



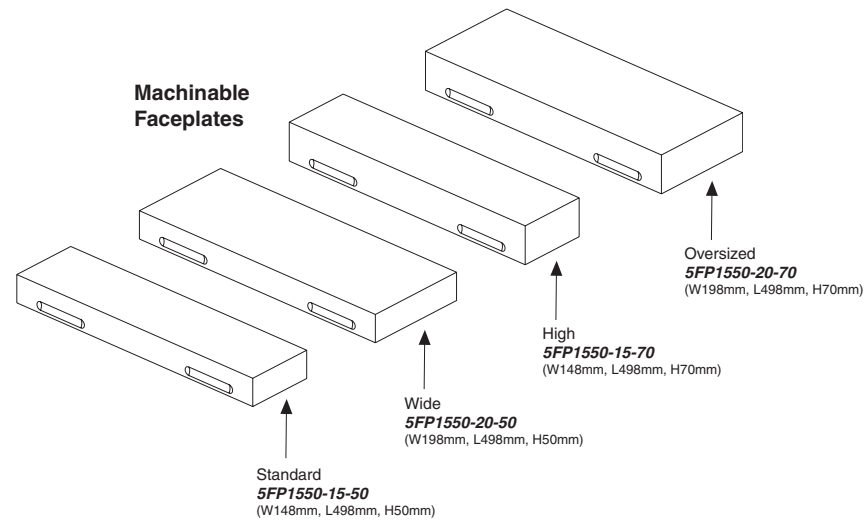
Notes

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 **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)

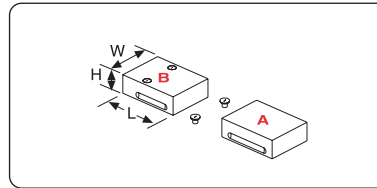
High

- 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)

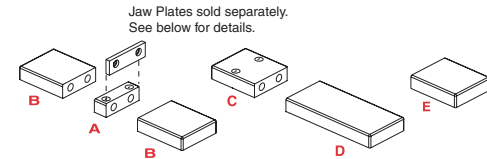
High

- 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)

- A** **5JC1550-FC-IN**
- B** **5JC1550-MC-IN**
- C** **5JC1550-SC-IN**
- D** **5JC1550-LM-IN**
- E** **5JC1550-SM-IN**

Jaw Carriers (Metric)

- A** **5JC1550-FC-MM**
- B** **5JC1550-MC-MM**
- C** **5JC1550-SC-MM**
- D** **5JC1550-LM-MM**
- E** **5JC1550-SM-MM**

- A** Dual Station Fixed
- B** Dual Station Moveable

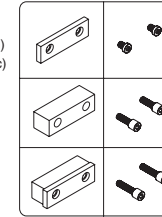
- C** Single Station Fixed
- D** Single Station Long Moveable

- E** Single Station Short Moveable

Jaw Plates

- Standard (Set of 4)
JH6STD (Inch)
MJH15 (Metric)

HARD JAW PLATES



- Standard Mounting Screws: 1/2-13x5/8"
LHCS-500-063-008 (Inch)
LHCS-M10-012-008 (Metric)

- Thick (Set of 2)
JH6THK

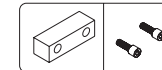
- Thick Mounting Screws: 1/2-13x1.25"
SHCS-500-125-008

- Both Sizes
JH6STD &
JH6THK

- Both Sizes Mounting Screws: 1/2-13x1.75"
SHCS-500-175-008

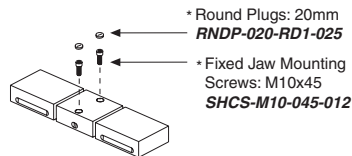
- Standard (Set of 4)
JS6AL

SOFT JAW PLATES

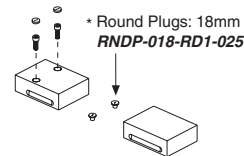


- Soft Mounting Screws: 1/2-13x1.25"
SHCS-500-125-012

Screws and Plugs



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



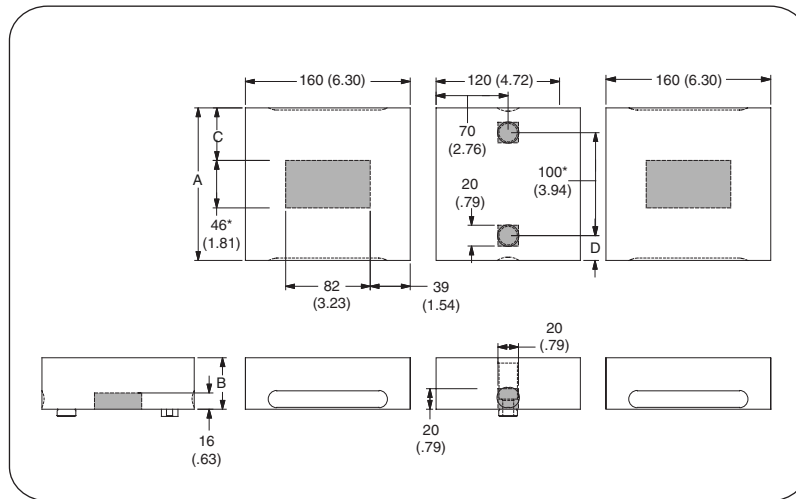
- * Round Plugs: 18mm
RNDP-018-RD1-025

Notes

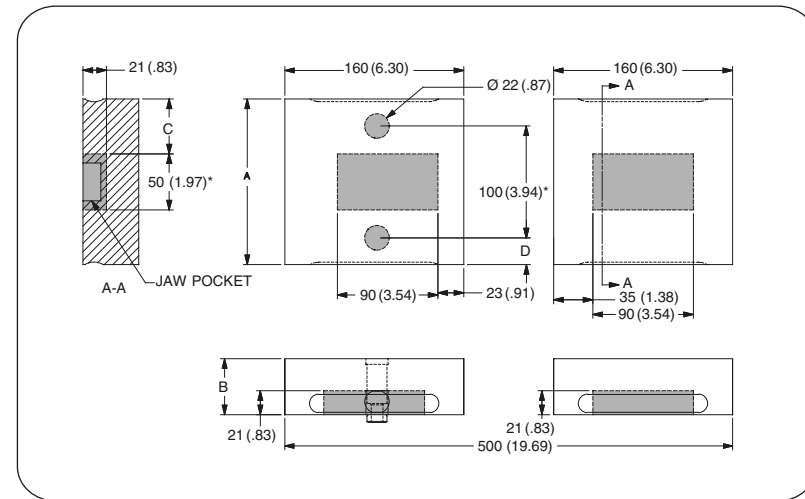
Grey or * item is included with a standard system

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Dual Station



Single Station



| Item Number | Description | A | B | C | D |
|----------------------|-------------|------------|-----------|-----------|-----------|
| 5DS1550-15-50 | Standard | 148 [5.83] | 50 [1.97] | 51 [2.01] | 24 [.94] |
| 5DS1550-15-70 | High | 148 [5.83] | 70 [2.76] | 51 [2.01] | 24 [.94] |
| 5DS1550-20-50 | Wide | 198 [7.80] | 50 [1.97] | 76 [2.99] | 49 [1.93] |
| 5DS1550-20-70 | Oversized | 198 [7.80] | 70 [2.76] | 76 [2.99] | 49 [1.93] |

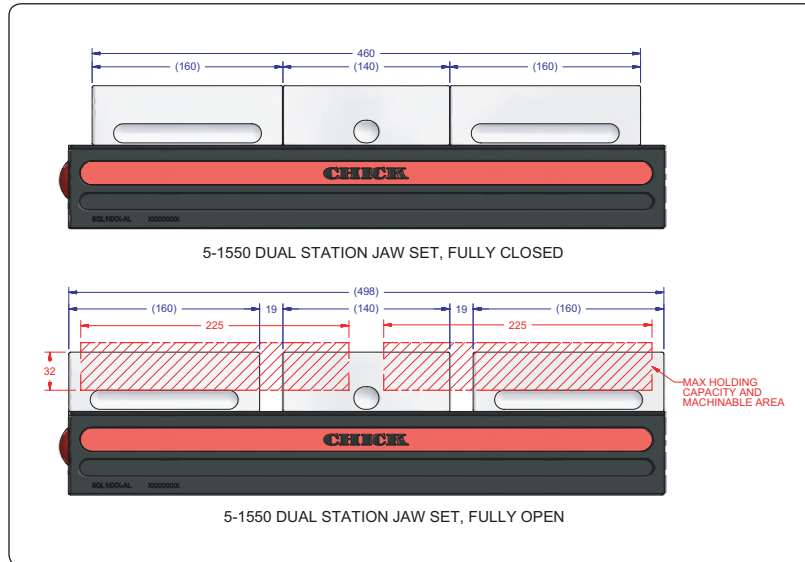
| Item Number | Description | A | B | C | D |
|----------------------|-------------|------------|-----------|-----------|-----------|
| 5SS1550-15-50 | Standard | 148 [5.83] | 50 [1.97] | 49 [1.93] | 24 [.94] |
| 5SS1550-15-70 | High | 148 [5.83] | 70 [2.76] | 49 [1.93] | 24 [.94] |
| 5SS1550-20-50 | Wide | 198 [7.80] | 50 [1.97] | 74 [2.91] | 49 [1.93] |
| 5SS1550-20-70 | Oversized | 198 [7.80] | 70 [2.76] | 74 [2.91] | 49 [1.93] |

Notes

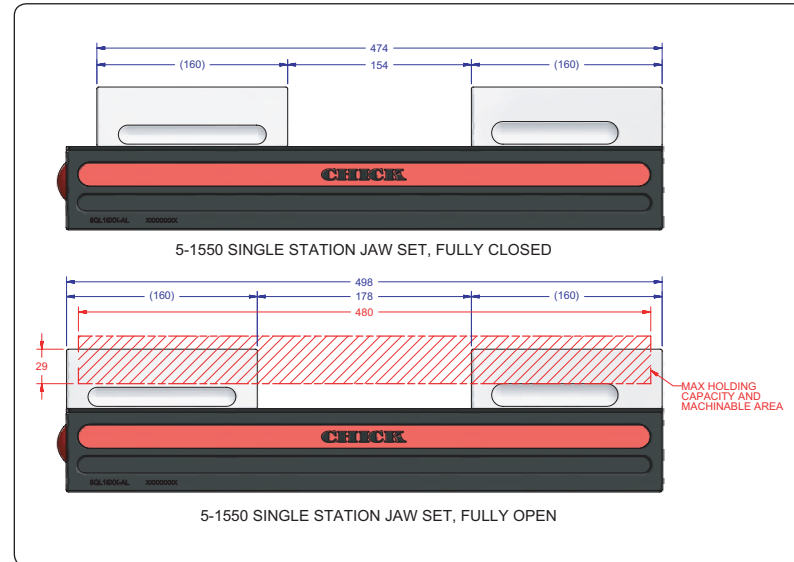
Grey area indicates no cut zone
 All dimensions are MM [IN]
 Dimensions centered on the "A" dimension.

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Dual Station



Single Station



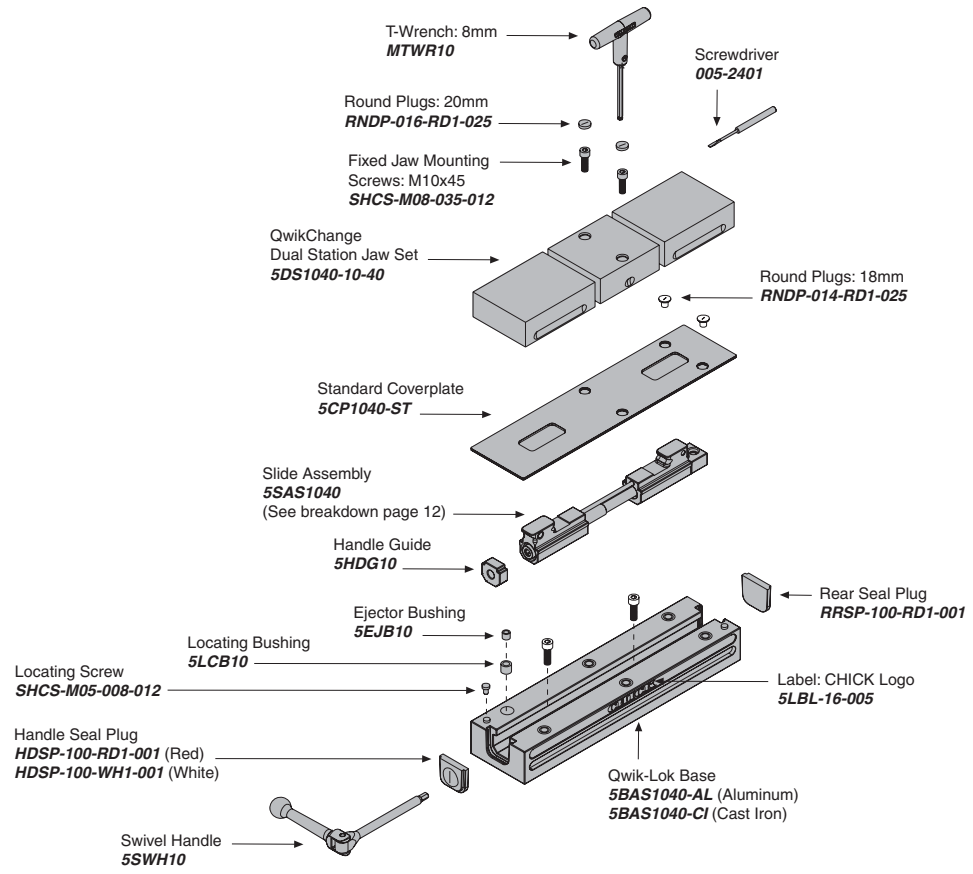
| Item Number | Description | A | Jaw Width |
|----------------------|-------------|-----------|------------|
| 5DS1550-15-50 | Standard | 32 [1.26] | 148 [5.83] |
| 5DS1550-15-70 | High | 52 [2.05] | 148 [5.83] |
| 5DS1550-20-50 | Wide | 32 [1.26] | 198 [7.80] |
| 5DS1550-20-70 | Oversized | 52 [2.05]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

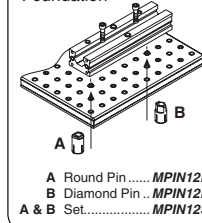
All dimensions are MM [IN]
 Additional closure is available with an Extended Travel Coverplate.
 Contact CHICK for details.

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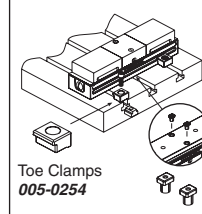


MOUNTING

Foundation

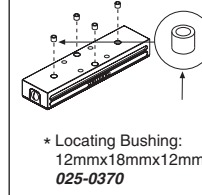


T-Slotted Table



Bolt and T-Nut supplied by customer

Bottom of Base



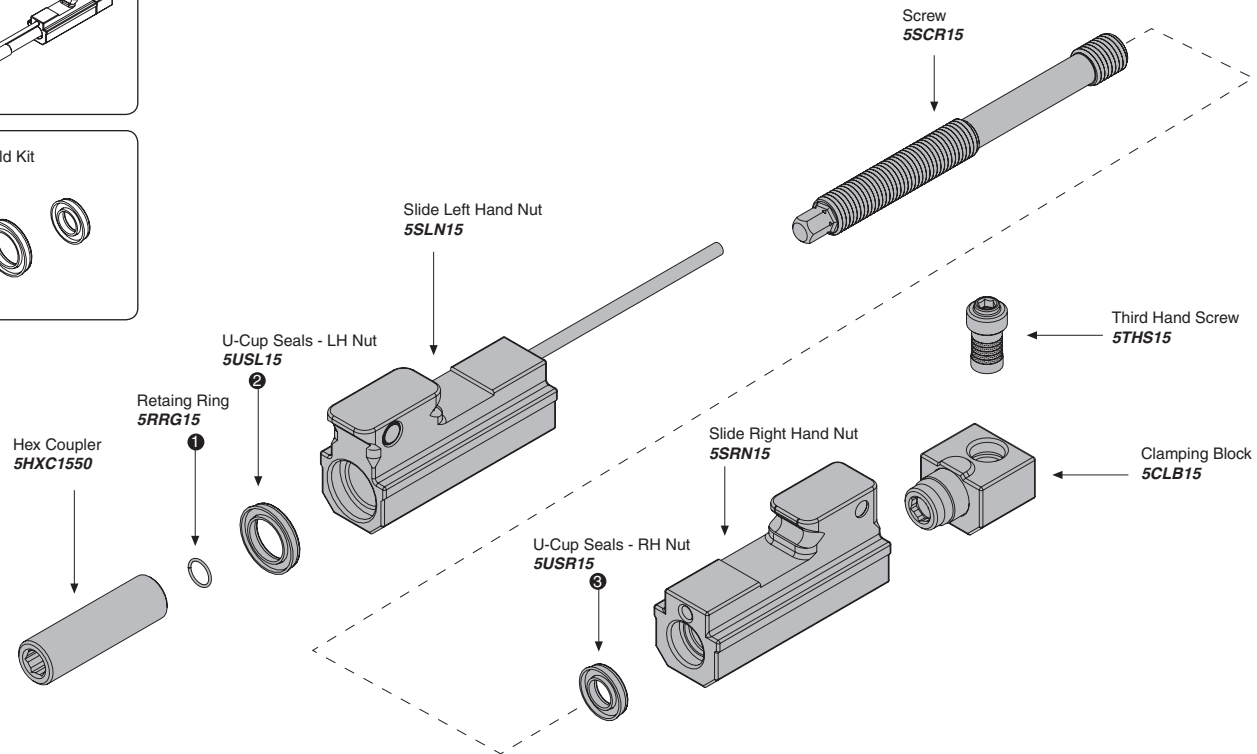
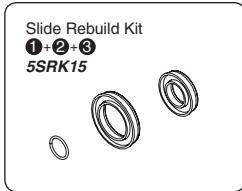
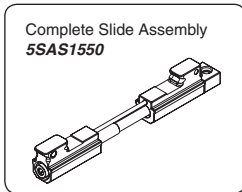
Locating Keys

| 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 5-8

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Notes

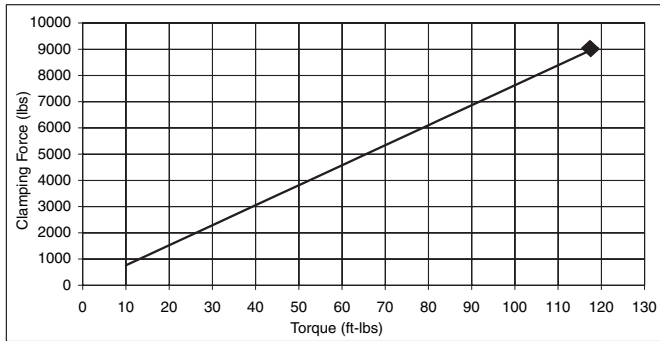
Grey items are included with a standard system

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Pounds (lbs)

| | | | | |
|-------|---|--------|---|-------|
| Force | = | Torque | X | Slope |
| lbs | = | in-lb | x | 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 |

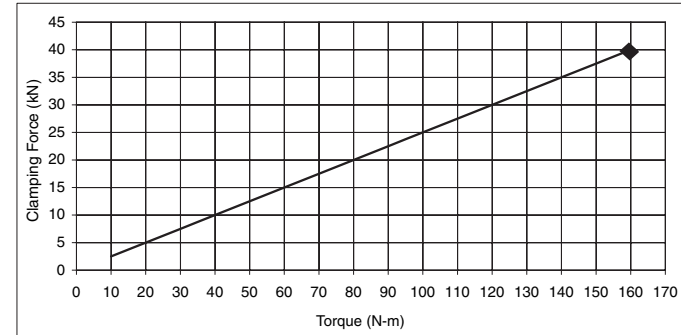


Note: ◆ Maximum Recommended Torque. Actual results may vary.

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.

Notes

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