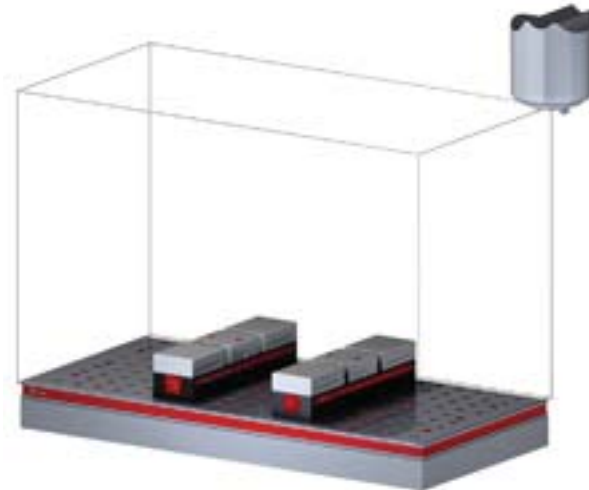


## 5VP-HAAS-00156

This workholding package is designed for your HAAS VF-3 machining center.



Workholding package



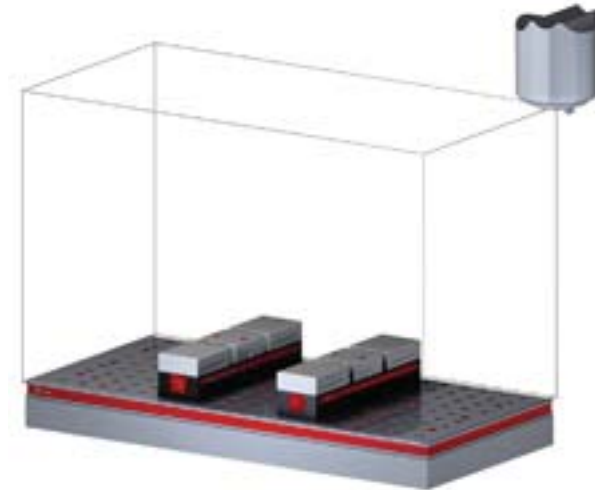
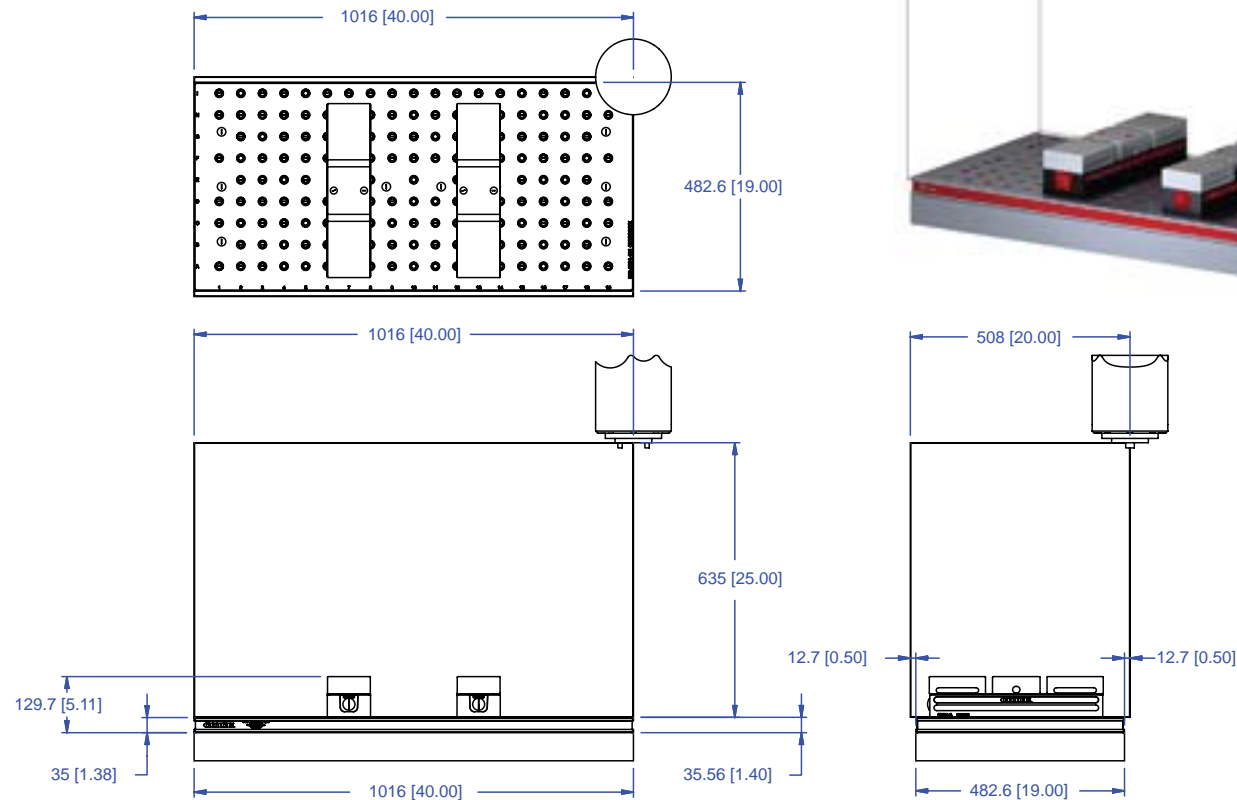
Workholding package  
in machine envelope

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-00156

This workholding package is designed for your HAAS VF-3 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]

**CHICK WORKHOLDING SOLUTIONS, INC.**

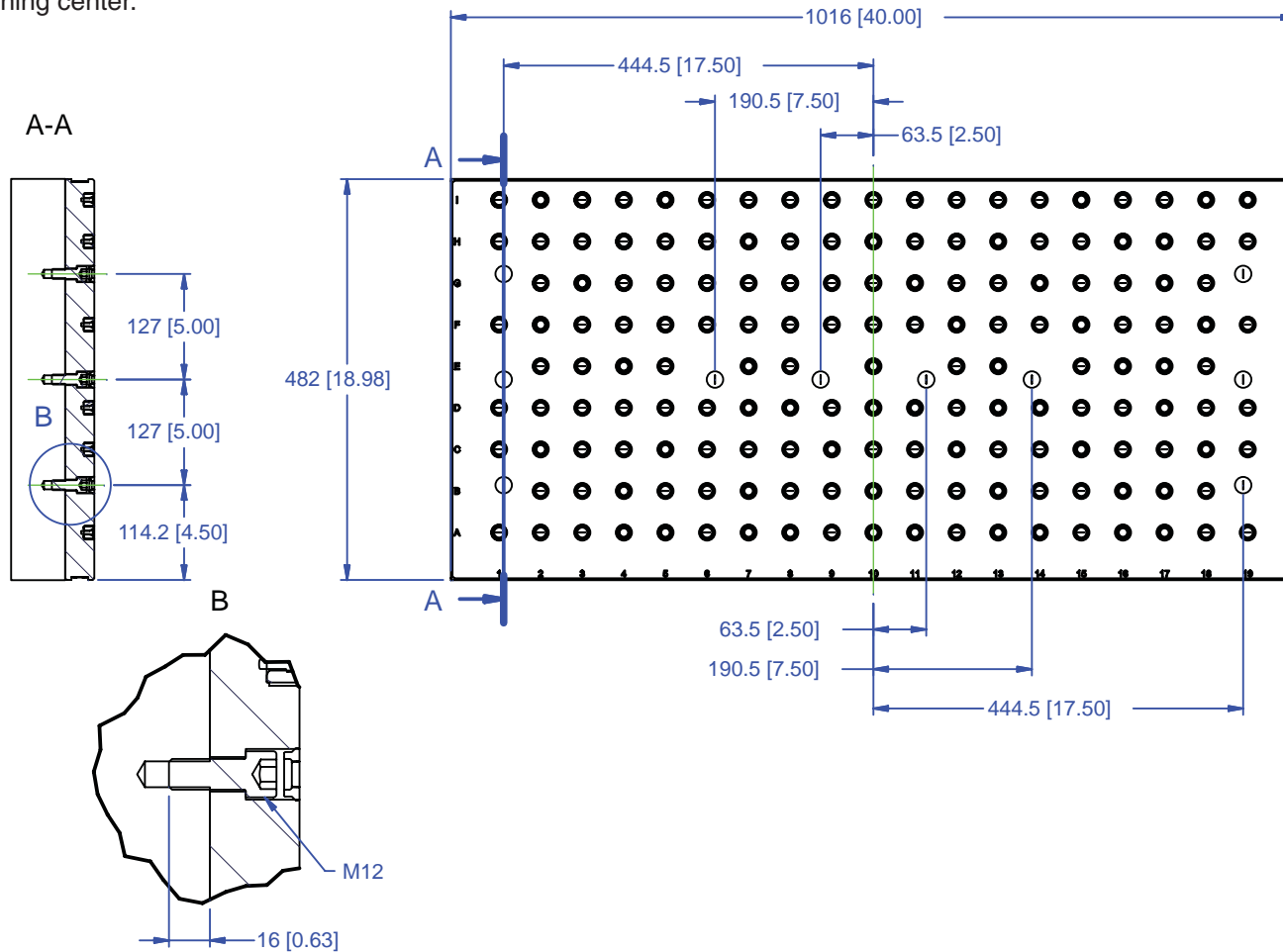
500 Keystone Drive • Warrendale, PA 15086 USA

Phone: (724) 772-1644 • Fax: (724) 772-1633

[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

## 5VP-HAAS-00156

This workholding package is designed for your HAAS VF-3 machining center.



### Notes

All dimensions are MM [IN]

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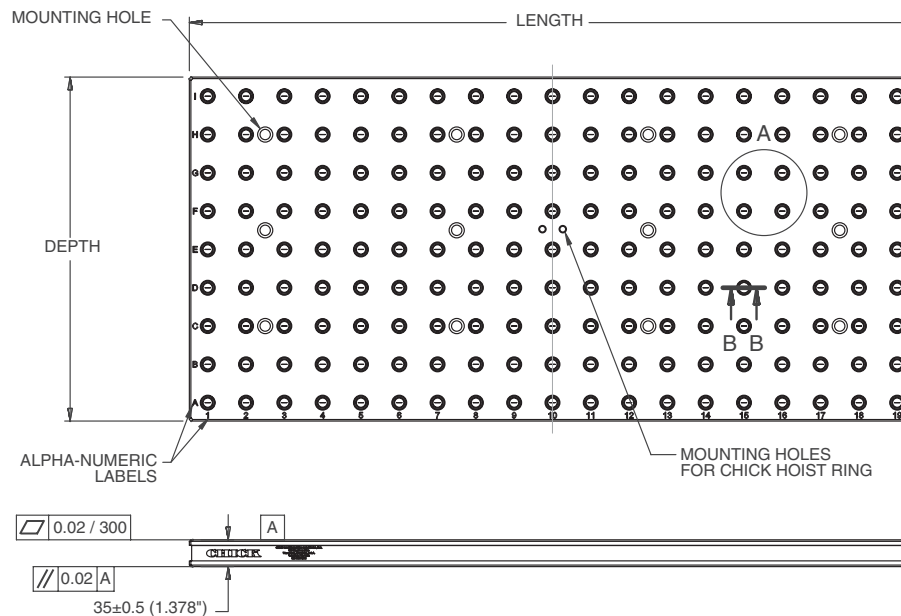
Phone: (724) 772-1644 • Fax: (724) 772-1633

[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

## 5VP-HAAS-00156

This workholding package is designed for your HAAS VF-3 machining center.

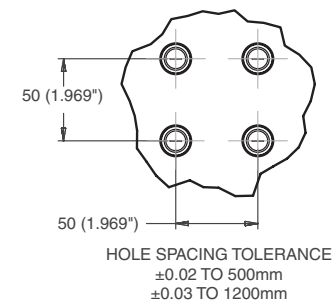
FOUNDATION LENGTH, DEPTH, AND MOUNTING HOLE CONFIGURATION DESIGNED ACCORDING TO MACHINE TOOL SPECIFICATION



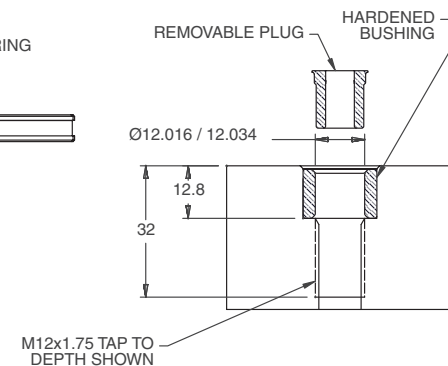
FOUNDATION MAT'L: CAST IRON

FOUNDATION INCLUDES INSTALLATION HARDWARE

DETAIL A



SECTION B-B



### Notes

All dimensions are MM [IN]

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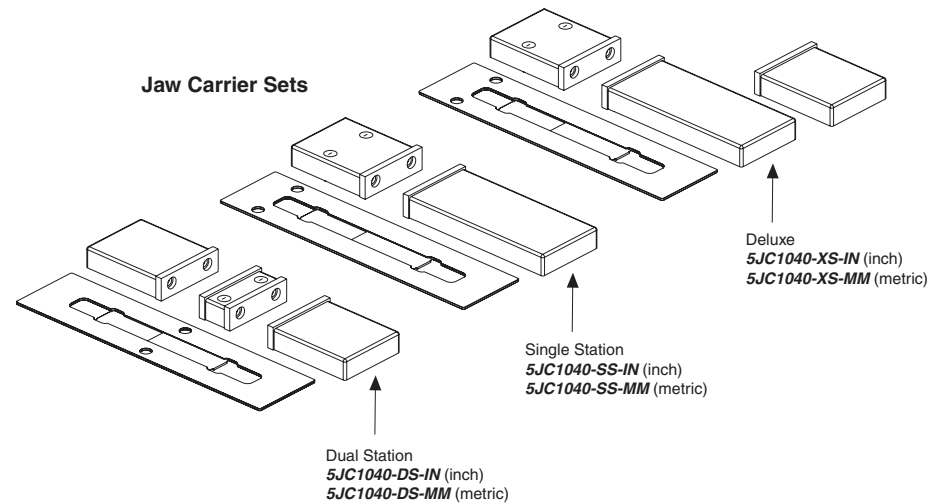
Phone: (724) 772-1644 • Fax: (724) 772-1633

[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

## 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.

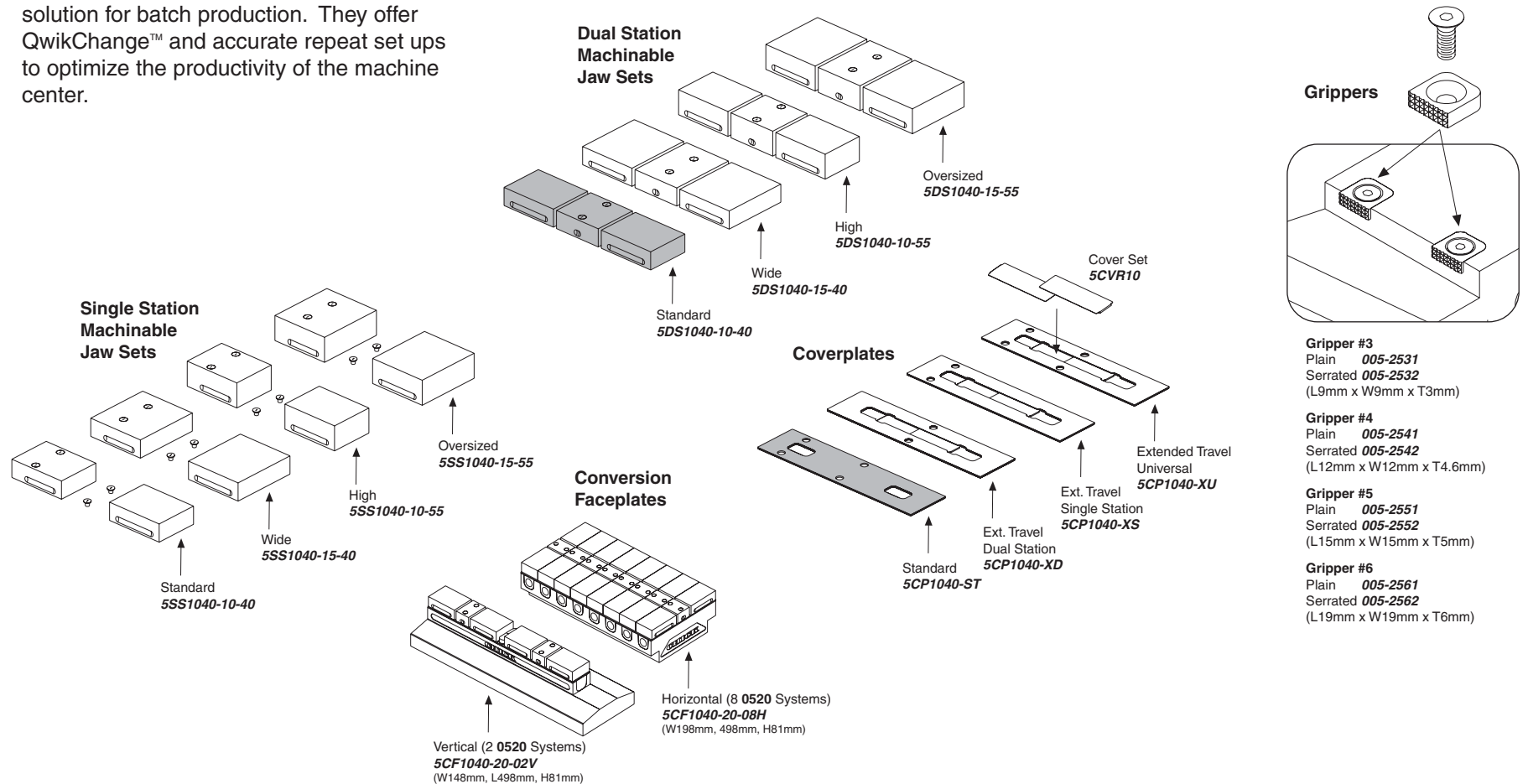


Notes

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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.



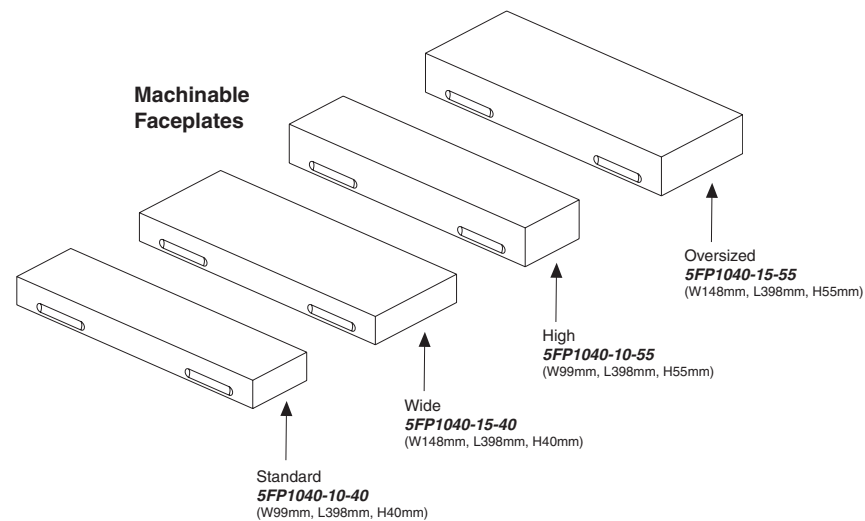
### Notes

Grey item is included with a standard system

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## Dedicated Fixturing

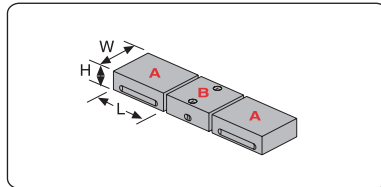
Machinable Faceplates provide QwikChange™ dedicated fixturing and are optimal for awkward or hard to hold parts. A mini pallet changer can be created by utilizing two Faceplates in tandem.



Notes

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## QwikChange Machinable Dual Station Jaws



### Individual Dual Station Jaws

Standard

- A** Moveable Jaw ..... **5MJ1040-10-40**  
(W99mm, H130mm, L40mm)  
**B** Fixed Jaw ..... **5FJ1040-10-40**  
(W99mm, H110mm, L40mm)

Wide

- A** Moveable Jaw ..... **5MJ1040-15-40**  
(W148mm, H130mm, L40mm)  
**B** Fixed Jaw ..... **5FJ1040-15-40**  
(W148mm, H110mm, L40mm)

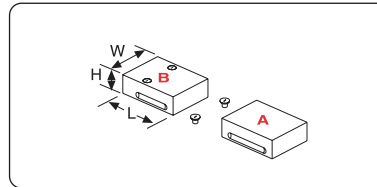
High

- A** Moveable Jaw ..... **5MJ1040-10-55**  
(W99mm, H130mm, L55mm)  
**B** Fixed Jaw ..... **5FJ1040-10-55**  
(W99mm, H110mm, L55mm)

Oversized

- A** Moveable Jaw ..... **5MJ1040-15-55**  
(W148mm, H130mm, L55mm)  
**B** Fixed Jaw ..... **5FJ1040-15-55**  
(W148mm, H110mm, L55mm)

## QwikChange Machinable Single Station Jaws



### Individual Single Station Jaws

Standard

- A** Moveable Jaw ..... **5MJ1040-10-40**  
(W99mm, H130mm, L40mm)  
**B** Fixed Jaw ..... **5SJ1040-10-40**  
(W99mm, H130mm, L40mm)

Wide

- A** Moveable Jaw ..... **5MJ1040-15-40**  
(W148mm, H130mm, L40mm)  
**B** Fixed Jaw ..... **5SJ1040-15-40**  
(W148mm, H130mm, L40mm)

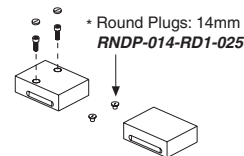
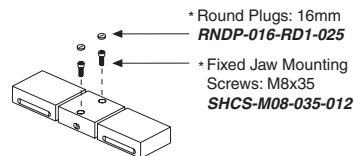
High

- A** Moveable Jaw ..... **5MJ1040-10-55**  
(W99mm, H130mm, L55mm)  
**B** Fixed Jaw ..... **5SJ1040-10-55**  
(W99mm, H130mm, L55mm)

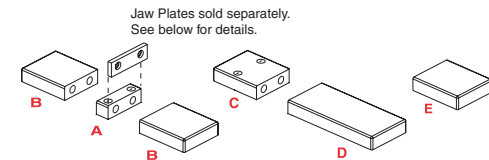
Oversized

- A** Moveable Jaw ..... **5MJ1040-15-55**  
(W148mm, H130mm, L55mm)  
**B** Fixed Jaw ..... **5SJ1040-15-55**  
(W148mm, H130mm, L55mm)

## Screws and Plugs



## QwikChange Jaw Carriers



Jaw Carriers (Inch)

- A** 5JC1040-FC-IN  
**B** 5JC1040-MC-IN  
**C** 5JC1040-SC-IN  
**D** 5JC1040-LM-IN  
**E** 5JC1040-SM-IN

Jaw Carriers (Metric)

- A** 5JC1040-FC-MM  
**B** 5JC1040-MC-MM  
**C** 5JC1040-SC-MM  
**D** 5JC1040-LM-MM  
**E** 5JC1040-SM-MM

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

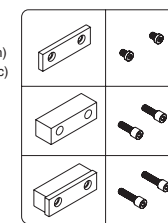
- C** Single Station Fixed  
**D** Single Station Long Moveable

- E** Single Station Short Moveable

## Jaw Plates

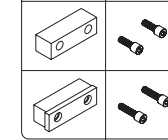
### HARD JAW PLATES

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



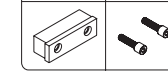
- Standard Mounting Screws:  
3/8-16x1/2"  
**LHCS-375-050-008** (Inch)  
**LHCS-M08-016-008** (Metric)

- Thick  
(Set of 2)  
**JH4THK**



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

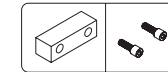
- Both Sizes  
**JH4STD** &  
**JH4THK**



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

### SOFT JAW PLATES

- Standard  
(Set of 4)  
**JS4AL**



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

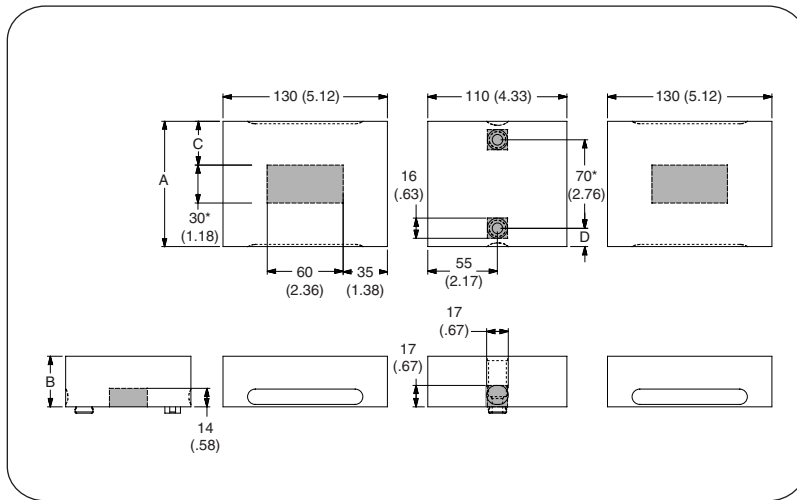
## Notes

Grey or \* item is included with a standard system

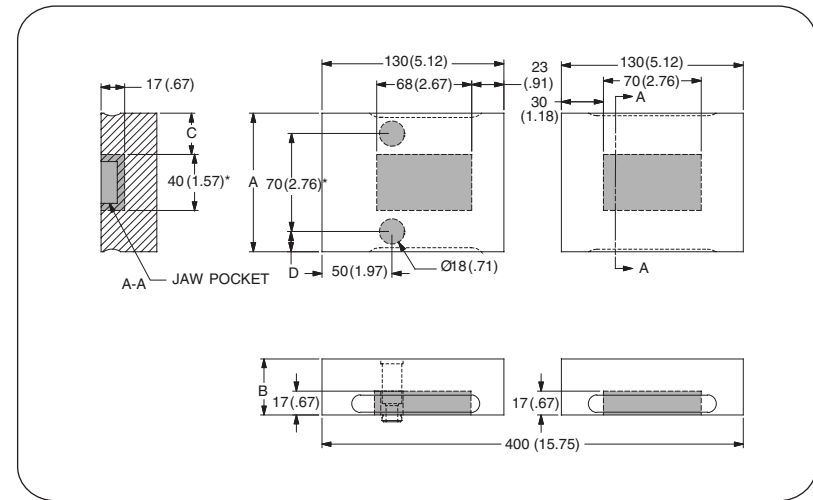
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500 Keystone Drive • Warrendale, PA 15086 USA  
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## Dual Station



## Single Station



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

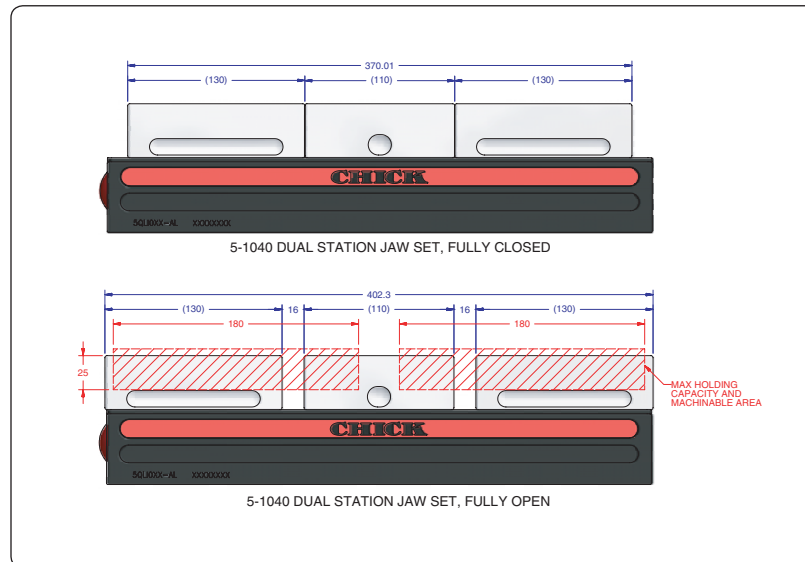
Item Number	Description	A	B	C	D
<b>5SS1040-10-40</b>	Standard	99 [3.90]	40 [1.57]	29.5 [1.16]	14.5 [.57]
<b>5SS1040-10-55</b>	High	99 [3.90]	55 [2.17]	29.5 [1.16]	14.5 [.57]
<b>5SS1040-15-40</b>	Wide	148 [5.83]	40 [1.57]	54 [2.13]	39 [1.54]
<b>5SS1040-15-55</b>	Oversized	148 [5.83]	55 [2.17]	54 [2.13]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

### Notes

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

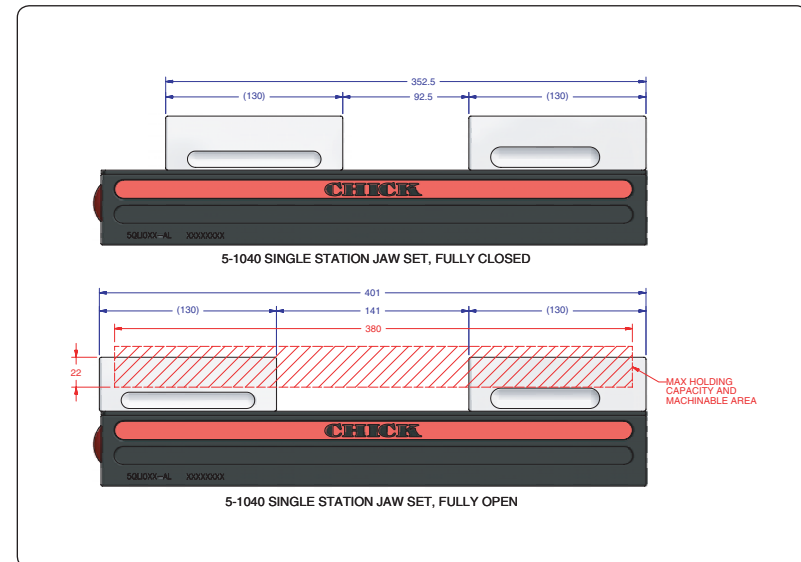
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## Dual Station



Item Number	Description	A	Jaw Width
<b>5DS1040-10-40</b>	Standard	26 [1.02]	99 [3.90]
<b>5DS1040-10-55</b>	High	41 [1.61]	99 [3.90]
<b>5DS1040-15-40</b>	Wide	26 [1.02]	148 [5.83]
<b>5DS1040-15-55</b>	Oversized	41 [1.61]	148 [5.83]

## Single Station

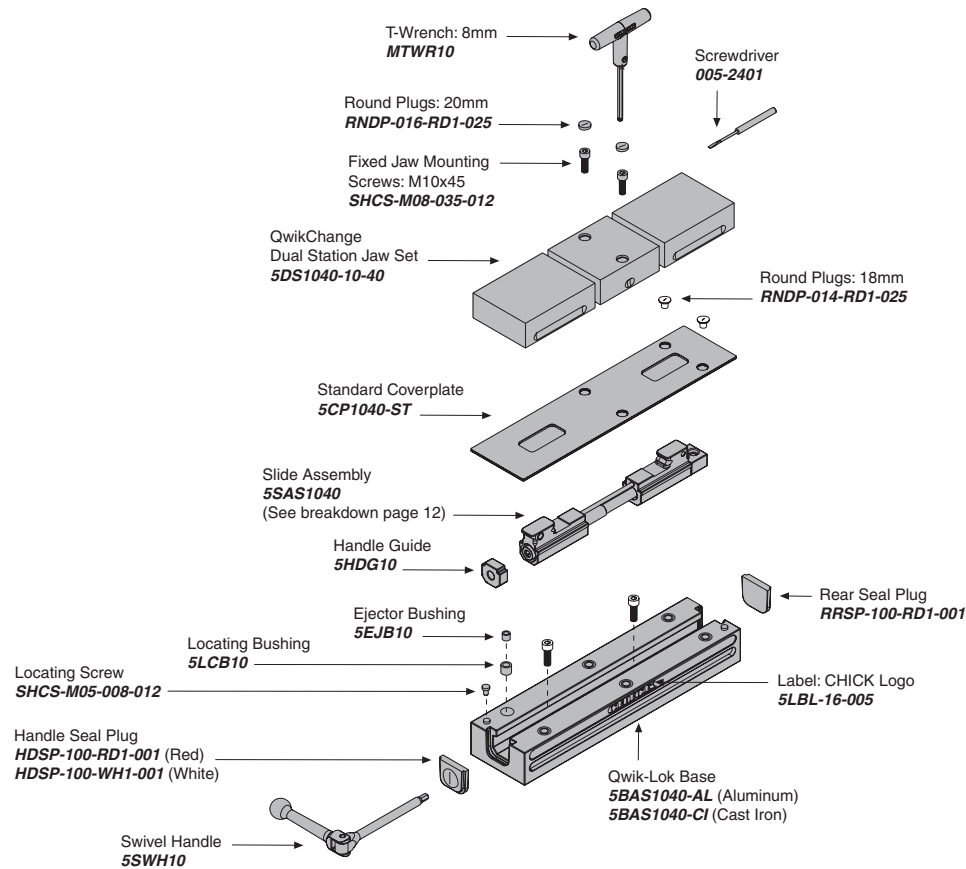


Item Number	Description	A	Jaw Width
<b>5SS1040-10-40</b>	Standard	26 [1.02]	99 [3.90]
<b>5SS1040-10-55</b>	High	41 [1.61]	99 [3.90]
<b>5SS1040-15-40</b>	Wide	26 [1.02]	148 [5.83]
<b>5SS1040-15-55</b>	Oversized	41 [1.61]	148 [5.83]

### Notes

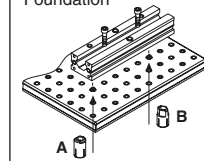
All dimensions are MM [IN]  
 Additional closure is available with an Extended Travel Coverplate.  
 Contact CHICK for details.

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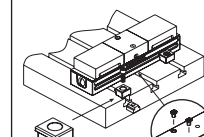
## MOUNTING

### Foundation



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

### T-Slotted Table

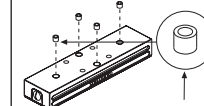


### Toe Clamps

**005-0254**

Bolt and T-Nut  
 supplied by customer

### Bottom of Base



\* Locating Bushing:  
 12mmx18mmx12mm  
**025-0370**

### Locating Keys

#### Inch Size

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

#### Metric Size

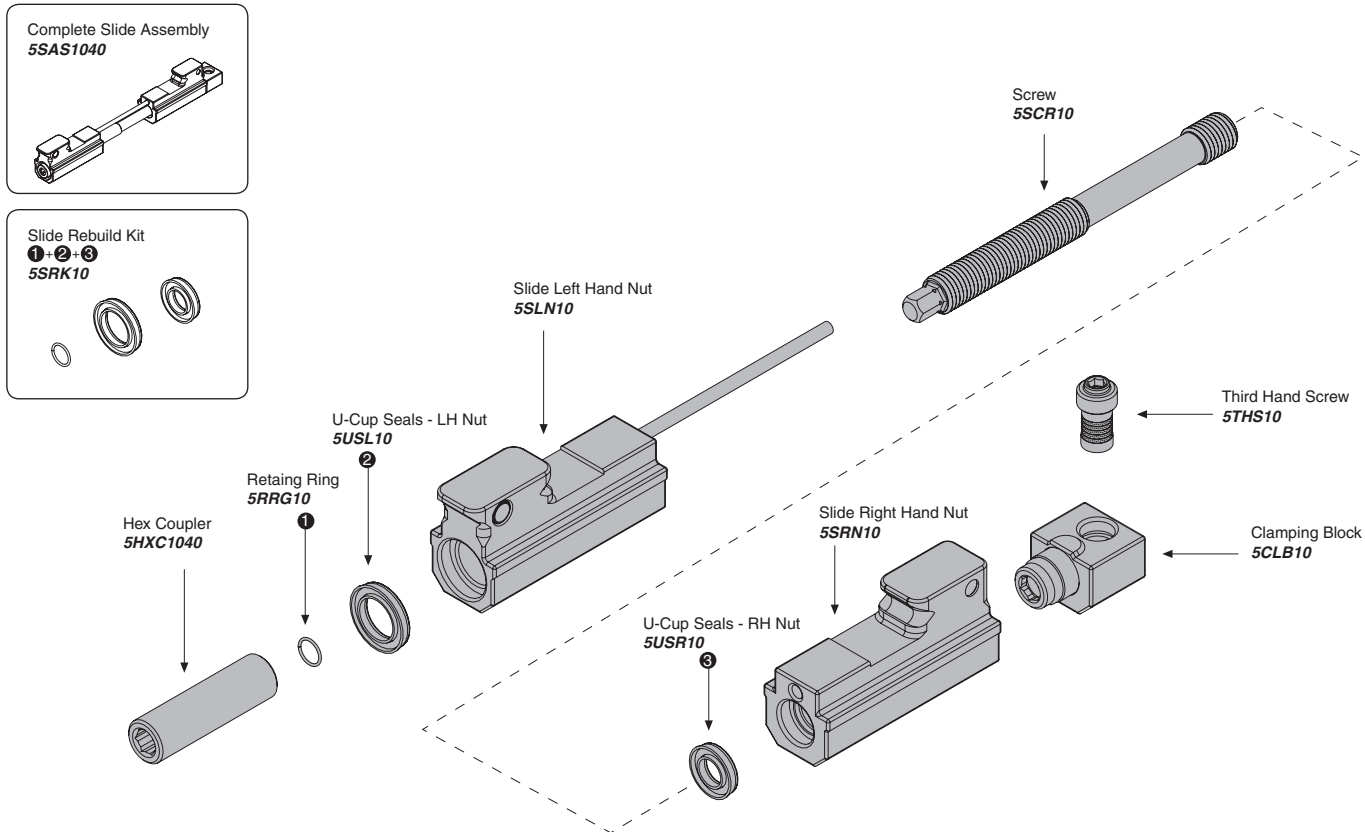
MKE10 (10mm)
MKE12 (12mm)
MKE14X18 (14mm)
MKE16 (16mm)
MKE20 (20mm)

## 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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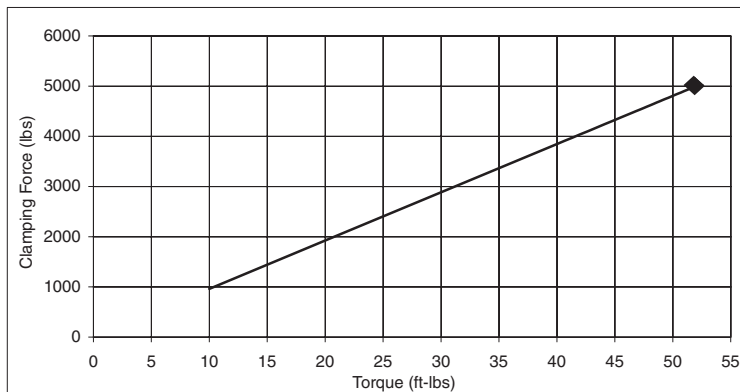
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## Pounds (lbs)

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

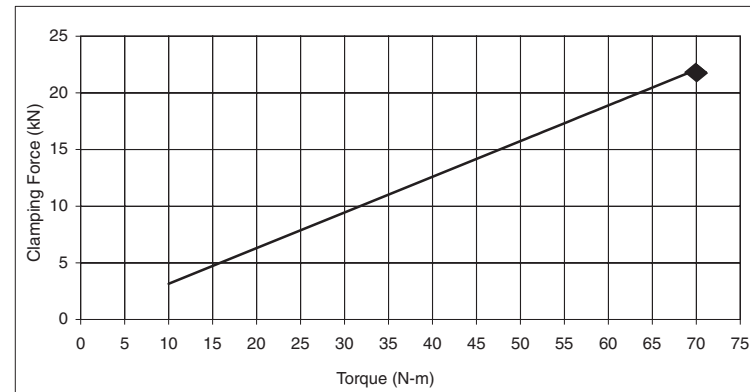


Note: ♦ Maximum Recommended Torque. Actual results may vary.

## 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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