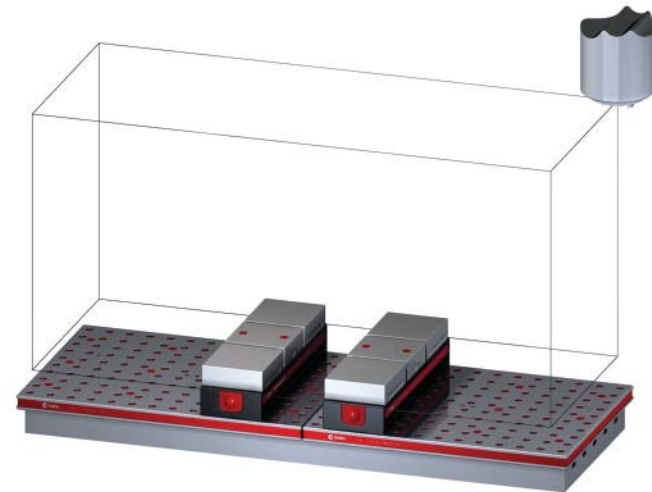


5VP-HAAS-00204

This workholding package is designed for your HAAS VF-4 machining center.



Workholding package



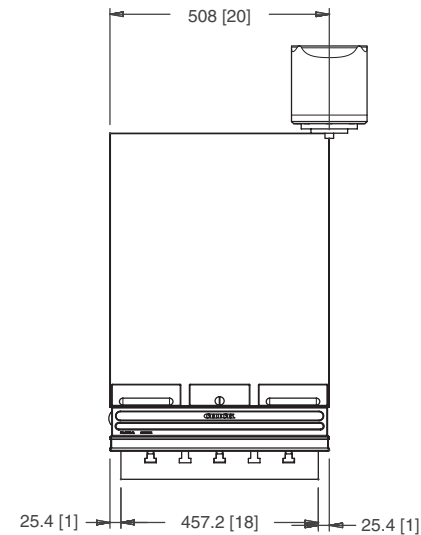
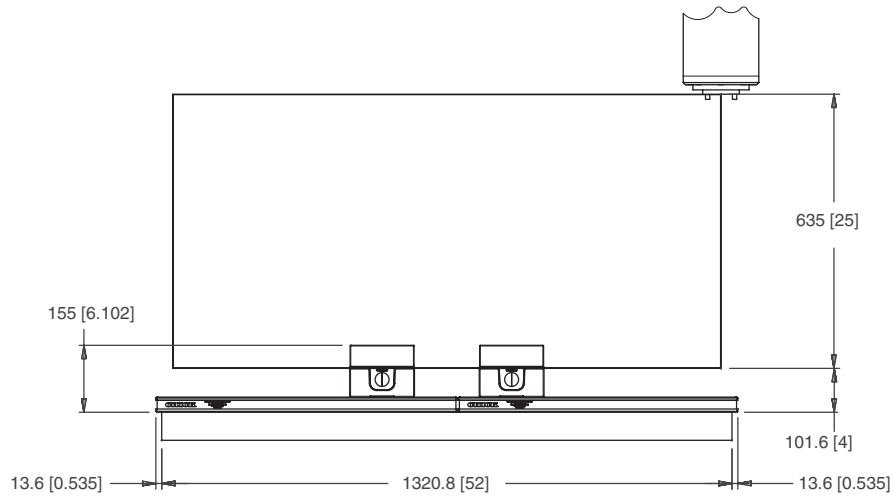
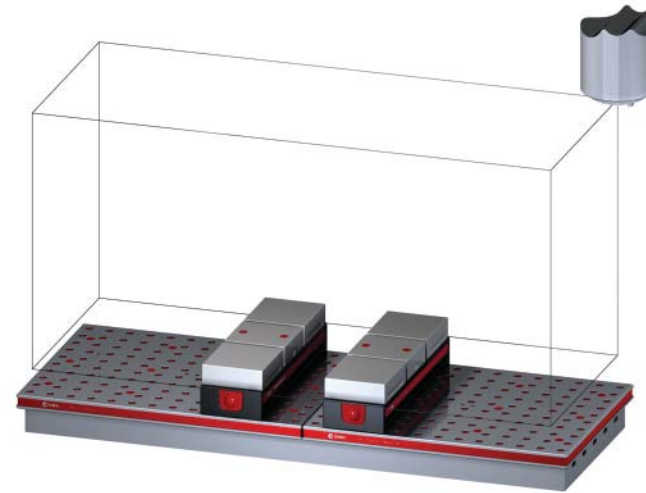
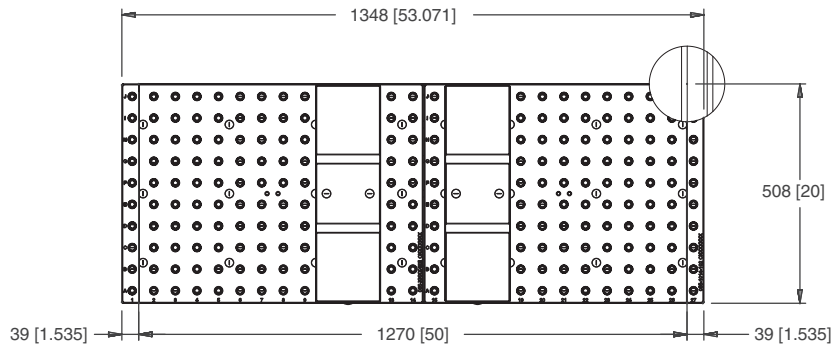
Workholding package
in machine envelope

Notes

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

5VP-HAAS-00204

This workholding package is designed for your HAAS VF-4 machining center.



Notes

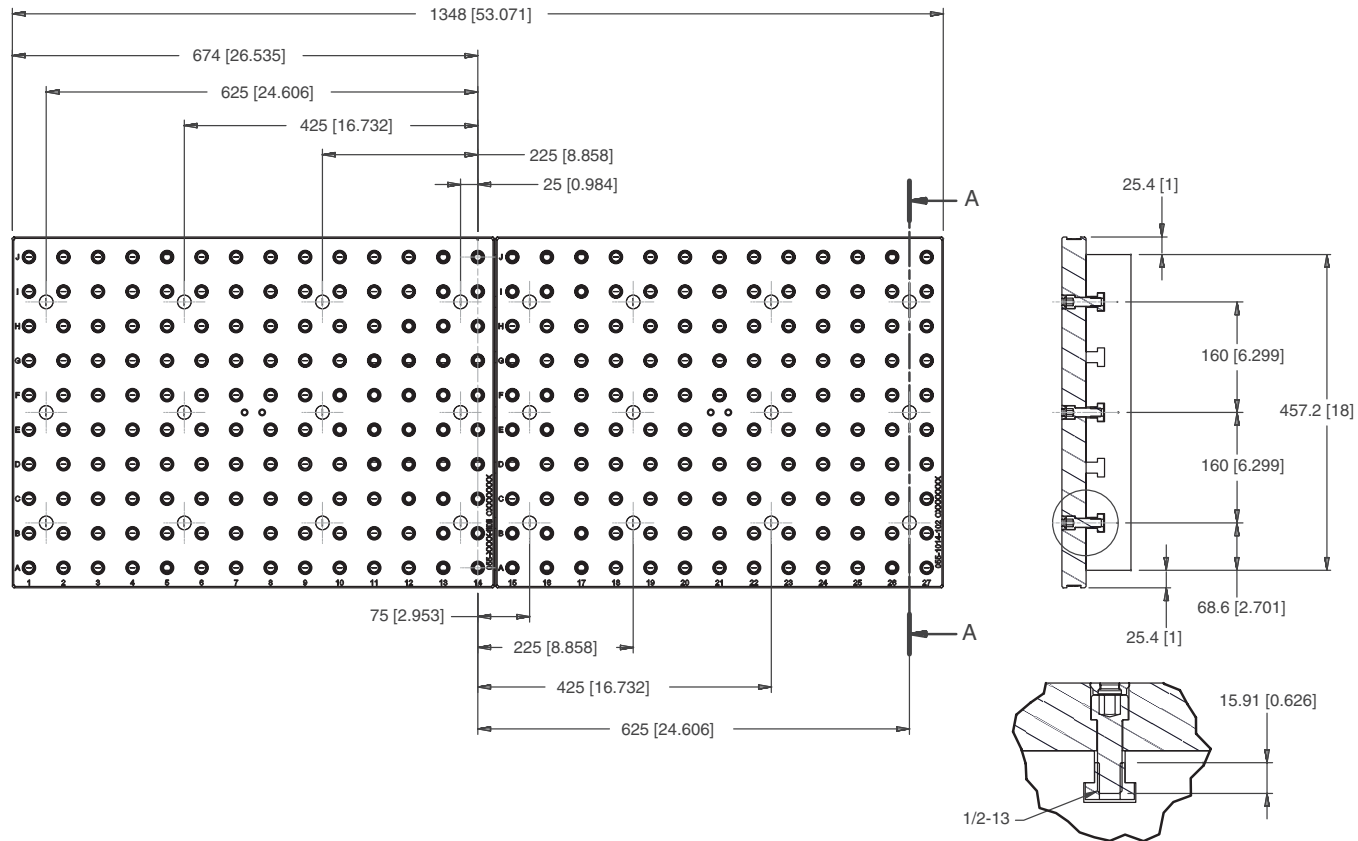
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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5VP-HAAS-00204

This workholding package is designed for your HAAS VF-4 machining center.



Notes
All dimensions are MM [IN]

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5VP-HAAS-00204

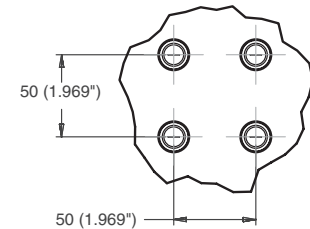
This workholding package is designed for your HAAS VF-4 machining center.

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



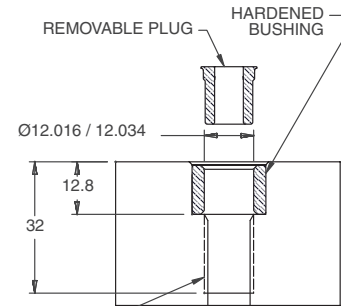
FOUNDATION MAT'L: CAST IRON
FOUNDATION INCLUDES INSTALLATION HARDWARE

DETAIL A



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

SECTION B-B



M12x1.75 TAP TO DEPTH SHOWN

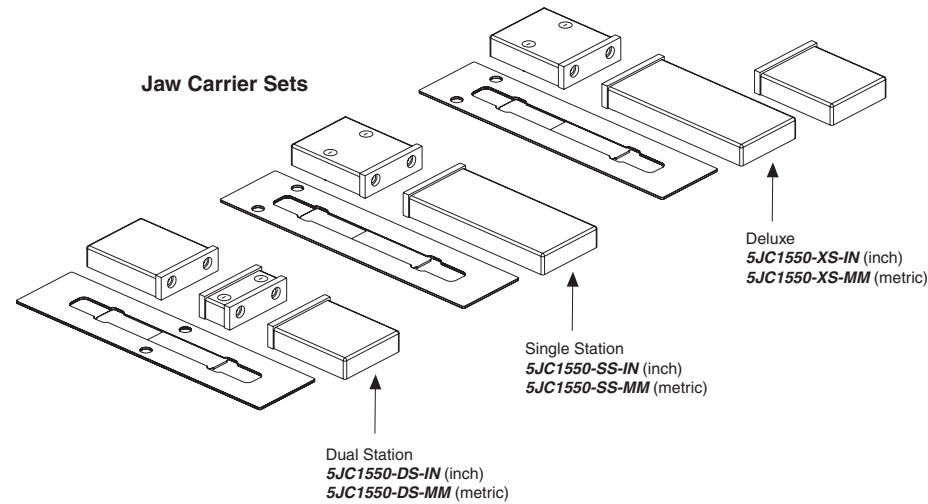
Notes
All dimensions are MM [IN]

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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.

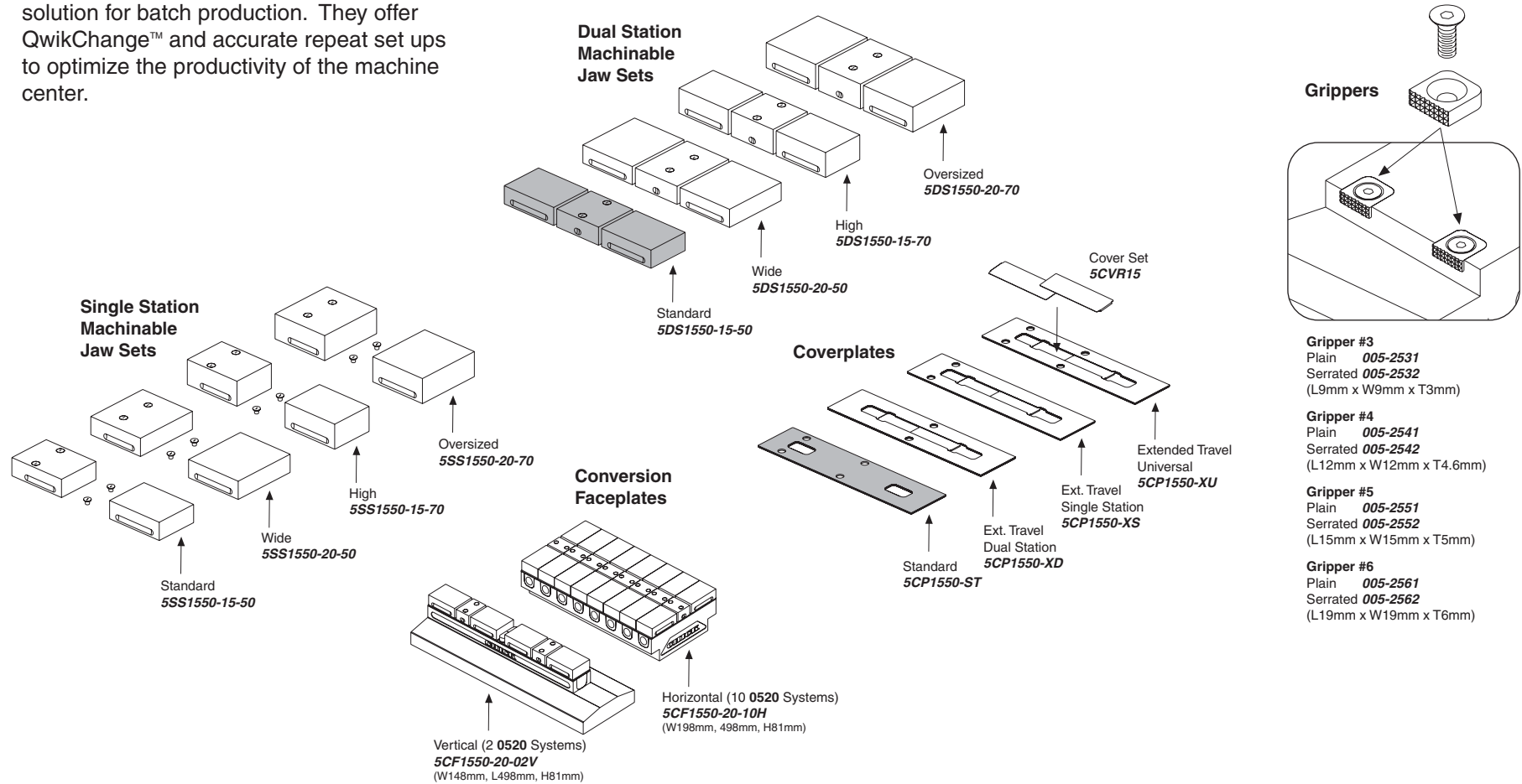


Notes

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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.



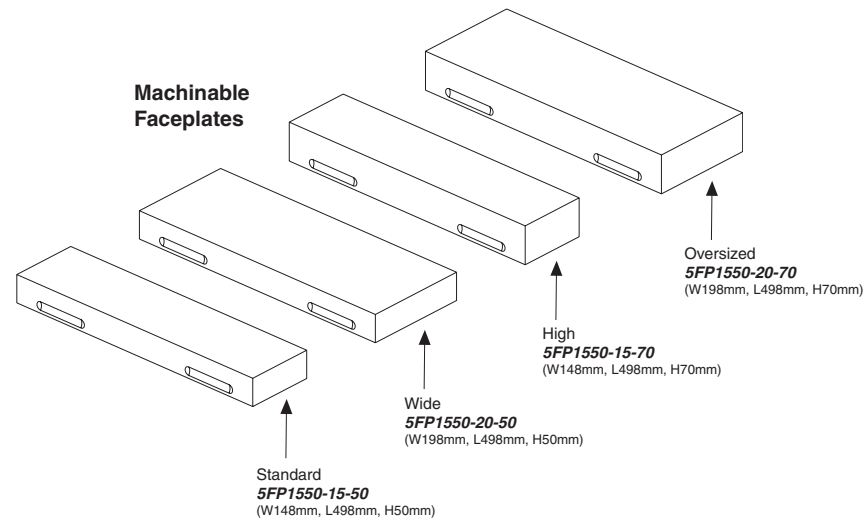
Notes

Grey item is included with a standard system

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Dedicated Fixturing

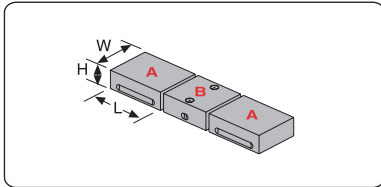
Machinable Faceplates provide QwikChange™ dedicated fixturing and are optimal for awkward or hard to hold parts. A mini pallet changer can be created by utilizing two Faceplates in tandem.



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)

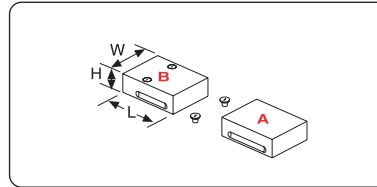
High

- 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)

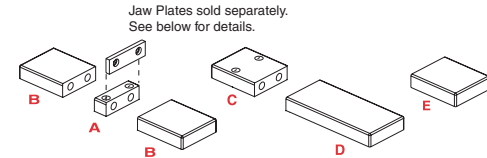
High

- 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

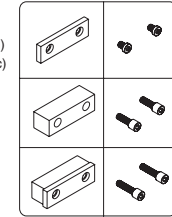
- C** Single Station Fixed
- D** Single Station Long Moveable

- 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

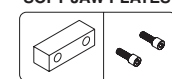
- Thick Mounting
Screws: 1/2-13x1.25"
SHCS-500-125-008

- Both Sizes
JH6STD &
JH6THK

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

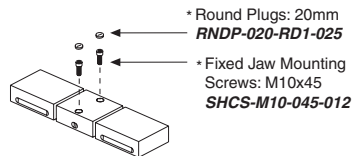
- Standard
(Set of 4)
JS6AL

SOFT JAW PLATES

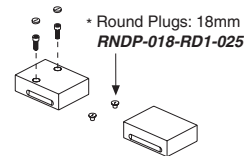


- Soft Mounting
Screws: 1/2-13x1.25"
SHCS-500-125-012

Screws and Plugs



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



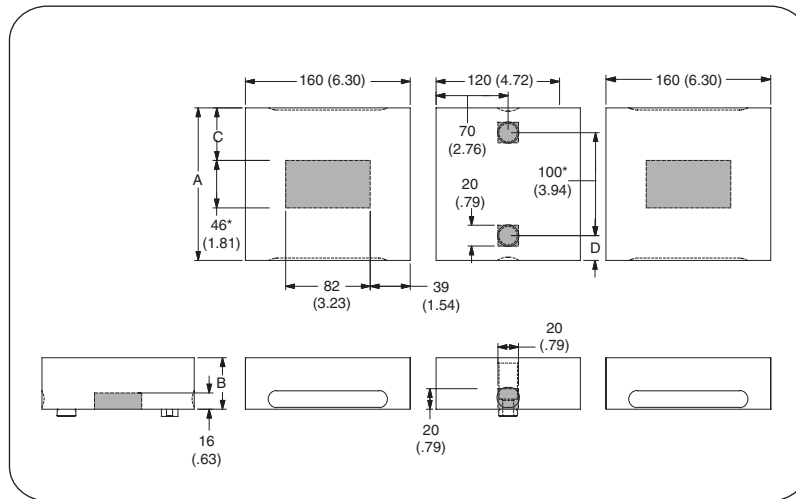
- * Round Plugs: 18mm
RNDP-018-RD1-025

Notes

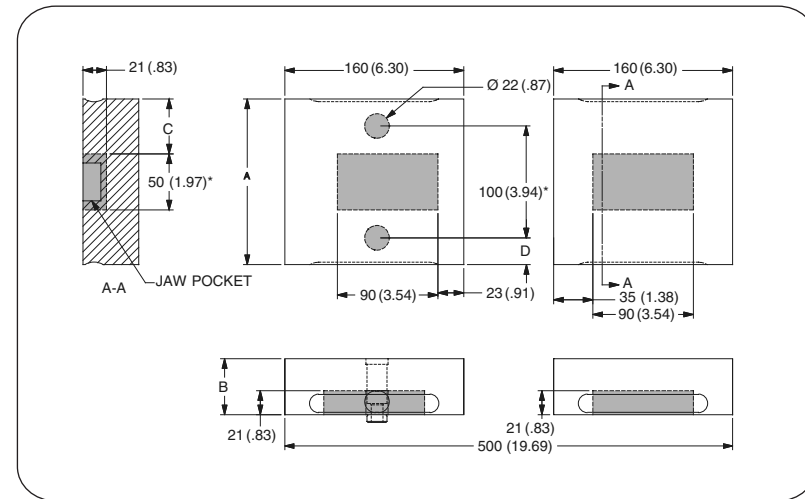
Grey or * item is included with a standard system

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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]

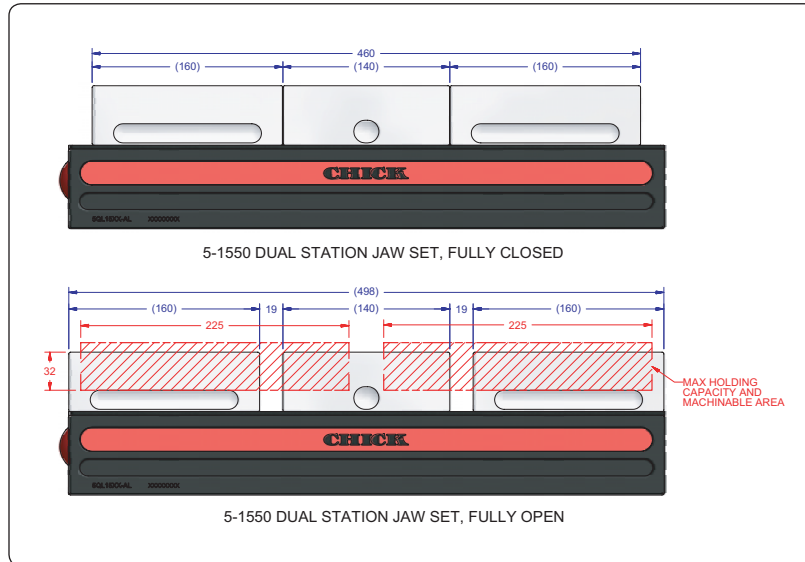
Item Number	Description	A	B	C	D
5SS1550-15-50	Standard	148 [5.83]	50 [1.97]	49 [1.93]	24 [.94]
5SS1550-15-70	High	148 [5.83]	70 [2.76]	49 [1.93]	24 [.94]
5SS1550-20-50	Wide	198 [7.80]	50 [1.97]	74 [2.91]	49 [1.93]
5SS1550-20-70	Oversized	198 [7.80]	70 [2.76]	74 [2.91]	49 [1.93]

Notes

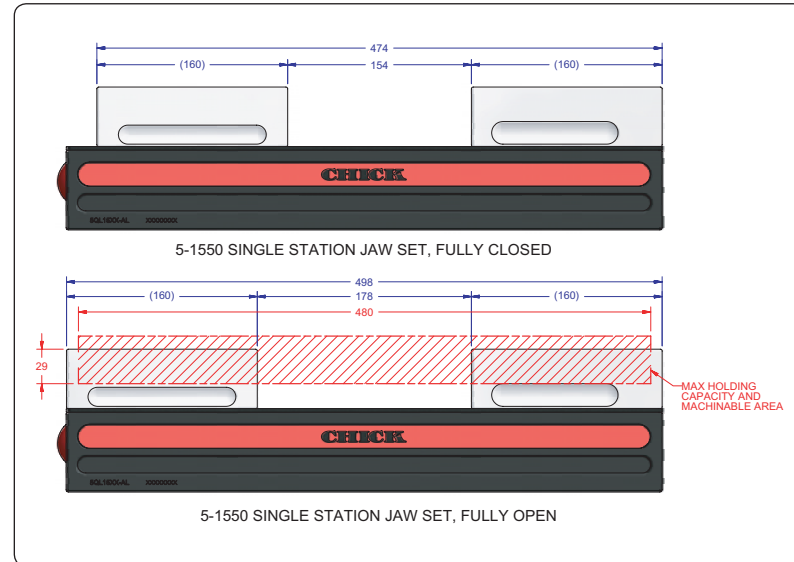
Grey area indicates no cut zone
 All dimensions are MM [IN]
 Dimensions centered on the "A" dimension.

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Dual Station



Single Station



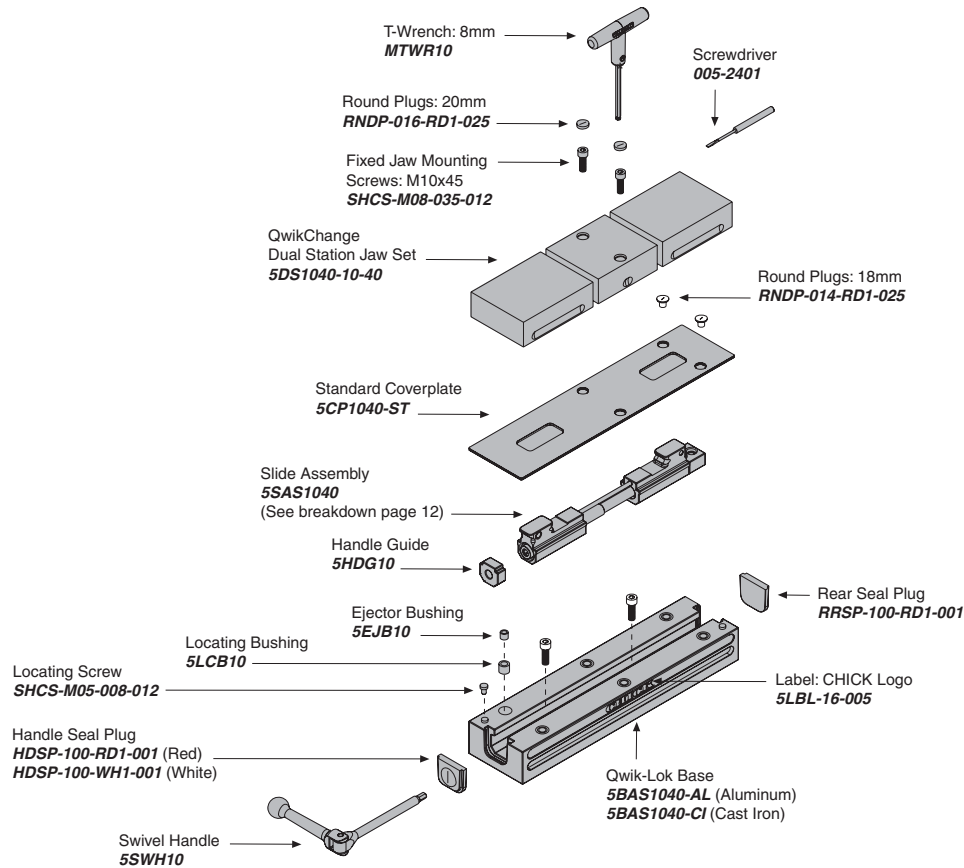
Item Number	Description	A	Jaw Width
5DS1550-15-50	Standard	32 [1.26]	148 [5.83]
5DS1550-15-70	High	52 [2.05]	148 [5.83]
5DS1550-20-50	Wide	32 [1.26]	198 [7.80]
5DS1550-20-70	Oversized	52 [2.05]	198 [7.80]

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

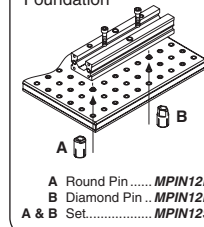
All dimensions are MM [IN]
 Additional closure is available with an Extended Travel Coverplate.
 Contact CHICK for details.

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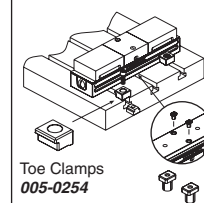


MOUNTING

Foundation

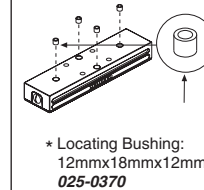


T-Slotted Table



Bolt and T-Nut
supplied by customer

Bottom of Base

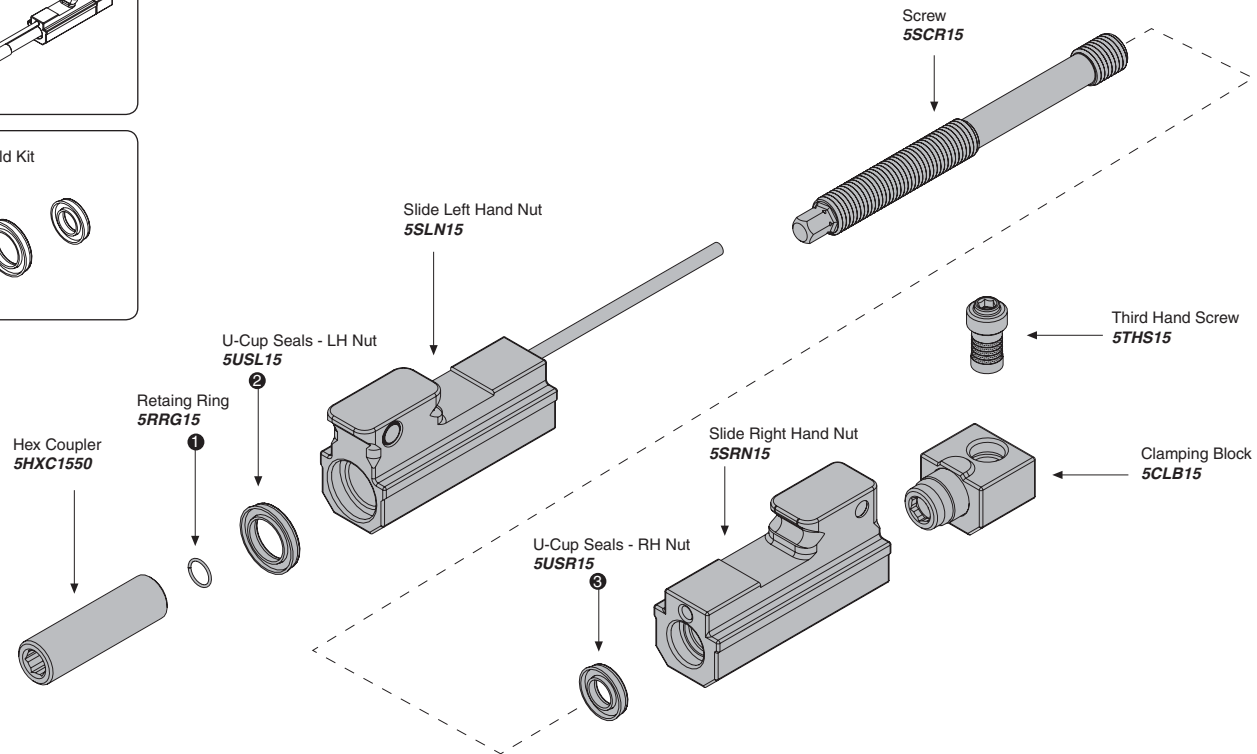
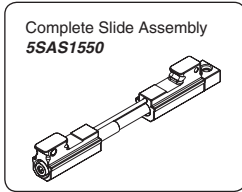


Locating Keys	
Inch Size	
MKE500	(1/2")
MKE562	(9/16")
MKE625	(5/8")
MKE688	(11/16")
MKE750	(3/4")
MKE812	(13/16")
Metric Size	
MKE10	(10mm)
MKE12	(12mm)
MKE14X18	(14mm)
MKE16	(16mm)
MKE20	(20mm)

Notes

Grey items are included with a standard system
For QwikChange™ Jaw accessories, see pages 5-8

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Notes

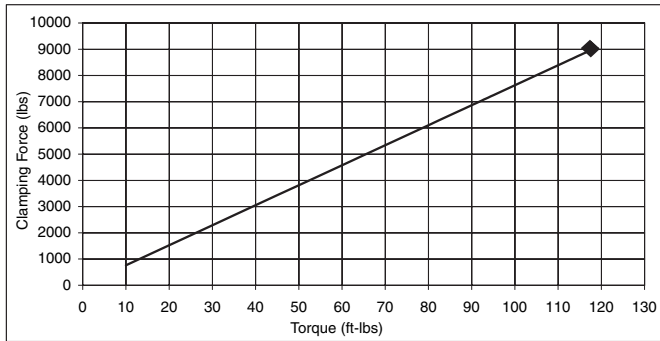
Grey items are included with a standard system

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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

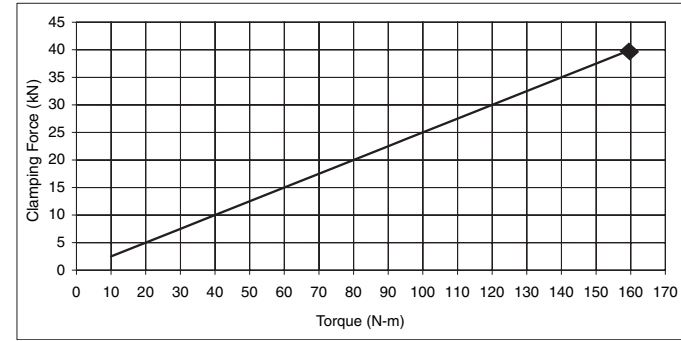


Note:  Maximum Recommended Torque. Actual results may vary.

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.

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