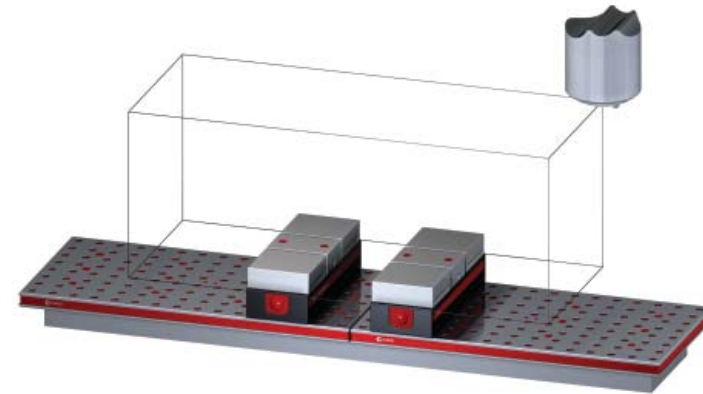


## 5VP-HAAS-00250

This workholding package is designed for your HAAS TM-2 (Inch) machining center.



Workholding package



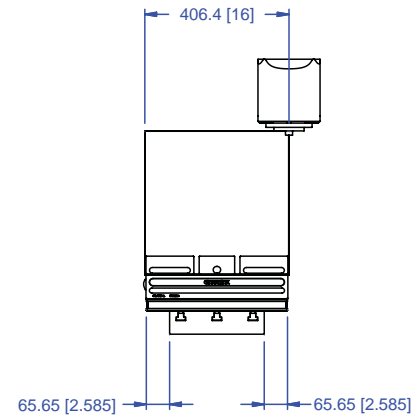
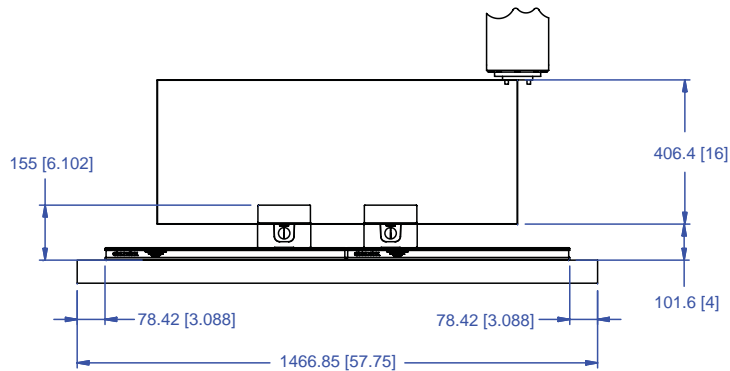
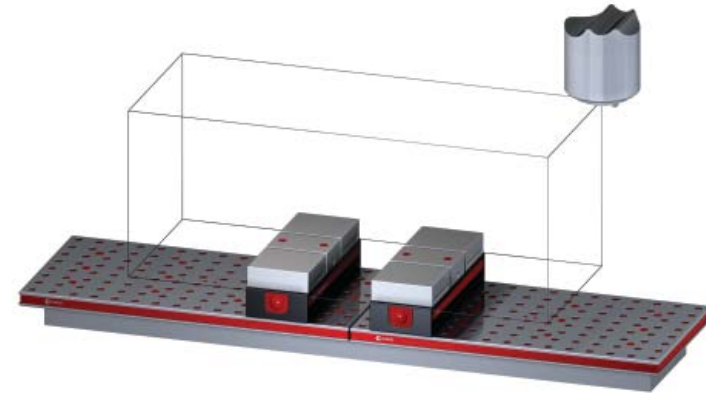
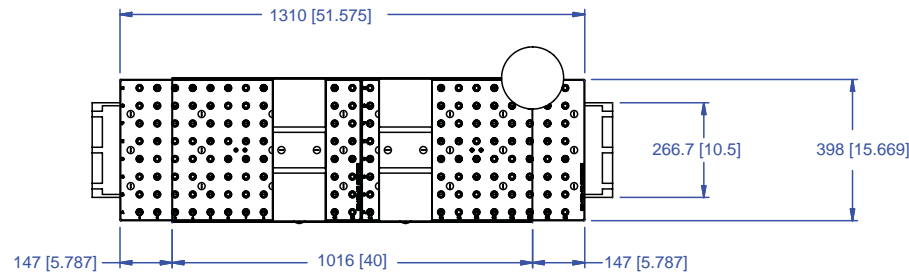
Workholding package  
in machine envelope

Notes

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# 5VP-HAAS-00250

This workholding package is designed for your HAAS TM-2 (Inch) machining center.



**Notes**

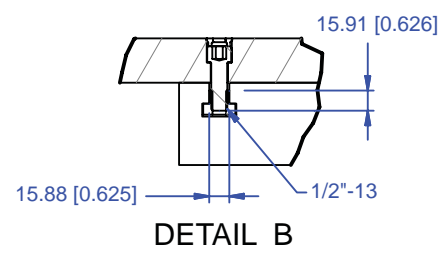
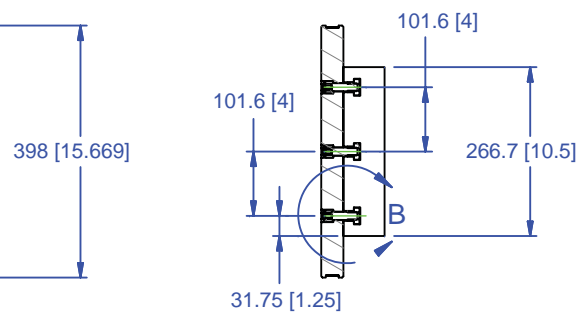
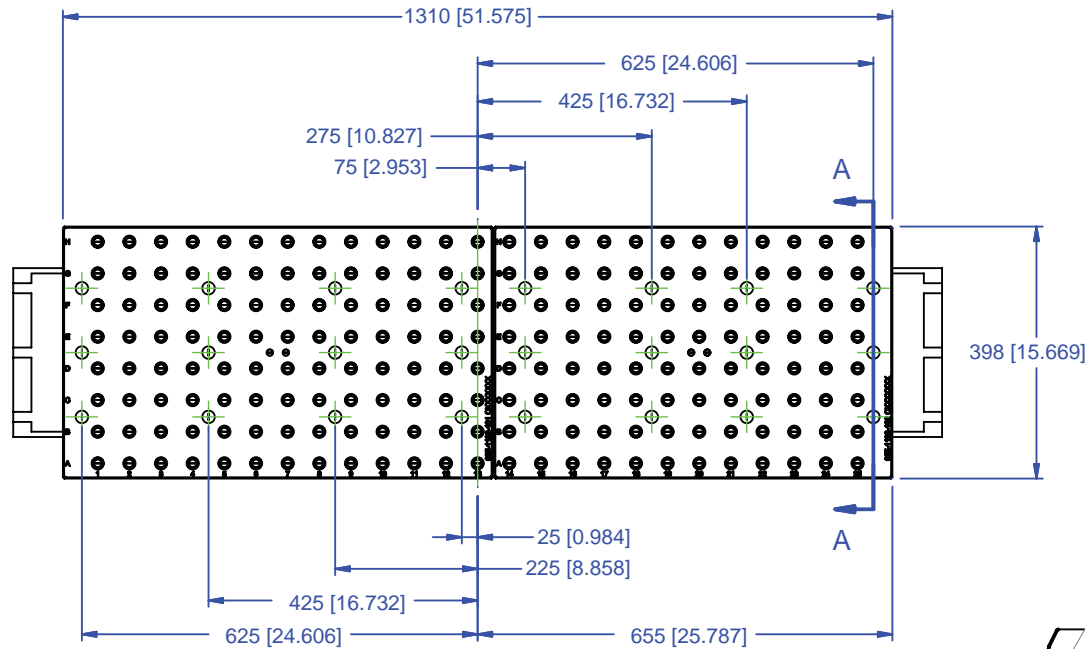
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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# 5VP-HAAS-00250

This workholding package is designed for your HAAS TM-2 (Inch) machining center.



Notes  
All dimensions are MM [IN]

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# 5VP-HAAS-00250

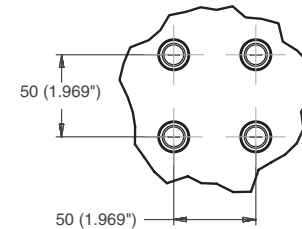
This workholding package is designed for your HAAS TM-2 (Inch) machining center.

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



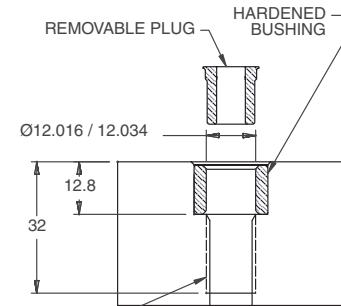
FOUNDATION MAT'L: CAST IRON  
FOUNDATION INCLUDES INSTALLATION HARDWARE

**DETAIL A**



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

**SECTION B-B**



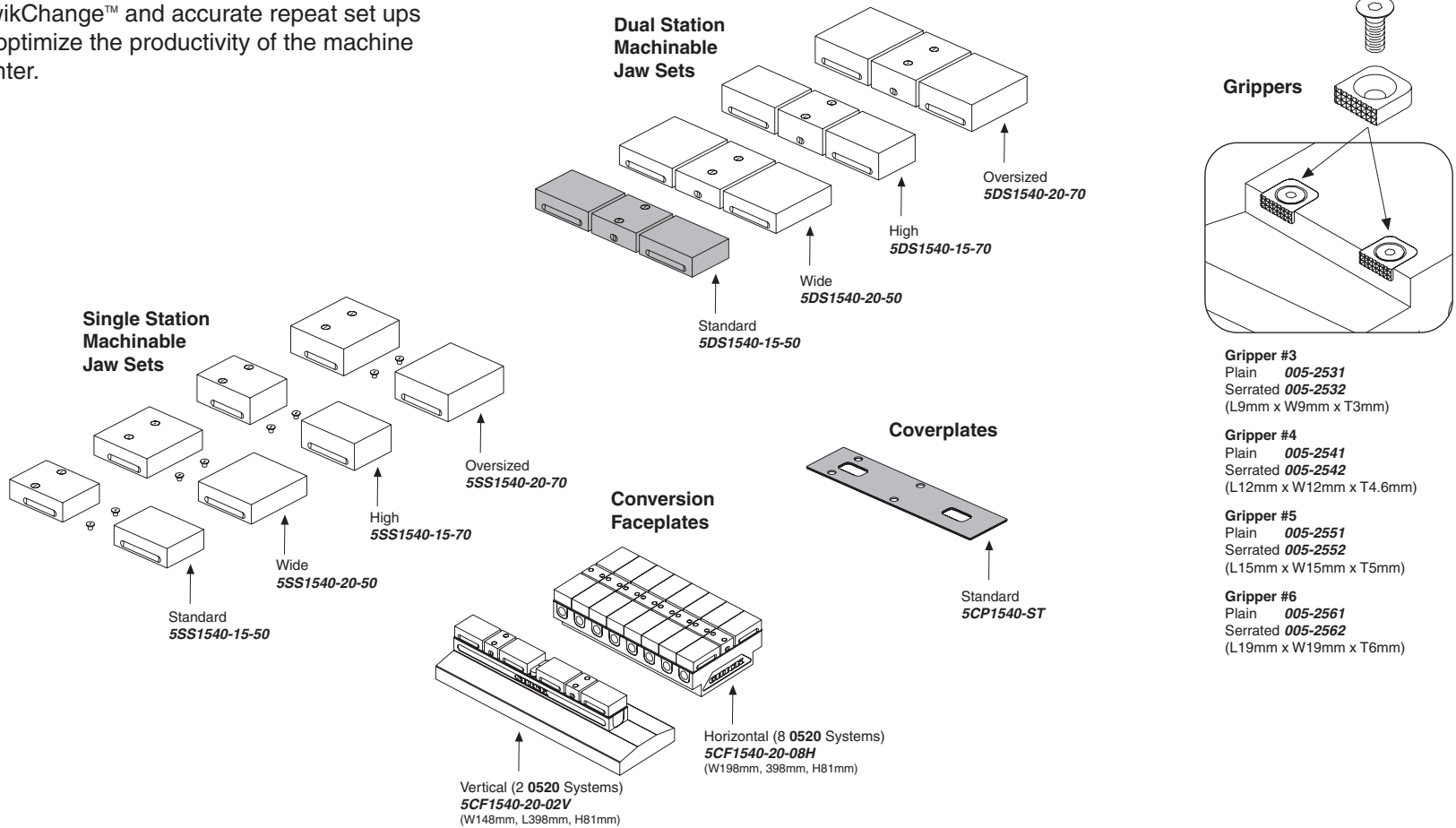
M12x1.75 TAP TO DEPTH SHOWN

Notes  
All dimensions are MM [IN]

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## 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.



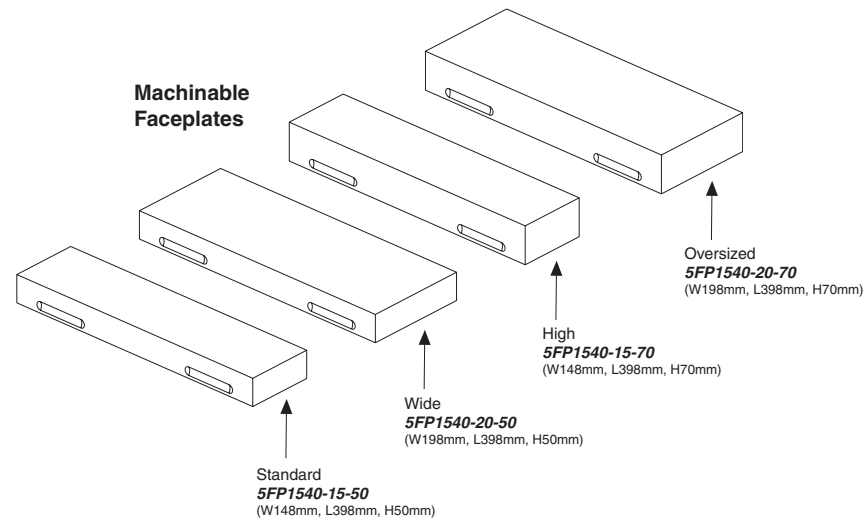
**Notes**

Grey item is included with a standard system

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## Dedicated Fixturing

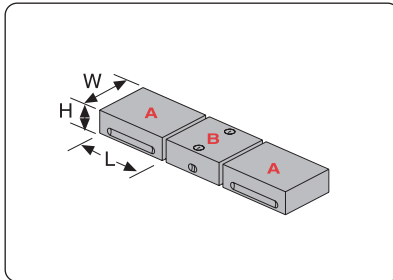
Machinable Faceplates provide QwikChange™ dedicated fixturing and are optimal for awkward or hard to hold parts. A mini pallet changer can be created by utilizing two Faceplates in tandem.



Notes

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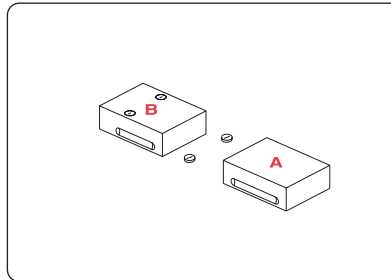
## QwikChange Machinable Dual Station Jaws



### Individual Dual Station Jaws

Standard	
<b>A</b> Moveable Jaw .....	<b>5MJ1540-15-50</b> (W148mm, H50mm, L135mm)
<b>B</b> Fixed Jaw .....	<b>5FJ1540-15-50</b> (W148mm, H50mm, L100mm)
Wide	
<b>A</b> Moveable Jaw .....	<b>5MJ1540-20-50</b> (W198mm, H50mm, L135mm)
<b>B</b> Fixed Jaw .....	<b>5FJ1540-20-50</b> (W198mm, H50mm, L100mm)
High	
<b>A</b> Moveable Jaw .....	<b>5MJ1540-15-70</b> (W148mm, H70mm, L135mm)
<b>B</b> Fixed Jaw .....	<b>5FJ1540-15-70</b> (W148mm, H70mm, L100mm)
Oversized	
<b>A</b> Moveable Jaw .....	<b>5MJ1540-20-70</b> (W198mm, H70mm, L135mm)
<b>B</b> Fixed Jaw .....	<b>5FJ1540-20-70</b> (W198mm, H70mm, L100mm)

## QwikChange Machinable Single Station Jaws

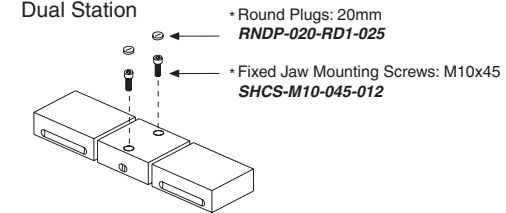


### Individual Single Station Jaws

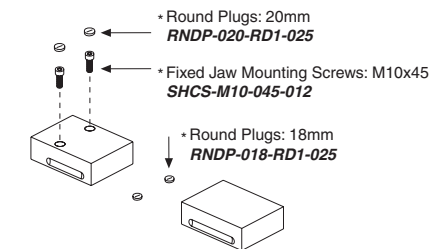
Standard	
<b>A</b> Moveable Jaw .....	<b>5MJ1540-15-50</b> (W148mm, H50mm, L135mm)
<b>B</b> Fixed Jaw .....	<b>5SJ1540-15-50</b> (W148mm, H50mm, L135mm)
Wide	
<b>A</b> Moveable Jaw .....	<b>5MJ1540-20-50</b> (W198mm, H50mm, L135mm)
<b>B</b> Fixed Jaw .....	<b>5SJ1540-20-50</b> (W198mm, H50mm, L135mm)
High	
<b>A</b> Moveable Jaw .....	<b>5MJ1540-15-70</b> (W148mm, H70mm, L135mm)
<b>B</b> Fixed Jaw .....	<b>5SJ1540-15-70</b> (W148mm, H70mm, L135mm)
Oversized	
<b>A</b> Moveable Jaw .....	<b>5MJ1540-20-70</b> (W198mm, H70mm, L135mm)
<b>B</b> Fixed Jaw .....	<b>5SJ1540-20-70</b> (W198mm, H70mm, L135mm)

## Screws and Plugs

### Dual Station

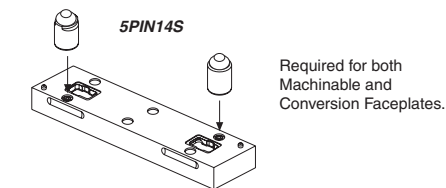


### Single Station



## Faceplate Round & Diamond Pin Set

(Included w/ Faceplate purchase)

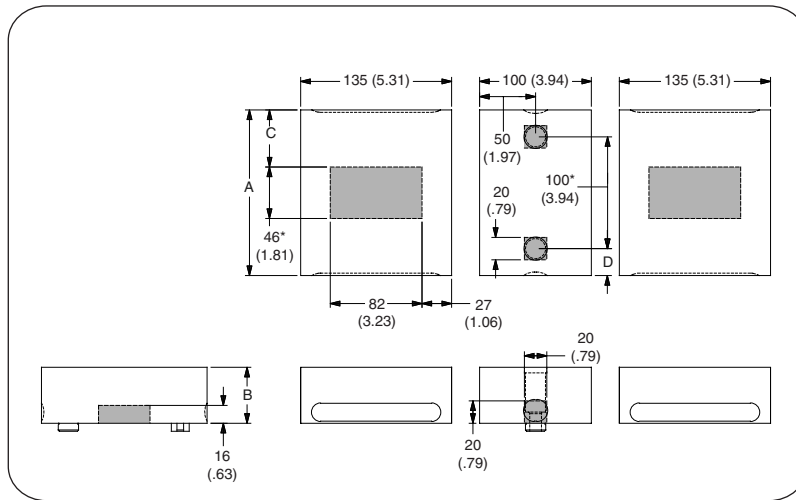


### Notes

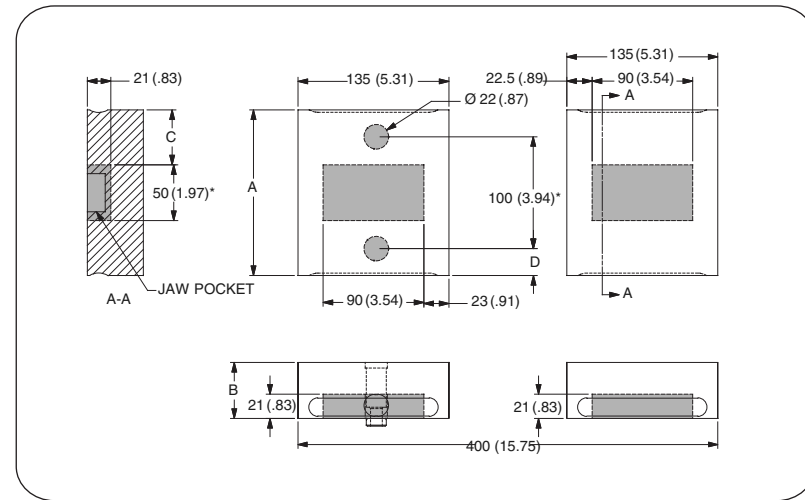
Grey or \* item is included with a standard system

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Dual Station



Single Station



Item Number	Description	A	B	C	D
5DS1540-15-50	Standard	148 [5.83]	50 [1.97]	51 [2.01]	24 [.94]
5DS1540-15-70	High	148 [5.83]	70 [2.76]	51 [2.01]	24 [.94]
5DS1540-20-50	Wide	198 [7.80]	50 [1.97]	76 [2.99]	49 [1.93]
5DS1540-20-70	Oversized	198 [7.80]	70 [2.76]	76 [2.99]	49 [1.93]

Item Number	Description	A	B	C	D
5SS1540-15-50	Standard	148 [5.83]	50 [1.97]	49 [1.93]	24 [.94]
5SS1540-15-70	High	148 [5.83]	70 [2.76]	49 [1.93]	24 [.94]
5SS1540-20-50	Wide	198 [7.80]	50 [1.97]	74 [2.91]	49 [1.93]
5SS1540-20-70	Oversized	198 [7.80]	70 [2.76]	74 [2.91]	49 [1.93]

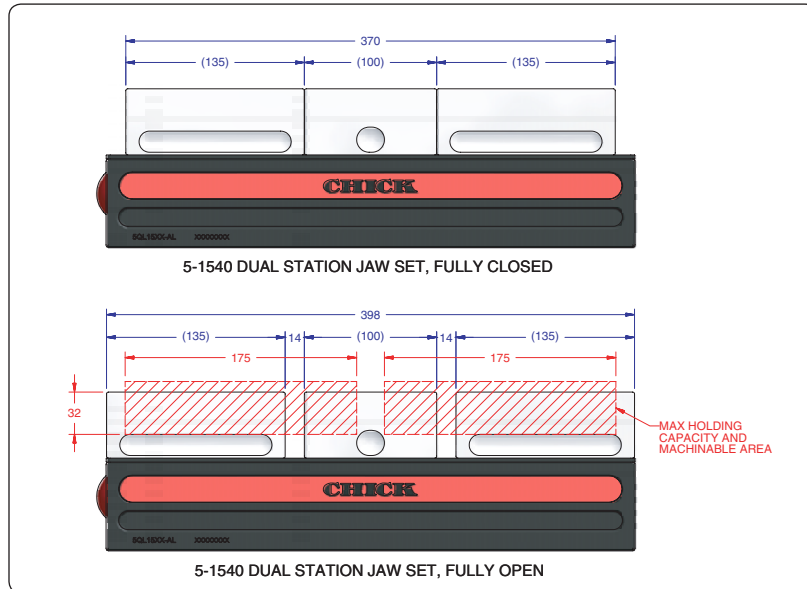
Notes

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

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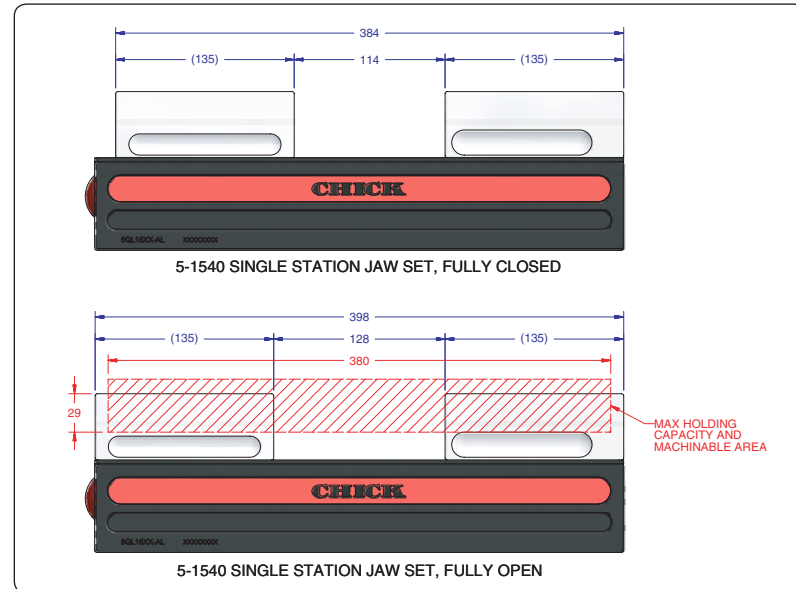


**Dual Station**



Item Number	Description	A	Jaw Width
5DS1540-15-50	Standard	32 [1.26]	148 [5.83]
5DS1540-15-70	High	52 [2.05]	148 [5.83]
5DS1540-20-50	Wide	32 [1.26]	198 [7.80]
5DS1540-20-70	Oversized	52 [2.05]	198 [7.80]

**Single Station**

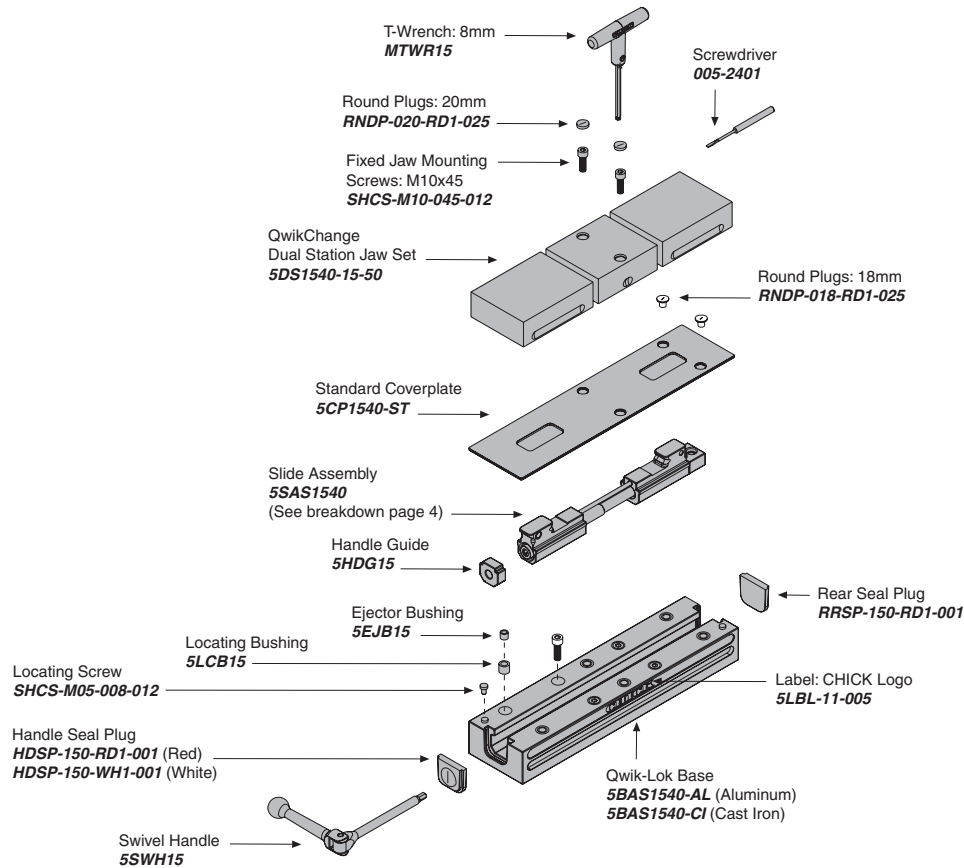


Item Number	Description	A	Jaw Width
5SS1540-15-50	Standard	29 [1.14]	148 [5.83]
5SS1540-15-70	High	49 [1.93]	148 [5.83]
5SS1540-20-50	Wide	29 [1.14]	198 [7.80]
5SS1540-20-70	Oversized	49 [1.93]	198 [7.80]

**Notes**

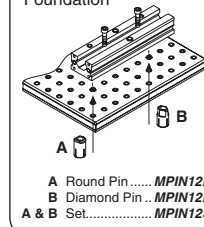
All dimensions are MM [IN]  
 Additional closure is available with an Extended Travel Coverplate.  
 Contact CHICK for details.

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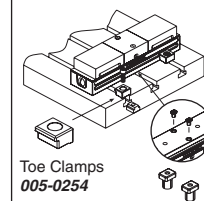


## MOUNTING

### Foundation

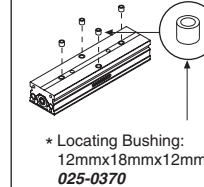


### T-Slotted Table



Bolt and T-Nut supplied by customer

### Bottom of Base



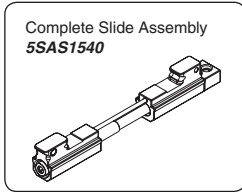
### Locating Keys

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 4-7

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**Notes**

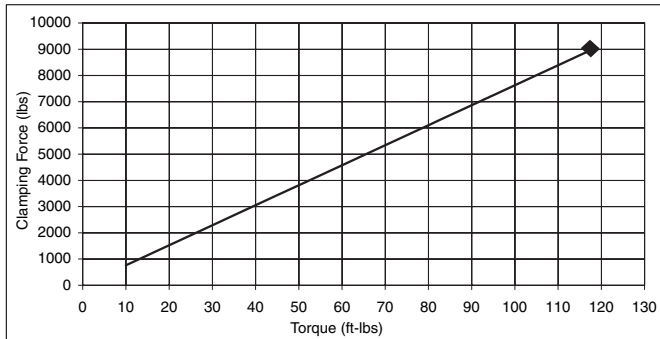
Grey items are included with a standard system

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**Pounds (lbs)**

Force	=	Torque	X	Slope
lbs	=	in-lb	x	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

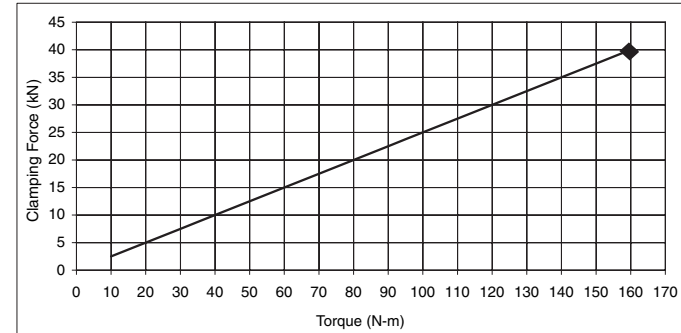


Note: ◆ Maximum Recommended Torque. Actual results may vary.

**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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