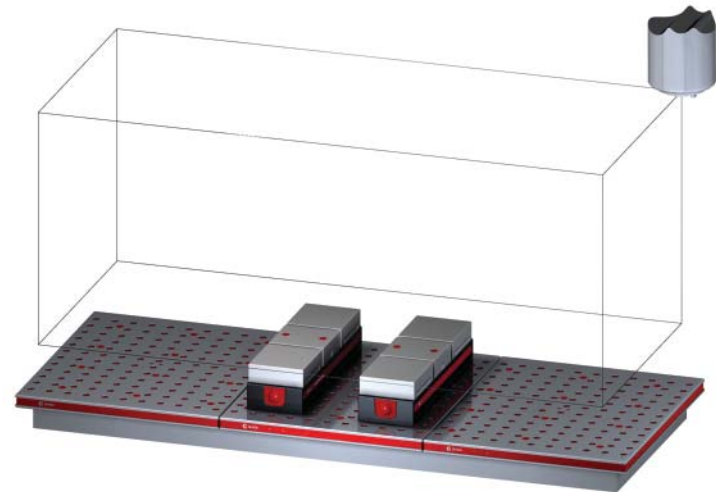


## 5VP-HAAS-00253

This workholding package is designed for your HAAS VF-5XT machining center.



Workholding package



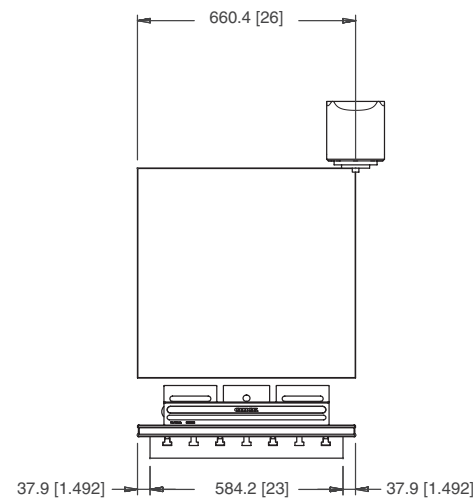
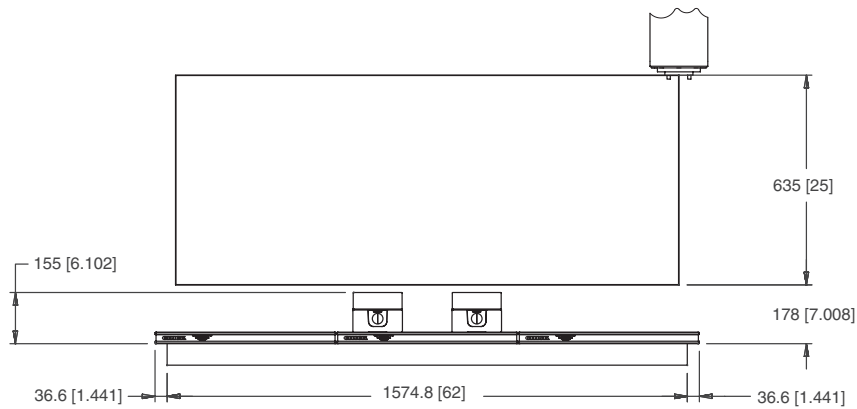
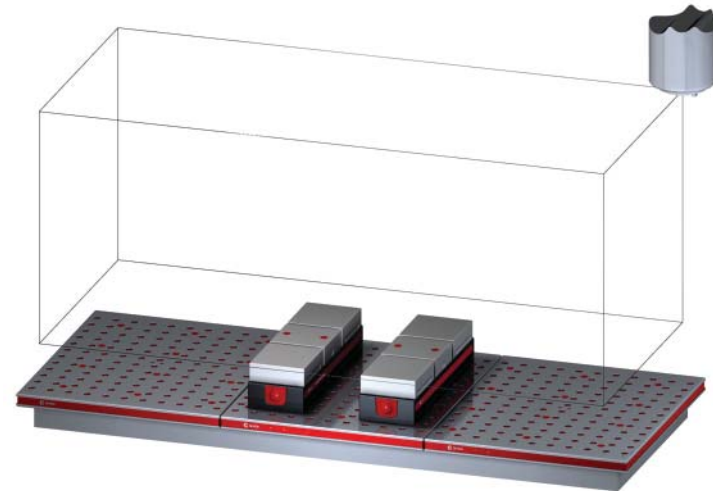
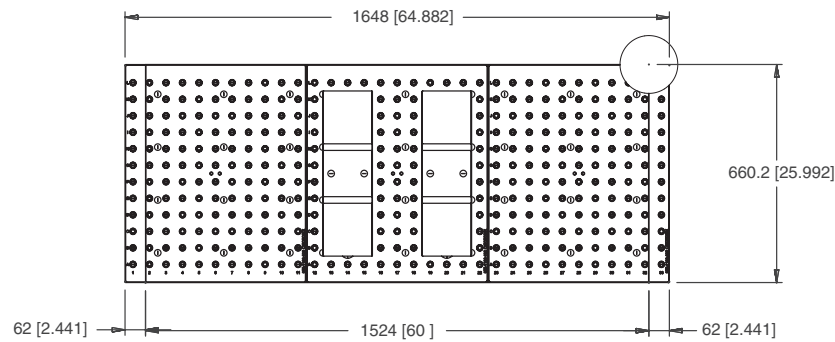
Workholding package  
in machine envelope

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-00253

This workholding package is designed for your HAAS VF-5XT machining center.



**Notes**

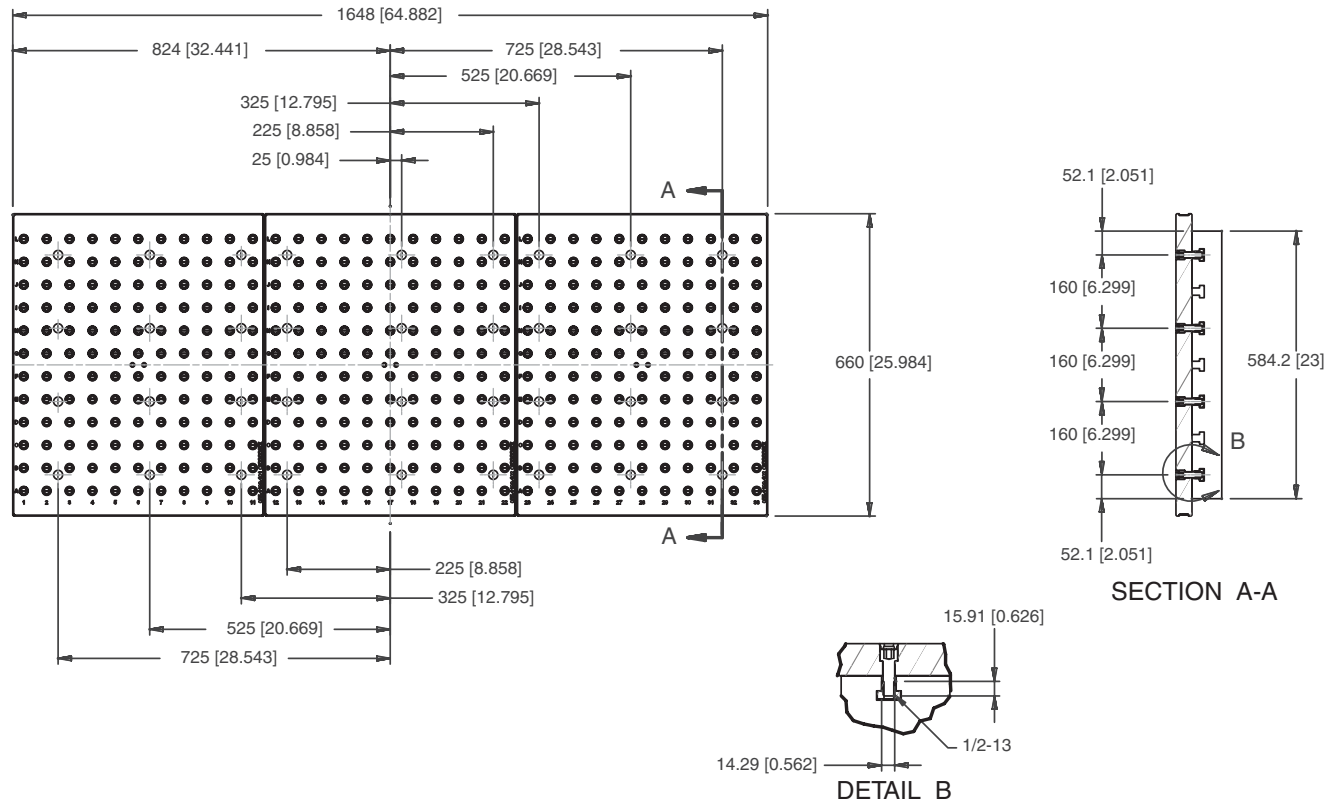
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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# 5VP-HAAS-00253

This workholding package is designed for your HAAS VF-5XT machining center.



Notes  
All dimensions are MM [IN]

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# 5VP-HAAS-00253

This workholding package is designed for your HAAS VF-5XT machining center.

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



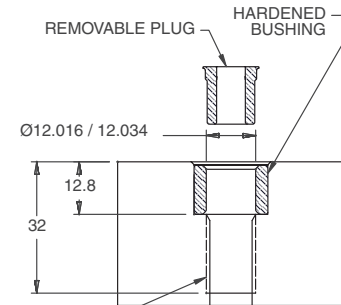
FOUNDATION MAT'L: CAST IRON  
FOUNDATION INCLUDES INSTALLATION HARDWARE

### DETAIL A



HOLE SPACING TOLERANCE  
 $\pm 0.02$  TO 500mm  
 $\pm 0.03$  TO 1200mm

### SECTION B-B



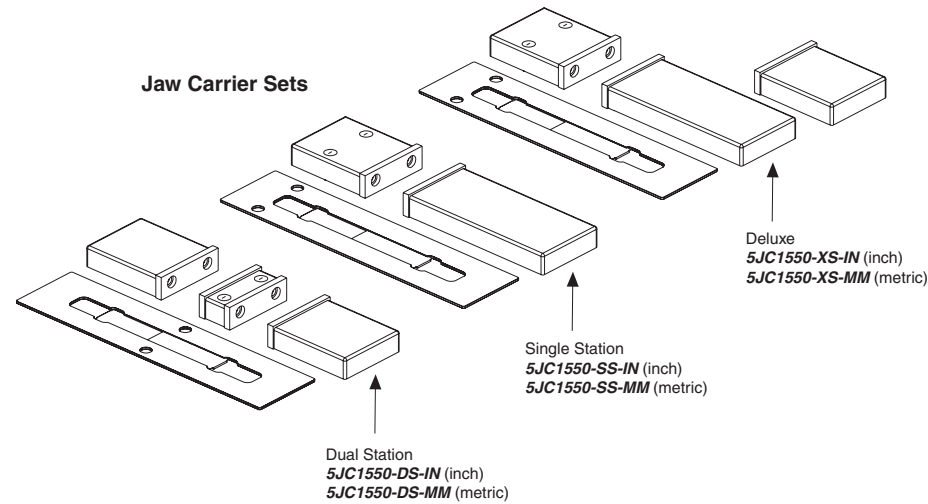
Notes  
All dimensions are MM [IN]

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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.

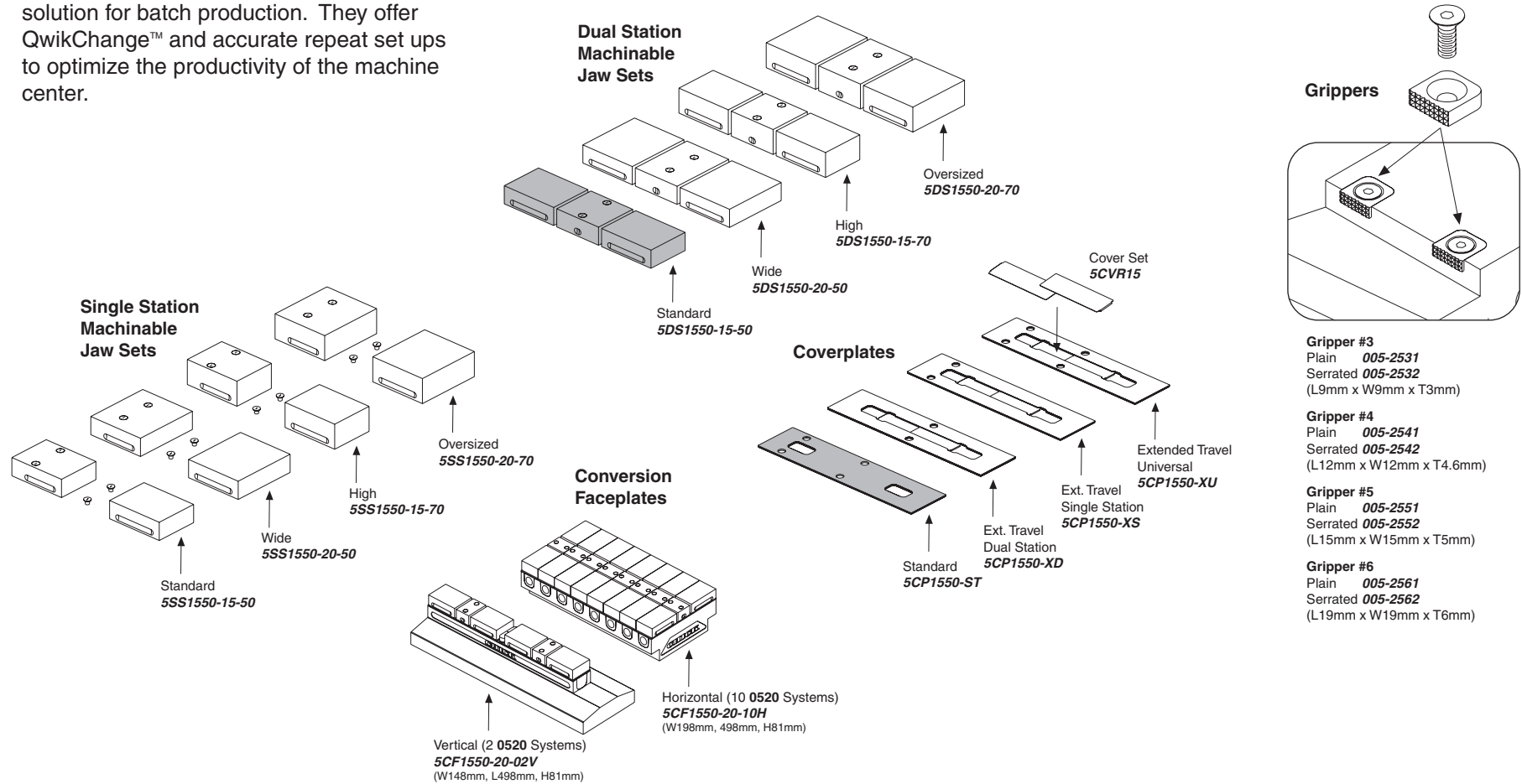


Notes

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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.



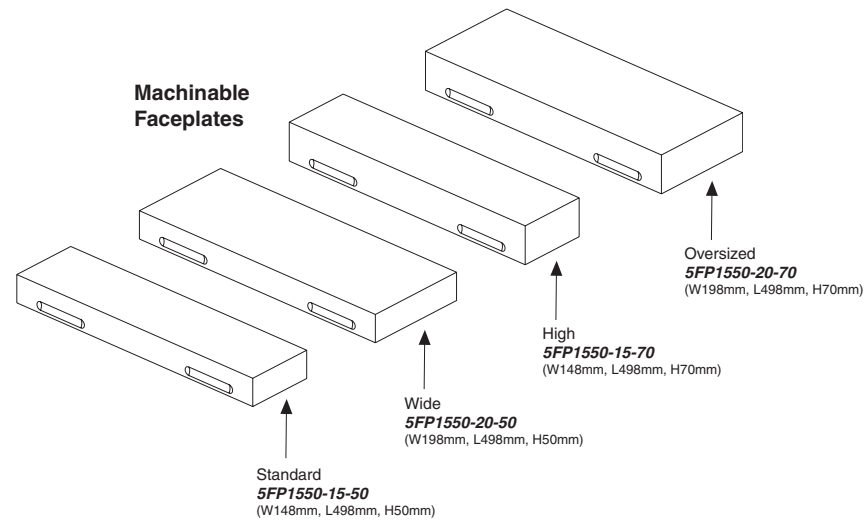
**Notes**

Grey item is included with a standard system

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## Dedicated Fixturing

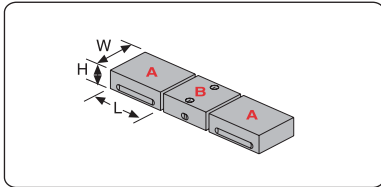
Machinable Faceplates provide QwikChange™ dedicated fixturing and are optimal for awkward or hard to hold parts. A mini pallet changer can be created by utilizing two Faceplates in tandem.



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)

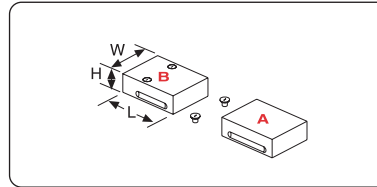
High

- 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)

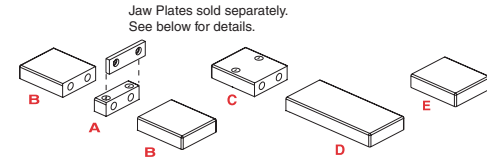
High

- 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

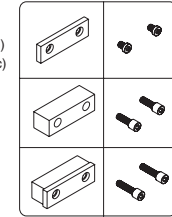
- C** Single Station Fixed
- D** Single Station Long Moveable

- 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**

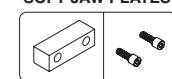
- Thick Mounting  
Screws: 1/2-13x1.25"  
**SHCS-500-125-008**

- Both Sizes  
**JH6STD** &  
**JH6THK**

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

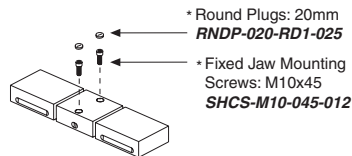
- Standard  
(Set of 4)  
**JS6AL**

### SOFT JAW PLATES

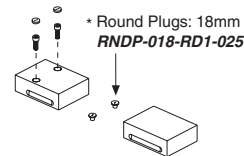


- Soft Mounting  
Screws: 1/2-13x1.25"  
**SHCS-500-125-012**

## 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**

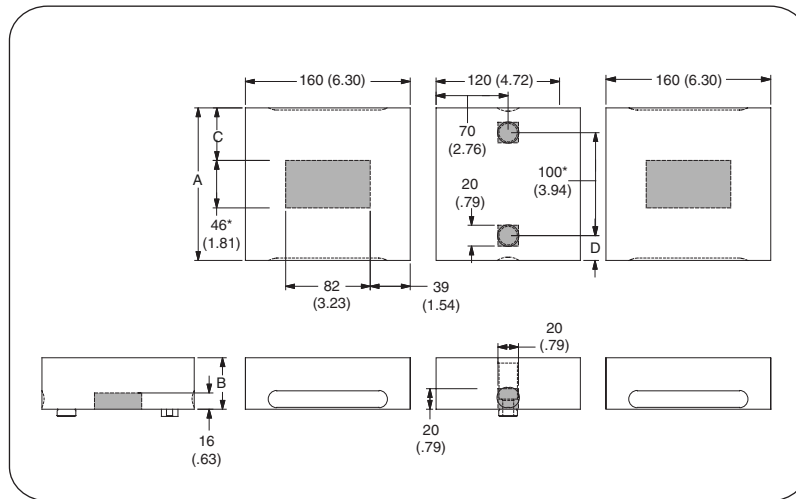
## Notes

Grey or \* item is included with a standard system

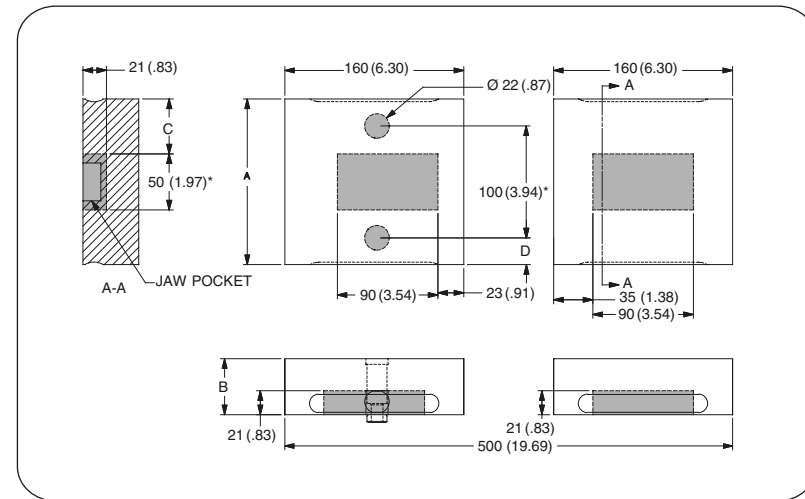
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**Dual Station**



**Single Station**



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

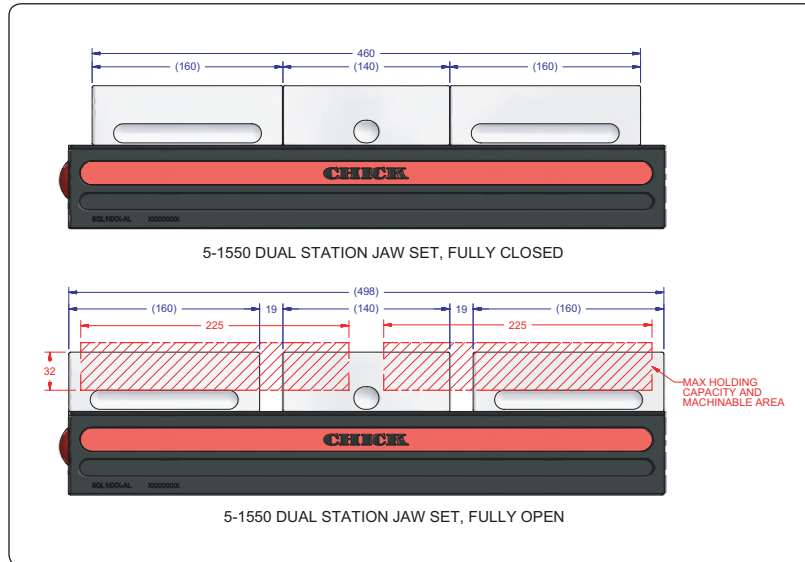
Item Number	Description	A	B	C	D
5SS1550-15-50	Standard	148 [5.83]	50 [1.97]	49 [1.93]	24 [.94]
5SS1550-15-70	High	148 [5.83]	70 [2.76]	49 [1.93]	24 [.94]
5SS1550-20-50	Wide	198 [7.80]	50 [1.97]	74 [2.91]	49 [1.93]
5SS1550-20-70	Oversized	198 [7.80]	70 [2.76]	74 [2.91]	49 [1.93]

**Notes**

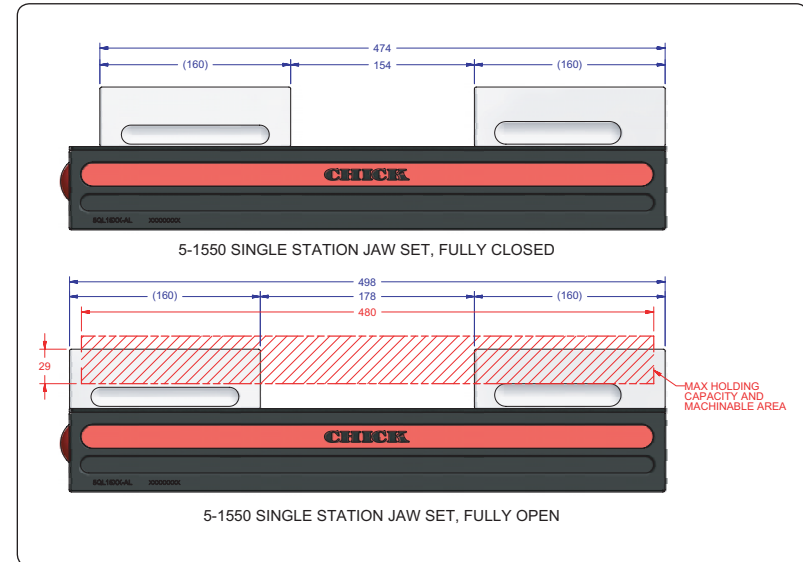
Grey area indicates no cut zone  
 All dimensions are MM [IN]  
 Dimensions centered on the "A" dimension.

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**Dual Station**



**Single Station**



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

Item Number	Description	A	Jaw Width
<b>5SS1550-15-50</b>	Standard	29 [1.14]	148 [5.83]
<b>5SS1550-15-70</b>	High	49 [1.93]	148 [5.83]
<b>5SS1550-20-50</b>	Wide	29 [1.14]	198 [7.80]
<b>5SS1550-20-70</b>	Oversized	49 [1.93]	198 [7.80]

**Notes**

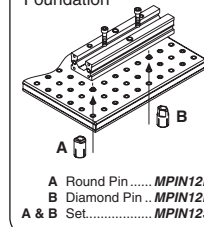
All dimensions are MM [IN]  
 Additional closure is available with an Extended Travel Coverplate.  
 Contact CHICK for details.

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**MOUNTING**

**Foundation**



**T-Slotted Table**



Bolt and T-Nut supplied by customer

**Bottom of Base**



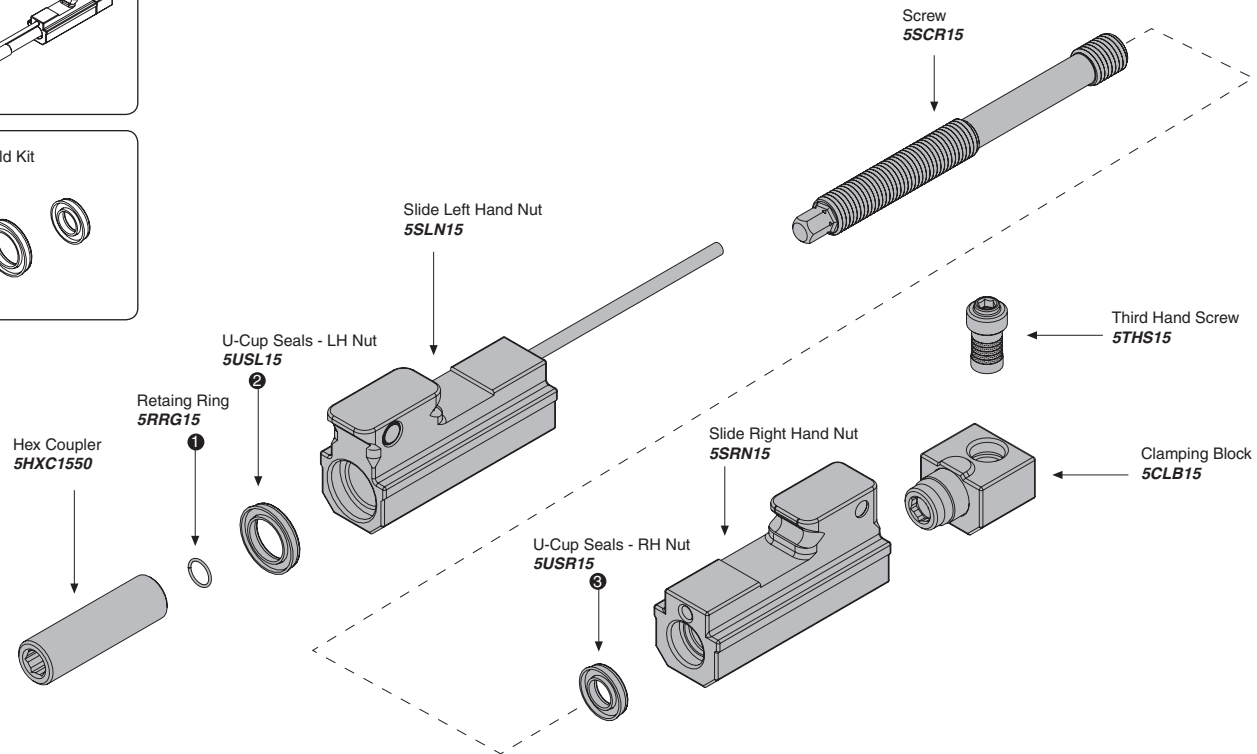
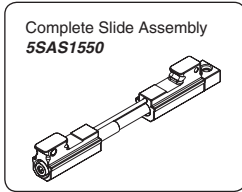
**Locating Keys**

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**

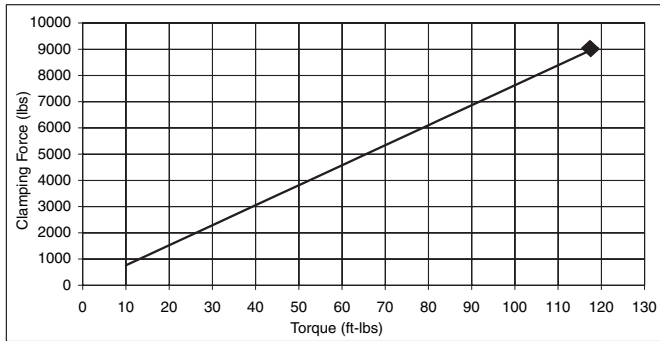
Grey items are included with a standard system

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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

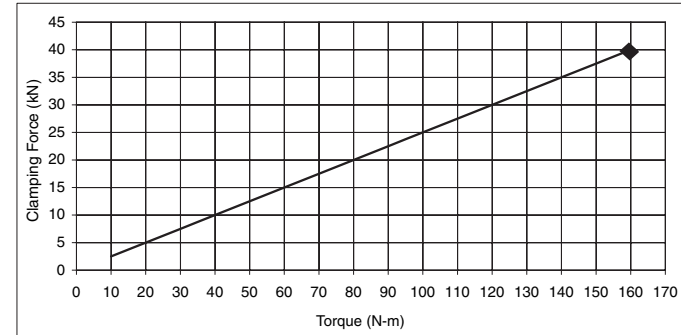


Note: ◆ Maximum Recommended Torque. Actual results may vary.

**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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