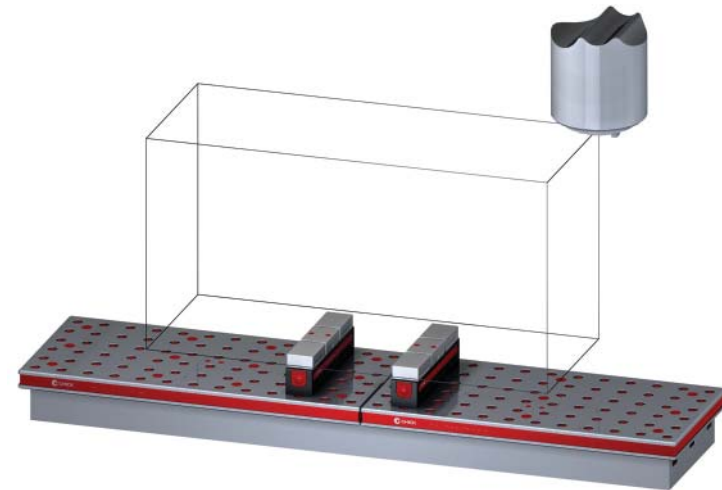


## 5VP-HAAS-00282

This workholding package is designed for your HAAS TM-1P (Metric) machining center.



Workholding package



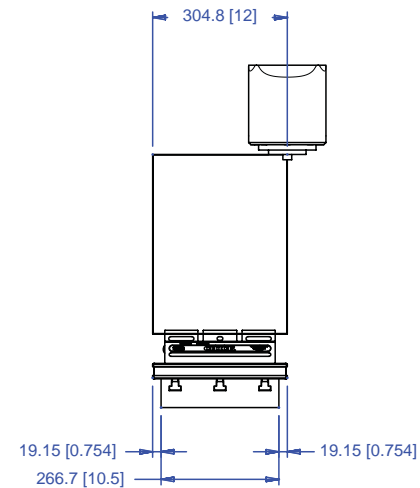
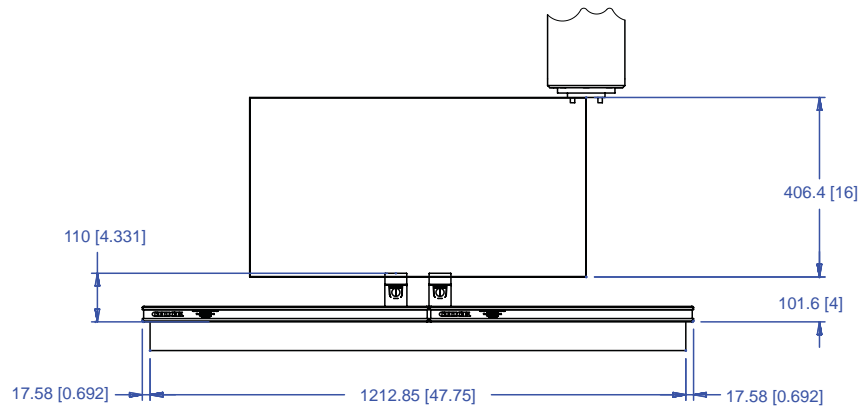
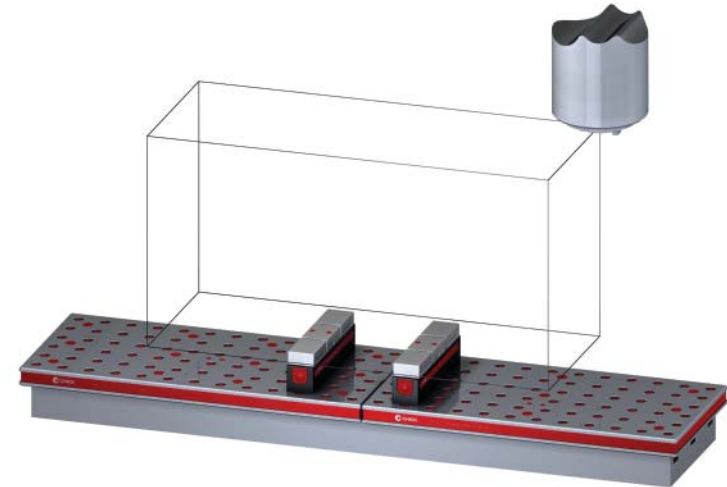
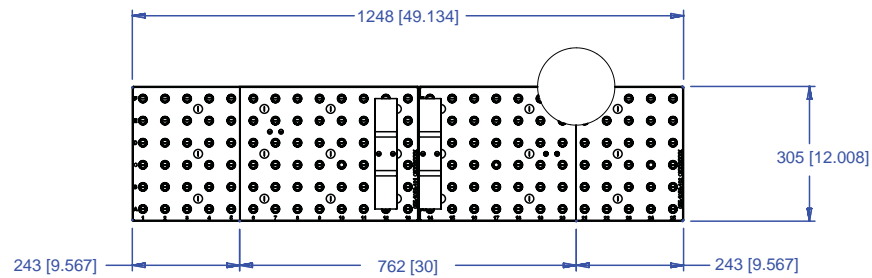
Workholding package  
in machine envelope

Notes

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# 5VP-HAAS-00282

This workholding package is designed for your HAAS TM-1P (Metric) machining center.



**Notes**

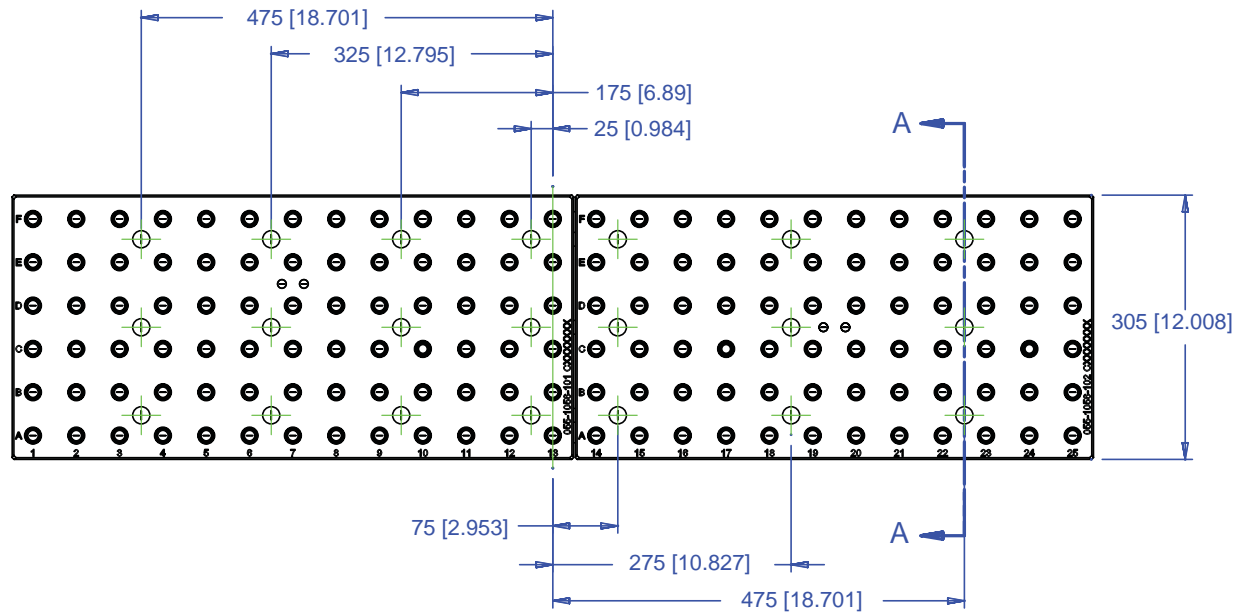
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

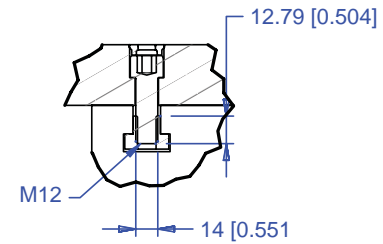
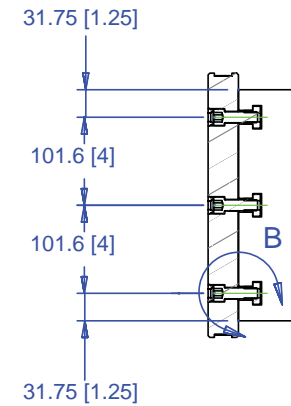
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# 5VP-HAAS-00282

This workholding package is designed for your HAAS TM-1P (Metric) machining center.



## SECTION A-A



## DETAIL B

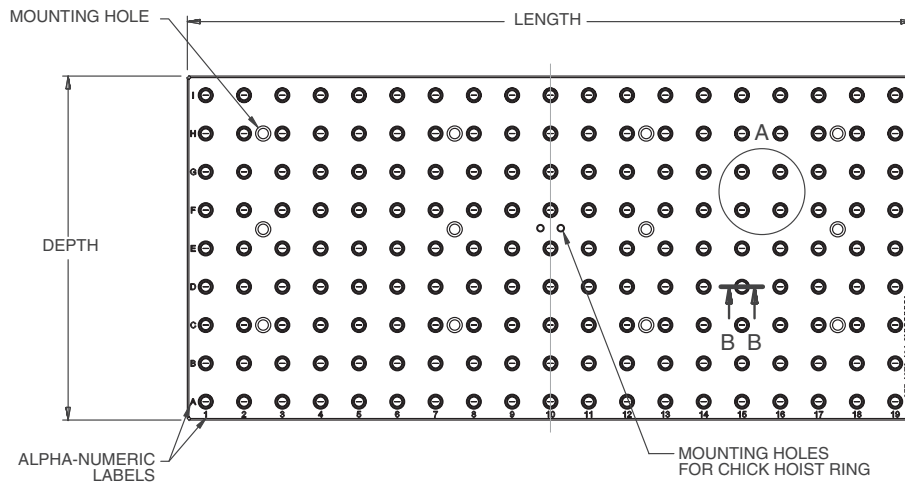
Notes  
All dimensions are MM [IN]

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# 5VP-HAAS-00282

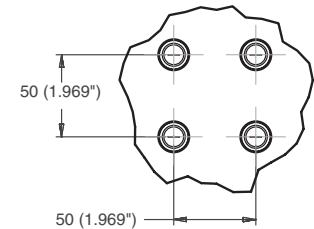
This workholding package is designed for your HAAS TM-1P (Metric) machining center.

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



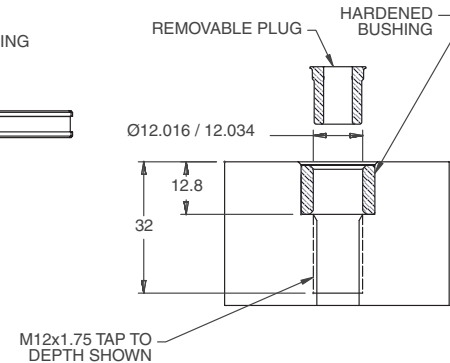
FOUNDATION MAT'L: CAST IRON  
FOUNDATION INCLUDES INSTALLATION HARDWARE

**DETAIL A**



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

**SECTION B-B**

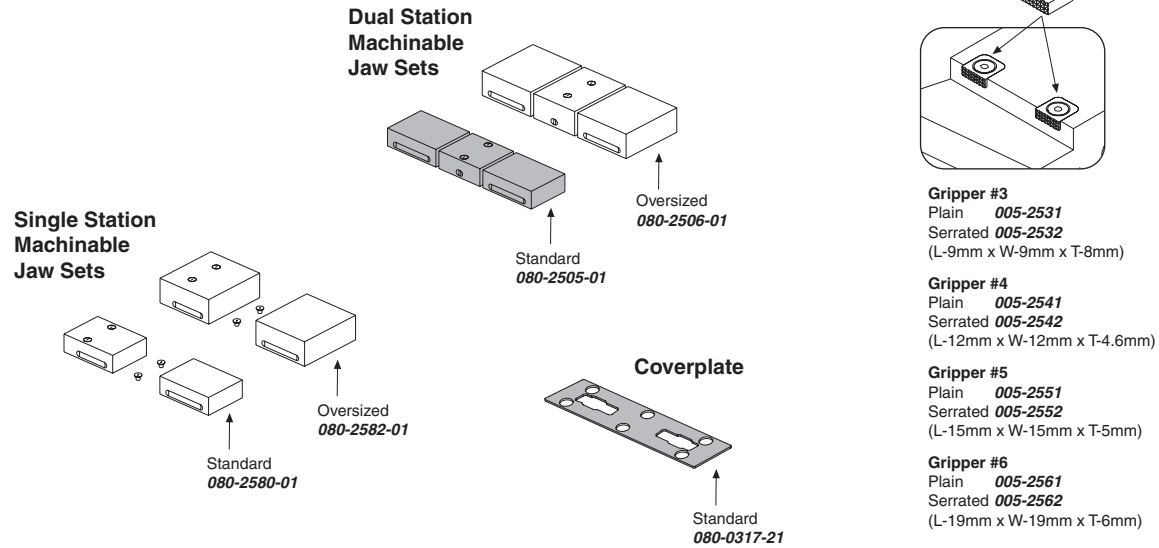


Notes  
All dimensions are MM [IN]

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## 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**

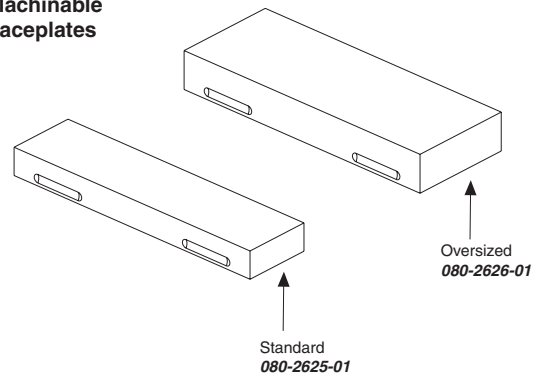
Grey item is included with a standard system

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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.

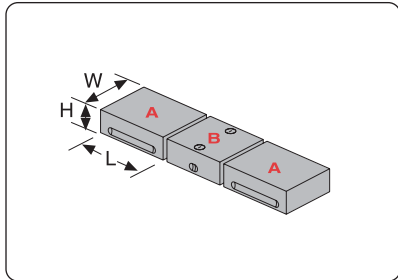
### Machinable Faceplates



Notes

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**QwikChange Machinable  
Dual Station Jaws**



**Individual Dual Station Jaws**

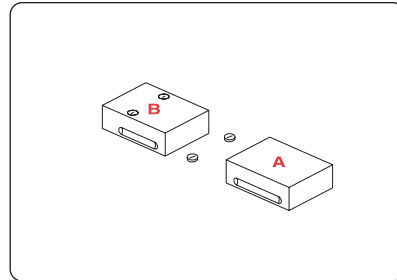
Standard

- A** Moveable Jaw ..... **080-2511-01**  
(W49mm, H25mm, L75mm)
- B** Fixed Jaw ..... **080-2553-01**  
(W49mm, H25mm, L76mm)

Oversized

- A** Moveable Jaw ..... **080-2512-01**  
(W80mm, H35mm, L75mm)
- B** Fixed Jaw ..... **080-2554-01**  
(W80mm, H35mm, L76mm)

**QwikChange Machinable  
Single Station Jaws**



**Individual Single Station Jaws**

Standard

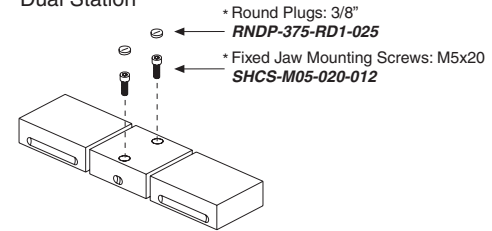
- A** Moveable Jaw ..... **080-2511-01**  
(W49mm, H25mm, L75mm)
- B** Fixed Jaw ..... **080-2571-01**  
(W49mm, H25mm, L75mm)

Oversized

- A** Moveable Jaw ..... **080-2512-01**  
(W80mm, H35mm, L75mm)
- B** Fixed Jaw ..... **080-2572-01**  
(W80mm, H35mm, L75mm)

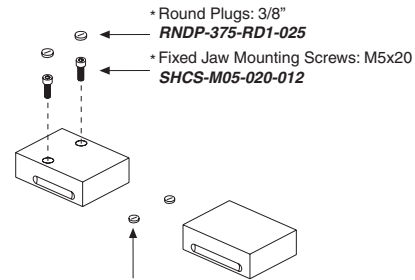
**Screws and Plugs**

**Dual Station**



- \* Round Plugs: 3/8"  
**RNDP-375-RD1-025**
- \* Fixed Jaw Mounting Screws: M5x20  
**SHCS-M05-020-012**

**Single Station**



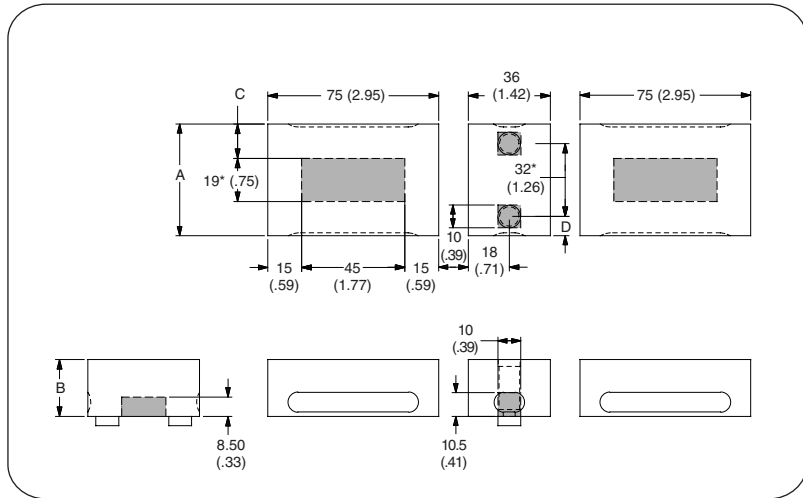
- \* Round Plugs: 3/8"  
**RNDP-375-RD1-025**

**Notes**

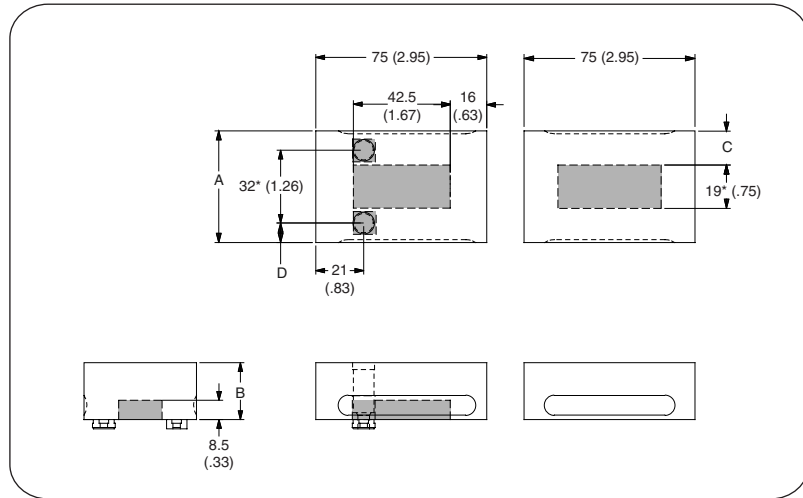
Grey or \* item is included with a standard system

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Dual Station



Single Station



Item Number	Description	A	B	C	D
<b>080-2500</b>	Standard	49 [1.93]	25 [.98]	15 [.59]	8.5 [.33]
<b>080-2506</b>	Oversized	80 [3.15]	35 [1.38]	30.5 [1.20]	24 [.94]

Item Number	Description	A	B	C	D
<b>080-2580</b>	Standard	49 [1.93]	25 [.98]	15 [.59]	8.5 [.33]
<b>080-2582</b>	Oversized	80 [3.15]	35 [1.38]	30.5 [1.20]	24 [.94]

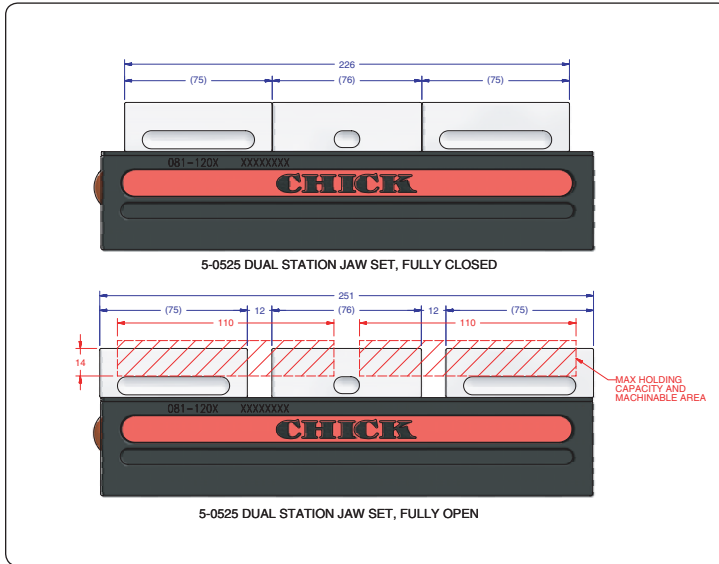
Notes

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

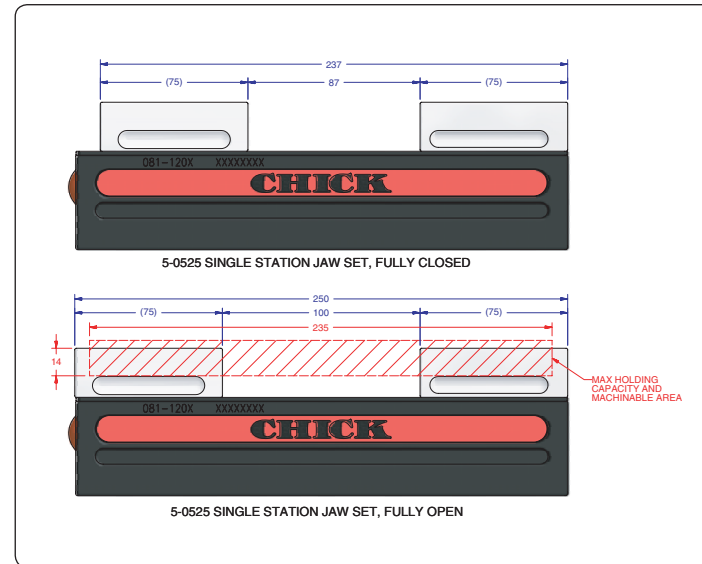
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Dual Station



Single Station



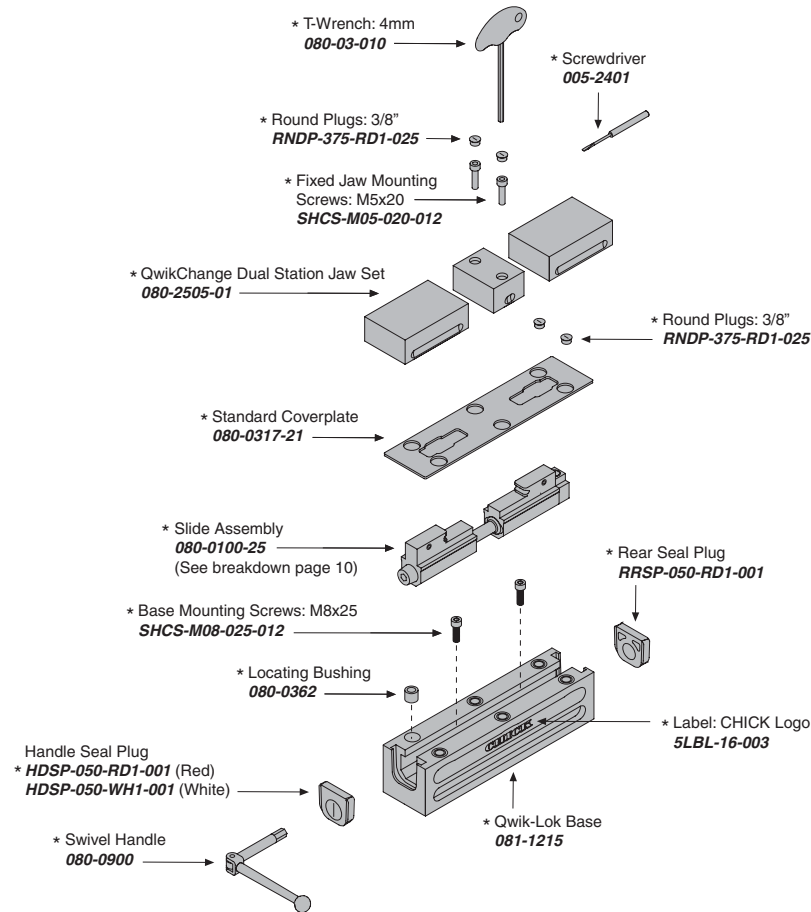
Item Number	Description	A	Jaw Width
<b>080-2500</b>	Standard	14 [0.57]	49 [1.93]
<b>080-2506</b>	Oversized	24 [0.96]	80 [3.15]

Item Number	Description	A	Jaw Width
<b>080-2580</b>	Standard	14 [0.57]	49 [1.93]
<b>080-2582</b>	Oversized	24 [0.96]	80 [3.15]

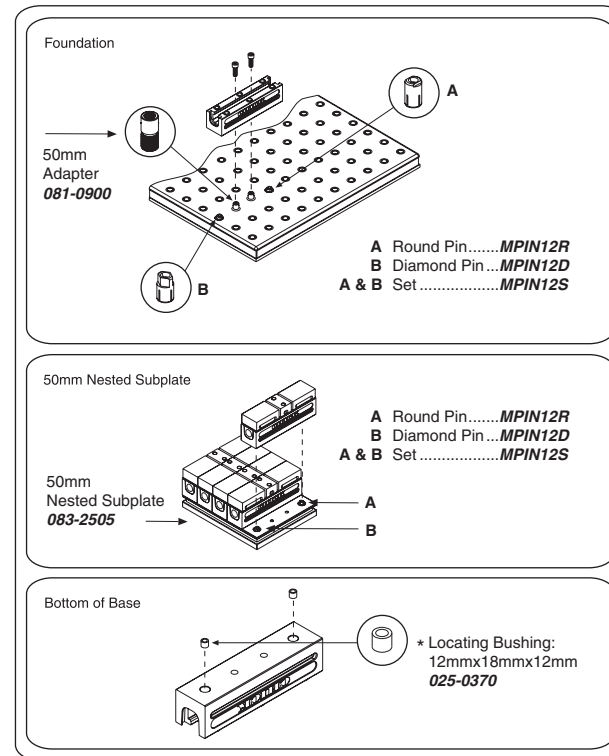
Notes

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

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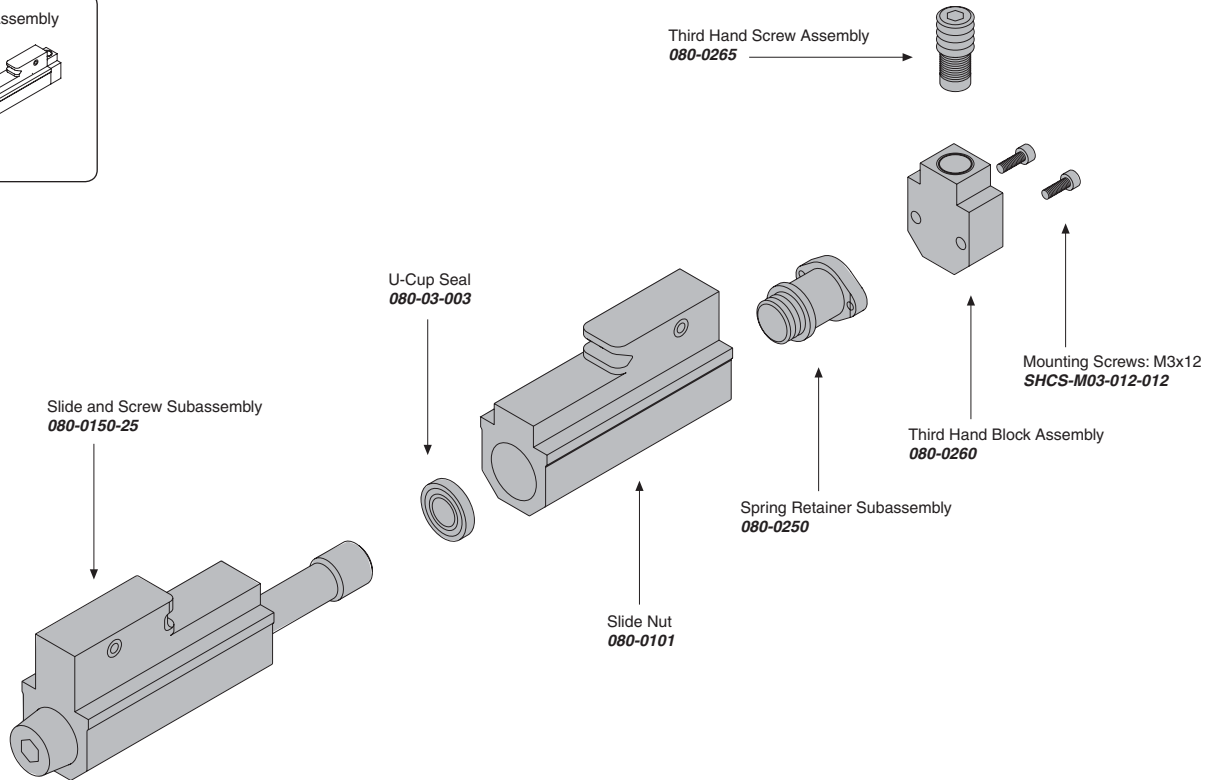
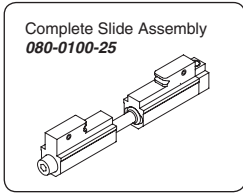
## MOUNTING



### Notes

Grey items are included with a standard system  
 For QwikChange™ Jaw accessories, see pages 4-6

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**Notes**

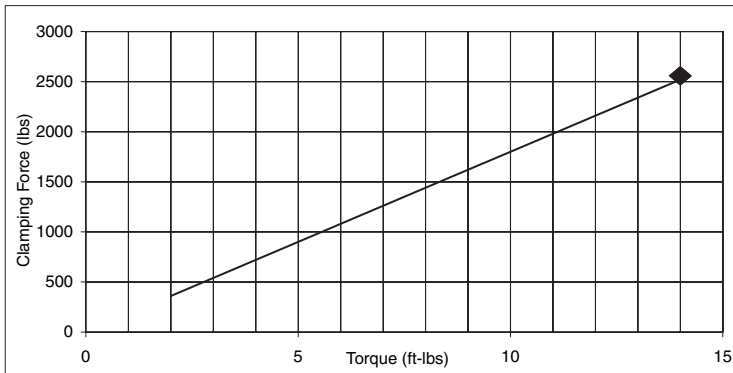
Grey items are included with a standard system

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**Pounds (lbs)**

Force	=	Torque	X	Slope
lbs	=	in-lb	x	15
lbs	=	ft-lbs	x	180

Torque (ft-lb)	Force (lbs)
0	0
2	360
4	720
6	1080
8	1440
10	1800
12	2160
14	2520

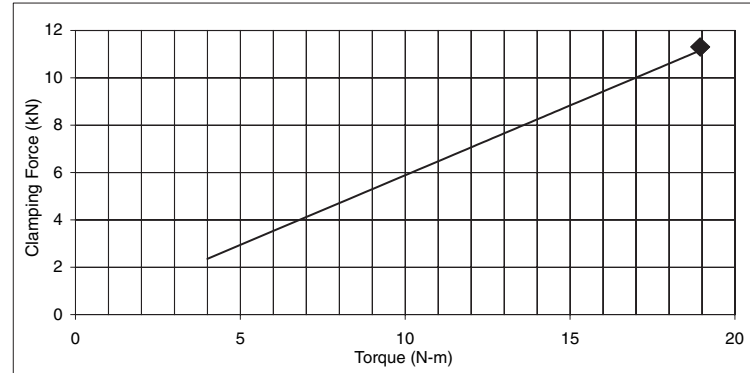


Note: ◆ Maximum Recommended Torque. Actual results may vary.

**Kilonewtons (kN)**

Force	=	Torque	X	Slope
N	=	N-m	x	590
kN	=	N-m	x	0.59

Torque (N-m)	Force (kN)
0	0.0
4	2.4
8	4.7
12	7.1
14	8.2
18	10.6
19	11.2



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

Notes

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