

## 5VP-HAAS-00365

This workholding package is designed for your HAAS MiniMill machining center.



Workholding package



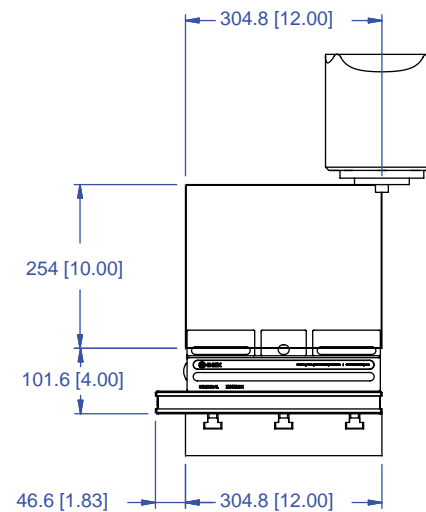
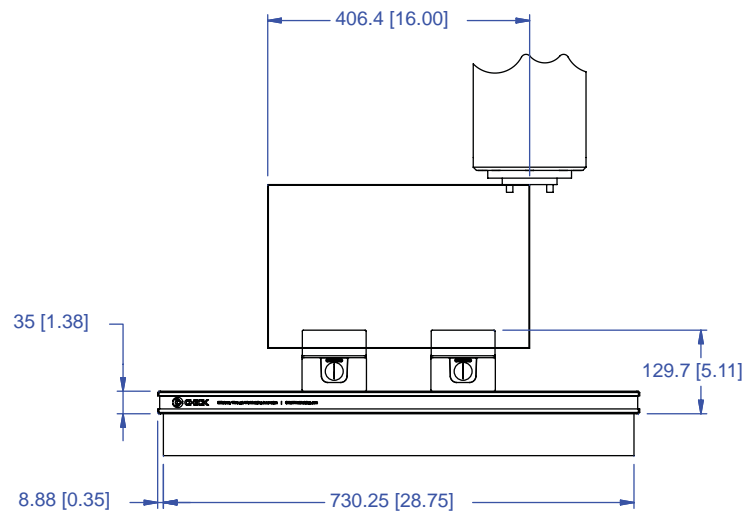
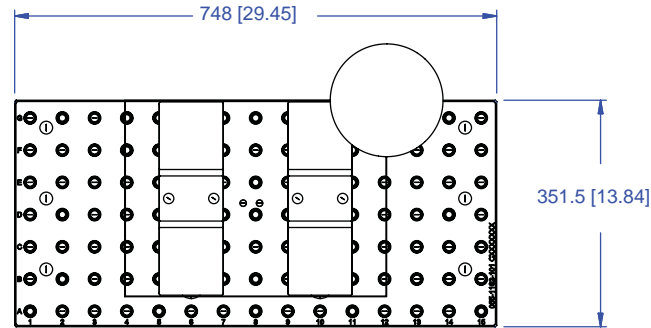
Workholding package  
in machine envelope

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)

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**Notes**

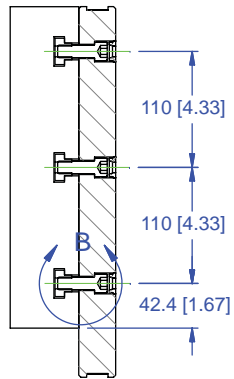
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

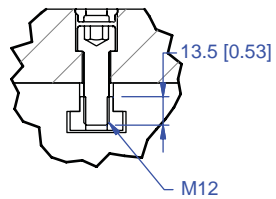
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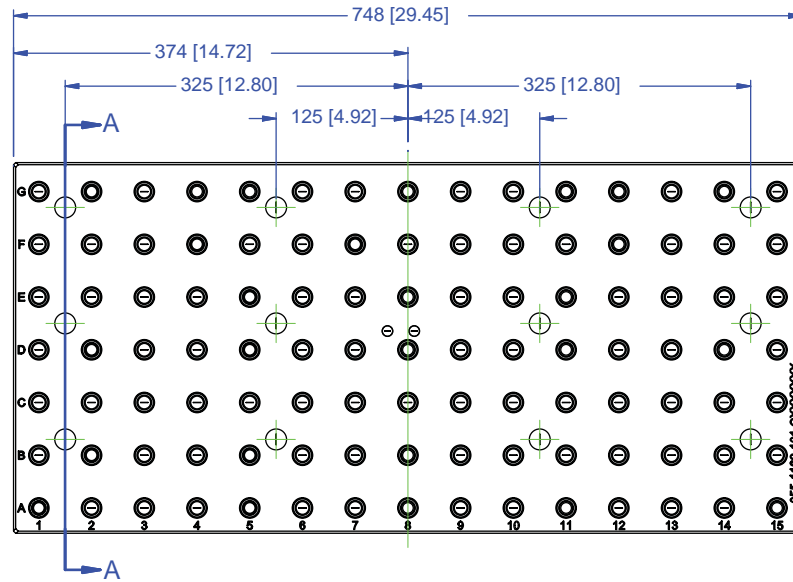
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SECTION A-A



DETAIL B



Notes  
All dimensions are MM [IN]

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This workholding package is designed for your HAAS MiniMill machining center.

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



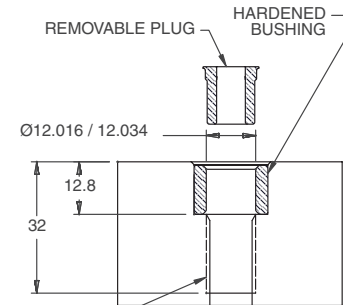
FOUNDATION MAT'L: CAST IRON  
FOUNDATION INCLUDES INSTALLATION HARDWARE

## DETAIL A



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

## SECTION B-B



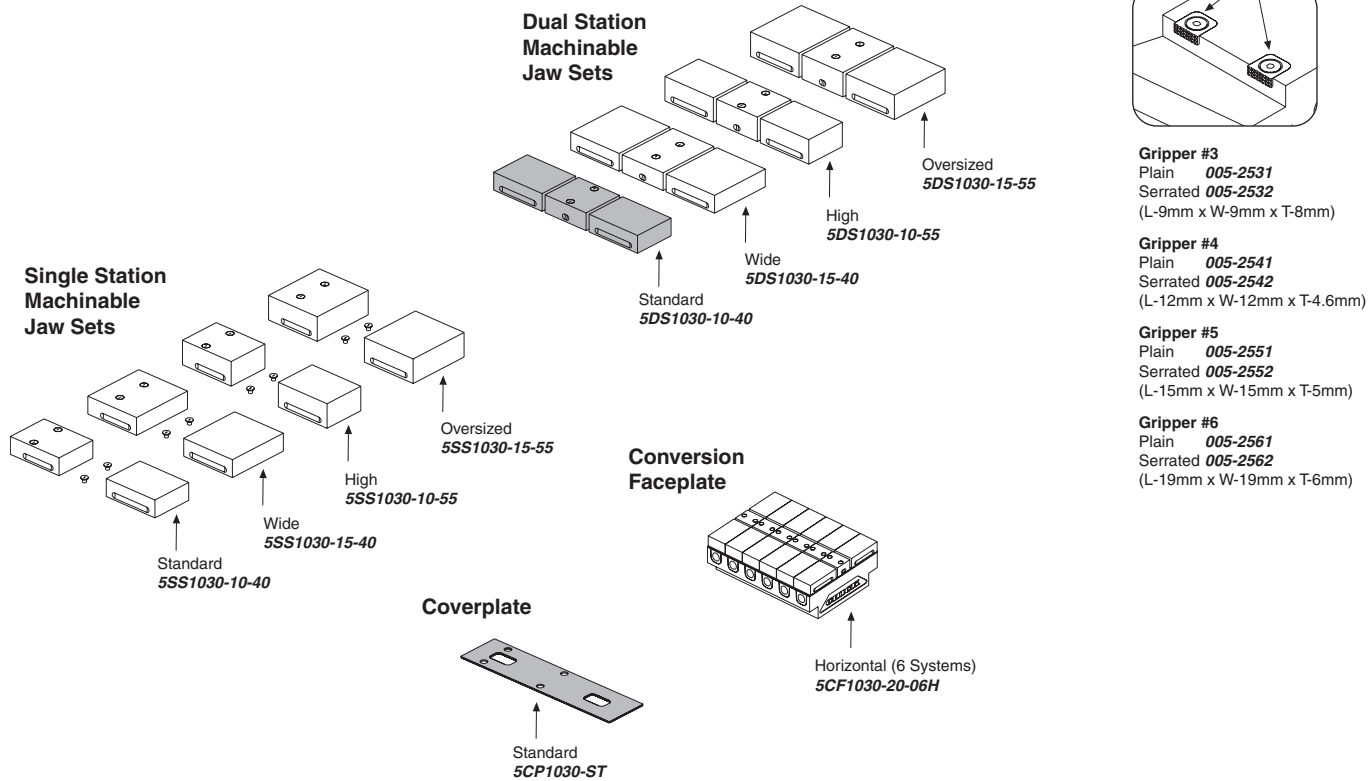
M12x1.75 TAP TO DEPTH SHOWN

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.



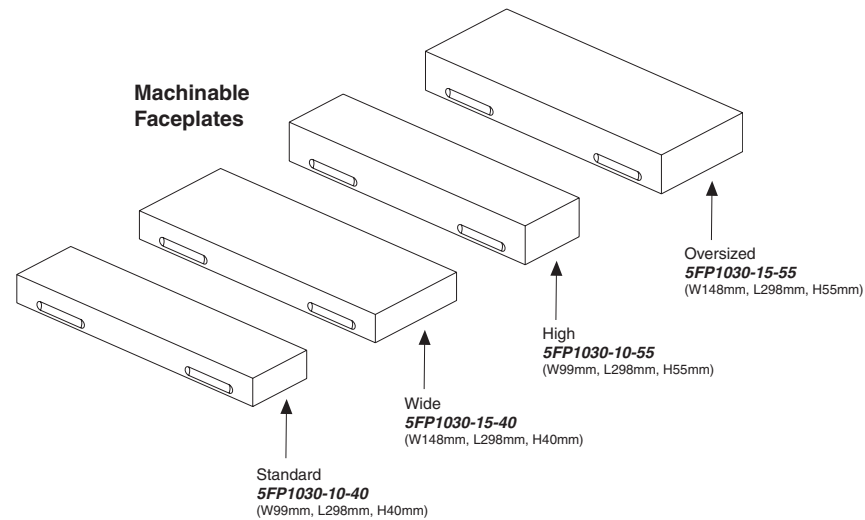
**Notes**

Grey item is included with a standard system

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## Dedicated Fixturing

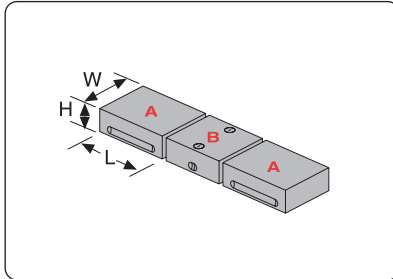
Machinable Faceplates provide QwikChange™ dedicated fixturing and are optimal for awkward or hard to hold parts. A mini pallet changer can be created by utilizing two Faceplates in tandem.



Notes

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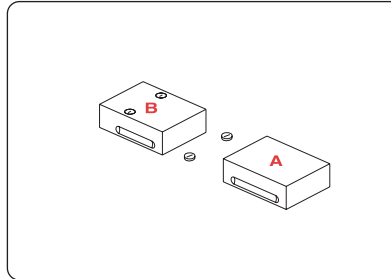
**QwikChange Machinable  
Dual Station Jaws**



**Individual Dual Station Jaws**

- Standard  
**A** Moveable Jaw ..... **5MJ1030-10-40**  
 (W99mm, H40mm, L105mm)  
**B** Fixed Jaw ..... **5FJ1030-10-40**  
 (W99mm, H40mm, L70mm)
- Wide  
**A** Moveable Jaw ..... **5MJ1030-15-40**  
 (W148mm, H40mm, L105mm)  
**B** Fixed Jaw ..... **5FJ1030-15-40**  
 (W148mm, H40mm, L70mm)
- High  
**A** Moveable Jaw ..... **5MJ1030-10-55**  
 (W99mm, H55mm, L105mm)  
**B** Fixed Jaw ..... **5FJ1030-10-55**  
 (W99mm, H55mm, L70mm)
- Oversized  
**A** Moveable Jaw ..... **5MJ1030-15-55**  
 (W148mm, H55mm, L105mm)  
**B** Fixed Jaw ..... **5FJ1030-15-55**  
 (W148mm, H55mm, L70mm)

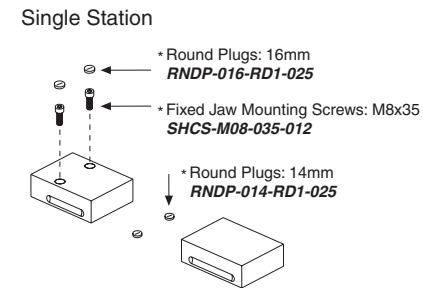
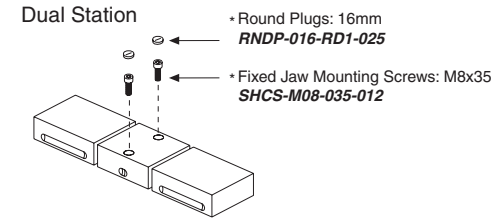
**QwikChange Machinable  
Single Station Jaws**



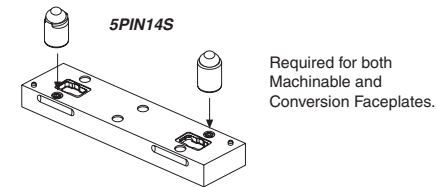
**Individual Single Station Jaws**

- Standard  
**A** Moveable Jaw ..... **5MJ1030-10-40**  
 (W99mm, H40mm, L105mm)  
**B** Fixed Jaw ..... **5SJ1030-10-40**  
 (W99mm, H40mm, L105mm)
- Wide  
**A** Moveable Jaw ..... **5MJ1030-15-40**  
 (W148mm, H40mm, L105mm)  
**B** Fixed Jaw ..... **5SJ1030-15-40**  
 (W148mm, H40mm, L105mm)
- High  
**A** Moveable Jaw ..... **5MJ1030-10-55**  
 (W99mm, H55mm, L105mm)  
**B** Fixed Jaw ..... **5SJ1030-10-55**  
 (W99mm, H55mm, L105mm)
- Oversized  
**A** Moveable Jaw ..... **5MJ1030-15-55**  
 (W148mm, H55mm, L105mm)  
**B** Fixed Jaw ..... **5SJ1030-15-55**  
 (W148mm, H55mm, L105mm)

**Screws and Plugs**



**Faceplate Round & Diamond Pin Set**  
 (Included w/ Faceplate purchase)

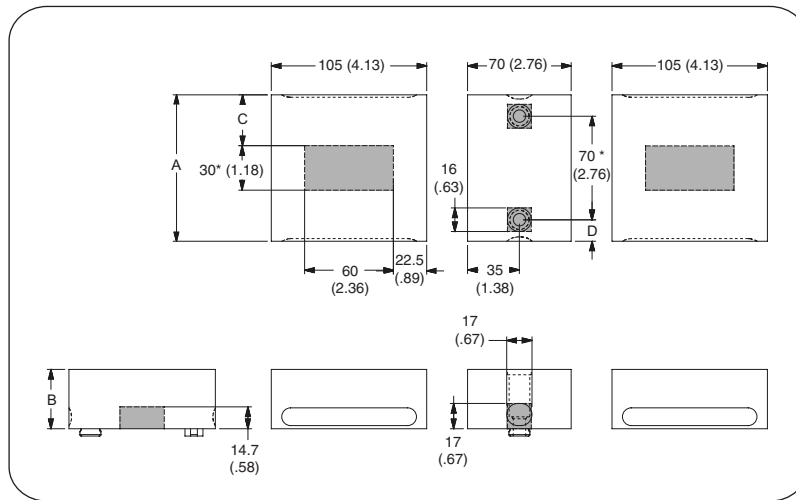


**Notes**

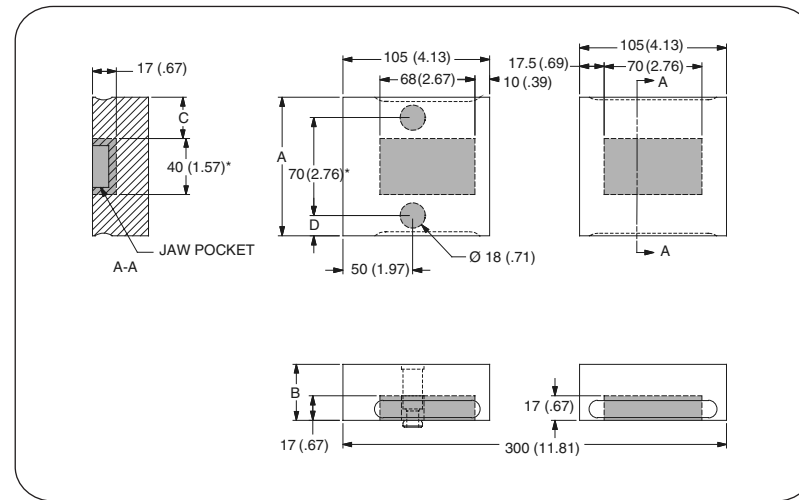
Grey or \* item is included with a standard system

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Dual Station



Single Station



Item Number	Description	A	B	C	D
<b>5DS1030-10-40</b>	Standard	99 [3.90]	40 [1.57]	34.5 [1.36]	14.5 [.57]
<b>5DS1030-10-55</b>	High	99 [3.90]	55 [2.17]	34.5 [1.36]	14.5 [.57]
<b>5DS1030-15-40</b>	Wide	148 [5.83]	40 [1.57]	59 [2.32]	39 [1.54]
<b>5DS1030-15-55</b>	Oversized	148 [5.83]	55 [2.17]	59 [2.32]	39 [1.54]

Item Number	Description	A	B	C	D
<b>5SS1030-10-40</b>	Standard	99 [3.90]	40 [1.57]	29.5 [1.16]	14.5 [.57]
<b>5SS1030-10-55</b>	High	99 [3.90]	55 [2.17]	29.5 [1.16]	14.5 [.57]
<b>5SS1030-15-40</b>	Wide	148 [5.83]	40 [1.57]	54 [2.13]	39 [1.54]
<b>5SS1030-15-55</b>	Oversized	148 [5.83]	55 [2.17]	54 [2.13]	39 [1.54]

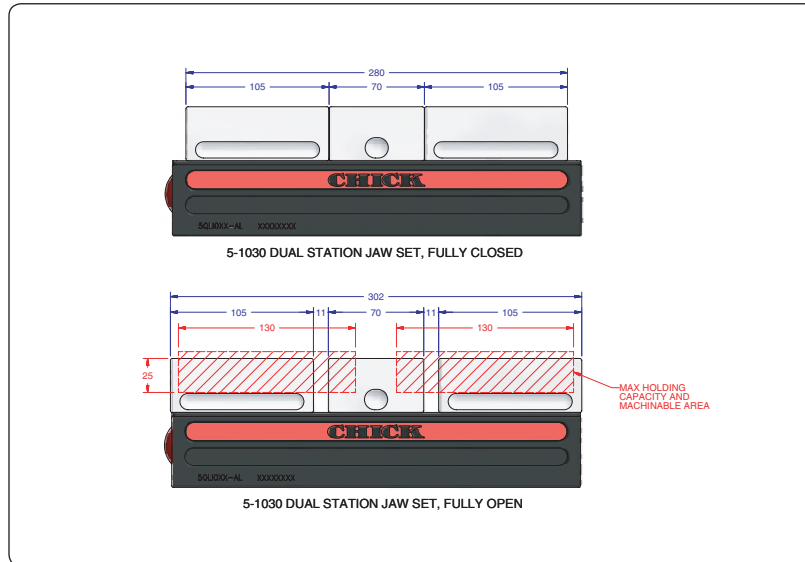
Notes

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

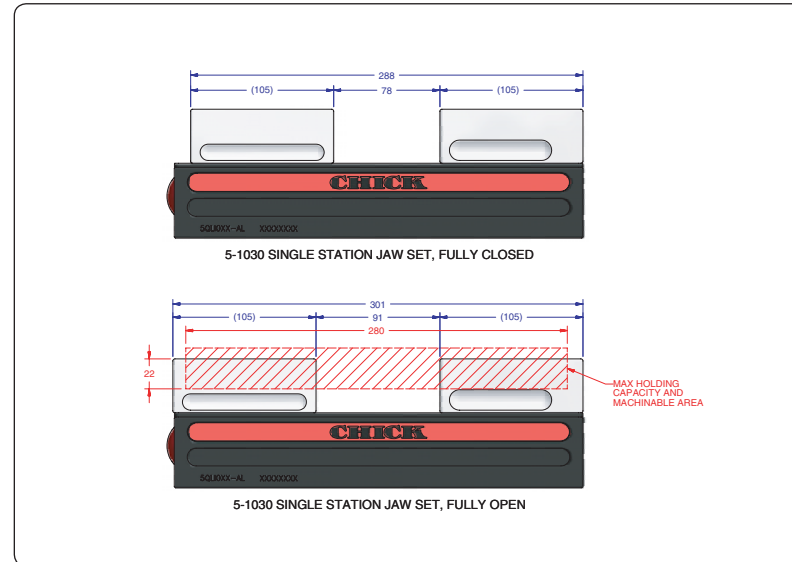
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**Dual Station**



**Single Station**



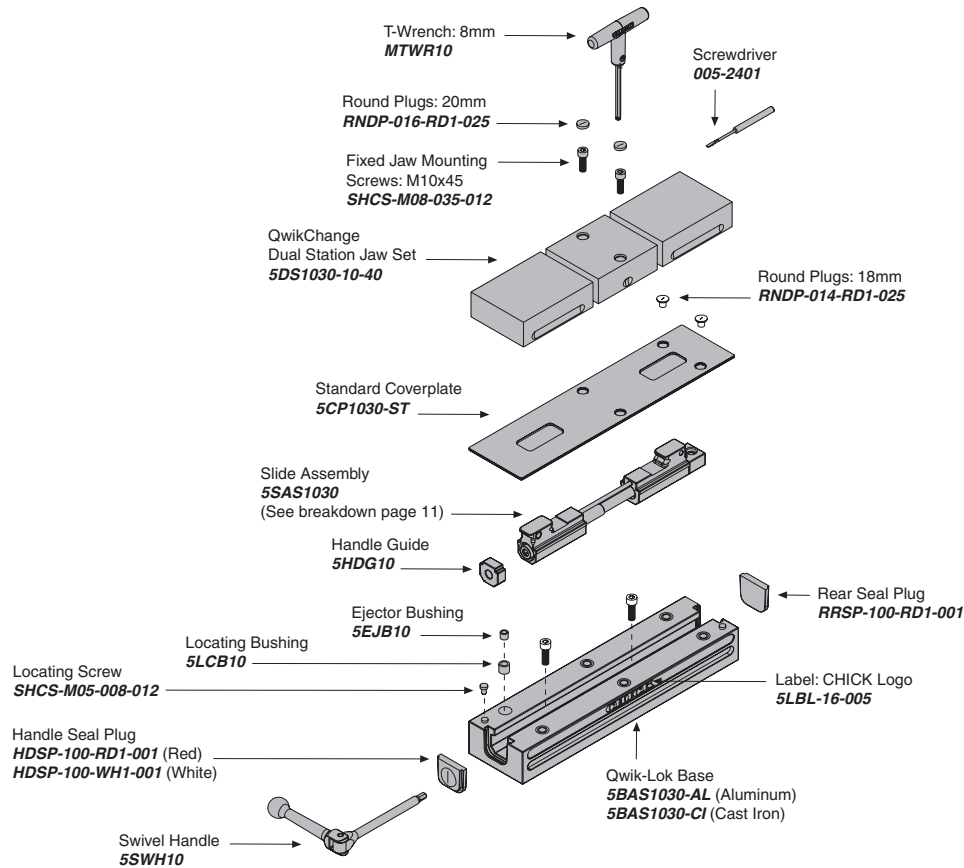
Item Number	Description	A	Jaw Width
<b>5DS1030-10-40</b>	Standard	26 [1.02]	99 [3.90]
<b>5DS1030-10-55</b>	High	41 [1.61]	99 [3.90]
<b>5DS1030-15-40</b>	Wide	26 [1.02]	148 [5.83]
<b>5DS1030-15-55</b>	Oversized	41 [1.61]	148 [5.83]

Item Number	Description	A	Jaw Width
<b>5SS1030-10-40</b>	Standard	26 [1.02]	99 [3.90]
<b>5SS1030-10-55</b>	High	41 [1.61]	99 [3.90]
<b>5SS1030-15-40</b>	Wide	26 [1.02]	148 [5.83]
<b>5SS1030-15-55</b>	Oversized	41 [1.61]	148 [5.83]

**Notes**

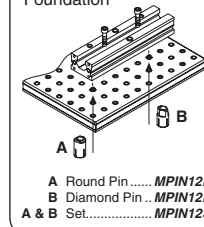
All dimensions are MM [IN]  
 Additional closure is available with an Extended Travel Coverplate.  
 Contact CHICK for details.

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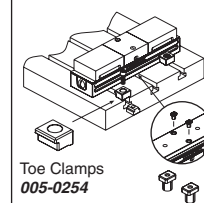


**MOUNTING**

**Foundation**

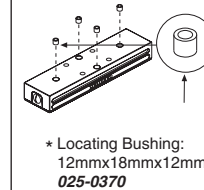


**T-Slotted Table**



Bolt and T-Nut supplied by customer

**Bottom of Base**

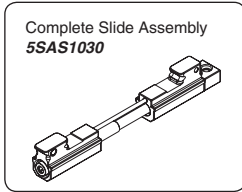


Locating Keys	
Inch Size	
MKE500	(1/2")
MKE562	(9/16")
MKE625	(5/8")
MKE688	(11/16")
MKE750	(3/4")
MKE812	(13/16")
Metric Size	
MKE10	(10mm)
MKE12	(12mm)
MKE14X18	(14mm)
MKE16	(16mm)
MKE20	(20mm)

**Notes**

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

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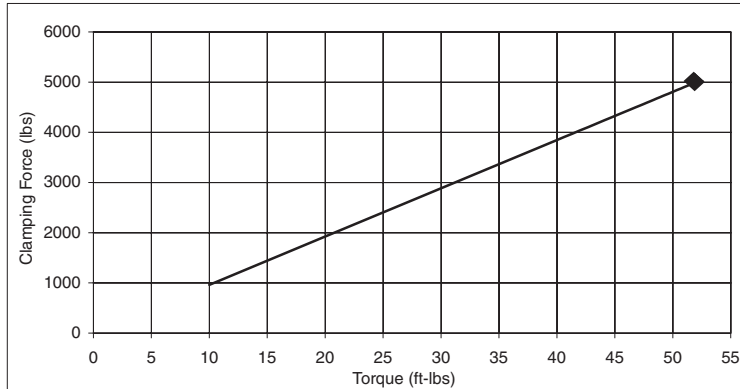
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**Pounds (lbs)**

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

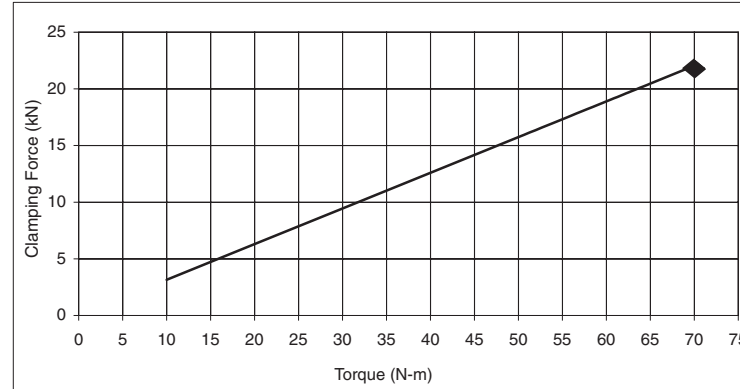


Note: ◆ Maximum Recommended Torque. Actual results may vary.

**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.

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