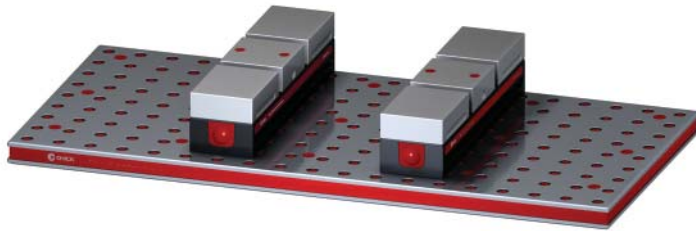


## 5VP-KITA-00046

This workholding package is designed for your KITAMURA 3XiF machining center.

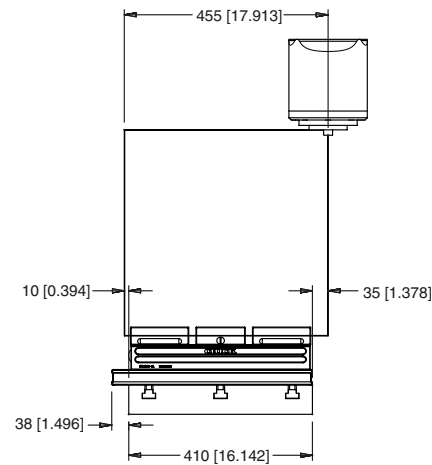
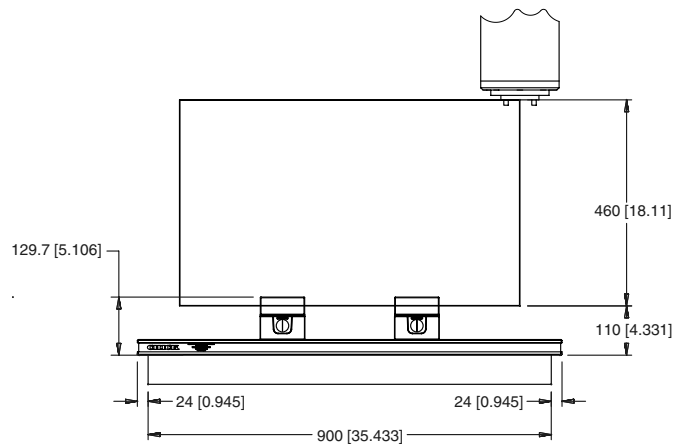
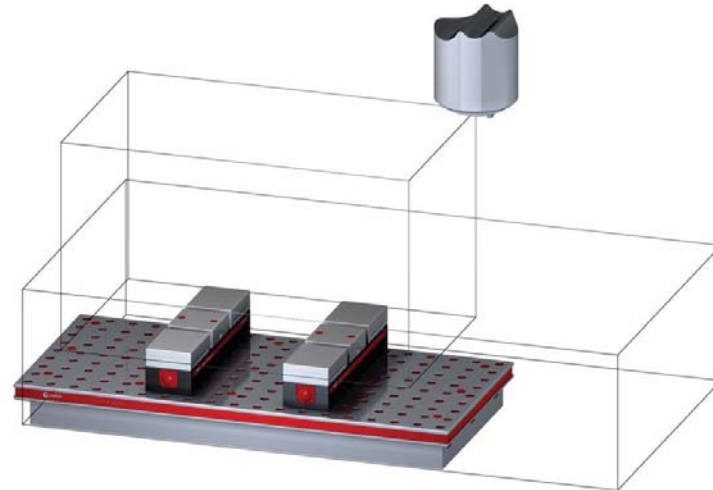
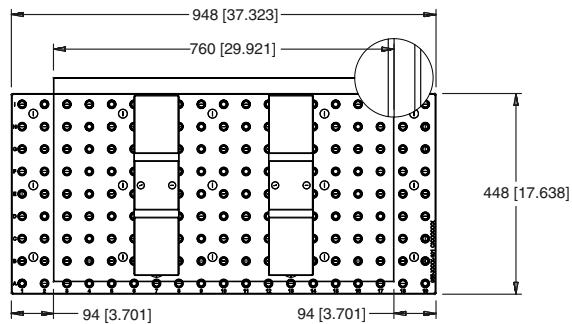


Notes

**CHICK WORKHOLDING SOLUTIONS, INC**  
500 Keystone Drive • Warrendale, PA 15086 USA  
Phone: (724) 772-1644 • Fax: (724) 772-1633  
Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

# 5VP-KITA-00046

This workholding package is designed for your KITAMURA 3XiF machining center.



**Notes**

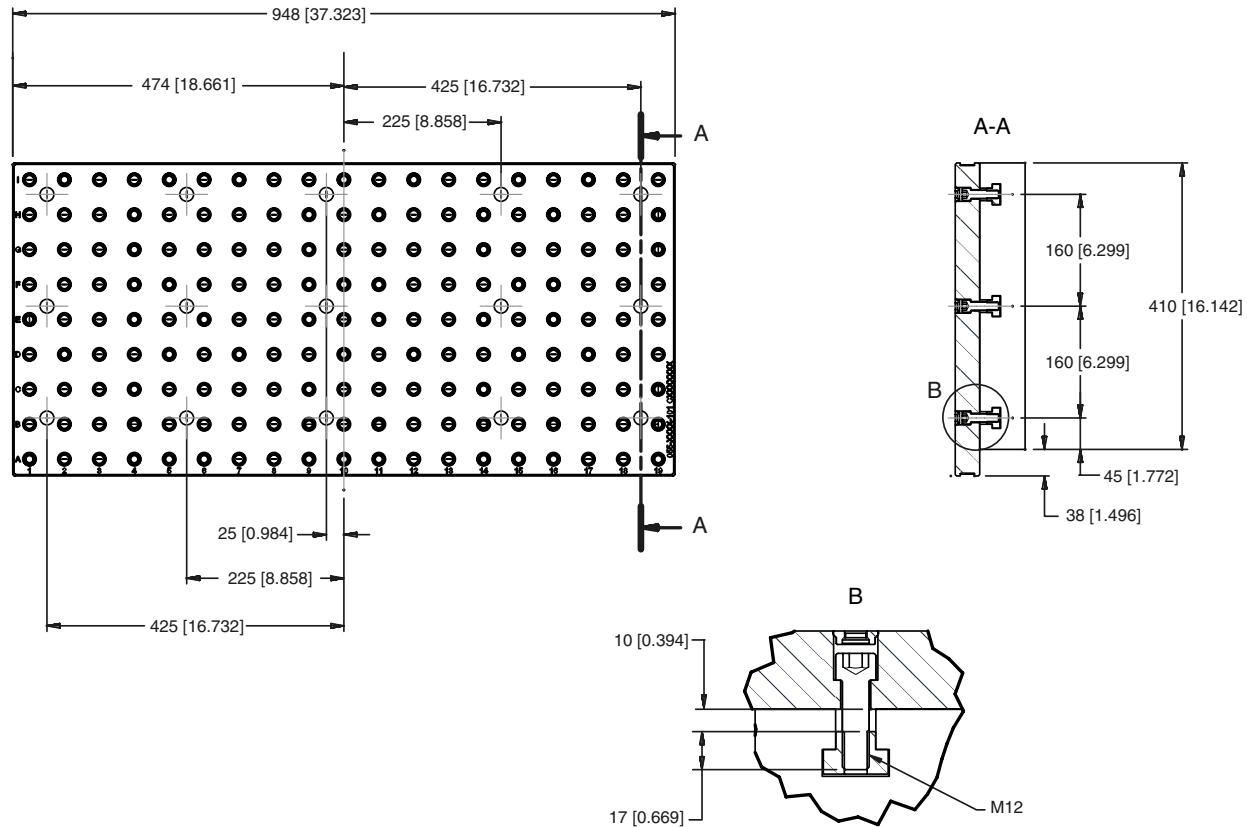
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

**CHICK WORKHOLDING SOLUTIONS, INC**  
 500 Keystone Drive • Warrendale, PA 15086 USA  
 Phone: (724) 772-1644 • Fax: (724) 772-1633  
 Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

# 5VP-KITA-00046

This workholding package is designed for your KITAMURA 3XiF machining center.



Notes  
All dimensions are MM [IN]

**CHICK WORKHOLDING SOLUTIONS, INC**  
 500 Keystone Drive • Warrendale, PA 15086 USA  
 Phone: (724) 772-1644 • Fax: (724) 772-1633  
 Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

# 5VP-KITA-00046

This workholding package is designed for your KITAMURA 3XiF machining center.

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



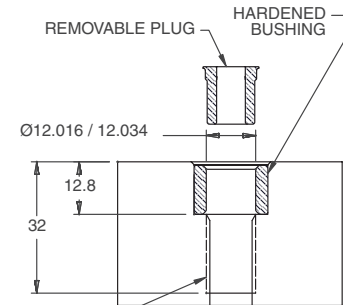
FOUNDATION MAT'L: CAST IRON  
FOUNDATION INCLUDES INSTALLATION HARDWARE

### DETAIL A



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

### SECTION B-B



M12x1.75 TAP TO DEPTH SHOWN

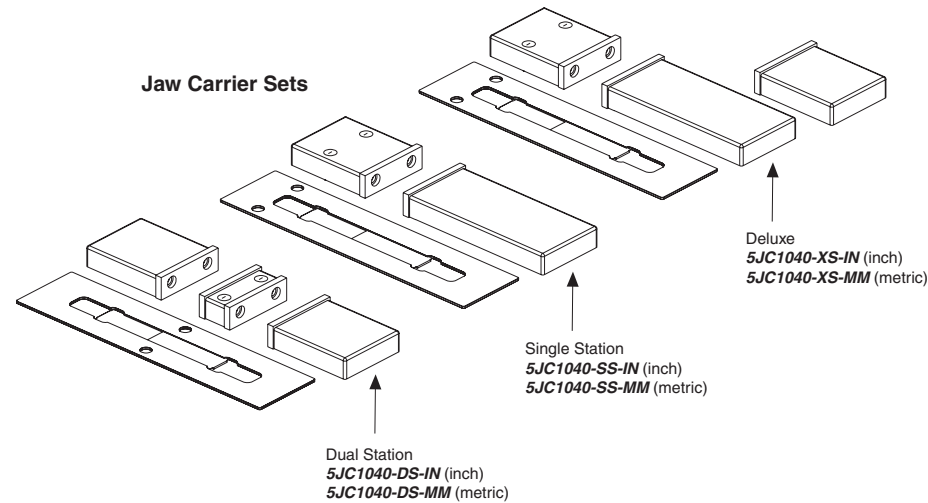
Notes  
All dimensions are MM [IN]

**CHICK WORKHOLDING SOLUTIONS, INC**  
500 Keystone Drive • Warrendale, PA 15086 USA  
Phone: (724) 772-1644 • Fax: (724) 772-1633  
Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

## 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.

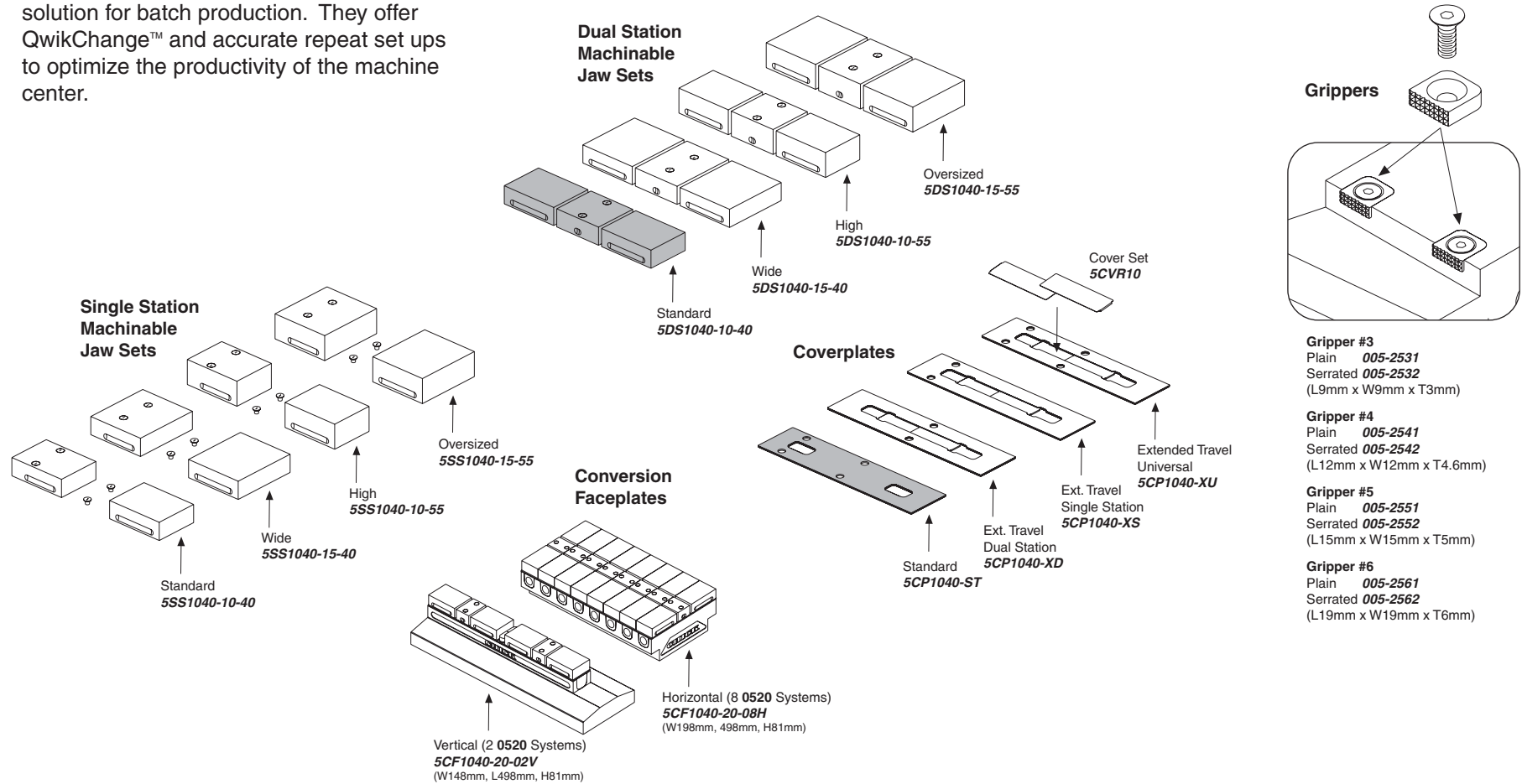


Notes

**CHICK WORKHOLDING SOLUTIONS, INC**  
 500 Keystone Drive • Warrendale, PA 15086 USA  
 Phone: (724) 772-1644 • Fax: (724) 772-1633  
 Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

# 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.



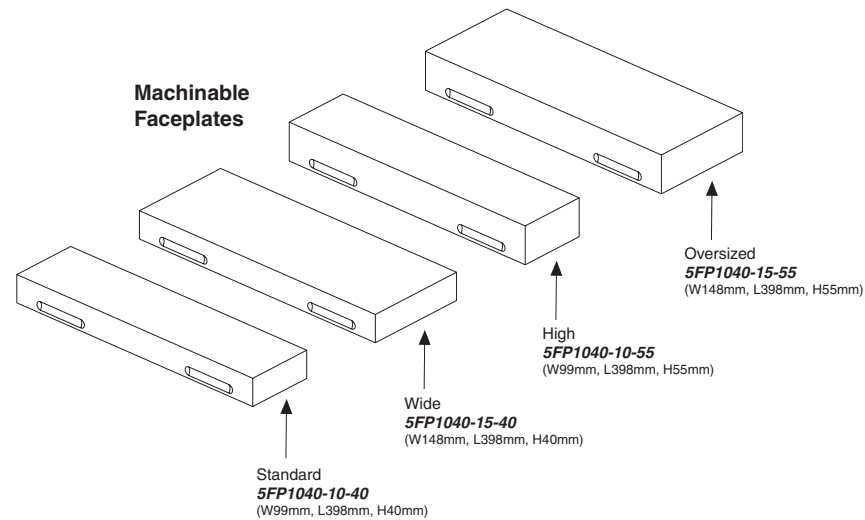
**Notes**

Grey item is included with a standard system

**CHICK WORKHOLDING SOLUTIONS, INC**  
 500 Keystone Drive • Warrendale, PA 15086 USA  
 Phone: (724) 772-1644 • Fax: (724) 772-1633  
 Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

## Dedicated Fixturing

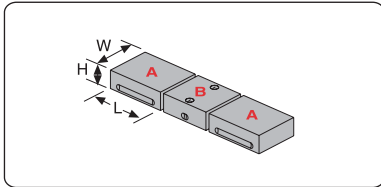
Machinable Faceplates provide QwikChange™ dedicated fixturing and are optimal for awkward or hard to hold parts. A mini pallet changer can be created by utilizing two Faceplates in tandem.



Notes

**CHICK WORKHOLDING SOLUTIONS, INC**  
500 Keystone Drive • Warrendale, PA 15086 USA  
Phone: (724) 772-1644 • Fax: (724) 772-1633  
Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

## QwikChange Machinable Dual Station Jaws



### Individual Dual Station Jaws

Standard

- A** Moveable Jaw ..... **5MJ1040-10-40**  
(W99mm, H130mm, L40mm)
- B** Fixed Jaw ..... **5FJ1040-10-40**  
(W99mm, H110mm, L40mm)

Wide

- A** Moveable Jaw ..... **5MJ1040-15-40**  
(W148mm, H130mm, L40mm)
- B** Fixed Jaw ..... **5FJ1040-15-40**  
(W148mm, H110mm, L40mm)

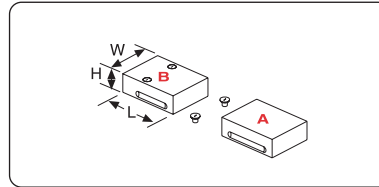
High

- A** Moveable Jaw ..... **5MJ1040-10-55**  
(W99mm, H130mm, L55mm)
- B** Fixed Jaw ..... **5FJ1040-10-55**  
(W99mm, H110mm, L55mm)

Oversized

- A** Moveable Jaw ..... **5MJ1040-15-55**  
(W148mm, H130mm, L55mm)
- B** Fixed Jaw ..... **5FJ1040-15-55**  
(W148mm, H110mm, L55mm)

## QwikChange Machinable Single Station Jaws



### Individual Single Station Jaws

Standard

- A** Moveable Jaw ..... **5MJ1040-10-40**  
(W99mm, H130mm, L40mm)
- B** Fixed Jaw ..... **5SJ1040-10-40**  
(W99mm, H130mm, L40mm)

Wide

- A** Moveable Jaw ..... **5MJ1040-15-40**  
(W148mm, H130mm, L40mm)
- B** Fixed Jaw ..... **5SJ1040-15-40**  
(W148mm, H130mm, L40mm)

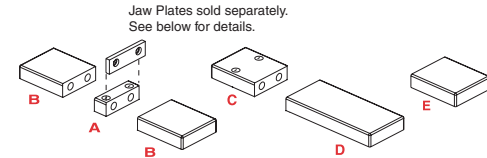
High

- A** Moveable Jaw ..... **5MJ1040-10-55**  
(W99mm, H130mm, L55mm)
- B** Fixed Jaw ..... **5SJ1040-10-55**  
(W99mm, H130mm, L55mm)

Oversized

- A** Moveable Jaw ..... **5MJ1040-15-55**  
(W148mm, H130mm, L55mm)
- B** Fixed Jaw ..... **5SJ1040-15-55**  
(W148mm, H130mm, L55mm)

## QwikChange Jaw Carriers



Jaw Carriers (Inch)

- A** **5JC1040-FC-IN**
- B** **5JC1040-MC-IN**
- C** **5JC1040-SC-IN**
- D** **5JC1040-LM-IN**
- E** **5JC1040-SM-IN**

Jaw Carriers (Metric)

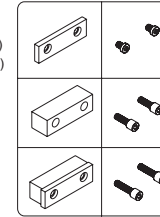
- A** **5JC1040-FC-MM**
- B** **5JC1040-MC-MM**
- C** **5JC1040-SC-MM**
- D** **5JC1040-LM-MM**
- E** **5JC1040-SM-MM**

- 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)  
**JH4STD** (Inch)  
**MJH10** (Metric)

### HARD JAW PLATES



Standard Mounting Screws:  
3/8-16x1/2"  
**LHCS-375-050-008** (Inch)  
**LHCS-M08-016-008** (Metric)

Thick  
(Set of 2)  
**JH4THK**

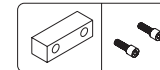
Thick Mounting Screws: 3/8-16x1"  
**SHCS-375-100-012**

Both Sizes  
**JH4STD** &  
**JH4THK**

Both Sizes Mounting Screws: 3/8-16x1.25"  
**SHCS-375-125-008**

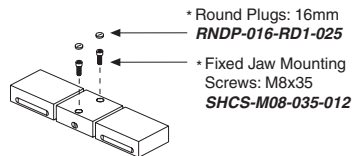
Standard  
(Set of 4)  
**JS4AL**

### SOFT JAW PLATES

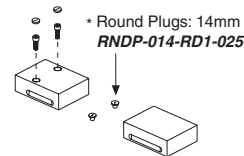


Soft Mounting Screws: 3/8-16x1"  
**SHCS-375-100-012**

## Screws and Plugs



- \* Round Plugs: 16mm  
**RNDP-016-RD1-025**
- \* Fixed Jaw Mounting Screws: M8x35  
**SHCS-M08-035-012**



- \* Round Plugs: 14mm  
**RNDP-014-RD1-025**

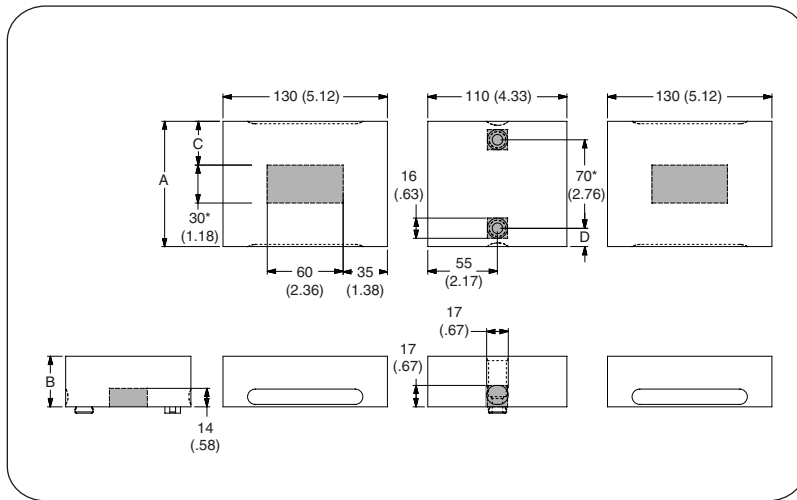
## Notes

Grey or \* item is included with a standard system

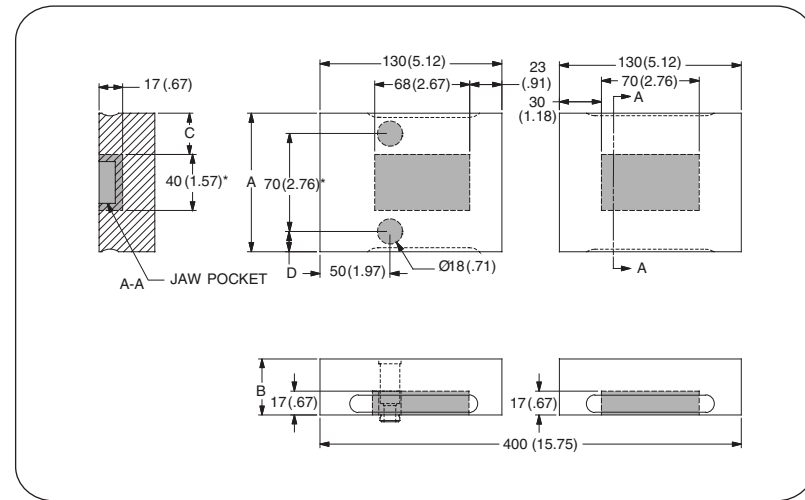
**CHICK WORKHOLDING SOLUTIONS, INC**  
500 Keystone Drive • Warrendale, PA 15086 USA  
Phone: (724) 772-1644 • Fax: (724) 772-1633  
Toll Free: (800) 33-CHICK • (800) 332-4425  
www.ChickWorkholding.com



Dual Station



Single Station



| Item Number          | Description | A          | B         | C           | D          |
|----------------------|-------------|------------|-----------|-------------|------------|
| <b>5DS1040-10-40</b> | Standard    | 99 [3.90]  | 40 [1.57] | 34.5 [1.36] | 14.5 [.57] |
| <b>5DS1040-10-55</b> | High        | 99 [3.90]  | 55 [2.17] | 34.5 [1.36] | 14.5 [.57] |
| <b>5DS1040-15-40</b> | Wide        | 148 [5.83] | 40 [1.57] | 59 [2.32]   | 39 [1.54]  |
| <b>5DS1040-15-55</b> | Oversized   | 148 [5.83] | 55 [2.17] | 59 [2.32]   | 39 [1.54]  |

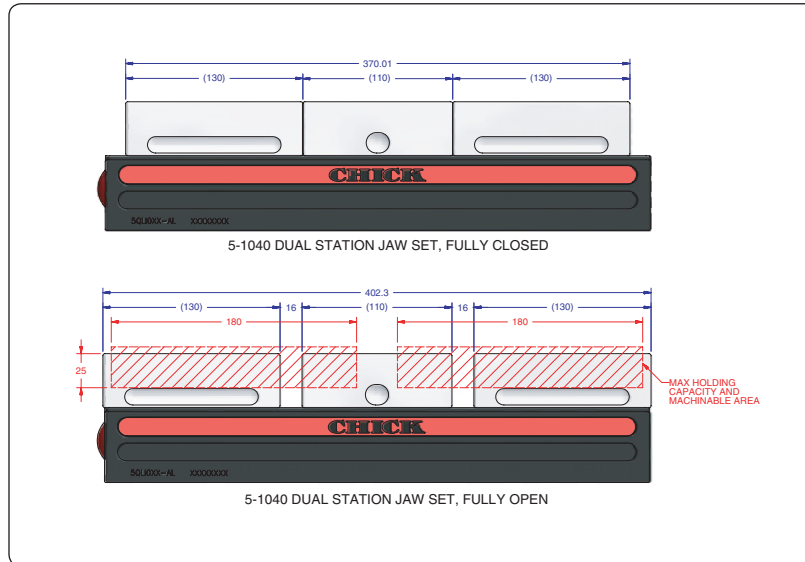
| Item Number          | Description | A          | B         | C           | D          |
|----------------------|-------------|------------|-----------|-------------|------------|
| <b>5SS1040-10-40</b> | Standard    | 99 [3.90]  | 40 [1.57] | 29.5 [1.16] | 14.5 [.57] |
| <b>5SS1040-10-55</b> | High        | 99 [3.90]  | 55 [2.17] | 29.5 [1.16] | 14.5 [.57] |
| <b>5SS1040-15-40</b> | Wide        | 148 [5.83] | 40 [1.57] | 54 [2.13]   | 39 [1.54]  |
| <b>5SS1040-15-55</b> | Oversized   | 148 [5.83] | 55 [2.17] | 54 [2.13]   | 39 [1.54]  |

Notes

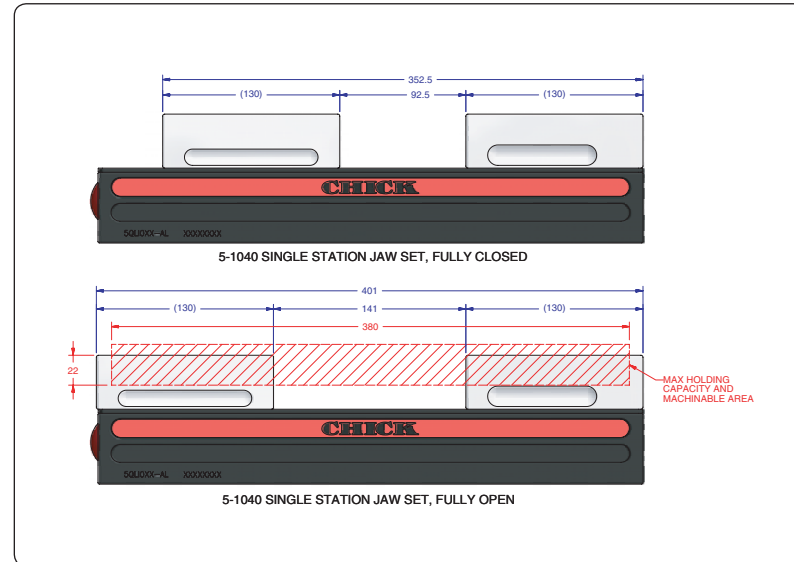
Grey area indicates no cut zone  
 All dimensions are MM [IN]  
 Dimensions centered on the "A" dimension.

**CHICK WORKHOLDING SOLUTIONS, INC**  
 500 Keystone Drive • Warrendale, PA 15086 USA  
 Phone: (724) 772-1644 • Fax: (724) 772-1633  
 Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

**Dual Station**



**Single Station**



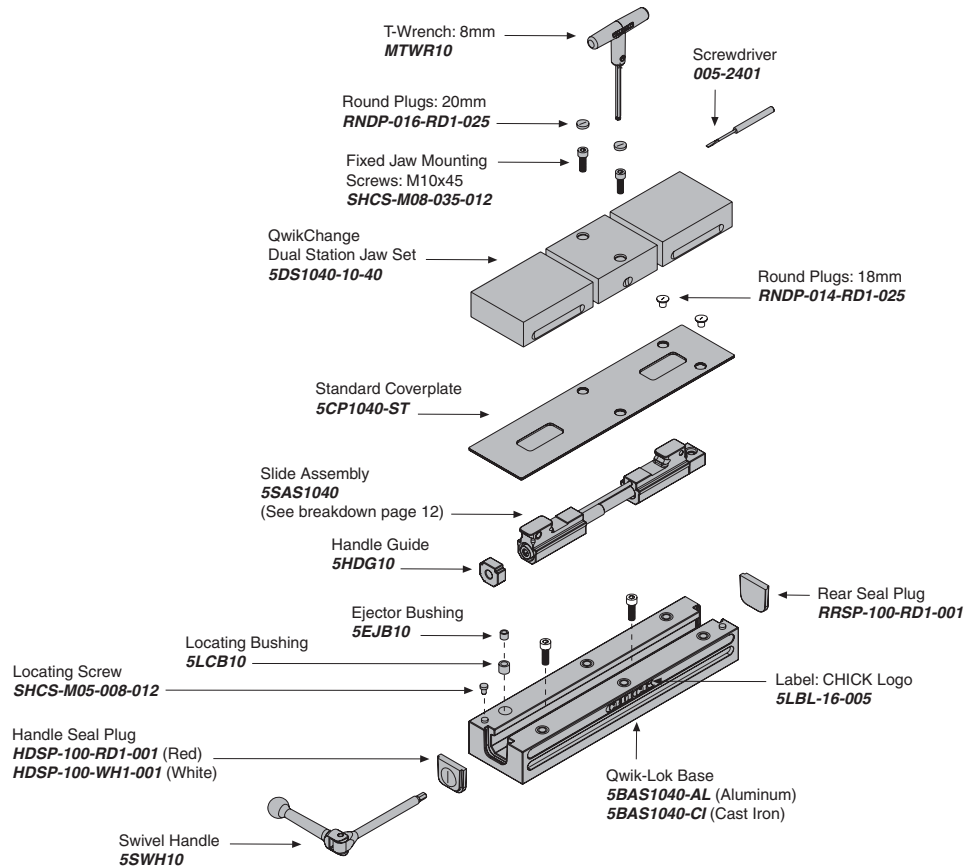
| Item Number          | Description | A         | Jaw Width  |
|----------------------|-------------|-----------|------------|
| <b>5DS1040-10-40</b> | Standard    | 26 [1.02] | 99 [3.90]  |
| <b>5DS1040-10-55</b> | High        | 41 [1.61] | 99 [3.90]  |
| <b>5DS1040-15-40</b> | Wide        | 26 [1.02] | 148 [5.83] |
| <b>5DS1040-15-55</b> | Oversized   | 41 [1.61] | 148 [5.83] |

| Item Number          | Description | A         | Jaw Width  |
|----------------------|-------------|-----------|------------|
| <b>5SS1040-10-40</b> | Standard    | 26 [1.02] | 99 [3.90]  |
| <b>5SS1040-10-55</b> | High        | 41 [1.61] | 99 [3.90]  |
| <b>5SS1040-15-40</b> | Wide        | 26 [1.02] | 148 [5.83] |
| <b>5SS1040-15-55</b> | Oversized   | 41 [1.61] | 148 [5.83] |

**Notes**

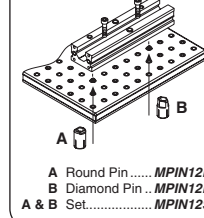
All dimensions are MM [IN]  
 Additional closure is available with an Extended Travel Coverplate.  
 Contact CHICK for details.

**CHICK WORKHOLDING SOLUTIONS, INC**  
 500 Keystone Drive • Warrendale, PA 15086 USA  
 Phone: (724) 772-1644 • Fax: (724) 772-1633  
 Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

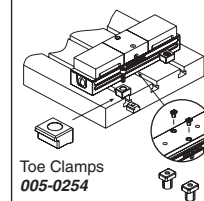


**MOUNTING**

**Foundation**

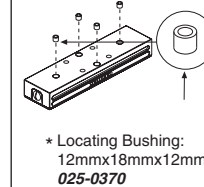


**T-Slotted Table**



Bolt and T-Nut supplied by customer

**Bottom of Base**



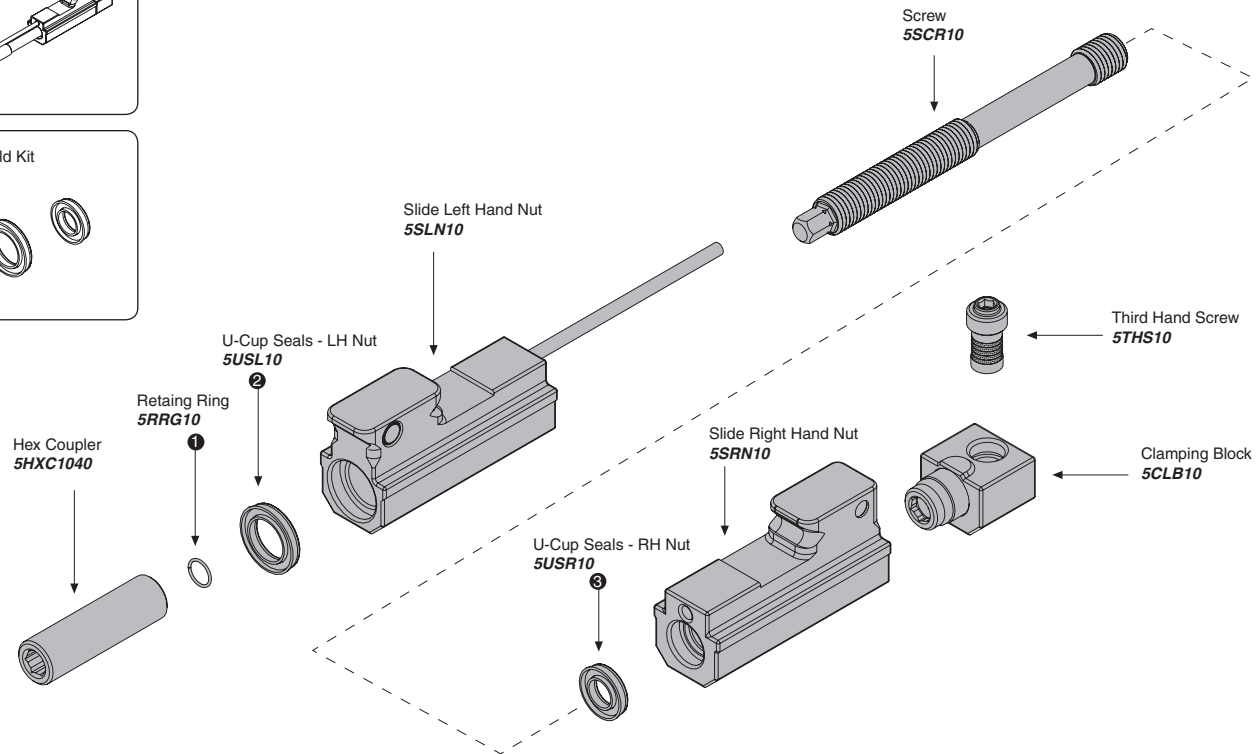
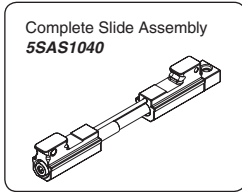
**Locating Keys**

| 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

**CHICK WORKHOLDING SOLUTIONS, INC**  
 500 Keystone Drive • Warrendale, PA 15086 USA  
 Phone: (724) 772-1644 • Fax: (724) 772-1633  
 Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)



**Notes**

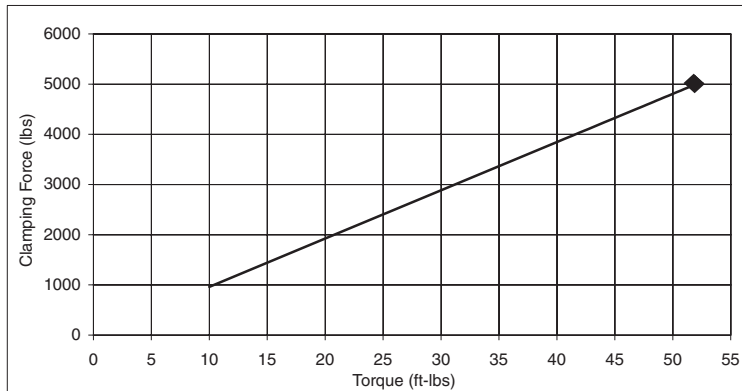
Grey items are included with a standard system

**CHICK WORKHOLDING SOLUTIONS, INC**  
 500 Keystone Drive • Warrendale, PA 15086 USA  
 Phone: (724) 772-1644 • Fax: (724) 772-1633  
 Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

**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        |

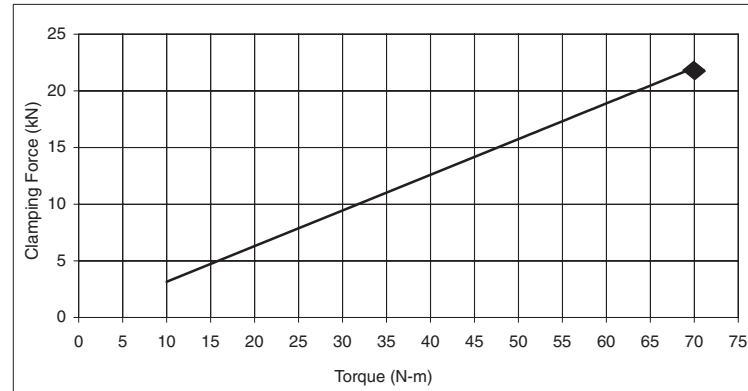


Note: ◆ Maximum Recommended Torque. Actual results may vary.

**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.

Notes

**CHICK WORKHOLDING SOLUTIONS, INC**  
 500 Keystone Drive • Warrendale, PA 15086 USA  
 Phone: (724) 772-1644 • Fax: (724) 772-1633  
 Toll Free: (800) 33-CHICK • (800) 332-4425  
[www.ChickWorkholding.com](http://www.ChickWorkholding.com)