

## 5VP-KITA-00061

This workholding package is designed for your KITAMURA 2XiF-Sparkchanger machining center.

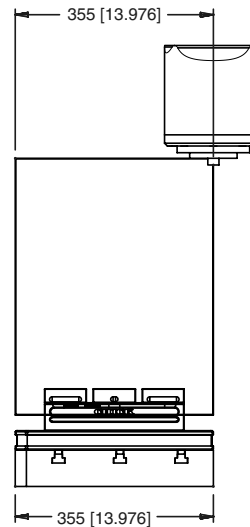
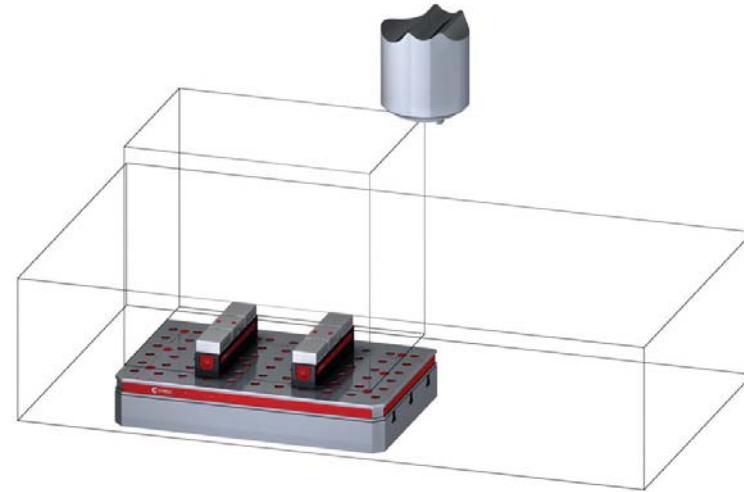
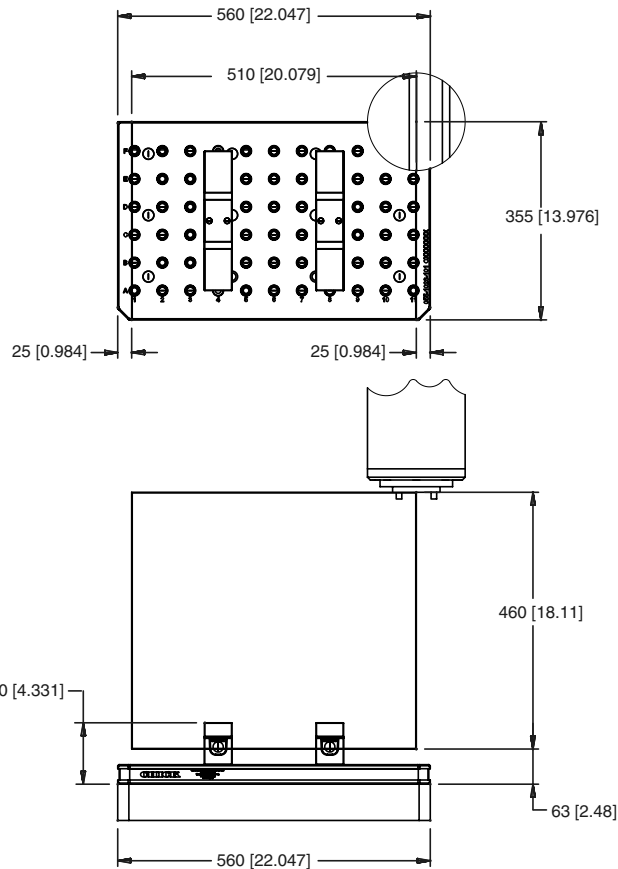


Notes

**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)

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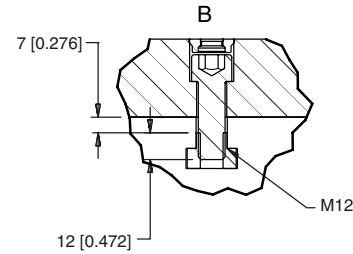
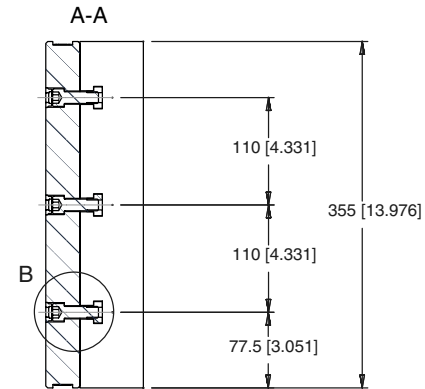
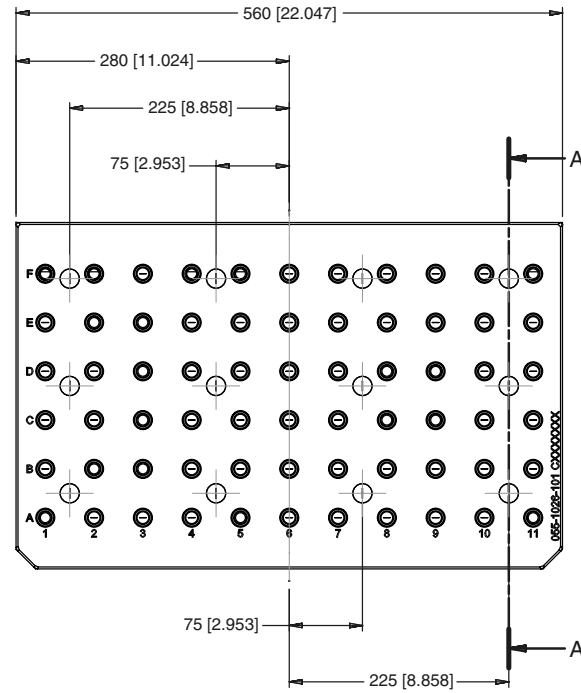
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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This workholding package is designed for your KITAMURA 2XiF-Sparkchanger machining center.

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



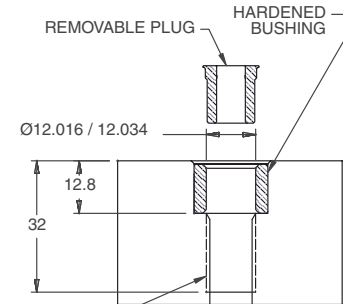
FOUNDATION MAT'L: CAST IRON  
FOUNDATION INCLUDES INSTALLATION HARDWARE

### DETAIL A



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

### SECTION B-B



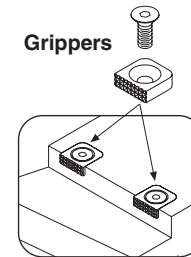
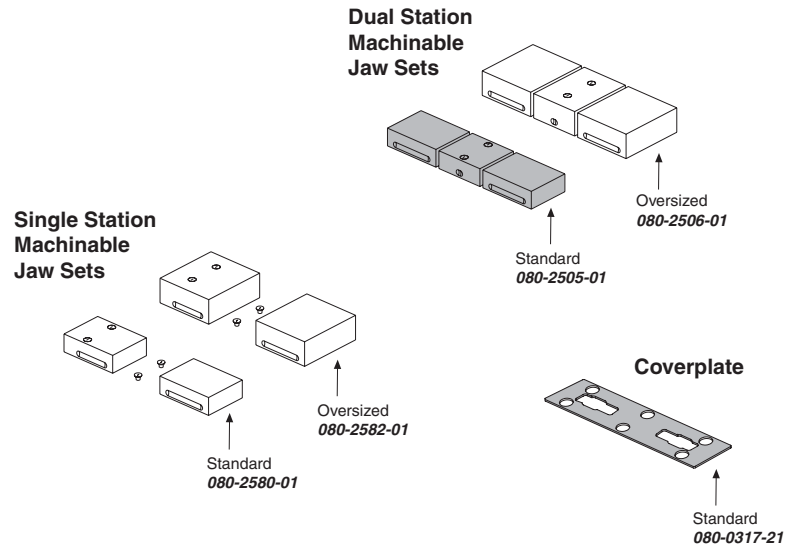
M12x1.75 TAP TO DEPTH SHOWN

Notes  
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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.



### Grippers

**Gripper #3**  
 Plain **005-2531**  
 Serrated **005-2532**  
 (L-9mm x W-9mm x T-8mm)

**Gripper #4**  
 Plain **005-2541**  
 Serrated **005-2542**  
 (L-12mm x W-12mm x T-4.6mm)

**Gripper #5**  
 Plain **005-2551**  
 Serrated **005-2552**  
 (L-15mm x W-15mm x T-5mm)

**Gripper #6**  
 Plain **005-2561**  
 Serrated **005-2562**  
 (L-19mm x W-19mm x T-6mm)

### Notes

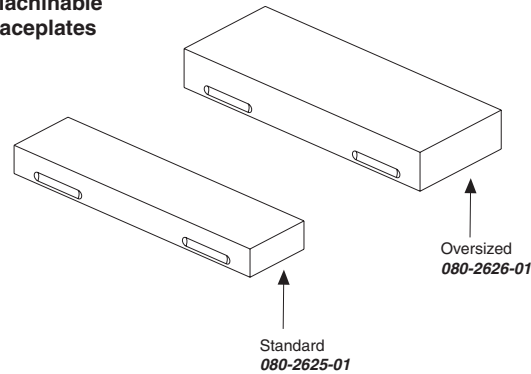
Grey item is included with a standard system

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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.

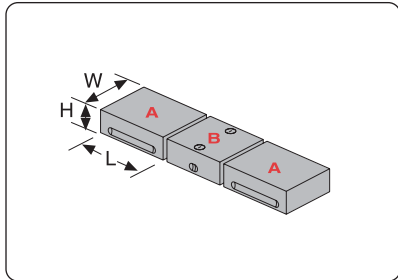
### Machinable Faceplates



Notes

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**QwikChange Machinable  
Dual Station Jaws**



**Individual Dual Station Jaws**

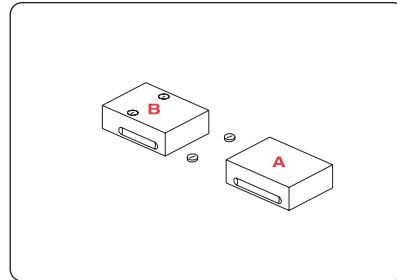
Standard

- 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

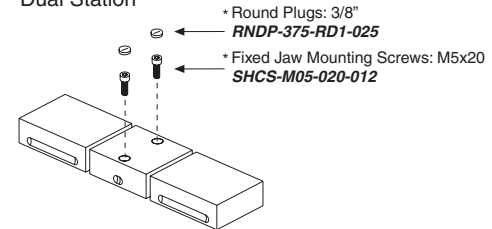
- A** Moveable Jaw ..... **080-2511-01**  
(W49mm, H25mm, L75mm)
- B** Fixed Jaw ..... **080-2571-01**  
(W49mm, H25mm, L75mm)

Oversized

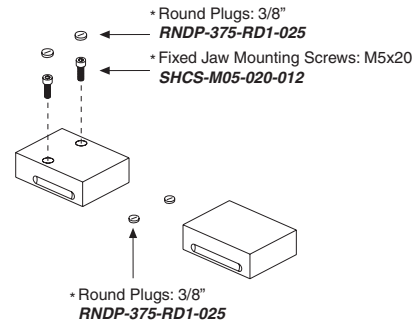
- A** Moveable Jaw ..... **080-2512-01**  
(W80mm, H35mm, L75mm)
- B** Fixed Jaw ..... **080-2572-01**  
(W80mm, H35mm, L75mm)

**Screws and Plugs**

**Dual Station**



**Single Station**

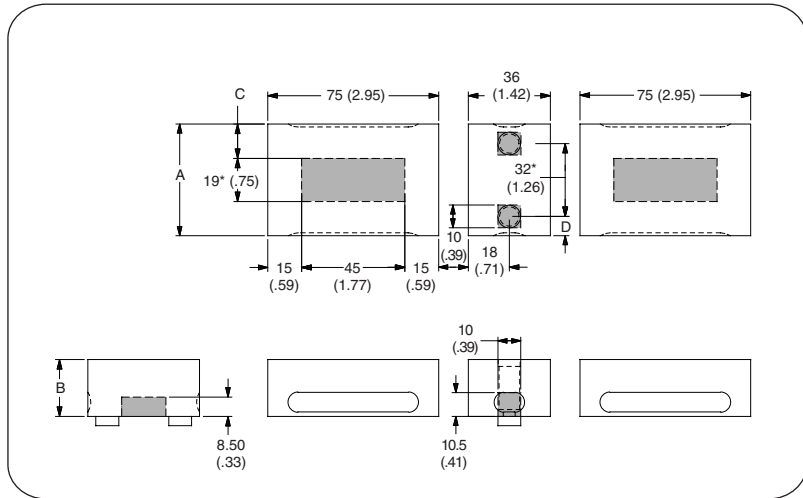


**Notes**

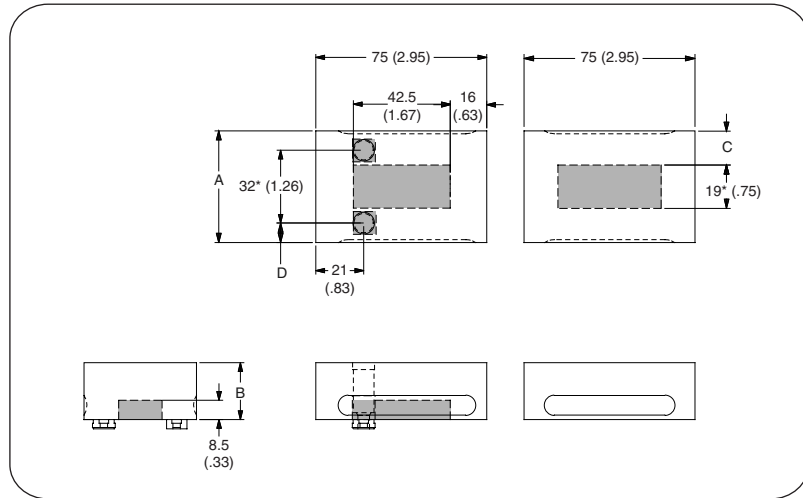
Grey or \* item is included with a standard system

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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]

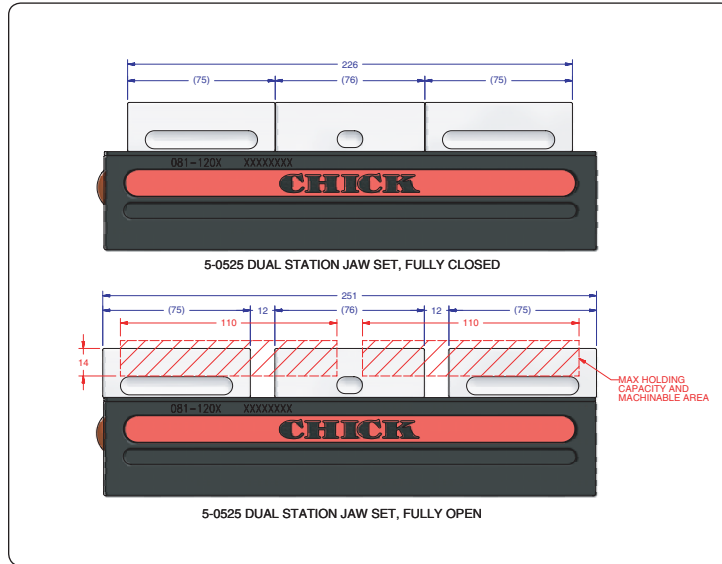
Notes

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

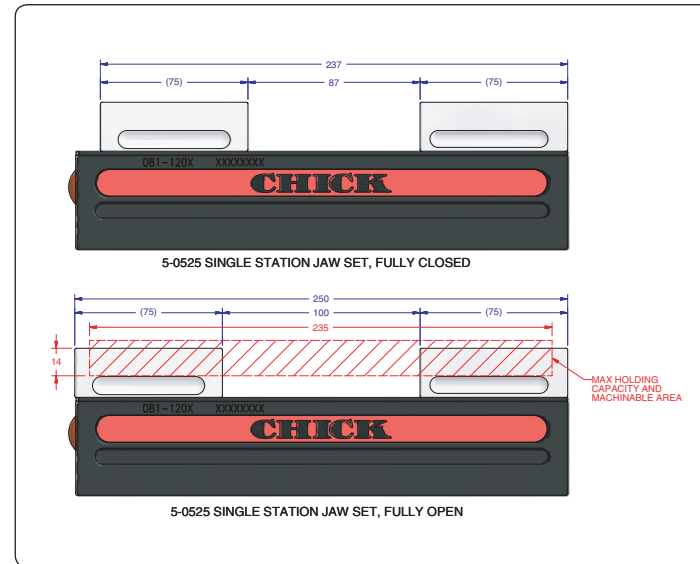
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**Dual Station**



**Single Station**



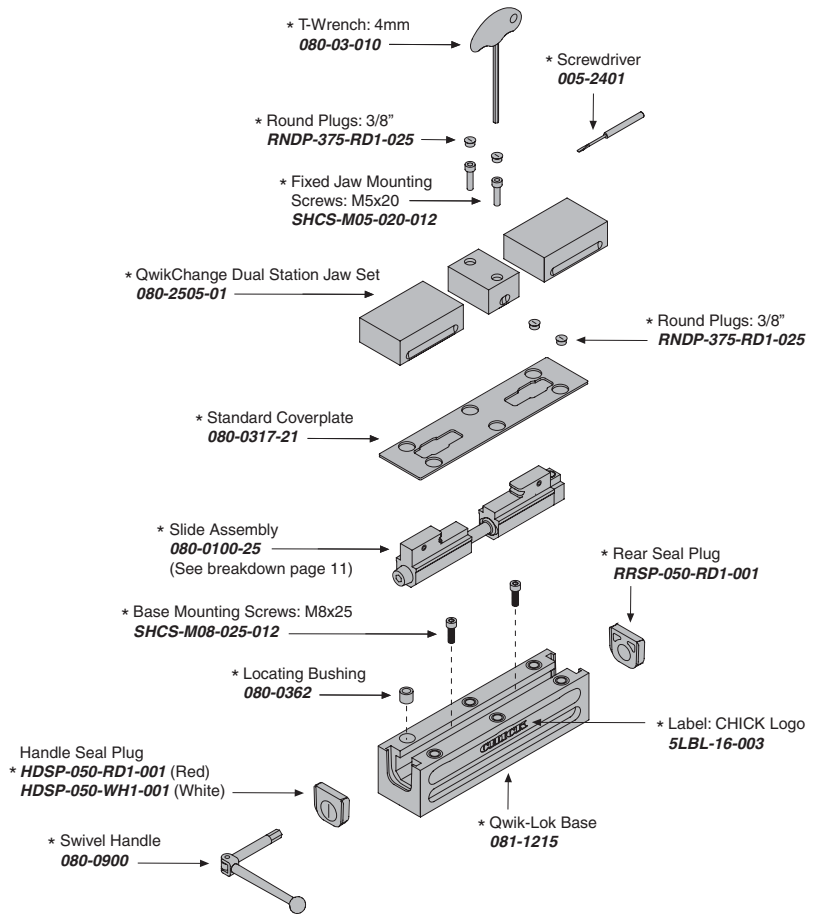
Item Number	Description	A	Jaw Width
<b>080-2500</b>	Standard	14 [0.57]	49 [1.93]
<b>080-2506</b>	Oversized	24 [0.96]	80 [3.15]

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]

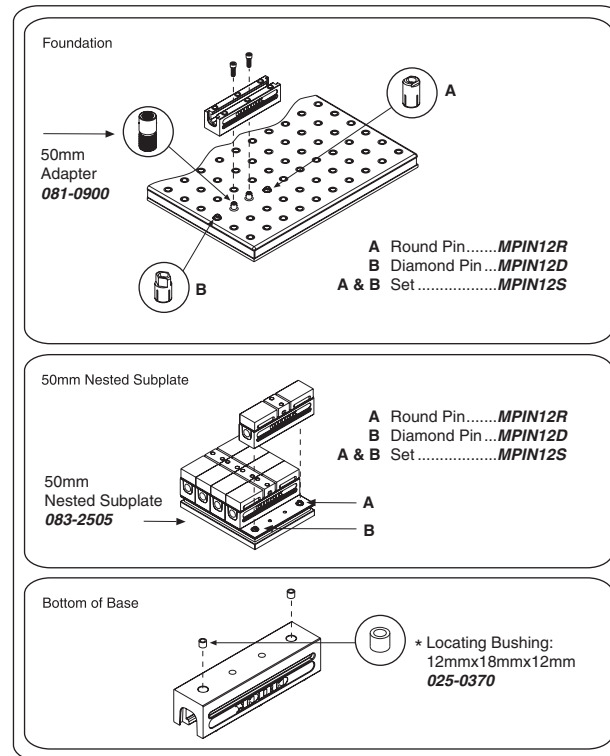
**Notes**

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

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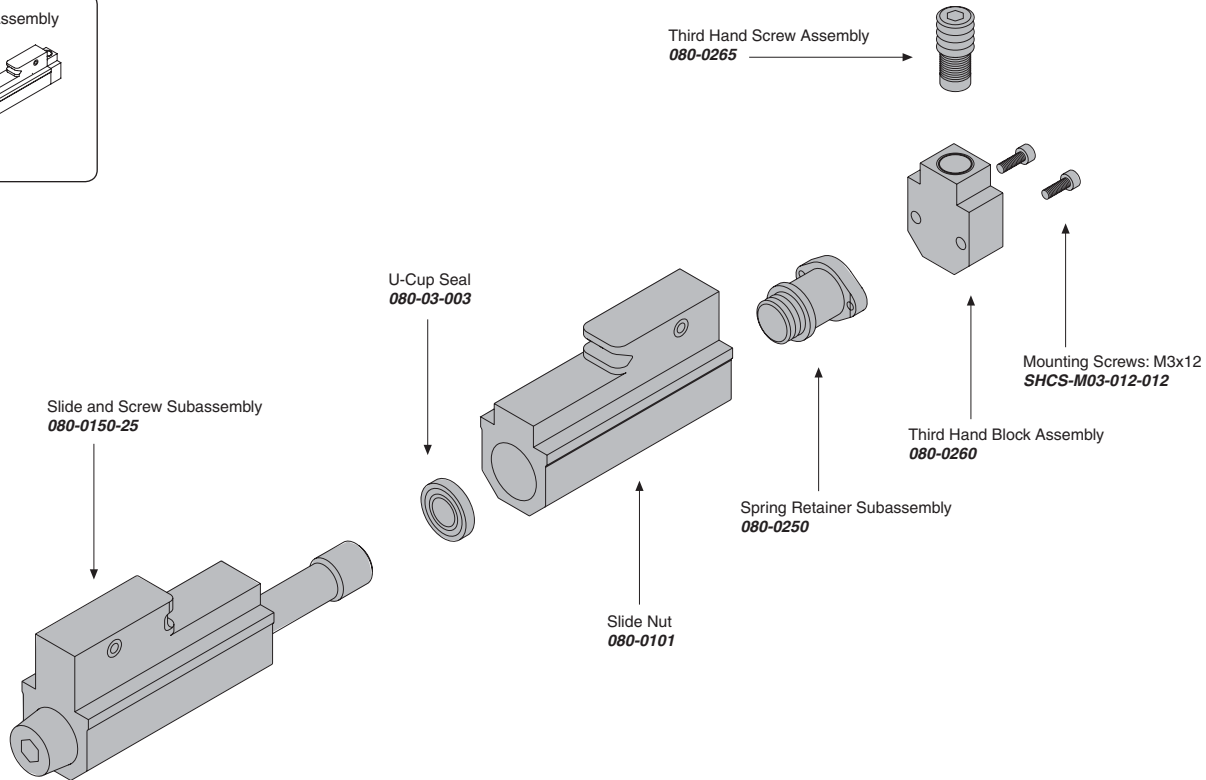
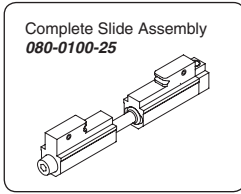
**MOUNTING**



**Notes**

Grey items are included with a standard system  
 For QwikChange™ Jaw accessories, see pages 5-7

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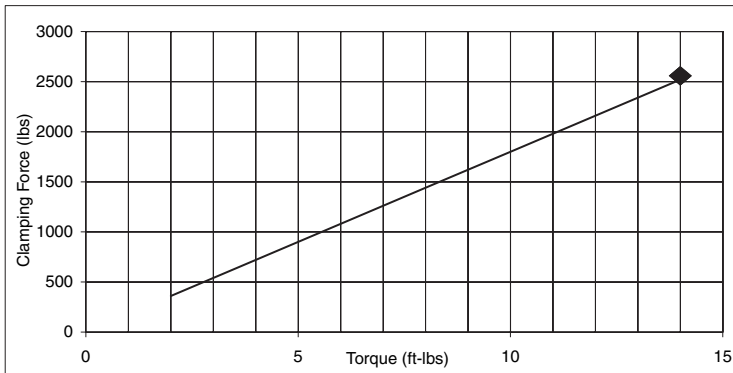
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**Pounds (lbs)**

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

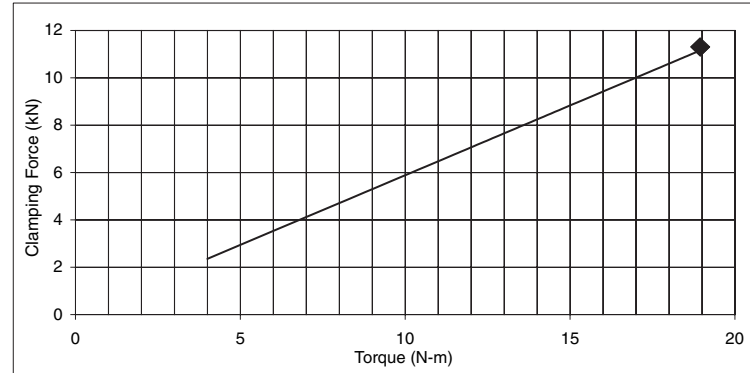


Note: ◆ Maximum Recommended Torque. Actual results may vary.

**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.

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