

5VP-KITA-00063

This workholding package is designed for your KITAMURA 1XiF-Sparkchanger machining center.

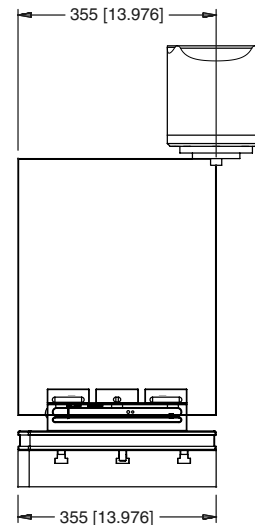
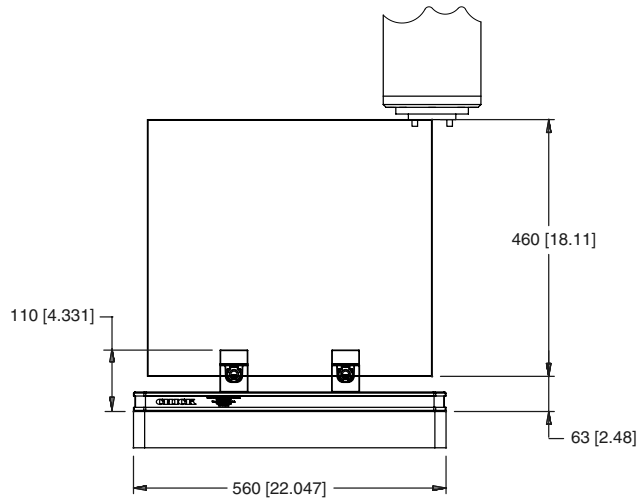
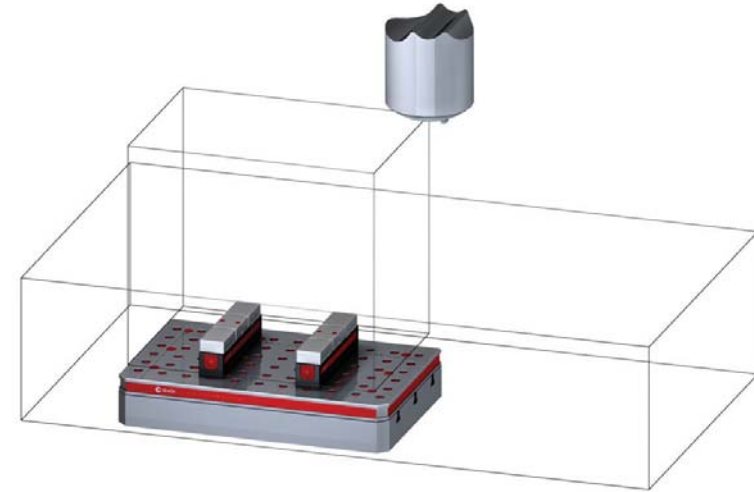
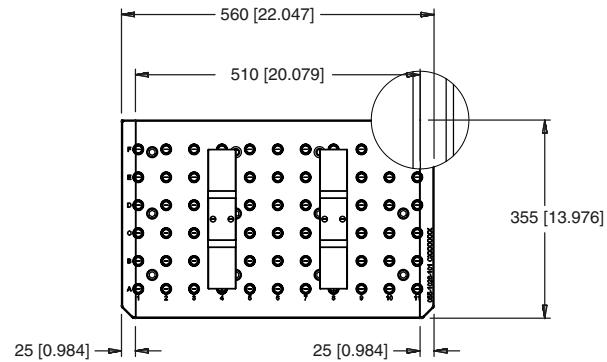


Notes

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

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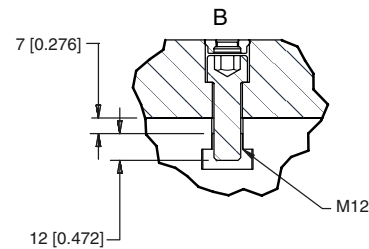
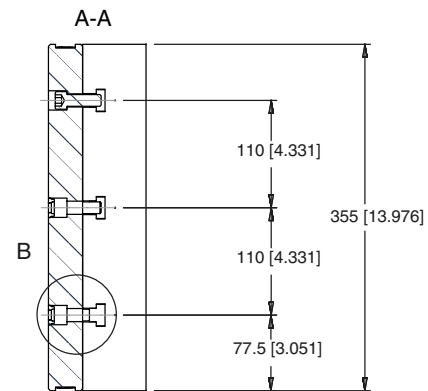
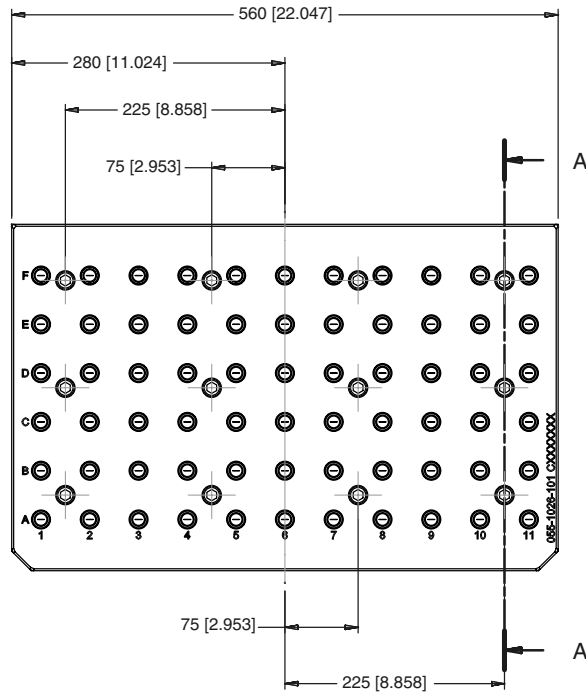
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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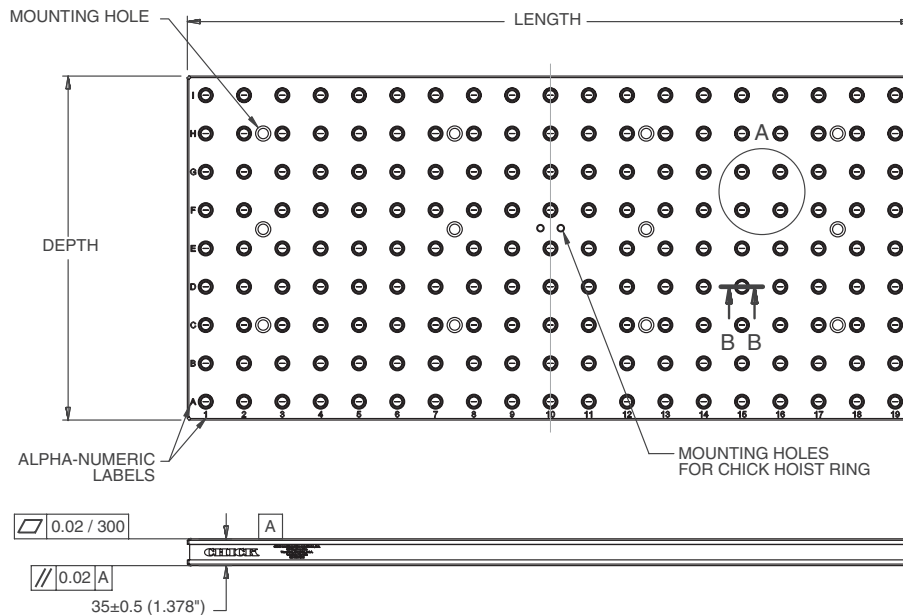
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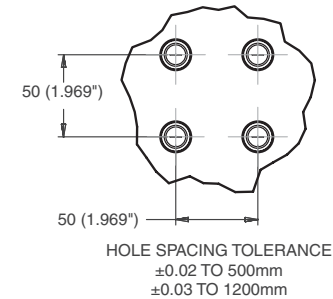
This workholding package is designed for your KITAMURA 1XiF-Sparkchanger machining center.

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

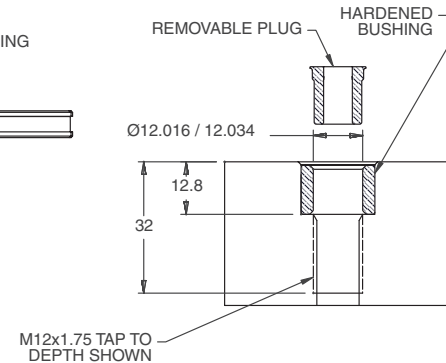


FOUNDATION MAT'L: CAST IRON
FOUNDATION INCLUDES INSTALLATION HARDWARE

DETAIL A



SECTION B-B

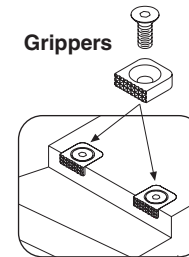
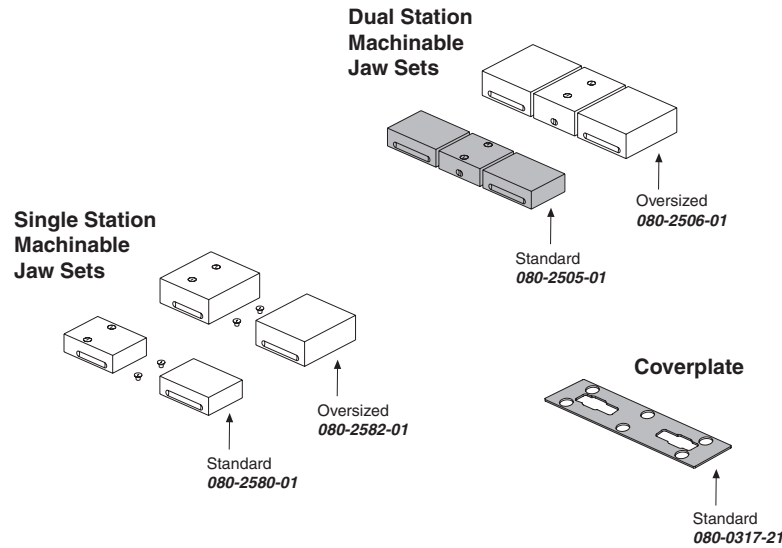


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Batch Production

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

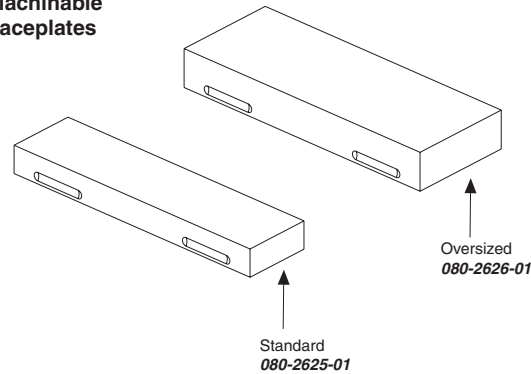
Grey item is included with a standard system

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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.

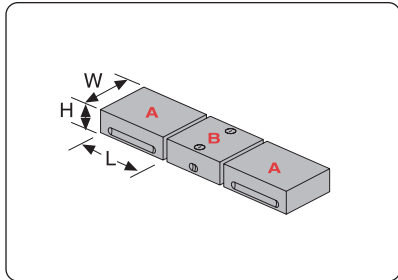
Machinable Faceplates



Notes

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**QwikChange Machinable
Dual Station Jaws**



Individual Dual Station Jaws

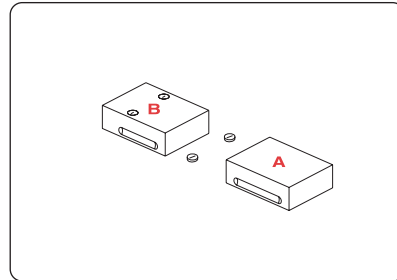
Standard

- 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

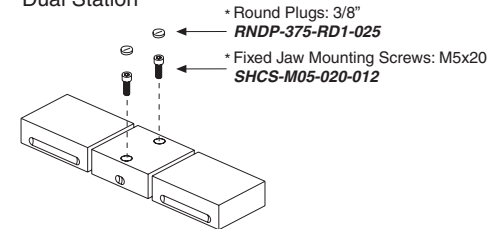
- A** Moveable Jaw **080-2511-01**
(W49mm, H25mm, L75mm)
- B** Fixed Jaw **080-2571-01**
(W49mm, H25mm, L75mm)

Oversized

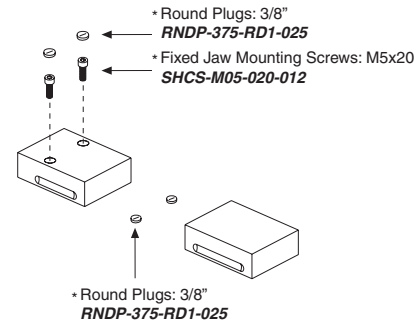
- A** Moveable Jaw **080-2512-01**
(W80mm, H35mm, L75mm)
- B** Fixed Jaw **080-2572-01**
(W80mm, H35mm, L75mm)

Screws and Plugs

Dual Station



Single Station

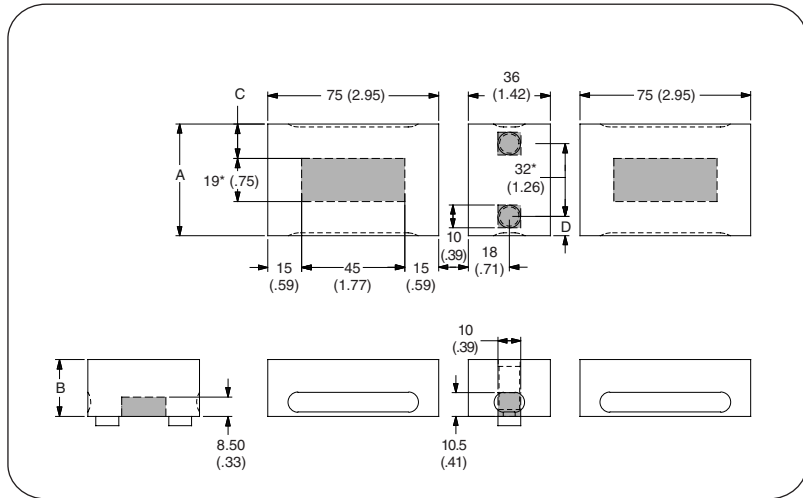


Notes

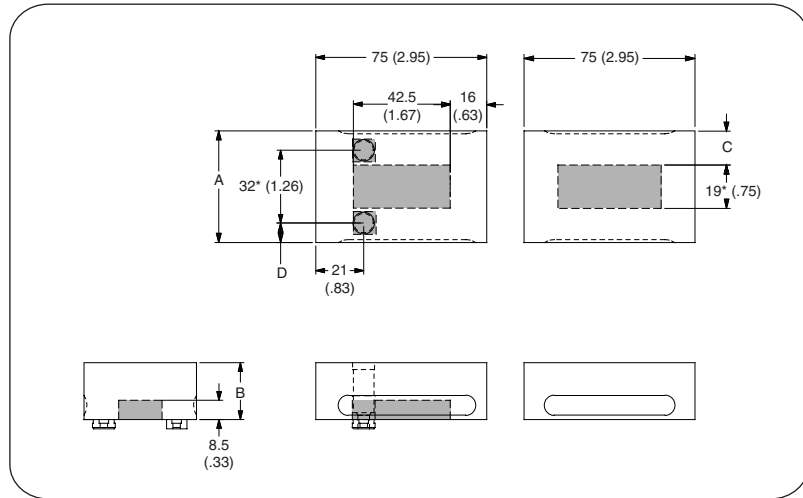
Grey or * item is included with a standard system

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Dual Station



Single Station



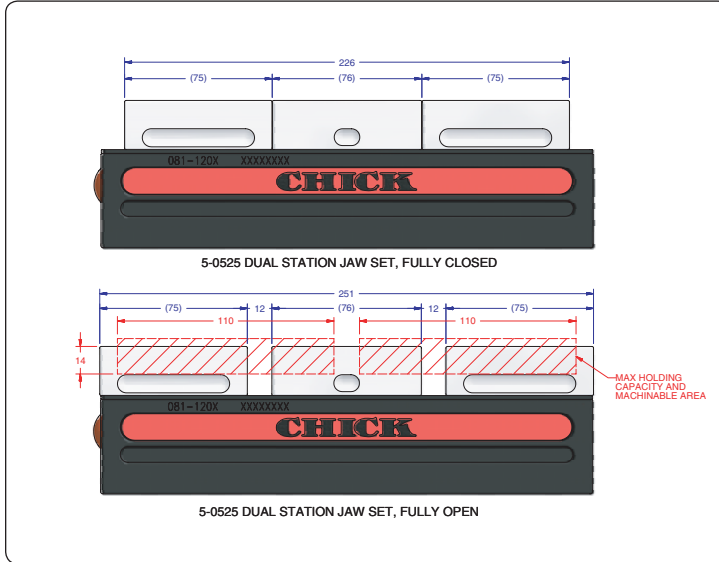
Item Number	Description	A	B	C	D
080-2500	Standard	49 [1.93]	25 [.98]	15 [.59]	8.5 [.33]
080-2506	Oversized	80 [3.15]	35 [1.38]	30.5 [1.20]	24 [.94]

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

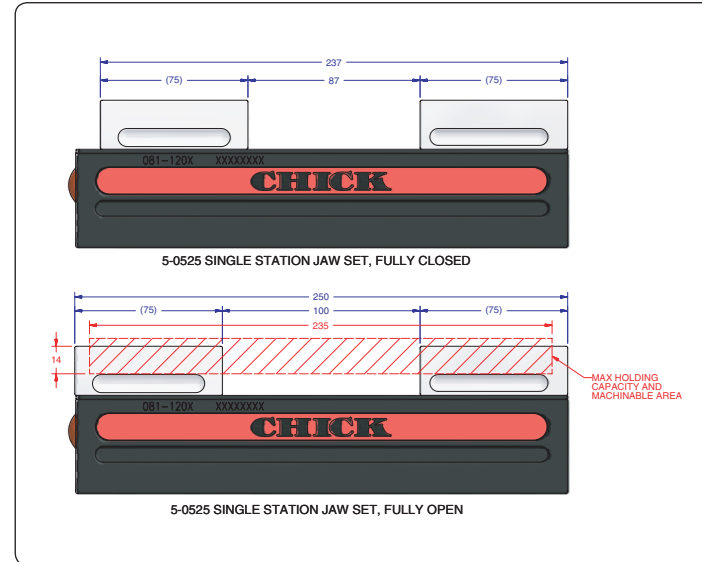
Notes
 Grey area indicates no cut zone
 All dimensions are MM [IN]
 Dimensions centered on the "A" dimension.

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Dual Station



Single Station



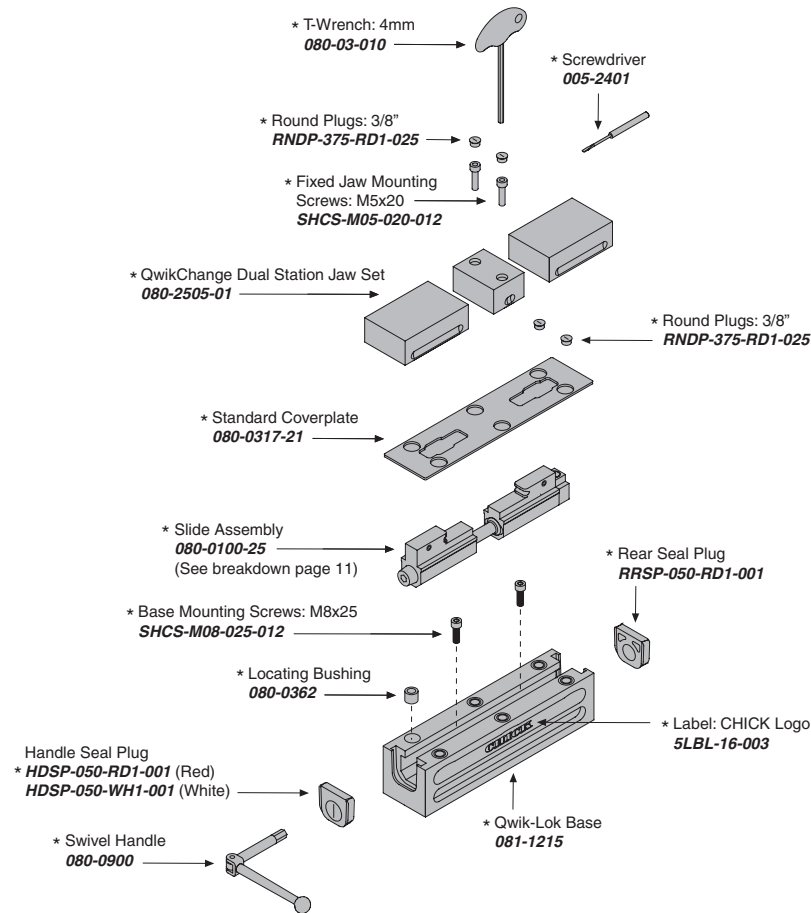
Item Number	Description	A	Jaw Width
080-2500	Standard	14 [0.57]	49 [1.93]
080-2506	Oversized	24 [0.96]	80 [3.15]

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

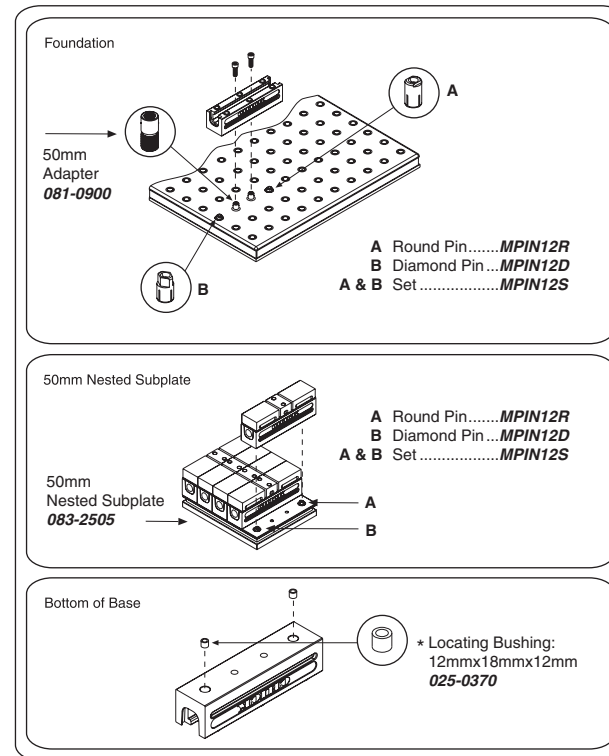
Notes

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

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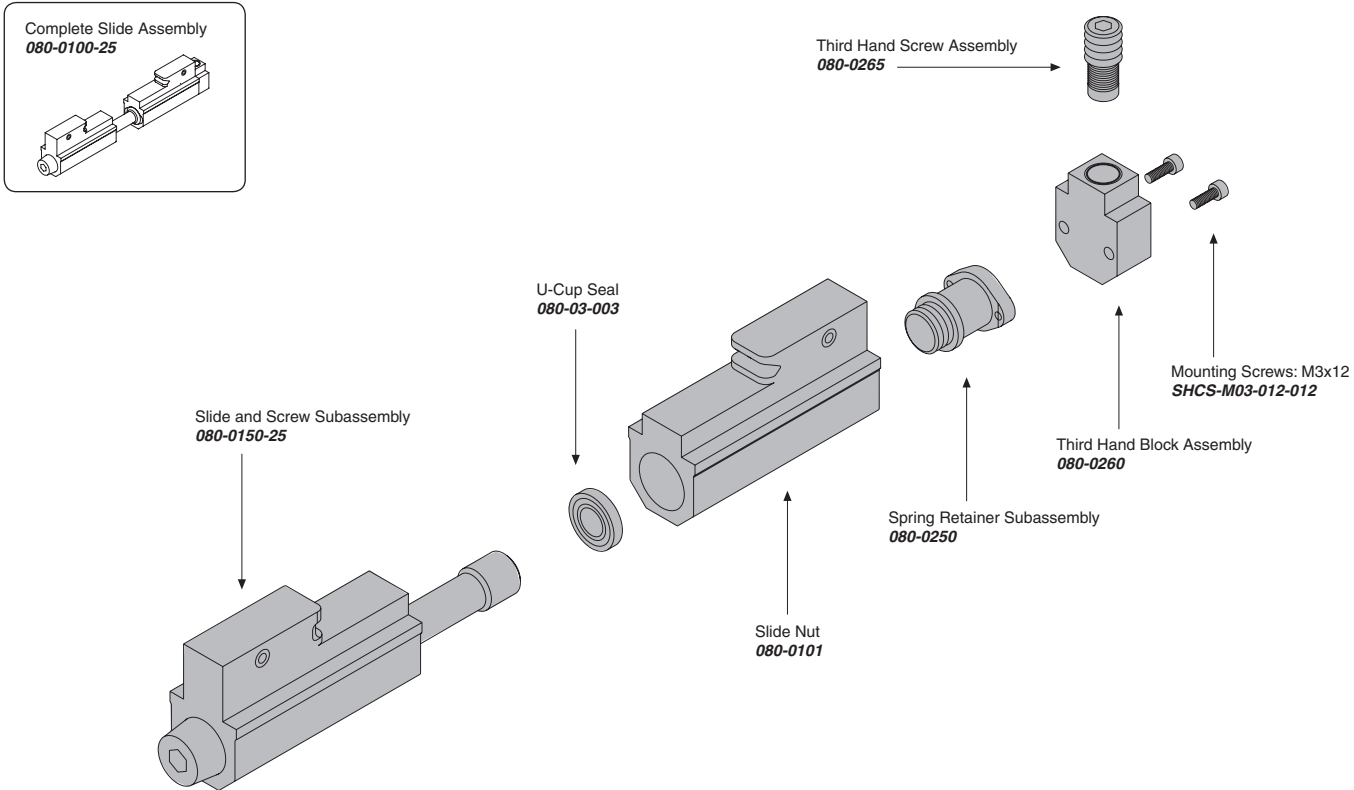
MOUNTING



Notes

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

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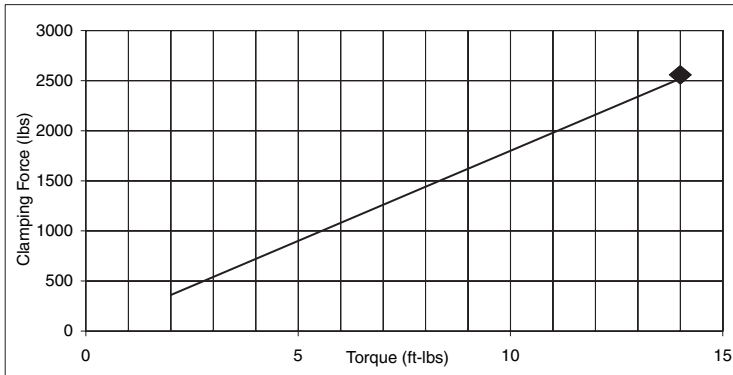
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Pounds (lbs)

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

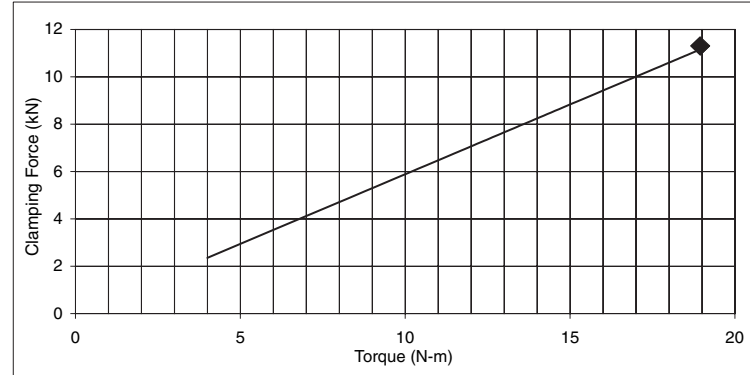


Note: ◆ Maximum Recommended Torque. Actual results may vary.

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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