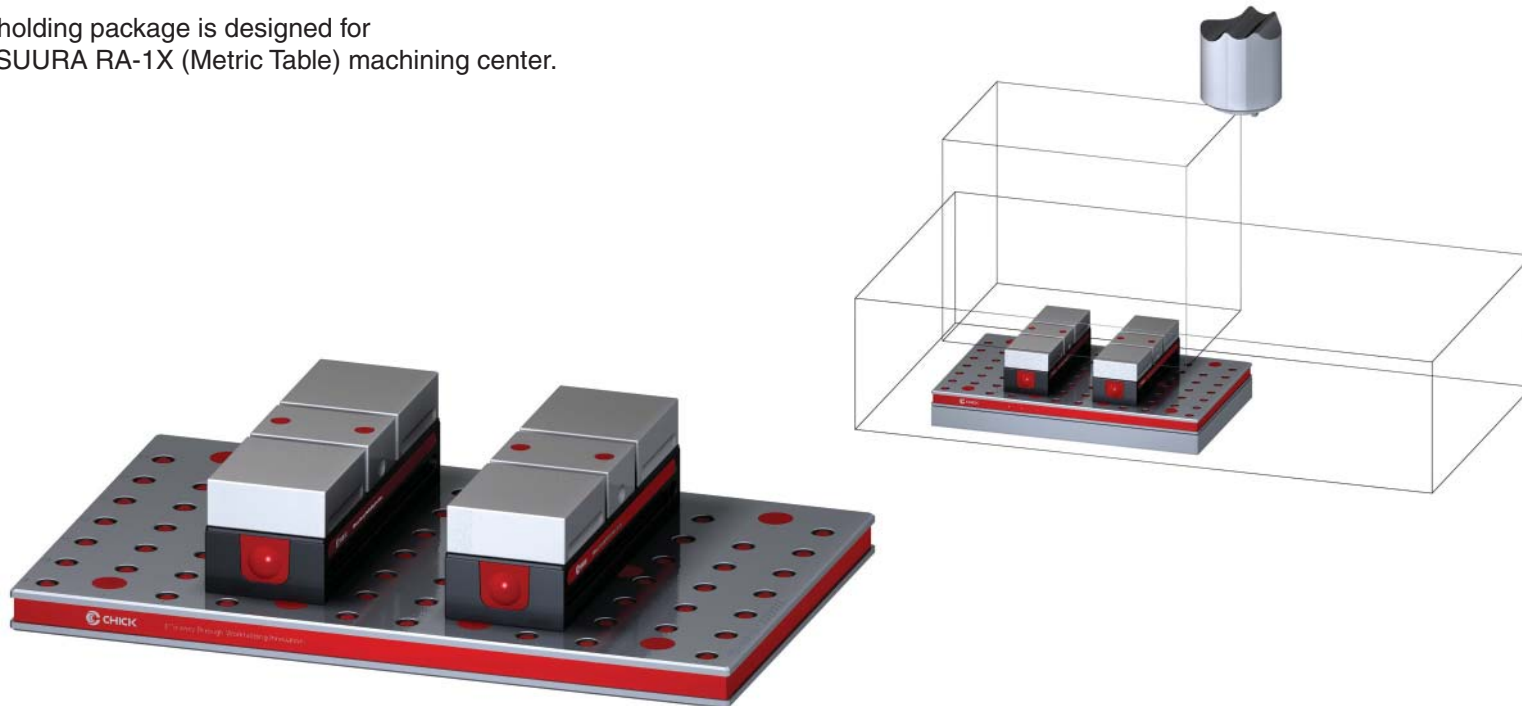


## 5VP-MATS-00102

This workholding package is designed for your MATSUURA RA-1X (Metric Table) machining center.

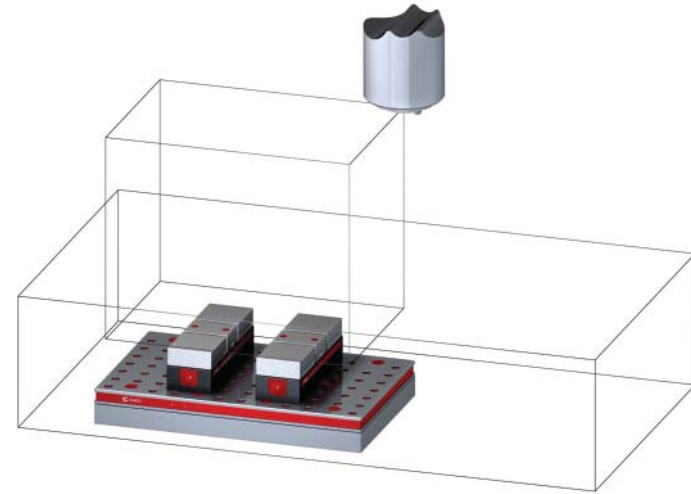
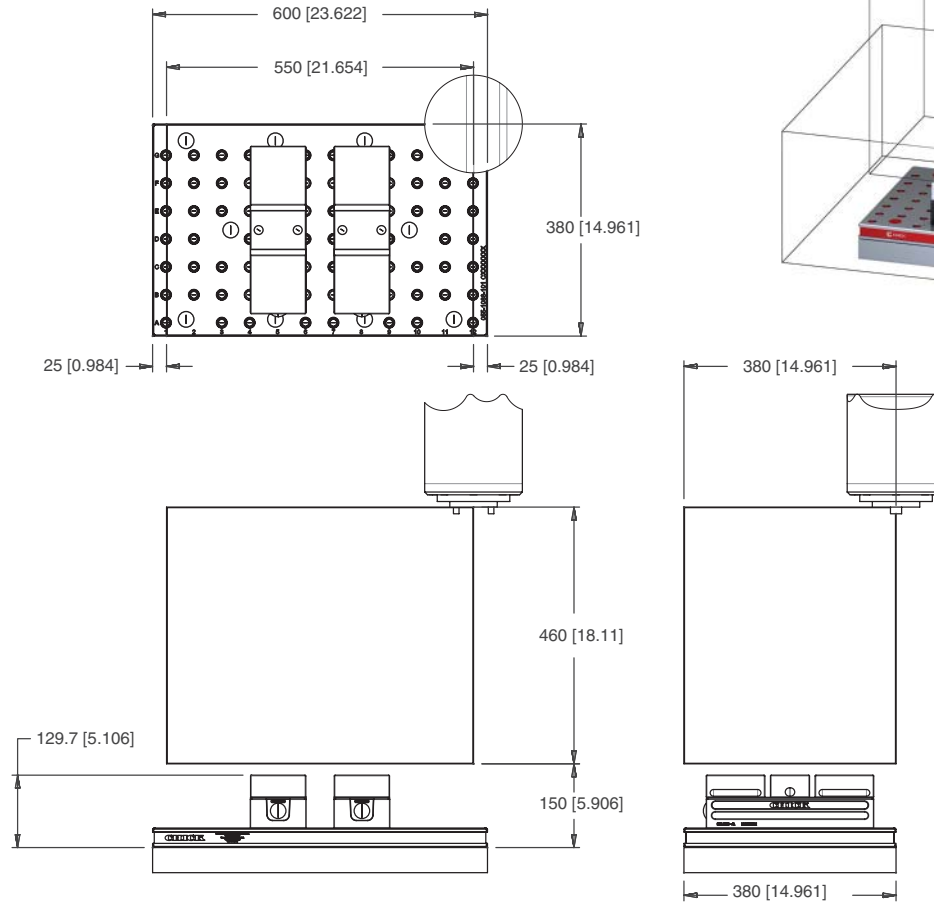


Notes

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[www.ChickWorkholding.com](http://www.ChickWorkholding.com)

# 5VP-MATS-00102

This workholding package is designed for your MATSUURA RA-1X (Metric Table) machining center.



**Notes**

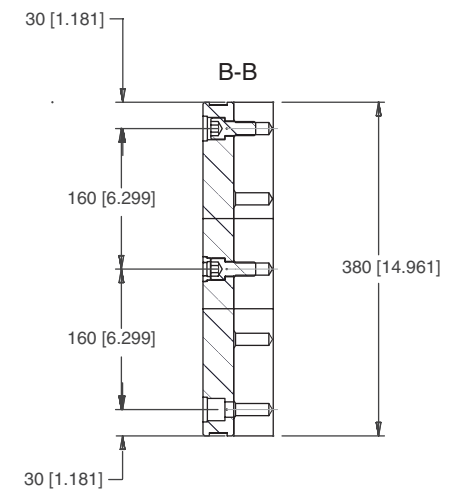
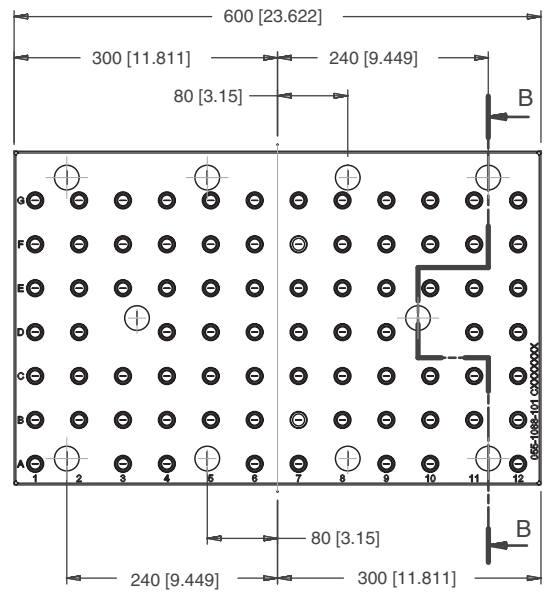
Machine travel may be limited by mechanical interference and/or machine safety zones. Please consult your machine's operating instructions for more information.

All dimensions are MM [IN]

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# 5VP-MATS-00102

This workholding package is designed for your MATSUURA RA-1X (Metric Table) machining center.



Notes  
All dimensions are MM [IN]

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# 5VP-MATS-00102

This workholding package is designed for your MATSUURA RA-1X (Metric Table) machining center.

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



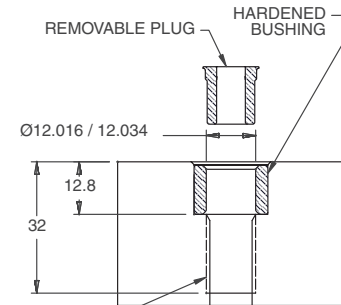
FOUNDATION MAT'L: CAST IRON  
FOUNDATION INCLUDES INSTALLATION HARDWARE

### DETAIL A



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

### SECTION B-B



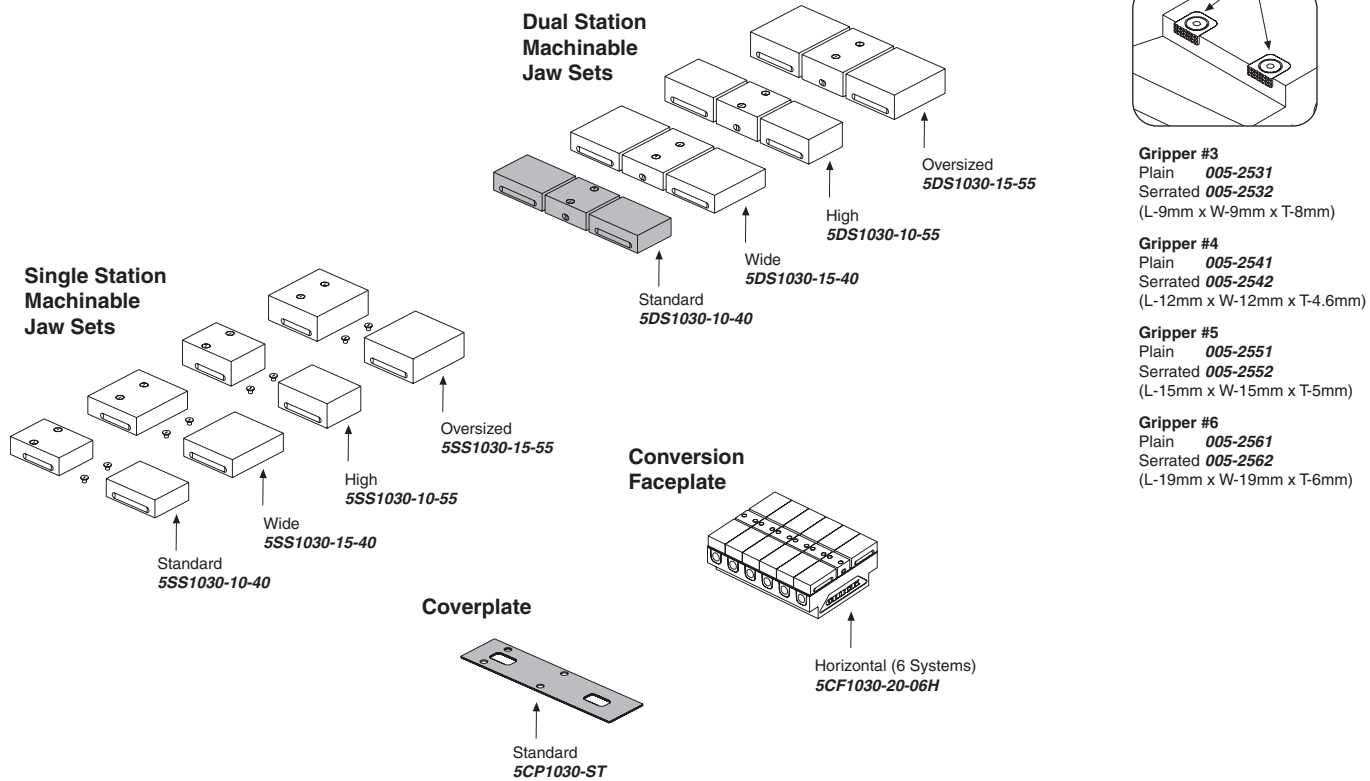
M12x1.75 TAP TO DEPTH SHOWN

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.



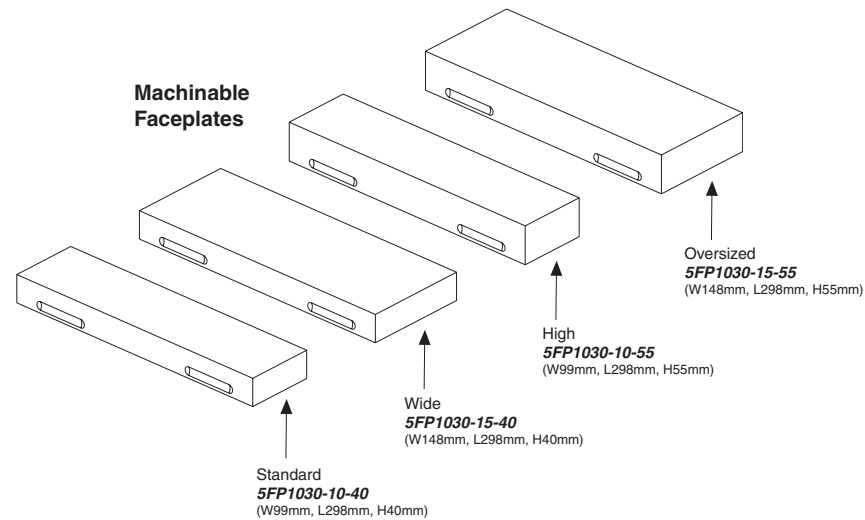
**Notes**

Grey item is included with a standard system

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## Dedicated Fixturing

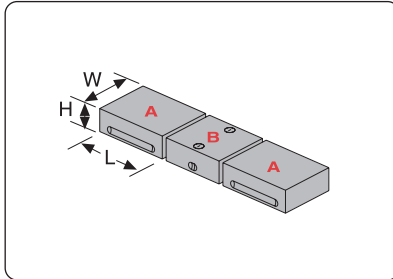
Machinable Faceplates provide QwikChange™ dedicated fixturing and are optimal for awkward or hard to hold parts. A mini pallet changer can be created by utilizing two Faceplates in tandem.



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)

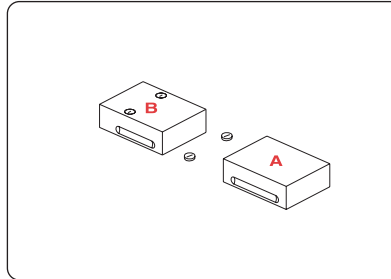
#### High

- 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

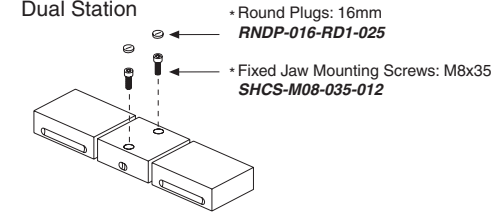
- A** Moveable Jaw ..... **5MJ1030-10-55**  
(W99mm, H55mm, L105mm)
- B** Fixed Jaw ..... **5SJ1030-10-55**  
(W99mm, H55mm, L105mm)

#### Oversized

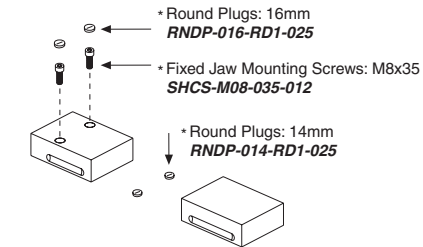
- A** Moveable Jaw ..... **5MJ1030-15-55**  
(W148mm, H55mm, L105mm)
- B** Fixed Jaw ..... **5SJ1030-15-55**  
(W148mm, H55mm, L105mm)

## Screws and Plugs

### Dual Station

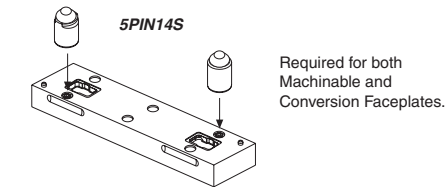


### Single Station



## Faceplate Round & Diamond Pin Set

(Included w/ Faceplate purchase)

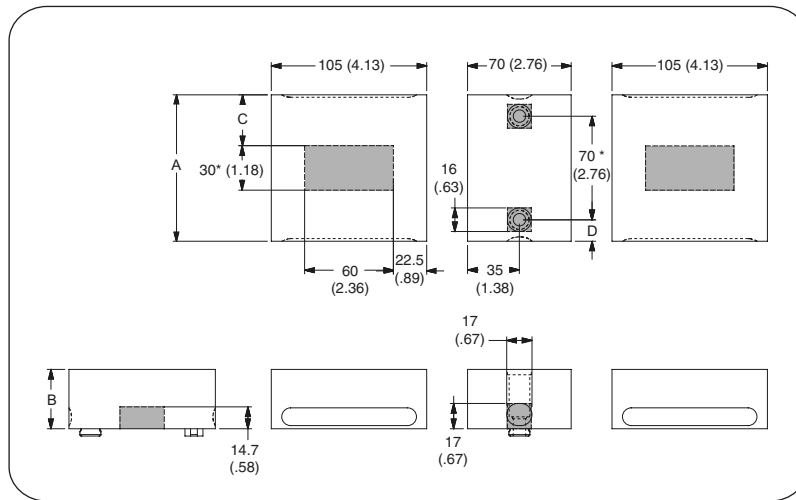


### Notes

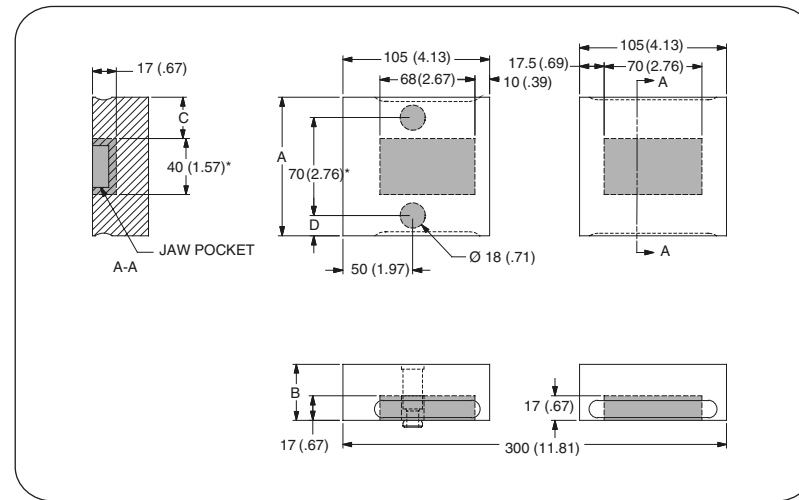
Grey or \* item is included with a standard system

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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]

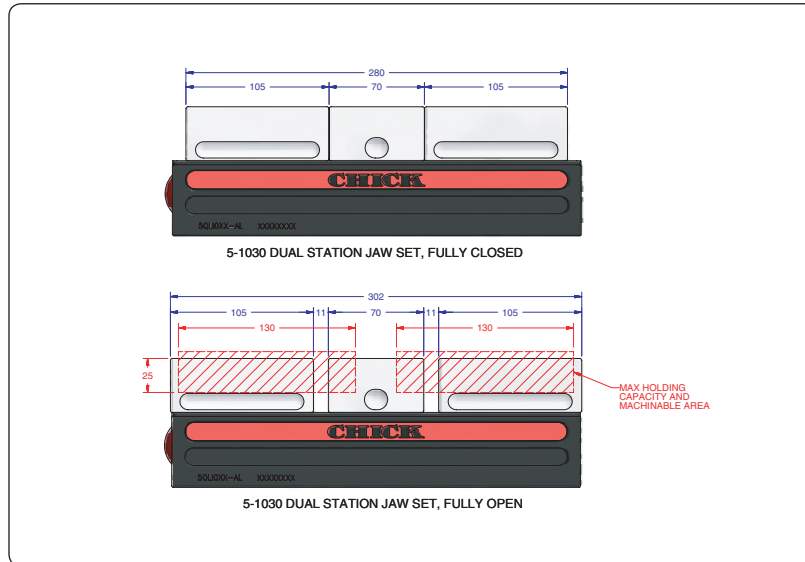
Notes

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

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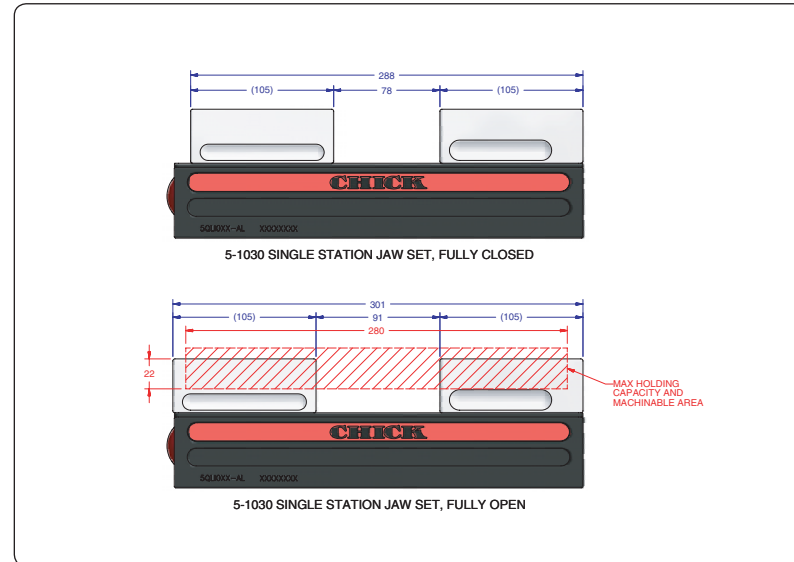


**Dual Station**



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]

**Single Station**

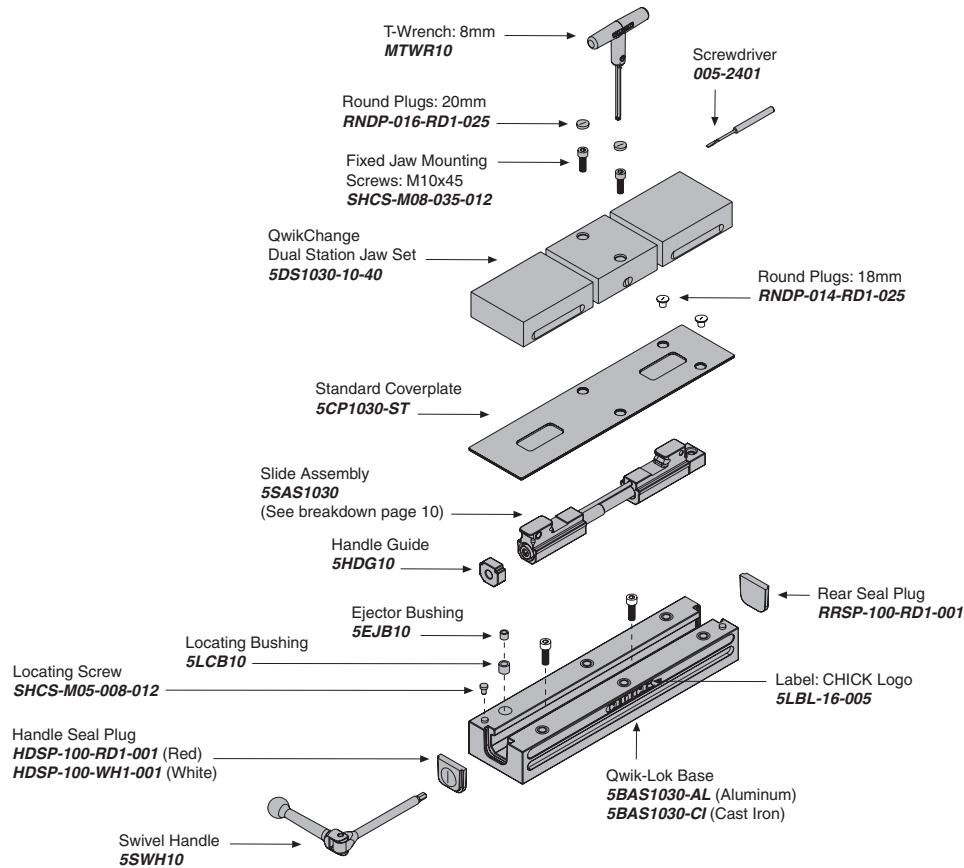


Item Number	Description	A	Jaw Width
<b>5SS1030-10-40</b>	Standard	26 [1.02]	99 [3.90]
<b>5SS1030-10-55</b>	High	41 [1.61]	99 [3.90]
<b>5SS1030-15-40</b>	Wide	26 [1.02]	148 [5.83]
<b>5SS1030-15-55</b>	Oversized	41 [1.61]	148 [5.83]

**Notes**

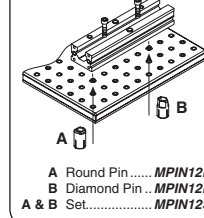
All dimensions are MM [IN]  
 Additional closure is available with an Extended Travel Coverplate.  
 Contact CHICK for details.

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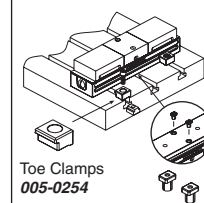


**MOUNTING**

**Foundation**

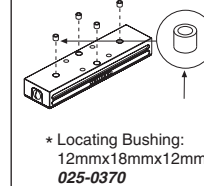


**T-Slotted Table**



Bolt and T-Nut supplied by customer

**Bottom of Base**

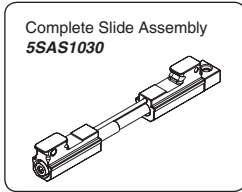


Locating Keys	
Inch Size	
MKE500	(1/2")
MKE562	(9/16")
MKE625	(5/8")
MKE688	(11/16")
MKE750	(3/4")
MKE812	(13/16")
Metric Size	
MKE10	(10mm)
MKE12	(12mm)
MKE14X18	(14mm)
MKE16	(16mm)
MKE20	(20mm)

**Notes**

Grey items are included with a standard system  
 For QwikChange™ Jaw accessories, see pages 4-7

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**Notes**

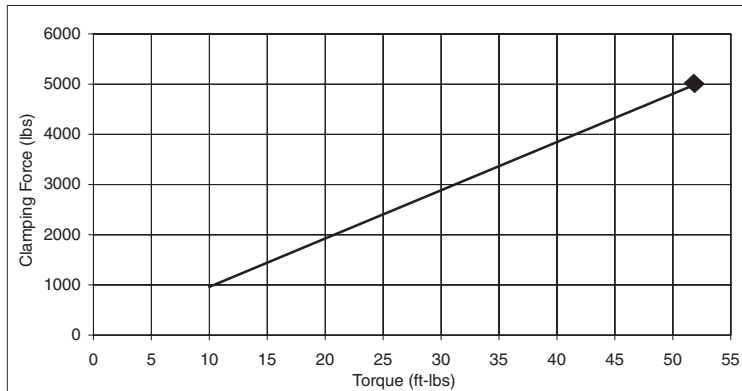
Grey items are included with a standard system

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**Pounds (lbs)**

Force	=	Torque	X	Slope
lbs	=	in-lb	x	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

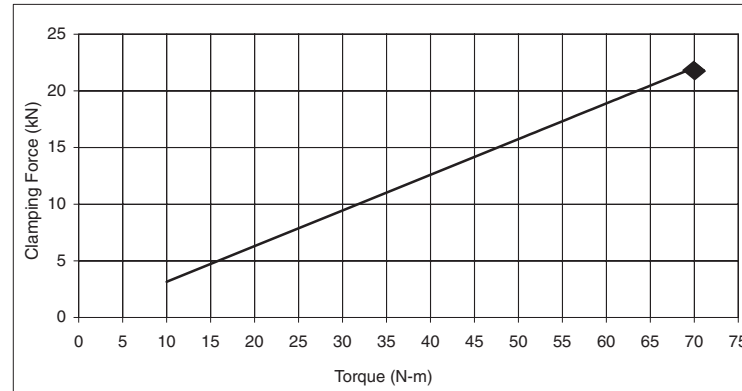


Note: ◆ Maximum Recommended Torque. Actual results may vary.

**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

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