# CHICK

How To...

Mount a Baseplate to a Multi-Lok

Most Multi-Loks require mounting to a Baseplate before they can be securely attached to a Pallet.

Chick's standard Center Locating Baseplate mounts on JIS or DIN standard pallets.
Center Locating Baseplates utilize the center hole of the pallet to center the Multi-Lok Column on the pallet.

Center Locating Baseplates are shipped with the following equipment:

One MPP50 Column Pilot Plug with four M6-1x70 Pilot Plug Mounting Screws
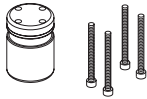
Eight M12-1.75x35 Column Mounting Screws
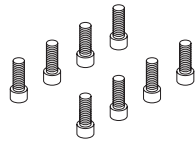
📑 **NOTE:** Length of screws may vary depending on the thickness of the Pilot Plug and/or the Baseplate.

If your pallet does not have a center hole, or the center hole is not Ø 50mm, the Center Locating Baseplate will securely hold your Multi-Lok to the pallet, but will not accurately locate your Multi-Lok System. Chick recommends ordering a Custom Baseplate if your pallet does not have a Ø 50mm center hole. Custom Baseplates are designed to meet your specifications and accurately align your Multi-Lok System.
To order a Custom Baseplate, contact Chick. Custom Baseplates are shipped with separate installation instructions.

STEP 1

Disassemble each FACE of your WORKHOLDING SYSTEM

A. Remove all **Jaws**, **Coverplates**, and **Slide Assemblies** from each **System** on the **Multi-Lok Column**.

📑 **IMPORTANT NOTE:** If your **Multi-Lok Workholding System** is attached to a baseplate, refer to *How To Mount to a Pallet*.
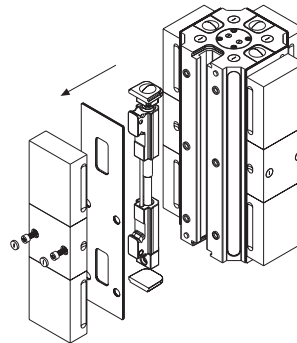
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STEP 2

Secure the COLUMN

A. Lay the stripped **Multi-Lok Column** on its side with the top of the column (the end with the engraved serial number) facing away from you. Chick recommends laying the **Column** on to parallels to avoid damage to high points such as the **Coverplate Guides**.

📖 **IMPORTANT NOTE:** Do not lay the **Column** on **Coverplate Guide Pins**.

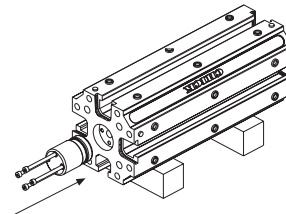Serial Number

Coverplate Guide Pins

Parallels
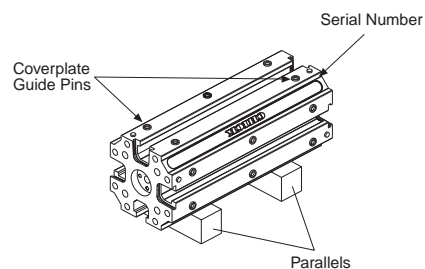
STEP 3

Attach the COLUMN PILOT PLUG to the COLUMN

A. Insert the **Column Pilot Plug** into the **Column Pilot Plug Hole** located on the bottom of the column.

B. Using a 5mm hex key, tighten the **Column Pilot Plug** to the **Column**. Tighten the **Column Pilot Plug Mounting screws** until hand tight. To draw the **Pilot Plug** into the **Column** evenly, continue tightening opposite screws one half-turn at a time until completely secure.

Recommended Torque Settings
14 N•m (10 ft-lb)

📖 **IMPORTANT NOTE:** If you are using a **Center Locating Baseplate** to secure your **Multi-Lok Column** to a pallet without a center locating hole, you may skip this step. To ensure accurate locating, you may wish to contact Chick for information about ordering a custom baseplate.

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STEP 4

Attach the COLUMN to the CENTER LOCATING BASEPLATE

A. Slide the center hole of the **Baseplate** over the **Column Pilot Plug**.

B. Visually square the **Column** to the **Baseplate**.

C. Align the mounting holes on the **Baseplate** with the mounting holes on the **Column**.

D. Insert the **Mounting Screws** through the **Baseplate** and into the **Column**.

E. Tighten the **Mounting Screws** until hand tight.
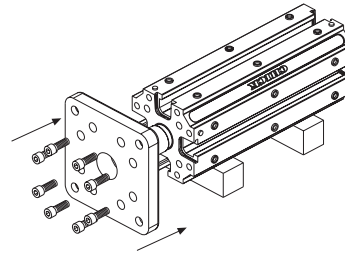
⚠ **CAUTION!:** To avoid damaging the Baseplate or Column, do NOT tighten the screws in a circular pattern around the baseplate. Use a star pattern similar to the pattern used to change a tire. Slightly tighten opposite screws, then move to the screw farthest from the last screw tightened, then to the screw opposite from that one. Continue in this pattern until all screws have been tightened slightly. Repeat this pattern until all the screws are tightened with the proper torque.

F. Using a 10mm hex key, continue tightening the **Mounting Screws** in a star pattern.

Recommended Torque Settings
  81 N•m (60 ft-lb)

Your Multi-Lok Column is now secured to the baseplate and ready to be mounted to a pallet!

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