

## How To...

## SYSTEM ⑤

### Mount a Qwik-Lok to a Foundation

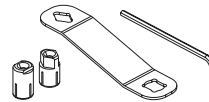
Easily mount your **Qwik-Lok** to a Foundation using the provided **Mounting Screws**.



System Size	
0520 - 0525	<b>M8-1.25x25</b>
1030 - 1040	<b>M12-1.75x35</b>
1540 - 1550	<b>M12-1.75x70</b>

You will also need an additional **Round and Diamond Pin Set (MPIN12S)** for each system.

⚠ **ATTENTION:** When mounting a 50mm Qwik-Lok, an Adaptor (**081-0900**) is also required.



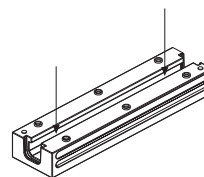
To order either of the above accessories, contact Chick.

#### STEP 1

**Access the MOUNTING HOLES of your WORKHOLDING SYSTEM**

A. Disassemble your **Workholding System** to access the **Mounting Holes**.

📄 **IMPORTANT NOTE:** Workholding Systems must be completely disassembled.



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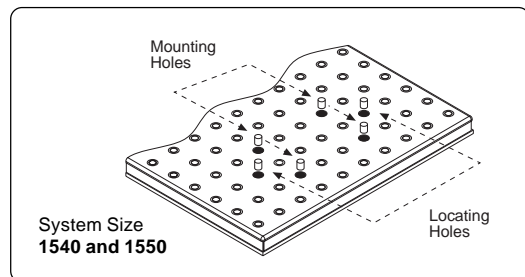
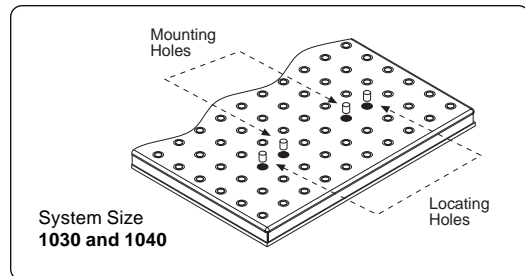
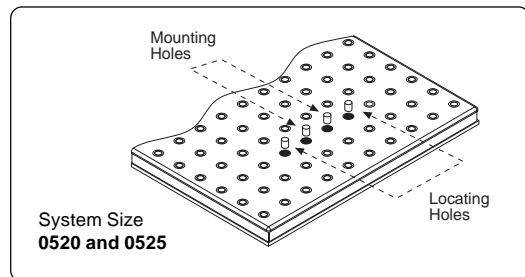
SYSTEM ⑤

### Mount a Qwik-Lok to a Foundation

#### STEP 2

**Remove CHIP PLUGS for locating and mounting**

- A. Remove the appropriate **Chip Plugs** from the Foundation to expose holes for locating and mounting.



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SYSTEM ⑤

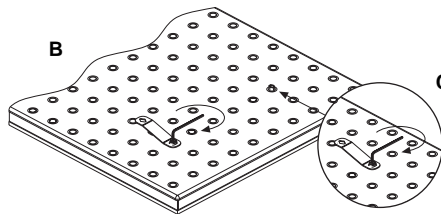
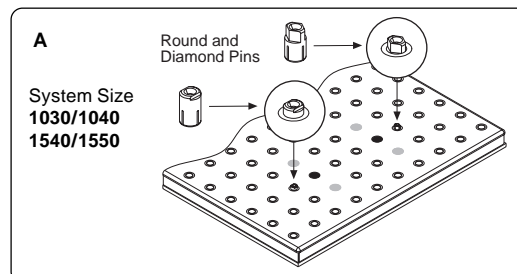
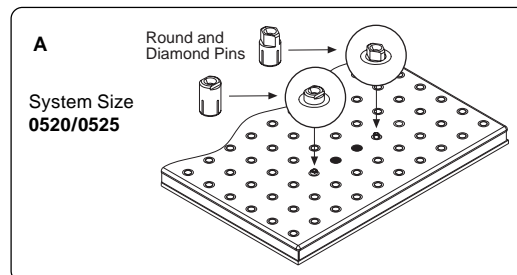
### Mount a Qwik-Lok to a Foundation

#### STEP 3

##### Insert the Round and Diamond Pins into the FOUNDATION

- A.** Insert the **Round and Diamond Pins** into the exposed locating holes (the outermost exposed holes) on the **Foundation**. Be sure to position the **Diamond Pin** so that the contact points of the diamond are perpendicular to the centerline that separates the two pins.
- B.** Use the supplied **Round and Diamond Pin Holding Wrench** to hold the **Round Pin**. While holding the **Round Pin**, insert the **Hex Key** into its head and turn clockwise.
- C.** Repeat sub-step b) for the other **Diamond Pin**.

**NOTE:** Mark alphanumeric locations for repeat setups.



**ATTENTION:** 50mm Systems require an **Adapter Set (081-8900)** to mount to a foundation.

Install the **Adapters** in the mounting holes of the **Foundation**.



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Unleash Milling Profitability

For more information, please call: 724-772-1644 or 800-332-4425

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#### STEP 4

##### Mount the BASE to the FOUNDATION

- A. Inspect the underside of the **Workholding System** and the top of the **Foundation's** mounting surface to ensure surfaces are free of chips, burs and debris.
  - B. Looking through the **Base**, align the **Mounting Holes** of the **Base** with the **Foundation's** mounting holes. Carefully place the **Base** onto the **Round and Diamond Pins** and **Mounting Adaptors** when applicable.
- IMPORTANT NOTE:** Dragging the **Base** across the **Round and Diamond Pins** or **Mounting Adaptors** may damage the **Base** or lessen the accuracy of the locating surfaces.
- C. Insert the **Mounting Screws** through the **Base** and into the exposed **Foundation** mounting holes. Use the appropriate hex key to evenly tighten the **Mounting Screws** to the following specifications:

##### Recommended Torque Settings

Use supplied swivel handle and screws.

System Size	Torque (N•m)	Torque (ft-lb)
0520 - 0525	27	20
1030 - 1040	81	60
1540 - 1550	81	60

*Your Workholding System is now mounted and ready to be reassembled!*

