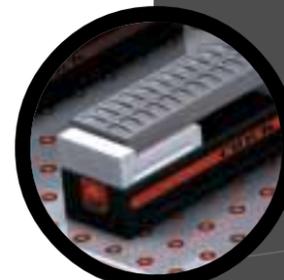
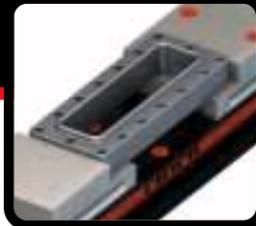


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CHICK

Modern Workholding For Modern Machines

SYSTEM **5**
Product Catalog

Made in the USA.

CHICK

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The Simply Flexible Workholding Solution...



MISSION

CHICK Workholding Solutions, Incorporated is dedicated to world leadership in workholding solutions for CNC machining centers.

To achieve our goal we will work, in partnership with our customers and suppliers, to diligently pursue quality, innovation and productivity while increasing profitability for the partnership.



CHICK

HISTORY

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MODERN WORKHOLDING

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Mounting

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Innovation

CHICK is the innovator of modern workholding for modern milling machines. Discover the evolution of dual station clamping and understand how CHICK has endured...

The test of time...

1984



Bi-Lok Classic

CHICK invents the concept of two station clamping.

- Cuts tool change time in half.
- Increases WalkAway™ time by allowing the machine to run longer, freeing the operator to “walk away” from the machine.
- Provides the flexibility of both single and dual station clamping.

1988



Multi-Lok Classic

CHICK revolutionizes workholding for horizontal machining centers.

- Brings the benefits of the Bi-Lok to the horizontal machining center.
- Machinable jaws provide the most accurate and repeatable method of location.
- QwikChange™ capabilities reduce repeat setup time from hours to minutes.

1990



E-Series

CHICK reinvents the classic products into a single uniform product line including the Bi-Lok, Qwik-Lok, and Multi-Lok.

- CHICK focuses the industry on chip handling as a major concern for workholding by creating the first system with chip covers.
- CHICK also develops the QwikChange™ faceplate allowing the system to act as a manual pallet changer.

1991



Engineering Team

CHICK develops a team whose sole focus is to help customers integrate CHICK workholding products into their production.

- This team provides a wide variety of services from answering the simplest of questions to offering complete turnkey solutions.
- Offers the customer the expertise of an experienced staff while saving time and money.

1993



Indexer Subsystem

CHICK advances workholding by developing an indexer subsystem package that takes advantage of the horizontal 3-side accessibility and places it on a vertical machining center.

- Provides access to multiple part sides thus increasing quality through less handling and fourth axis accessibility.
- Maintains the ease, flexibility, repeatability, and durability of the dual station clamping system.

1994



M-System

CHICK reaches new heights by creating the industry's only workholding family designed as a flexible modular system.

- Offers the option of a completely sealed system.
- A redesigned center fixed jaw proving the industry's most repeatable method of relocation.
- 50mm mounting and location spacing allows all systems to be removed and replaced easily and accurately.

1996



Pneu-Dex

CHICK creates the Pneu-Dex allowing the customer to place as many parts under a machine's spindle as possible.

- Multiple Pneu-Dex's placed in a machine's work envelope equals *zero* index time by allowing the spindle to machine on one Pneu-Dex while the other Pneu-Dex is indexing.
- One-of-a-kind system that provides the accuracy of ± 5 arc seconds and rigidity of 515 ft-lb (700N-m) all in a compact footprint.
- This system pays for itself by increasing walkaway time and decreasing tool change time 10-fold.

1997

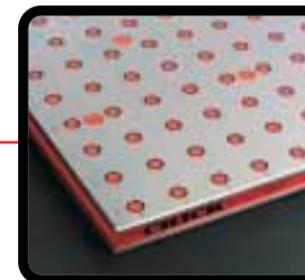


50mm (Intro to SYSTEM 5)

To meet the demands of precision machining of small intricate parts, the 50mm SYSTEM 5 product is added to CHICK's workholding family.

- Available as a stand-alone system or as an accessory to the M-System product line.
- Offers a completely sealed system with a stainless steel slide assembly and integrated single station.
- Further reduces setup time with snap on/snap off QwikChange™ accessories.

1999



Foundation

CHICK introduces the foundation to simplify and minimize fixture changeover time.

- Custom designed to maximize the machine's work envelope space.
- 50mm spaced holes are drilled and tapped for use as both location and hold down. Sealed with CHICK's patented chip plugs.
- Set up time from workholding system to system is minimized.

2000



SYSTEM 5 (Complete Family)

Through evolution and pursuit of innovation, CHICK presents a new and improved family of workholding systems.

- CHICK creates a safe low profile jaw interface, maximizing the machinable jaw area.
- Stainless steel slide assembly provides corrosion free maintenance. This combined with the simplicity of right hand and left hand thread means even greater longevity.
- CHICK is the first company to introduce the concept of a completely sealed system, which comes standard in the SYSTEM 5 line.

Today's most Innovative features.

A

Fixed/Single Station Jaws

- Industry's most accurate method of jaw location
- Precision die cut locating bosses
- Ejector bushings protect jaw locating features

B

Stainless Steel Slide Assembly

- Corrosion resistant
- Greater longevity
- Safe low profile jaw interface

C

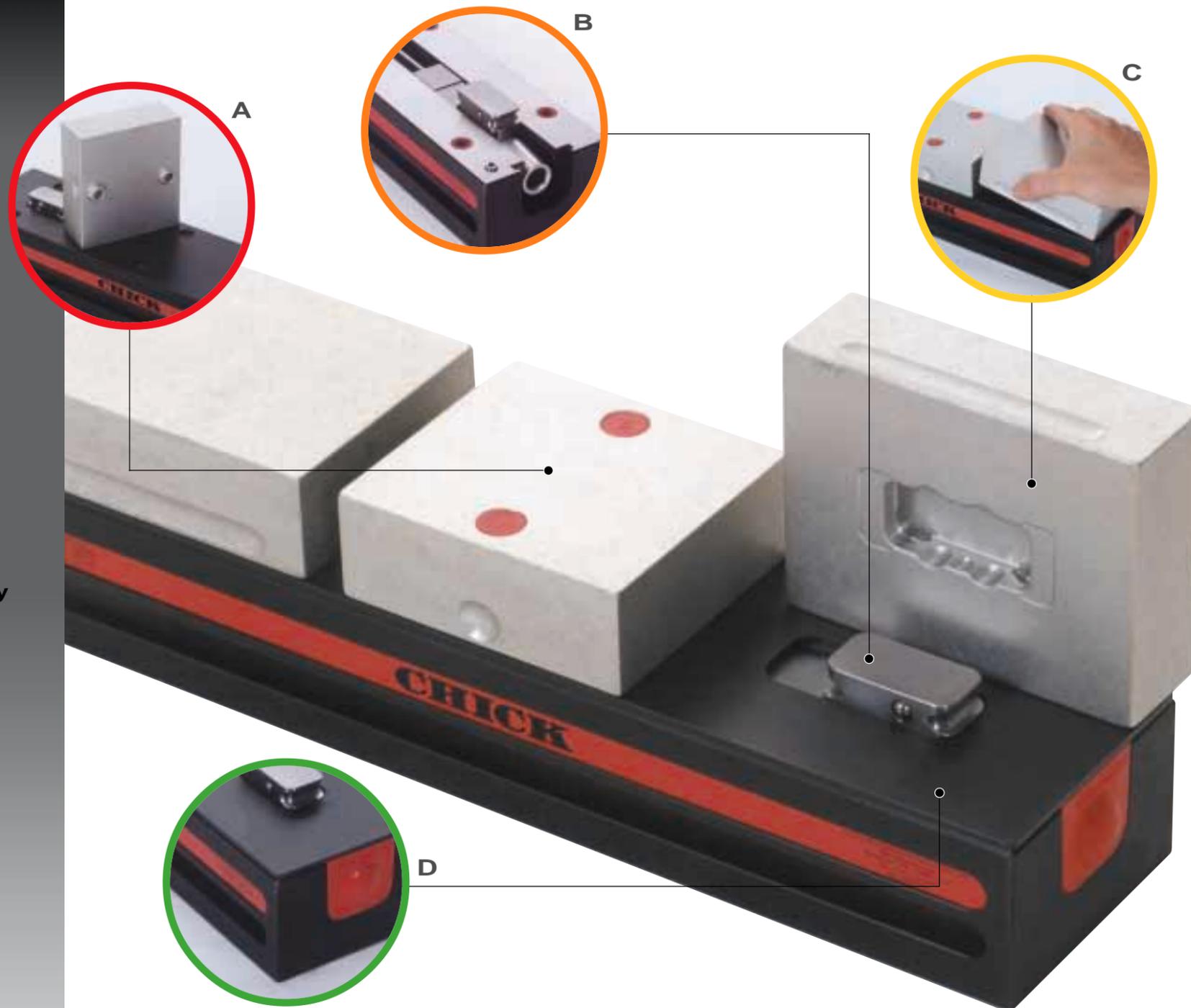
Snap ON/OFF Jaws

- Fast changeover
- Reversible
- No tools needed

D

Sealed Design

- Completely sealed system
- No exposed bolts or internal mechanisms
- No chip traps
- Minimum maintenance



QwikChange™ Accessories

One system... endless opportunities.



▶ Machinable Dual Station Jaws (Page 25)



▶ Machinable Single Station Jaws (Page 27)



▶ Machinable Faceplates (Page 29)



▶ Jaw Carriers (Page 31)



▶ Conversion Faceplates (Page 33)

VARIETY

Multiple configurations available in six sizes.

Configurations are available for both vertical and horizontal CNC machining centers in six sizes ranging from 50mm (2") to 150mm (6"). No matter what your requirements, CHICK can provide a complete workholding solution.



(Page 9)



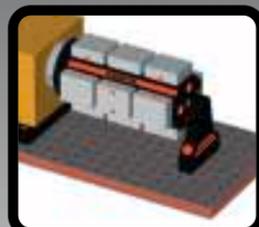
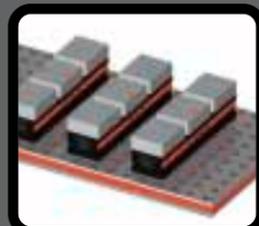
(Pages 15-22)



(Page 13)

Foundation

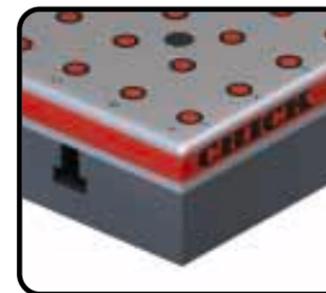
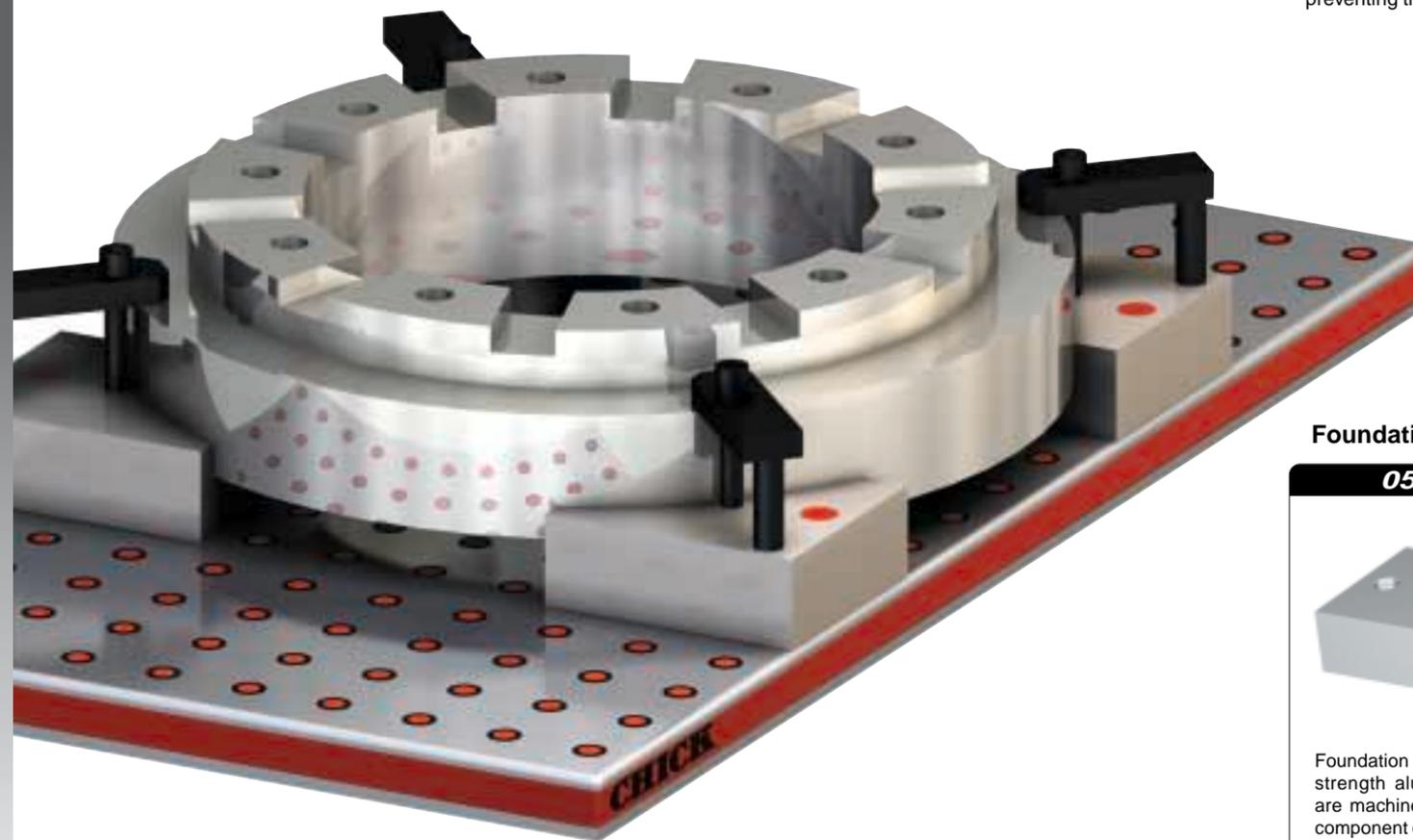
The Foundation's standard grid pattern simplifies designing, cataloging, and utilization of your fixtures, providing consistency and repeatability to your set-ups.



The perfect solution for repeat fixture setups.

- Precision ground cast iron to 35mm thick.
- Length and width tailored to the machine's work envelope.
- 50mm grid pattern of bushed and tapped holes.

Each Foundation is tailored to fit your machine's specifications. Due to the variety of machines, please contact CHICK to obtain the appropriate Foundation order number.



Foundation Design

All Foundations incorporate an alpha-numeric labeling system to simplify building and cataloging of fixtures.



Fixture Mounting Holes

Each hole within the 50mm grid pattern has a 12mm bushing for accurate location and an M12 thread for bolt down. These holes are sealed with patented chip plugs preventing the build up of chips.



Machine Interface Mounting Holes

Customized for each machining center. The hardware necessary to mount the Foundation to your table is included.

Accessories

Foundation Blox

050-0001



Foundation Blox are blank, high strength aluminum blocks that are machined into a dedicated component of your set-up. Ideal for designing component modular fixtures on Foundations. Use Accurate Bolts for unparalleled repeatability.

Accurate Bolts

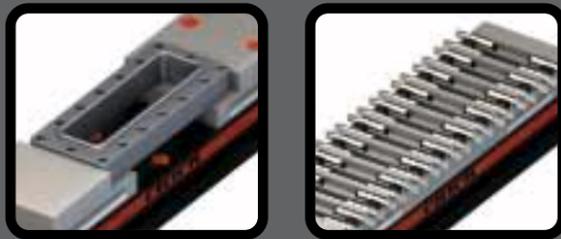
050-0002



These M12 bolts have a ground shoulder that provides precision repeatability when using Foundation Blox or any other modular fixturing components.

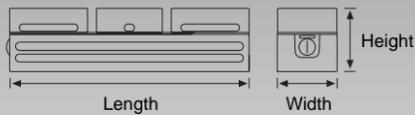
Qwik-Loks

Take advantage of the dual station clamping benefits thus increasing productivity twofold and amortizing tool change time. Select a base of either high strength aluminum or cast iron and design your fixturing from there. CHICK's wide variety of QwikChange™ accessories (pg's 23-34), provide you with the most flexible system in the industry.

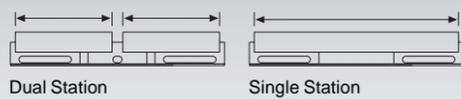


Nested Subplates
For 50mm systems only.
(See page 36 for information)

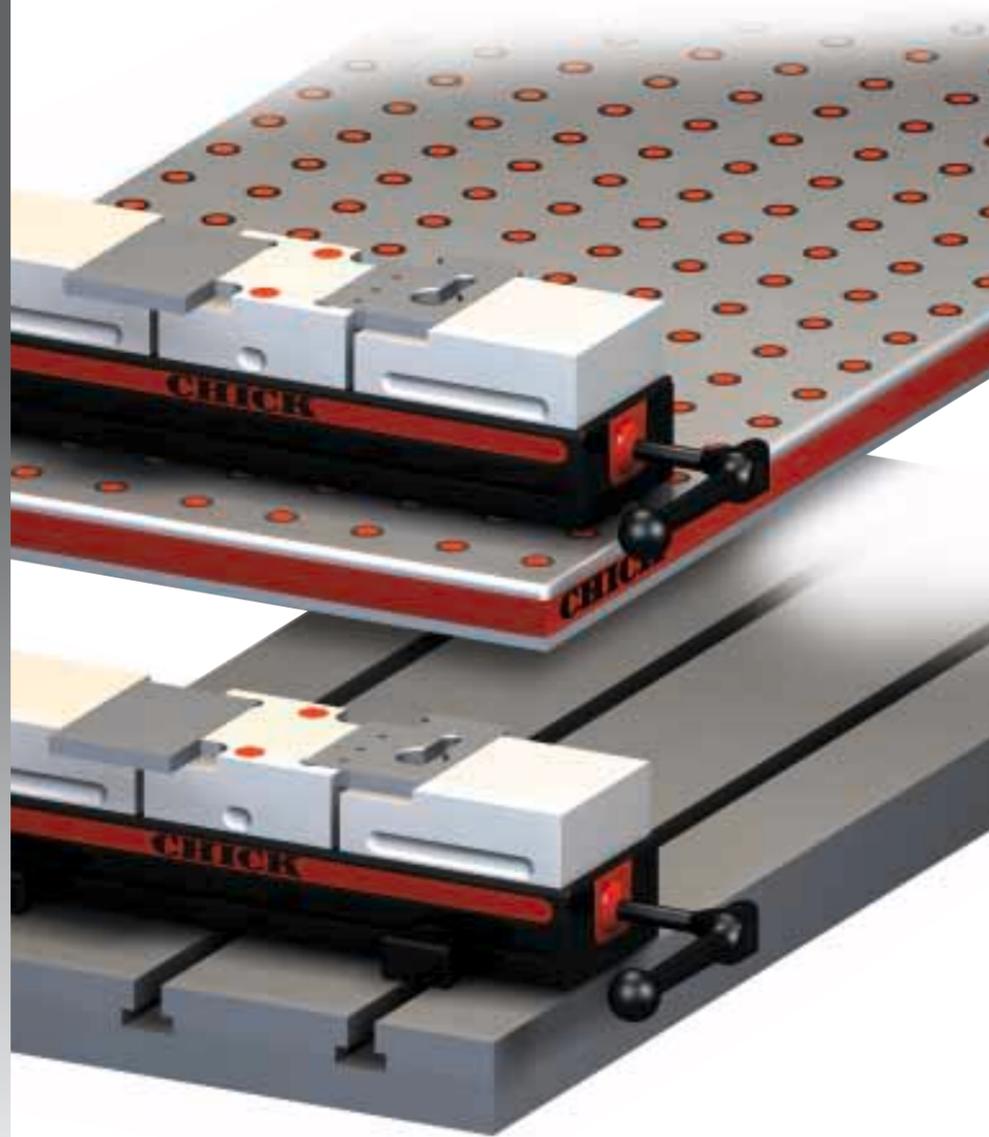
All dimensions and systems include standard jaws.



Holding Capacity



Qwik-Loks are most efficient when machining on one or opposing part sides.



0520 Qwik-Lok

081-1200



| Dimensions | mm | (inch) |
|------------|-----|--------|
| Height | 75 | (2.95) |
| Width | 50 | (1.97) |
| Length | 200 | (7.87) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 2 | (5) |

| Maximum Holding Capacity | mm | (inch) |
|---|-----|--------|
| Dual Station 2 - Workholding Stations | 85 | (3.35) |
| Single Station 1 - Workholding Station | 185 | (7.28) |

| Maximum Recommended Torque Clamping Force |
|---|
| 2,520 lbs. @ 14 Ft-lbs. (11.2 kN @ 19 N-m) |

1030 Qwik-Lok

5QL1030-AL



| Dimensions | mm | (inch) |
|------------|-----|---------|
| Height | 95 | (3.74) |
| Width | 100 | (3.94) |
| Length | 300 | (11.81) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 9 | (19) |

| Maximum Holding Capacity | mm | (inch) |
|---|-----|---------|
| Dual Station 2 - Workholding Stations | 130 | (5.12) |
| Single Station 1 - Workholding Station | 280 | (11.02) |

| Maximum Recommended Torque Clamping Force |
|---|
| 5,000 lbs. @ 52 Ft-lbs. (22.0 kN @ 70 N-m) |

1540 Qwik-Lok

5QL1540-AL



| Dimensions | mm | (inch) |
|------------|-----|---------|
| Height | 120 | (4.72) |
| Width | 150 | (5.91) |
| Length | 400 | (15.75) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 21 | (46) |

| Maximum Holding Capacity | mm | (inch) |
|--|-----|---------|
| Dual Station 2 - Total Workholding Stations | 175 | (6.89) |
| Single Station 1 - Workholding Station | 380 | (14.96) |

| Maximum Recommended Torque Clamping Force |
|---|
| 9,000 lbs. @ 118 Ft-lbs. (40.0 kN @ 160 N-m) |

0525 Qwik-Lok

081-1205



| Dimensions | mm | (inch) |
|------------|-----|--------|
| Height | 75 | (2.95) |
| Width | 50 | (1.97) |
| Length | 250 | (9.84) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 3 | (6) |

| Maximum Holding Capacity | mm | (inch) |
|---|-----|--------|
| Dual Station 2 - Workholding Stations | 110 | (4.33) |
| Single Station 1 - Workholding Station | 235 | (9.25) |

| Maximum Recommended Torque Clamping Force |
|---|
| 2,520 lbs. @ 14 Ft-lbs. (11.2 kN @ 19 N-m) |

1040 Qwik-Lok

Aluminum Base **5QL1040-AL**
Cast Iron Base **5QL1040-CI**



| Dimensions | mm | (inch) |
|------------|-----|---------|
| Height | 95 | (3.74) |
| Width | 100 | (3.94) |
| Length | 400 | (15.75) |

| Weight | kg | (lbs) |
|----------------|----|-------|
| Aluminum Base | 11 | (24) |
| Cast Iron Base | 18 | (39) |

| Maximum Holding Capacity | mm | (inch) |
|---|-----|---------|
| Dual Station 2 - Workholding Stations | 180 | (7.09) |
| Single Station 1 - Workholding Station | 380 | (14.96) |

| Maximum Recommended Torque Clamping Force |
|---|
| 5,000 lbs. @ 52 Ft-lbs. (22.0 kN @ 70 N-m) |

1550 Qwik-Lok

Aluminum Base **5QL1550-AL**
Cast Iron Base **5QL1550-CI**



| Dimensions | mm | (inch) |
|------------|-----|---------|
| Height | 120 | (4.72) |
| Width | 150 | (5.91) |
| Length | 500 | (19.69) |

| Weight | kg | (lbs) |
|----------------|----|-------|
| Aluminum Base | 24 | (54) |
| Cast Iron Base | 41 | (89) |

| Maximum Holding Capacity | mm | (inch) |
|---|-----|---------|
| Dual Station 2 - Workholding Stations | 225 | (8.86) |
| Single Station 1 - Workholding Station | 480 | (18.90) |

| Maximum Recommended Torque Clamping Force |
|---|
| 9,000 lbs. @ 118 Ft-lbs. (40.0 kN @ 160 N-m) |

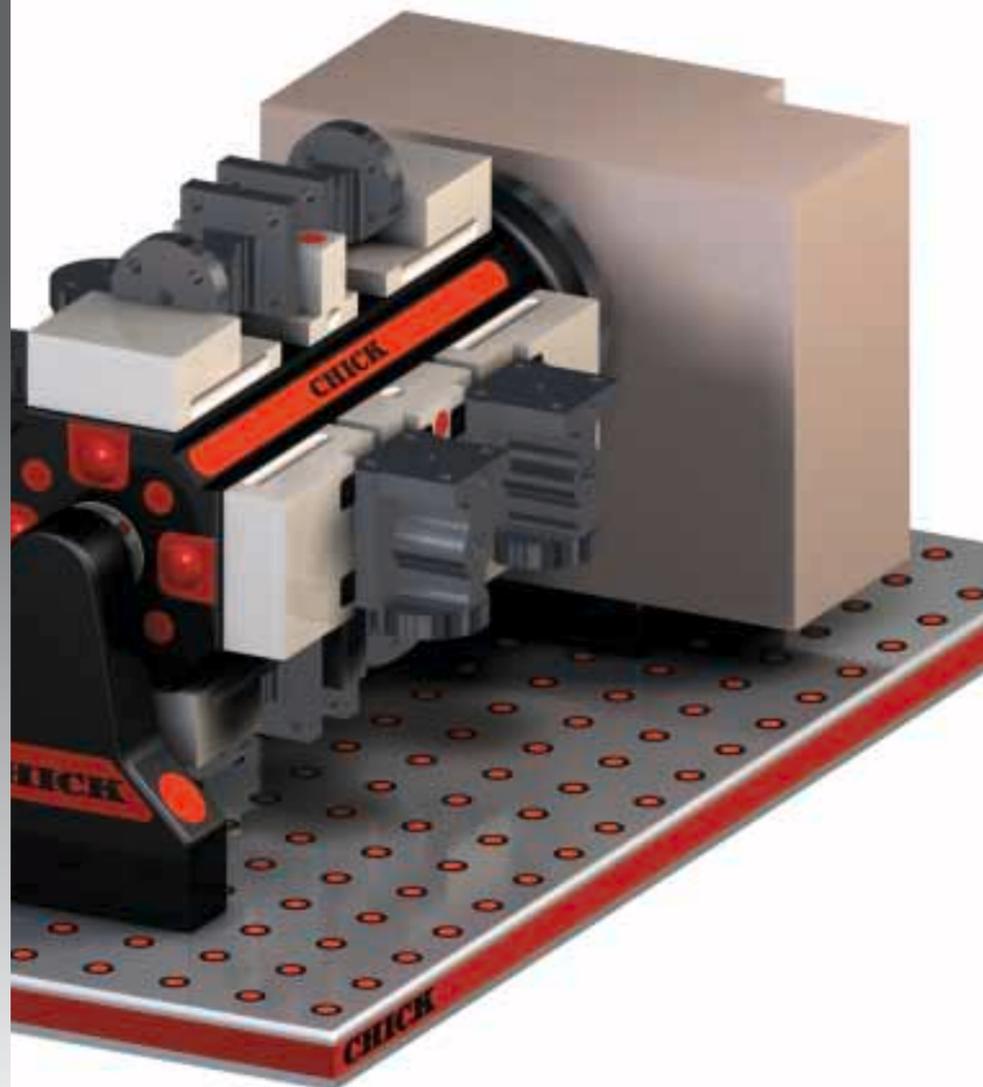
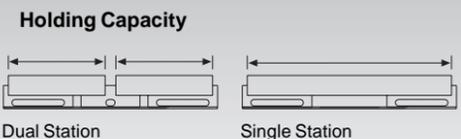
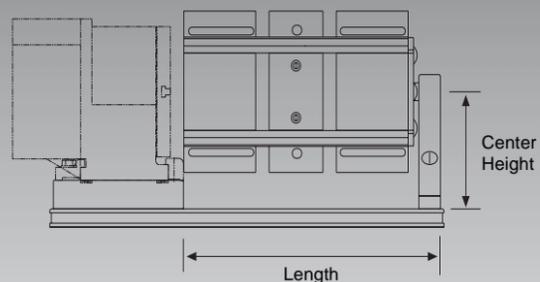
Indexer Subsystem

Obtain the benefits of a horizontal CNC machine on a vertical CNC machine, by using CHICK's Indexer Subsystem package (ISS). Utilize the indexer you have and marry it to one of CHICK's Multi-Loks. The ISS gives you the ability to machine on multiple part sides with only one clamping, therefore decreasing the cycle time and increasing accuracy of your part.

Indexer Subsystem (ISS) is most commonly used when fractional degree indexing is required.



All dimensions and systems include standard jaws. Indexer not included. Additional center height is available with riser blocks.



0520(x2) 4 Sided ISS

ISS-082-4202



| Dimensions | mm | (inch) |
|---------------|-----|---------|
| Length | 496 | (19.53) |
| Center Height | 200 | (7.87) |

Multi-Lok Specifications, Pages 15-20

Weight
Weight is based on your Indexer.

| Maximum Holding Capacity | mm | (inch) |
|----------------------------------|-----|--------|
| Dual Station | 85 | (3.35) |
| <i>16 - Workholding Stations</i> | | |
| Single Station | 185 | (7.28) |
| <i>8 - Workholding Stations</i> | | |

Maximum Recommended Torque Clamping Force
2,520 lbs. @ 14 Ft-lbs.
(11.2 kN @ 19 N-m)

1040 6 Sided ISS

5IS1040-61



| Dimensions | mm | (inch) |
|---------------|-----|---------|
| Length | 478 | (18.82) |
| Center Height | 200 | (7.87) |

Multi-Lok Specifications, Pages 15-20

Weight
Weight is based on your Indexer.

| Maximum Holding Capacity | mm | (inch) |
|----------------------------------|-----|---------|
| Dual Station | 180 | (7.09) |
| <i>12 - Workholding Stations</i> | | |
| Single Station | 380 | (14.96) |
| <i>6 - Workholding Stations</i> | | |

Maximum Recommended Torque Clamping Force
5,000 lbs. @ 52 Ft-lbs.
(22.0 kN @ 70 N-m)

1550 4 Sided ISS

5IS1550-41



| Dimensions | mm | (inch) |
|---------------|-----|---------|
| Length | 580 | (22.83) |
| Center Height | 200 | (7.87) |

Multi-Lok Specifications, Pages 15-20

Weight
Weight is based on your Indexer.

| Maximum Holding Capacity | mm | (inch) |
|---------------------------------|-----|---------|
| Dual Station | 225 | (8.86) |
| <i>8 - Workholding Stations</i> | | |
| Single Station | 480 | (18.90) |
| <i>4 - Workholding Stations</i> | | |

Maximum Recommended Torque Clamping Force
9,000 lbs. @ 118 Ft-lbs.
(40.0 kN @ 160 N-m)

0525 4 Sided ISS

ISS-082-4201



| Dimensions | mm | (inch) |
|---------------|-----|---------|
| Length | 326 | (12.83) |
| Center Height | 200 | (7.87) |

Multi-Lok Specifications, Pages 15-20

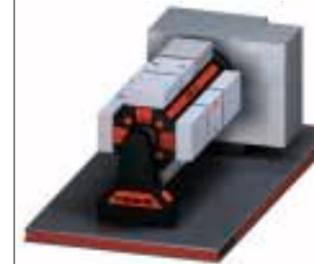
Weight
Weight is based on your Indexer.

| Maximum Holding Capacity | mm | (inch) |
|---------------------------------|-----|--------|
| Dual Station | 110 | (4.33) |
| <i>8 - Workholding Stations</i> | | |
| Single Station | 235 | (9.25) |
| <i>4 - Workholding Stations</i> | | |

Maximum Recommended Torque Clamping Force
2,520 lbs. @ 14 Ft-lbs.
(11.2 kN @ 19 N-m)

1040 4 Sided ISS

5IS1040-41



| Dimensions | mm | (inch) |
|---------------|-----|---------|
| Length | 478 | (18.82) |
| Center Height | 200 | (7.87) |

Multi-Lok Specifications, Pages 15-20

Weight
Weight is based on your Indexer.

| Maximum Holding Capacity | mm | (inch) |
|---------------------------------|-----|---------|
| Dual Station | 180 | (7.09) |
| <i>8 - Workholding Stations</i> | | |
| Single Station | 380 | (14.96) |
| <i>4 - Workholding Stations</i> | | |

Maximum Recommended Torque Clamping Force
5,000 lbs. @ 52 Ft-lbs.
(22.0 kN @ 70 N-m)



All Indexer Subsystems are compatible with CHICK's 4 Sided, 6 Sided and Specialty (small parts) Multi-Loks.

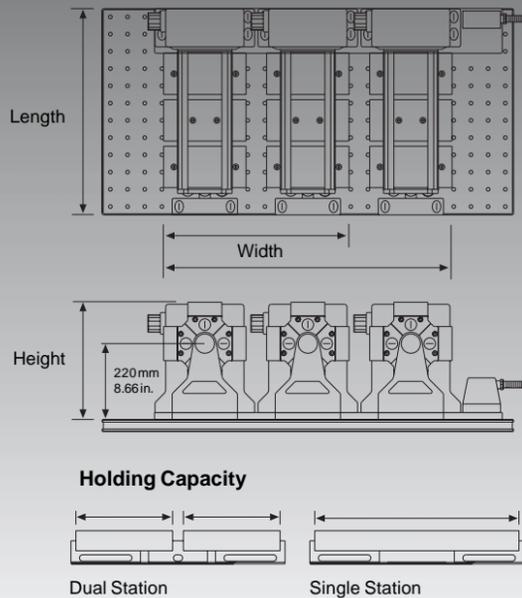
If you don't find the product you are looking for here, select a Multi-Lok from pages 15-20.

Pneu-Dex

Take the Indexer Subsystem concept a step further. Pneu-Dex's slim indexer allows the Pneu-Dex to be mounted in the Y axis, thus providing usable space to mount either multiple Pneu-Dex's, a Pneu-Dex with large plate work or a Pneu-Dex with several Qwik-Loks. Included with the purchase of any Pneu-Dex package is a Foundation and factory installation by CHICK.



All dimensions and systems include standard jaws. Additional center height is available with riser blocks.



Pneu-Dex is the optimal solution for your machine, combining all of the following features into one footprint:

- Zero Index time with multiple Pneu-Dex.
- Machine three part sides with only one clamping.
- QwikChange™ flexibility.
- Amortization of tool change time.
- Accurate 5° incremental indexing.
- Off center rigidity of 515 ft-lb (700N-m)
- Accuracy of ±5 arc seconds.



0520(x2) 4 Sided Double Pneu-Dex

MPD082-4202-2

| Dimensions | mm | (inch) |
|------------|-----|---------|
| Length | 598 | (23.54) |
| Width | 590 | (23.23) |
| Height | 370 | (14.57) |

Multi-Lok Specifications, Page 15

| Weight | kg | (lbs) |
|--------|-----|-------|
| | 101 | (224) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|--------|
| Dual Station | 85 | (3.35) |
| 32 - Workholding Stations | | |
| Single Station | 185 | (7.28) |
| 16 - Workholding Stations | | |

Maximum Recommended Torque Clamping Force
2,520 lbs. @ 14 Ft-lbs.
(11.2 kN @ 19 N-m)

1040 4 Sided Double Pneu-Dex

5PD1040-41-02

| Dimensions | mm | (inch) |
|------------|-----|---------|
| Length | 598 | (23.54) |
| Width | 590 | (23.23) |
| Height | 375 | (14.76) |

Multi-Lok Specifications, Page 15

| Weight | kg | (lbs) |
|--------|-----|-------|
| | 136 | (299) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|---------|
| Dual Station | 180 | (7.09) |
| 16 - Workholding Stations | | |
| Single Station | 380 | (14.96) |
| 8 - Workholding Stations | | |

Maximum Recommended Torque Clamping Force
5,000 lbs. @ 52 Ft-lbs.
(22.0 kN @ 70 N-m)

0525 4 Sided Double Pneu-Dex

MPD082-4201-2

| Dimensions | mm | (inch) |
|------------|-----|---------|
| Length | 448 | (17.64) |
| Width | 590 | (23.23) |
| Height | 370 | (14.57) |

Multi-Lok Specifications, Page 15

| Weight | kg | (lbs) |
|--------|----|-------|
| | 80 | (177) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|--------|
| Dual Station | 110 | (4.33) |
| 16 - Workholding Stations | | |
| Single Station | 235 | (9.25) |
| 8 - Workholding Stations | | |

Maximum Recommended Torque Clamping Force
2,520 lbs. @ 14 Ft-lbs.
(11.2 kN @ 19 N-m)

0520(x2) 4 Sided Triple Pneu-Dex

MPD082-4202-3

| Dimensions | mm | (inch) |
|------------|-----|---------|
| Length | 598 | (23.54) |
| Width | 890 | (35.04) |
| Height | 370 | (14.57) |

Multi-Lok Specifications, Page 15

| Weight | kg | (lbs) |
|--------|-----|-------|
| | 152 | (335) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|--------|
| Dual Station | 85 | (3.35) |
| 48 - Workholding Stations | | |
| Single Station | 185 | (7.28) |
| 24 - Workholding Stations | | |

Maximum Recommended Torque Clamping Force
2,520 lbs. @ 14 Ft-lbs.
(11.2 kN @ 19 N-m)

1040 4 Sided Triple Pneu-Dex

5PD1040-41-03

| Dimensions | mm | (inch) |
|------------|-----|---------|
| Length | 598 | (23.54) |
| Width | 890 | (35.04) |
| Height | 375 | (14.76) |

Multi-Lok Specifications, Page 15

| Weight | kg | (lbs) |
|--------|-----|-------|
| | 203 | (449) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|---------|
| Dual Station | 180 | (7.09) |
| 24 - Workholding Stations | | |
| Single Station | 380 | (14.96) |
| 12 - Workholding Stations | | |

Maximum Recommended Torque Clamping Force
5,000 lbs. @ 52 Ft-lbs.
(22.0 kN @ 70 N-m)



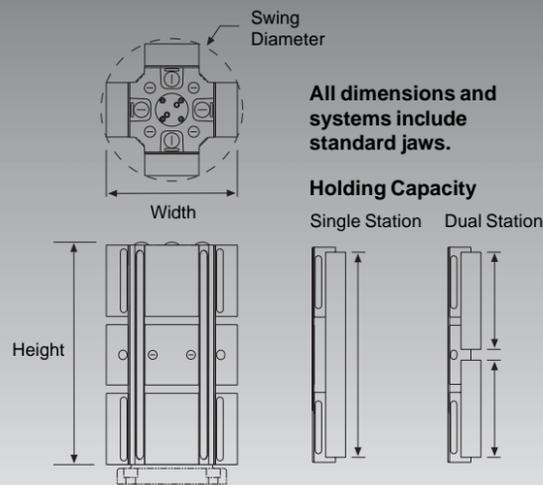
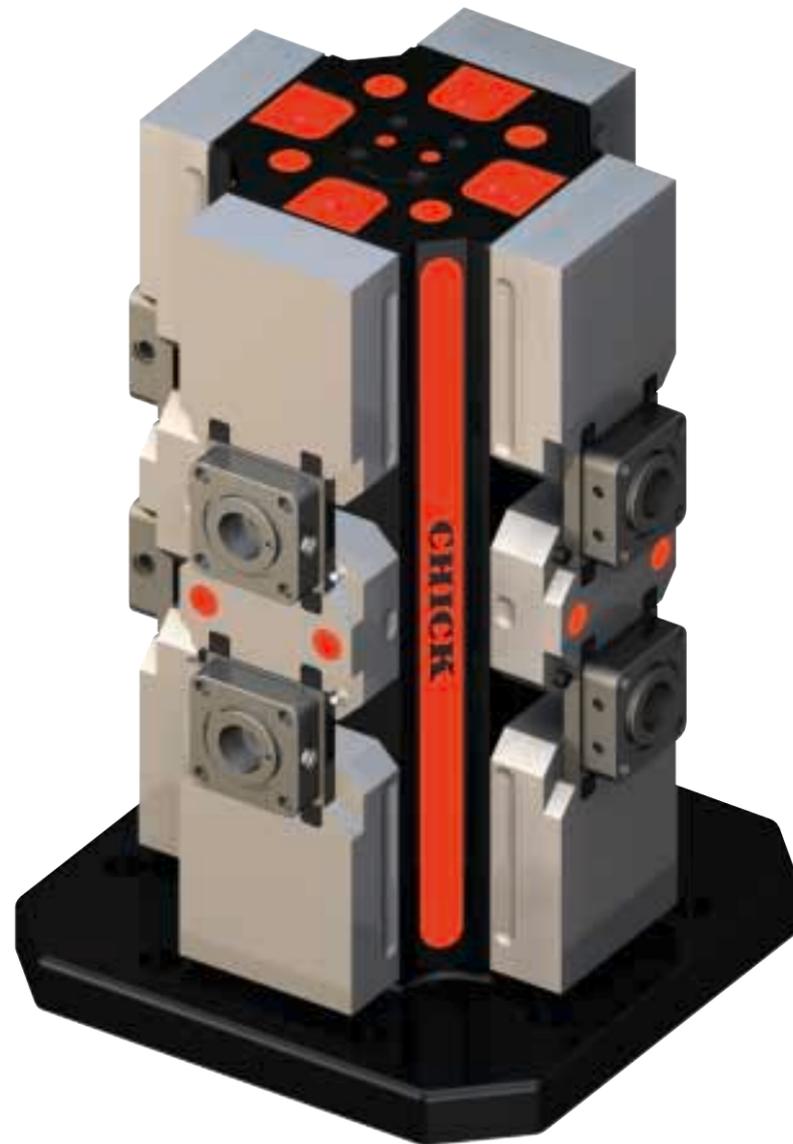
All Pneu-Dex systems are compatible with 50mm (2") or 100mm (4") 4 Sided, 6 Sided and Specialty (small parts) Multi-Loks.

If you don't find the product you are looking for here, select a Multi-Lok from pages 15-22.

4 Sided Multi-Loks

4 Sided Multi-Loks take full advantage of your horizontal CNC Machine by providing the accessibility of three part sides (per station), thus decreasing the cycle time and increasing the accuracy of your part.

4 Sided Multi-Loks are the most versatile products of their kind.



Baseplate not included. For Baseplate information, see pages 37-38.

0520 4 Sided Multi-Lok

082-4200



| Dimensions | mm | (inch) |
|----------------|-----|--------|
| Height | 203 | (7.99) |
| Width | 210 | (8.27) |
| Swing Diameter | 216 | (8.49) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 15 | (33) |

| Maximum Holding Capacity | mm | (inch) |
|--------------------------|-----|--------|
| Dual Station | 85 | (3.35) |
| 8 - Workholding Stations | | |
| Single Station | 185 | (7.28) |
| 4 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 2,520 lbs. @ 14 Ft-lbs. (11.2 kN @ 19 N-m) |

1030 4 Sided Multi-Lok

5ML1030-41



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 305 | (12.01) |
| Width | 240 | (9.45) |
| Swing Diameter | 260 | (10.24) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 37 | (81) |

| Maximum Holding Capacity | mm | (inch) |
|--------------------------|-----|---------|
| Dual Station | 130 | (5.12) |
| 8 - Workholding Stations | | |
| Single Station | 280 | (11.02) |
| 4 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 5,000 lbs. @ 52 Ft-lbs. (22.0 kN @ 70 N-m) |

1540 4 Sided Multi-Lok

5ML1540-41



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 407 | (16.02) |
| Width | 300 | (11.81) |
| Swing Diameter | 334 | (13.15) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 80 | (177) |

| Maximum Holding Capacity | mm | (inch) |
|--------------------------|-----|---------|
| Dual Station | 175 | (6.89) |
| 8 - Workholding Stations | | |
| Single Station | 380 | (14.96) |
| 4 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 9,000 lbs. @ 118 Ft-lbs. (40.0 kN @ 160 N-m) |

0525 4 Sided Multi-Lok

082-4201



| Dimensions | mm | (inch) |
|----------------|-----|--------|
| Height | 253 | (9.96) |
| Width | 210 | (8.27) |
| Swing Diameter | 216 | (8.49) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 19 | (42) |

| Maximum Holding Capacity | mm | (inch) |
|--------------------------|-----|--------|
| Dual Station | 110 | (4.33) |
| 8 - Workholding Stations | | |
| Single Station | 235 | (9.25) |
| 4 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 2,520 lbs. @ 14 Ft-lbs. (11.2 kN @ 19 N-m) |

1040 4 Sided Multi-Lok

5ML1040-41



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 405 | (15.94) |
| Width | 240 | (9.45) |
| Swing Diameter | 260 | (10.24) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 47 | (103) |

| Maximum Holding Capacity | mm | (inch) |
|--------------------------|-----|---------|
| Dual Station | 180 | (7.09) |
| 8 - Workholding Stations | | |
| Single Station | 380 | (14.96) |
| 4 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 5,000 lbs. @ 52 Ft-lbs. (22.0 kN @ 70 N-m) |

1550 4 Sided Multi-Lok

5ML1550-41



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 507 | (19.96) |
| Width | 300 | (11.81) |
| Swing Diameter | 334 | (13.15) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 93 | (206) |

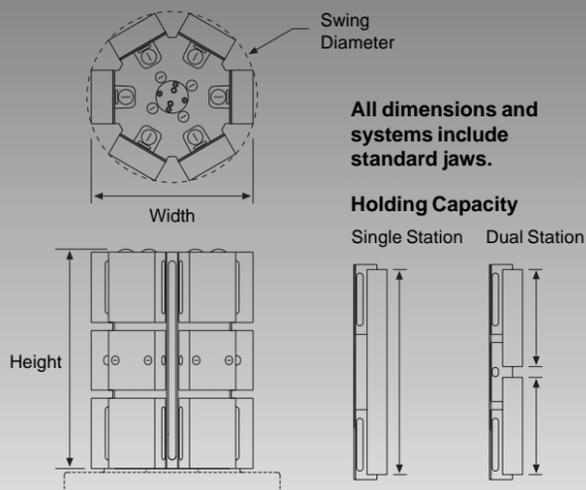
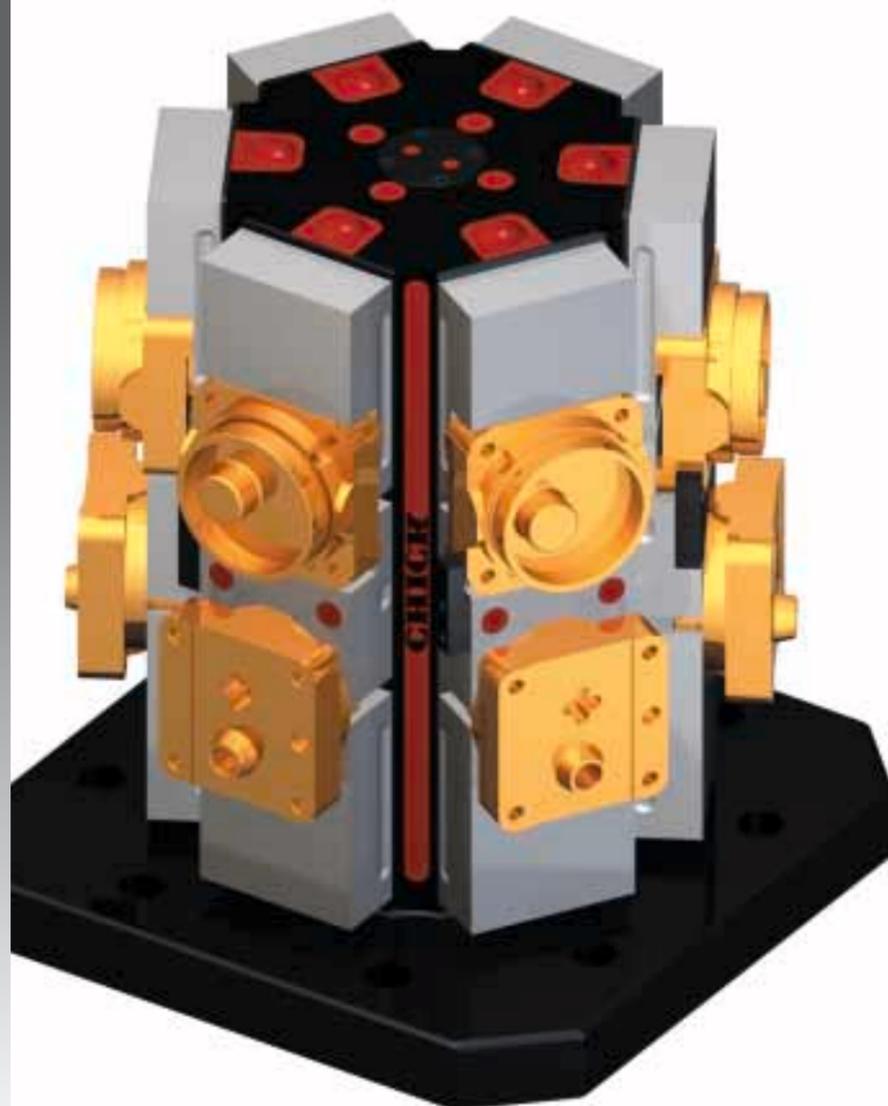
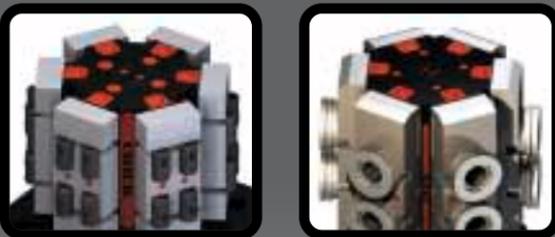
| Maximum Holding Capacity | mm | (inch) |
|--------------------------|-----|---------|
| Dual Station | 225 | (8.86) |
| 8 - Workholding Stations | | |
| Single Station | 480 | (18.90) |
| 4 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 9,000 lbs. @ 118 Ft-lbs. (40.0 kN @ 160 N-m) |

6 Sided Multi-Loks

6 Sided Multi-Loks provide the flexibility and versatility of six complete dual station workspaces in one compact footprint maximizing the quantity of parts presented to the spindle.

6 Sided Multi-Loks are most commonly used with applications requiring larger batch sizes and minimal 3 part side access.



All dimensions and systems include standard jaws.

Holding Capacity

Single Station Dual Station

Baseplate not included. For Baseplate information, see pages 37-38.

0520 6 Sided Multi-Lok

082-6200



| Dimensions | mm | (inch) |
|----------------|-----|--------|
| Height | 203 | (7.99) |
| Width | 230 | (9.06) |
| Swing Diameter | 235 | (9.25) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 20 | (43) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|--------|
| Dual Station | 85 | (3.35) |
| 12 - Workholding Stations | | |
| Single Station | 185 | (7.28) |
| 6 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 2,520 lbs. @ 14 Ft-lbs. (11.2 kN @ 19 N-m) |

1030 6 Sided Multi-Lok

5ML1030-61



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 305 | (12.01) |
| Width | 300 | (11.81) |
| Swing Diameter | 316 | (12.44) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 58 | (129) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|---------|
| Dual Station | 130 | (5.12) |
| 12 - Workholding Stations | | |
| Single Station | 280 | (11.02) |
| 6 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 5,000 lbs. @ 52 Ft-lbs. (22.0 kN @ 70 N-m) |

1540 6 Sided Multi-Lok

5ML1540-61



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 407 | (16.02) |
| Width | 410 | (16.14) |
| Swing Diameter | 436 | (17.17) |

| Weight | kg | (lbs) |
|--------|-----|-------|
| | 138 | (304) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|---------|
| Dual Station | 175 | (6.89) |
| 12 - Workholding Stations | | |
| Single Station | 380 | (14.96) |
| 6 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 9,000 lbs. @ 118 Ft-lbs. (40.0 kN @ 160 N-m) |

0525 6 Sided Multi-Lok

082-6201



| Dimensions | mm | (inch) |
|----------------|-----|--------|
| Height | 253 | (9.96) |
| Width | 230 | (9.06) |
| Swing Diameter | 235 | (9.25) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 23 | (52) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|--------|
| Dual Station | 110 | (4.33) |
| 12 - Workholding Stations | | |
| Single Station | 235 | (9.25) |
| 6 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 2,520 lbs. @ 14 Ft-lbs. (11.2 kN @ 19 N-m) |

1040 6 Sided Multi-Lok

5ML1040-61



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 405 | (15.94) |
| Width | 300 | (11.81) |
| Swing Diameter | 316 | (12.44) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 75 | (166) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|---------|
| Dual Station | 180 | (7.09) |
| 12 - Workholding Stations | | |
| Single Station | 380 | (14.96) |
| 6 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 5,000 lbs. @ 52 Ft-lbs. (22.0 kN @ 70 N-m) |

1550 6 Sided Multi-Lok

5ML1550-61



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 507 | (19.96) |
| Width | 410 | (16.14) |
| Swing Diameter | 436 | (17.17) |

| Weight | kg | (lbs) |
|--------|-----|-------|
| | 162 | (357) |

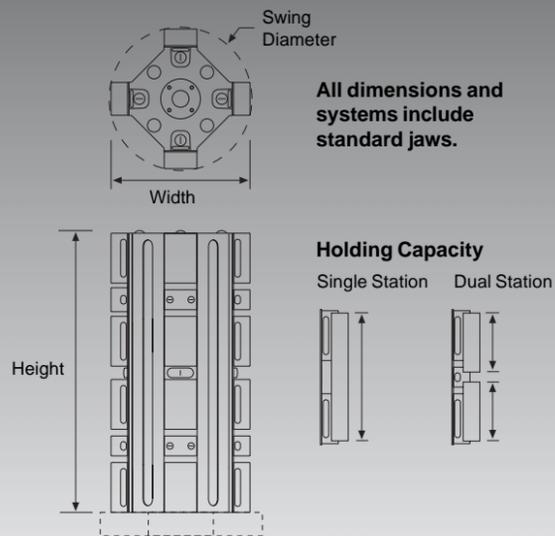
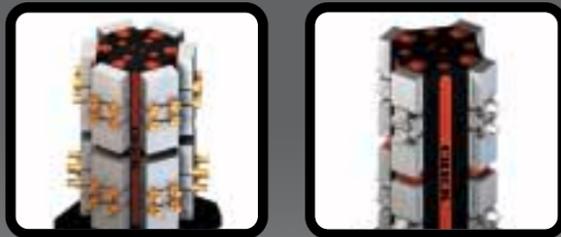
| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|---------|
| Dual Station | 225 | (8.86) |
| 12 - Workholding Stations | | |
| Single Station | 480 | (18.90) |
| 6 - Workholding Stations | | |

| Maximum Recommended Torque Clamping Force |
|---|
| 9,000 lbs. @ 118 Ft-lbs. (40.0 kN @ 160 N-m) |

Specialty Multi-Loks (Small Parts)

Specialty Multi-Loks are designed with specific applications in mind. CHICK has developed a group of Multi-Loks for small part applications or machines with a limited work envelope, without sacrificing the simplicity and flexibility of the System 5 product line.

Finally, workholding designed with your application in mind!



Baseplate not included.
For Baseplate information, see pages 37-38.

Specialty Multi-Loks are the perfect solution for small part applications or machines with a limited work envelope.



0520 (x2) 4 Sided Double Multi-Lok

082-4202

| Dimensions | | mm | (inch) |
|----------------|-----|-------|--------|
| Height | 423 | 16.65 | |
| Width | 210 | 8.27 | |
| Swing Diameter | 216 | 8.49 | |

| Weight | | kg | (lbs) |
|--------|--|----|-------|
| | | 30 | (65) |

| Maximum Holding Capacity | | mm | (inch) |
|----------------------------------|-----|------|--------|
| Dual Station | 85 | 3.35 | |
| <i>16 - Workholding Stations</i> | | | |
| Single Station | 185 | 7.28 | |
| <i>8 - Workholding Stations</i> | | | |

Maximum Recommended Torque Clamping Force
2,520 lbs. @ 14 Ft-lbs.
(11.2 kN @ 19 N-m)

0520 (x2) 6 Sided Double Multi-Lok

082-6202

| Dimensions | | mm | (inch) |
|----------------|-----|-------|--------|
| Height | 423 | 16.65 | |
| Width | 230 | 9.06 | |
| Swing Diameter | 235 | 9.25 | |

| Weight | | kg | (lbs) |
|--------|--|----|-------|
| | | 40 | (88) |

| Maximum Holding Capacity | | mm | (inch) |
|----------------------------------|-----|------|--------|
| Dual Station | 85 | 3.35 | |
| <i>24 - Workholding Stations</i> | | | |
| Single Station | 185 | 7.28 | |
| <i>12 - Workholding Stations</i> | | | |

Maximum Recommended Torque Clamping Force
2,520 lbs. @ 14 Ft-lbs.
(11.2 kN @ 19 N-m)

0525 3 Sided Multi-Lok

Inch **082-3206-IN**
Metric **082-3206-MM**

| Dimensions | | mm | (inch) |
|----------------|-----|------|--------|
| Height | 253 | 9.96 | |
| Width | 160 | 6.3 | |
| Swing Diameter | 168 | 6.61 | |

| Weight | | kg | (lbs) |
|--------|--|----|-------|
| | | 12 | (26) |

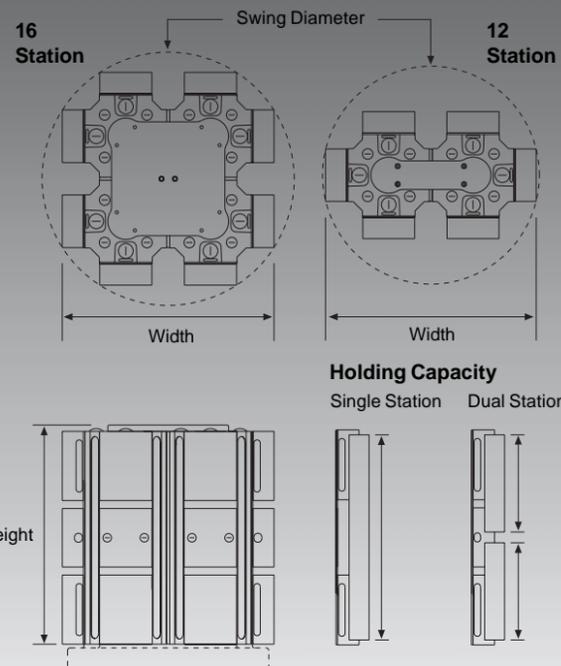
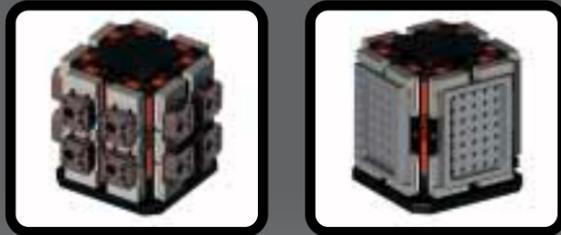
| Maximum Holding Capacity | | mm | (inch) |
|---------------------------------|-----|------|--------|
| Dual Station | 110 | 4.33 | |
| <i>6 - Workholding Stations</i> | | | |
| Single Station | 235 | 9.25 | |
| <i>3 - Workholding Stations</i> | | | |

Maximum Recommended Torque Clamping Force
2,520 lbs. @ 14 Ft-lbs.
(11.2 kN @ 19 N-m)

Specialty Multi-Loks (Large Parts)

This grouping of Specialty Multi-Loks is designed to hold large parts while maximizing the efficiency of your machine. No need to waste time completely switching fixtures. Simply, select the Multi-Lok that fits in your machining envelope and change your setups in minutes.

12 & 16 Station Multi-Loks provide the flexibility of being able to hold one extremely large part over multiple stations or clamping multiple average sized parts.



All dimensions and systems include standard jaws. Every 12- and 16-Station Multi-Lok must be shipped with a baseplate. For Baseplate information, see pages 37-38.

1040 12 Station Multi-Lok

5ML1040-41-12



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 412 | (16.22) |
| Width | 400 | (15.75) |
| Swing Diameter | 412 | (16.22) |

| Weight | kg | (lbs) |
|--------|----|-------|
| | 82 | (180) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|---------|
| Dual Station | 180 | (7.09) |
| 12 - Workholding Stations | | |
| Single Station | 380 | (14.96) |
| 6 - Workholding Stations | | |

Maximum Recommended Torque Clamping Force
 5,000 lbs. @ 52 Ft-lbs.
 (22.0 kN @ 70 N-m)

1550 12 Station Multi-Lok

5ML1550-41-12



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 519 | (20.43) |
| Width | 500 | (19.69) |
| Swing Diameter | 521 | (20.51) |

| Weight | kg | (lbs) |
|--------|-----|-------|
| | 188 | (415) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|---------|
| Dual Station | 225 | (8.86) |
| 16 - Workholding Stations | | |
| Single Station | 480 | (18.90) |
| 8 - Workholding Stations | | |

Maximum Recommended Torque Clamping Force
 9,000 lbs. @ 118 Ft-lbs.
 (40.0 kN @ 160 N-m)

1040 16 Station Multi-Lok

5ML1040-41-16



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 412 | (16.22) |
| Width | 400 | (15.75) |
| Swing Diameter | 476 | (18.74) |

| Weight | kg | (lbs) |
|--------|-----|-------|
| | 140 | (309) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|---------|
| Dual Station | 180 | (7.09) |
| 12 - Workholding Stations | | |
| Single Station | 380 | (14.96) |
| 6 - Workholding Stations | | |

Maximum Recommended Torque Clamping Force
 5,000 lbs. @ 52 Ft-lbs.
 (22.0 kN @ 70 N-m)

1550 16 Station Multi-Lok

5ML1550-41-16



| Dimensions | mm | (inch) |
|----------------|-----|---------|
| Height | 519 | (20.43) |
| Width | 500 | (19.69) |
| Swing Diameter | 609 | (23.98) |

| Weight | kg | (lbs) |
|--------|-----|-------|
| | 274 | (604) |

| Maximum Holding Capacity | mm | (inch) |
|---------------------------|-----|---------|
| Dual Station | 225 | (8.86) |
| 16 - Workholding Stations | | |
| Single Station | 480 | (18.90) |
| 8 - Workholding Stations | | |

Maximum Recommended Torque Clamping Force
 9,000 lbs. @ 118 Ft-lbs.
 (40.0 kN @ 160 N-m)

One System... Endless Opportunities

Chick Workholding was designed with flexibility in mind!

Maximize your productivity and drastically reduce your repeat setup time, thereby unleashing milling profitability.

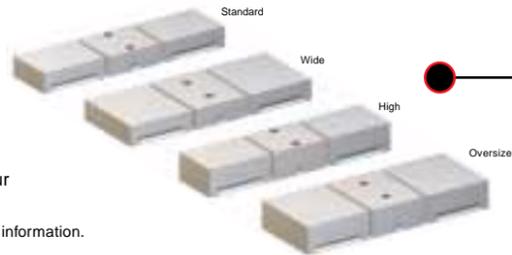
Grippers



Ideal for workpieces that require aggressive clamping

See pages 33-34 for ordering information.

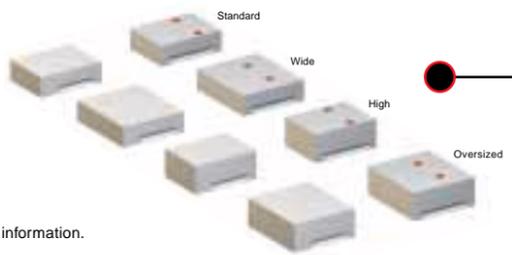
Dual Station Machinable Jaw Sets



Ideal for holding two or four 3" to 8" parts.

See pages 25-26 for ordering information.

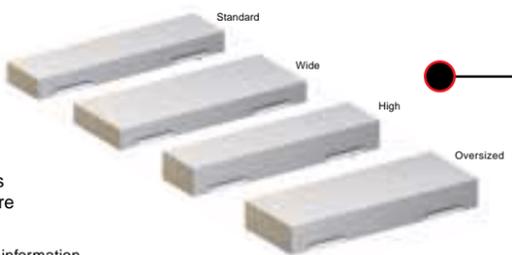
Single Station Machinable Jaw Sets



Ideal for holding one large 7" to 19" part.

See pages 27-28 for ordering information.

Machinable Faceplates



Ideal for holding numerous small parts or parts that are difficult to clamp.

See pages 29-30 for ordering information.

Jaw Carrier Sets



Ideal for "vise like" setup

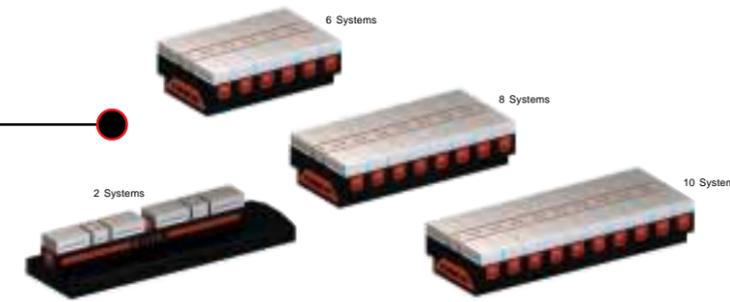
See pages 31-32 for ordering information.

Conversion Faceplates

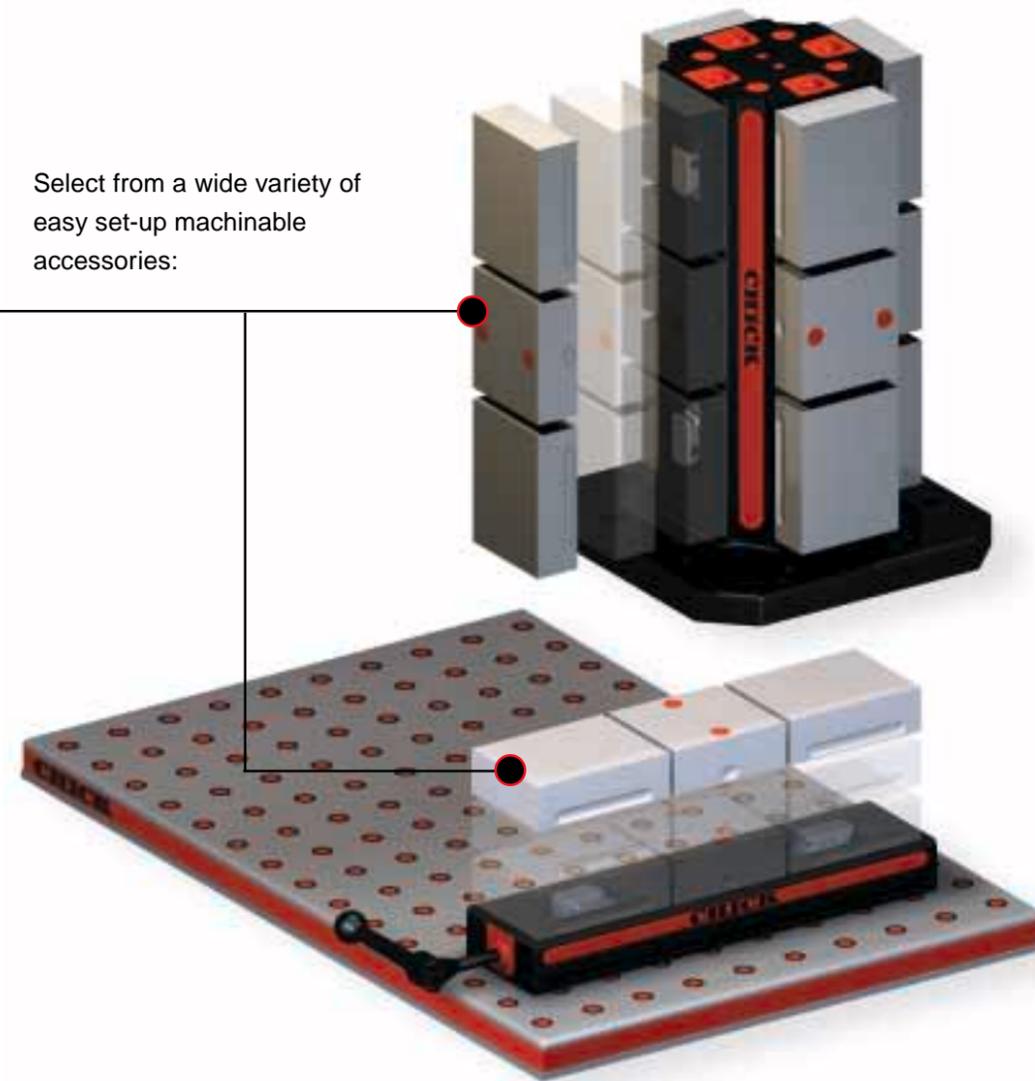


Ideal for clamping a variety of part sizes.

See pages 33-34 for ordering information.



Select from a wide variety of easy set-up machinable accessories:



Dual Station Machinable Jaw Sets

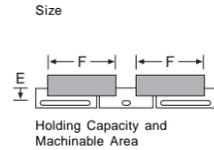
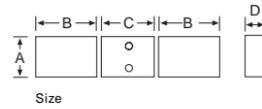
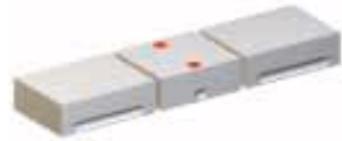
The Dual Station Machinable Jaw Sets clamp with an equal and opposing inward force, thus eliminating the potential for jaw lift. The safe low profile jaw interface maximizes the amount of machinable area, giving the ability to hold larger parts.



Machinable accessories are the optimal solution for repeat set-ups. The standard height and width is suitable for most applications. CHICK has designed wide, high and oversized accessories to provide a cost effective solution for those unique applications.

Standard Jaw Set

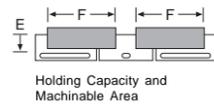
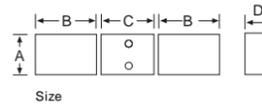
Dual Station Machinable



Set includes:
(2) Moveable Jaws
(1) Fixed Center Jaw

High Jaw Set

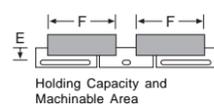
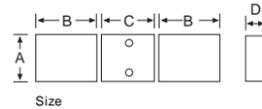
Dual Station Machinable



Set includes:
(2) Moveable Jaws
(1) Fixed Center Jaw

Wide Jaw Set

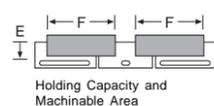
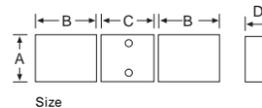
Dual Station Machinable



Set includes:
(2) Moveable Jaws
(1) Fixed Center Jaw

Oversized Jaw Set

Dual Station Machinable



Set includes:
(2) Moveable Jaws
(1) Fixed Center Jaw

System Sizes

0520 and 0525

| Order No. | 080-2500 | 080-2505 |
|------------|-----------|------------|
| Dimensions | mm (inch) | mm (inch) |
| A | 49 (1.93) | 49 (1.93) |
| B | 75 (2.95) | 75 (2.95) |
| C | 36 (1.42) | 76 (2.99) |
| D | 25 (0.98) | 25 (0.98) |
| E | 14 (0.57) | 14 (0.57) |
| F | 85 (3.35) | 110 (4.33) |

1030 and 1040

| 5DS | 5DS |
|------------|------------|
| 1030-10-40 | 1040-10-40 |
| mm (inch) | mm (inch) |
| 99 (3.90) | 99 (3.90) |
| 105 (4.13) | 130 (5.12) |
| 70 (2.76) | 110 (4.33) |
| 40 (1.57) | 40 (1.57) |
| 26 (1.02) | 26 (1.02) |
| 130 (5.12) | 180 (7.09) |

1540 and 1550

| 5DS | 5DS |
|------------|------------|
| 1540-15-50 | 1550-15-50 |
| mm (inch) | mm (inch) |
| 148 (5.83) | 148 (5.83) |
| 135 (5.31) | 160 (6.30) |
| 100 (3.94) | 140 (5.51) |
| 50 (1.97) | 50 (1.97) |
| 32 (1.26) | 32 (1.26) |
| 175 (6.89) | 225 (8.86) |

NOT AVAILABLE IN THIS SIZE

| 5DS | 5DS |
|------------|------------|
| 1030-10-55 | 1040-10-55 |
| mm (inch) | mm (inch) |
| 99 (3.90) | 99 (3.90) |
| 105 (4.13) | 130 (5.12) |
| 70 (2.76) | 110 (4.33) |
| 55 (2.17) | 55 (2.17) |
| 41 (1.61) | 41 (1.61) |
| 130 (5.12) | 180 (7.09) |

| 5DS | 5DS |
|------------|------------|
| 1540-15-70 | 1550-15-70 |
| mm (inch) | mm (inch) |
| 148 (5.83) | 148 (5.83) |
| 135 (5.31) | 160 (6.30) |
| 100 (3.94) | 140 (5.51) |
| 70 (2.76) | 70 (2.76) |
| 52 (2.05) | 52 (2.05) |
| 175 (6.89) | 225 (8.86) |

NOT AVAILABLE IN THIS SIZE

| 5DS | 5DS |
|------------|------------|
| 1030-15-40 | 1040-15-40 |
| mm (inch) | mm (inch) |
| 148 (5.83) | 148 (5.83) |
| 105 (4.13) | 130 (5.12) |
| 70 (2.76) | 110 (4.33) |
| 40 (1.57) | 40 (1.57) |
| 26 (1.02) | 26 (1.02) |
| 130 (5.12) | 180 (7.09) |

| 5DS | 5DS |
|------------|------------|
| 1540-20-50 | 1550-20-50 |
| mm (inch) | mm (inch) |
| 198 (7.80) | 198 (7.80) |
| 135 (5.31) | 160 (6.30) |
| 100 (3.94) | 140 (5.51) |
| 50 (1.97) | 50 (1.97) |
| 32 (1.26) | 32 (1.26) |
| 175 (6.89) | 225 (8.86) |

| Order No. | 080-2502 | 080-2506 |
|------------|-----------|------------|
| Dimensions | mm (inch) | mm (inch) |
| A | 80 (3.15) | 80 (3.15) |
| B | 75 (2.95) | 75 (2.95) |
| C | 36 (1.42) | 76 (2.99) |
| D | 35 (1.38) | 35 (1.38) |
| E | 24 (0.96) | 24 (0.96) |
| F | 85 (3.35) | 110 (4.33) |

| 5DS | 5DS |
|------------|------------|
| 1030-15-55 | 1040-15-55 |
| mm (inch) | mm (inch) |
| 148 (5.83) | 148 (5.83) |
| 105 (4.13) | 130 (5.12) |
| 70 (2.76) | 110 (4.33) |
| 55 (2.17) | 55 (2.17) |
| 41 (1.61) | 41 (1.61) |
| 130 (5.12) | 180 (7.09) |

| 5DS | 5DS |
|------------|------------|
| 1540-20-70 | 1550-20-70 |
| mm (inch) | mm (inch) |
| 198 (7.80) | 198 (7.80) |
| 135 (5.31) | 160 (6.30) |
| 100 (3.94) | 140 (5.51) |
| 70 (2.76) | 70 (2.76) |
| 52 (2.05) | 52 (2.05) |
| 175 (6.89) | 225 (8.86) |

Single Station Machinable Jaw Sets

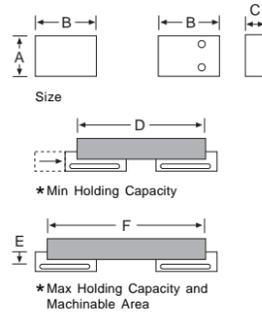
Single Station Machinable Jaw Sets increase the flexibility of your system by eliminating the need to completely switch fixtures for jobs requiring greater holding capacity. Simply QwikChange™ the jaws and the set-up is ready in minutes.



Machinable accessories are the optimal solution for repeat set-ups. The standard height and width is suitable for most applications. CHICK has designed wide, high and oversized accessories to provide a cost effective solution for those unique applications.

Standard Jaw Set

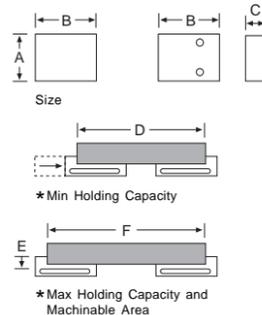
Single Station Machinable



Set includes:
(1) Moveable Jaw
(1) Fixed Single Station Jaw

High Jaw Set

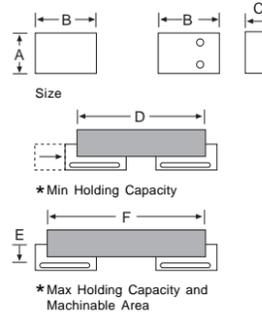
Single Station Machinable



Set includes:
(1) Moveable Jaw
(1) Fixed Single Station Jaw

Wide Jaw Set

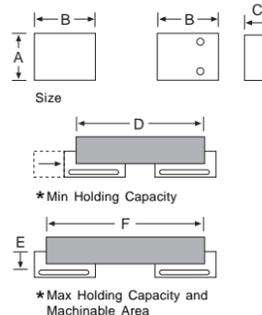
Single Station Machinable



Set includes:
(1) Moveable Jaw
(1) Fixed Single Station Jaw

Oversized Jaw Set

Single Station Machinable



Set includes:
(1) Moveable Jaw
(1) Fixed Single Station Jaw

System Sizes

0520 and 0525

| Order No. | 080-2580 | 080-2580 |
|------------|------------|------------|
| Dimensions | mm (inch) | mm (inch) |
| A | 49 (1.91) | 49 (1.91) |
| B | 75 (2.95) | 75 (2.95) |
| C | 25 (0.98) | 25 (0.98) |
| D | 45 (1.77) | 91 (3.58) |
| E | 14 (0.57) | 14 (0.57) |
| F | 185 (7.28) | 235 (9.25) |

1030 and 1040

| 5SS | 5SS |
|-------------|-------------|
| 1030-10-40 | 1040-10-40 |
| mm (inch) | mm (inch) |
| 99 (3.90) | 99 (3.90) |
| 105 (4.13) | 130 (5.12) |
| 40 (1.57) | 40 (1.57) |
| 48 (1.89) | 138 (5.43) |
| 26 (1.02) | 26 (1.02) |
| 280 (11.02) | 380 (14.96) |

1540 and 1550

| 5SS | 5SS |
|-------------|-------------|
| 1540-15-50 | 1550-15-50 |
| mm (inch) | mm (inch) |
| 148 (5.83) | 148 (5.83) |
| 135 (5.31) | 160 (6.30) |
| 50 (1.97) | 50 (1.97) |
| 63 (2.48) | 153 (6.02) |
| 32 (1.26) | 32 (1.26) |
| 380 (14.96) | 480 (18.90) |

NOT AVAILABLE IN THIS SIZE

| 5SS | 5SS |
|-------------|-------------|
| 1030-10-55 | 1040-10-55 |
| mm (inch) | mm (inch) |
| 99 (3.90) | 99 (3.90) |
| 105 (4.13) | 130 (5.12) |
| 55 (2.17) | 55 (2.17) |
| 48 (1.89) | 138 (5.43) |
| 41 (1.61) | 41 (1.61) |
| 280 (11.02) | 380 (14.96) |

| 5SS | 5SS |
|-------------|-------------|
| 1540-15-70 | 1550-15-70 |
| mm (inch) | mm (inch) |
| 148 (5.83) | 148 (5.83) |
| 135 (5.31) | 160 (6.30) |
| 70 (2.76) | 70 (2.76) |
| 63 (2.48) | 153 (6.02) |
| 52 (2.05) | 52 (2.05) |
| 380 (14.96) | 480 (18.90) |

NOT AVAILABLE IN THIS SIZE

| 5SS | 5SS |
|-------------|-------------|
| 1030-15-40 | 1040-15-40 |
| mm (inch) | mm (inch) |
| 148 (5.83) | 148 (5.83) |
| 105 (4.13) | 130 (5.12) |
| 40 (1.57) | 40 (1.57) |
| 48 (1.89) | 138 (5.43) |
| 26 (1.02) | 26 (1.02) |
| 280 (11.02) | 380 (14.96) |

| 5SS | 5SS |
|-------------|-------------|
| 1540-20-50 | 1550-20-50 |
| mm (inch) | mm (inch) |
| 198 (7.80) | 198 (7.80) |
| 135 (5.31) | 160 (6.30) |
| 50 (1.97) | 50 (1.97) |
| 63 (2.48) | 153 (6.02) |
| 32 (1.26) | 32 (1.26) |
| 380 (14.96) | 480 (18.90) |

| Order No. | 080-2582 | 080-2582 |
|------------|------------|------------|
| Dimensions | mm (inch) | mm (inch) |
| A | 80 (3.15) | 80 (3.15) |
| B | 75 (2.95) | 75 (2.95) |
| C | 35 (1.38) | 35 (1.38) |
| D | 45 (1.77) | 91 (3.58) |
| E | 24 (0.96) | 24 (0.96) |
| F | 185 (7.28) | 235 (9.25) |

| 5SS | 5SS |
|-------------|-------------|
| 1030-15-55 | 1040-15-55 |
| mm (inch) | mm (inch) |
| 148 (5.83) | 148 (5.83) |
| 105 (4.13) | 130 (5.12) |
| 55 (2.17) | 55 (2.17) |
| 48 (1.89) | 138 (5.43) |
| 41 (1.61) | 41 (1.61) |
| 280 (11.02) | 380 (14.96) |

| 5SS | 5SS |
|-------------|-------------|
| 1540-20-70 | 1550-20-70 |
| mm (inch) | mm (inch) |
| 198 (7.80) | 198 (7.80) |
| 135 (5.31) | 160 (6.30) |
| 70 (2.76) | 70 (2.76) |
| 63 (2.48) | 153 (6.02) |
| 52 (2.05) | 52 (2.05) |
| 380 (14.96) | 480 (18.90) |

* CHICK provides a variety of coverplates for extended travel. Contact CHICK for additional information.

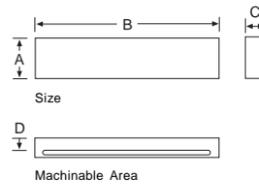
Machinable Faceplates

Machinable Faceplates provide QwikChange™ dedicated fixturing for those awkward parts that are too difficult to clamp. A mini pallet changer can be created by utilizing two Faceplates.



Machinable accessories are the optimal solution for repeat set-ups. The standard height and width is suitable for most applications. CHICK has designed wide, high and oversized accessories to provide a cost effective solution for those unique applications.

Standard Faceplates



System Sizes

Order No.

Dimensions

A
B
C
D

0520 and 0525

| Order No. | mm | (inch) | Order No. | mm | (inch) |
|-----------|-----|--------|-----------|-----|--------|
| 080-2621 | 49 | (1.91) | 080-2625 | 49 | (1.91) |
| | 198 | (7.80) | | 248 | (9.76) |
| | 25 | (0.98) | | 25 | (0.98) |
| | 14 | (0.57) | | 14 | (0.57) |

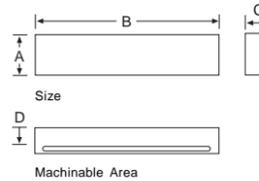
1030 and 1040

| Order No. | mm | (inch) | Order No. | mm | (inch) |
|----------------|-----|---------|----------------|-----|---------|
| 5FP 1030-10-40 | 99 | (3.90) | 5FP 1040-10-40 | 99 | (3.90) |
| | 298 | (11.73) | | 398 | (15.67) |
| | 40 | (1.57) | | 40 | (1.57) |
| | 26 | (1.02) | | 26 | (1.02) |

1540 and 1550

| Order No. | mm | (inch) | Order No. | mm | (inch) |
|----------------|-----|---------|----------------|-----|---------|
| 5FP 1540-15-50 | 148 | (5.83) | 5FP 1550-15-50 | 148 | (5.83) |
| | 398 | (15.67) | | 498 | (19.61) |
| | 50 | (1.97) | | 50 | (1.97) |
| | 32 | (1.26) | | 32 | (1.26) |

High Faceplates



Order No.

Dimensions

A
B
C
D

NOT AVAILABLE IN THIS SIZE

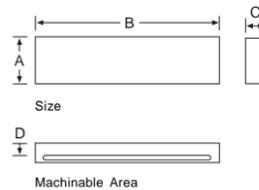
1030 and 1040

| Order No. | mm | (inch) | Order No. | mm | (inch) |
|----------------|-----|---------|----------------|-----|---------|
| 5FP 1030-10-55 | 99 | (3.90) | 5FP 1040-10-55 | 99 | (3.90) |
| | 298 | (11.73) | | 398 | (15.67) |
| | 55 | (2.17) | | 55 | (2.17) |
| | 41 | (1.61) | | 41 | (1.61) |

1540 and 1550

| Order No. | mm | (inch) | Order No. | mm | (inch) |
|----------------|-----|---------|----------------|-----|---------|
| 5FP 1540-15-70 | 148 | (5.83) | 5FP 1550-15-70 | 148 | (5.83) |
| | 398 | (15.67) | | 498 | (19.61) |
| | 70 | (2.76) | | 70 | (2.76) |
| | 52 | (2.05) | | 52 | (2.05) |

Wide Faceplates



Order No.

Dimensions

A
B
C
D

NOT AVAILABLE IN THIS SIZE

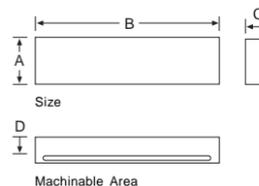
1030 and 1040

| Order No. | mm | (inch) | Order No. | mm | (inch) |
|----------------|-----|---------|----------------|-----|---------|
| 5FP 1030-15-40 | 148 | (5.83) | 5FP 1040-15-40 | 148 | (5.83) |
| | 298 | (11.73) | | 398 | (15.67) |
| | 40 | (1.57) | | 40 | (1.57) |
| | 26 | (1.02) | | 26 | (1.02) |

1540 and 1550

| Order No. | mm | (inch) | Order No. | mm | (inch) |
|----------------|-----|---------|----------------|-----|---------|
| 5FP 1540-20-50 | 198 | (7.80) | 5FP 1550-20-50 | 198 | (7.80) |
| | 398 | (15.67) | | 498 | (19.61) |
| | 50 | (1.97) | | 50 | (1.97) |
| | 32 | (1.26) | | 32 | (1.26) |

Oversized Faceplates



Order No.

Dimensions

A
B
C
D

| Order No. | mm | (inch) | Order No. | mm | (inch) |
|-----------|-----|--------|-----------|-----|--------|
| 080-2622 | 80 | (3.15) | 080-2626 | 80 | (3.15) |
| | 198 | (7.80) | | 248 | (9.76) |
| | 35 | (1.38) | | 35 | (1.38) |
| | 24 | (0.96) | | 24 | (0.96) |

| Order No. | mm | (inch) | Order No. | mm | (inch) |
|----------------|-----|---------|----------------|-----|---------|
| 5FP 1030-15-55 | 148 | (5.83) | 5FP 1040-15-55 | 148 | (5.83) |
| | 298 | (11.73) | | 398 | (15.67) |
| | 55 | (2.17) | | 55 | (2.17) |
| | 41 | (1.61) | | 41 | (1.61) |

| Order No. | mm | (inch) | Order No. | mm | (inch) |
|----------------|-----|---------|----------------|-----|---------|
| 5FP 1540-20-70 | 198 | (7.80) | 5FP 1550-20-70 | 198 | (7.80) |
| | 398 | (15.67) | | 498 | (19.61) |
| | 70 | (2.76) | | 70 | (2.76) |
| | 52 | (2.05) | | 52 | (2.05) |

Jaw Carrier Sets

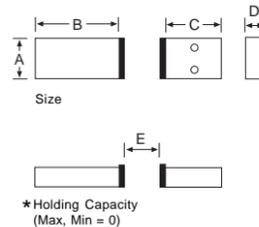
Jaw Carriers broaden your modern workholding flexibility by offering vise-like fixturing. Simply QwikChange™ the jaws and your modern workholding is ready for vise-like set-ups.



Jaw Carriers are the optimal solution for one-time set-ups or small batch sizes. Jaw Carriers are available in inch and metric as Single Station, Single Station Deluxe and Dual Station Sets for CHICK's 1040 and 1550 workholding systems.

Single Station Set

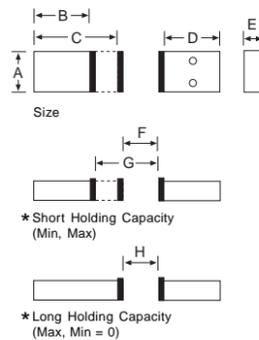
Jaw Carriers



- Set includes:**
 (1) Long Moveable Jaw Carrier
 (1) Fixed Single Station Jaw Carrier
 (1) Single Station Extended Travel Coverplate
 *Hard Jaws not included.

Single Station Deluxe Set

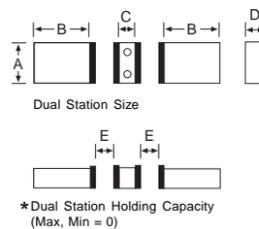
Jaw Carriers



- Set includes:**
 (1) Short Moveable Jaw Carrier
 (1) Long Moveable Jaw Carrier
 (1) Fixed Single Station Jaw Carrier
 (1) Single Station Extended Travel Coverplate
 *Hard Jaws not included.

Dual Station Set

Jaw Carriers



- Set includes:**
 (2) Moveable Jaw Carriers
 (1) Fixed Center Jaw Carrier
 (1) Dual Station Extended Travel Coverplate
 *Hard Jaws not included.

System Sizes

1040 and 1550

| Order No. | 5JC 1040-SS-IN | | 5JC 1550-SS-IN | |
|------------------|----------------|--------|----------------|---------|
| | mm | (inch) | mm | (inch) |
| A | 98 | (3.86) | 148 | (5.83) |
| B | 217 | (8.54) | 287 | (11.30) |
| C | 116 | (4.57) | 135 | (5.31) |
| D | 28 | (1.10) | 38 | (1.50) |
| Holding Capacity | mm | (inch) | mm | (inch) |
| | 102 | (4.00) | 110 | (4.33) |

| Order No. | 5JC 1040-XS-IN | | 5JC 1550-XS-IN | | |
|------------------|----------------|--------|----------------|---------|--------|
| | mm | (inch) | mm | (inch) | |
| A | 98 | (3.86) | 148 | (5.83) | |
| B | 166 | (6.54) | 190 | (7.48) | |
| C | 217 | (8.54) | 287 | (11.30) | |
| D | 116 | (4.57) | 135 | (5.31) | |
| E | 28 | (1.10) | 38 | (1.50) | |
| Holding Capacity | mm | (inch) | mm | (inch) | |
| | F | 51 | (2.00) | 97 | (3.82) |
| | G | 152 | (6.00) | 208 | (8.19) |
| | H | 102 | (4.00) | 110 | (4.33) |

| Order No. | 5JC 1040-DS-IN | | 5JC 1550-DS-IN | |
|------------------|----------------|--------|----------------|--------|
| | mm | (inch) | mm | (inch) |
| A | 98 | (3.86) | 148 | (5.83) |
| B | 116 | (4.57) | 151 | (5.94) |
| C | 50 | (1.97) | 46 | (1.80) |
| D | 28 | (1.10) | 38 | (1.50) |
| Holding Capacity | mm | (inch) | mm | (inch) |
| | 52 | (2.03) | 54 | (2.13) |

Metric Jaw Carrier Sets are also available, for details contact CHICK.

*The Holding Capacity dimensions are calculated using CHICK's standard Hard Jaws. See Hard Jaws dimensional information to make adjustments.

Hard Jaws



These steel hard jaws are perfect for one part applications. Bolt them onto CHICK's jaw carriers and the system is ready to go.

1040 Workholding Systems

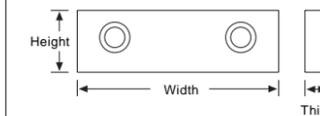
Order No. **JH4STD**

| Dimensions | mm | (inch) |
|------------|-----|--------|
| Height | 31 | (1.22) |
| Thickness | 9 | (0.35) |
| Width | 101 | (3.99) |

1550 Workholding Systems

Order No. **JH6STD**

| Dimensions | mm | (inch) |
|------------|-----|--------|
| Height | 44 | (1.72) |
| Thickness | 12 | (0.48) |
| Width | 152 | (5.99) |



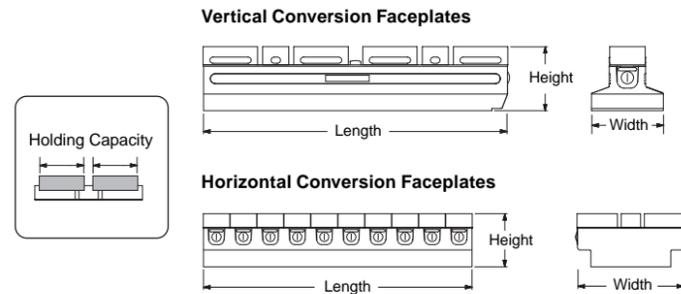
Conversion Faceplates

Maximize your flexibility with the Conversion Faceplates. Conversion Faceplates are ideal for those manufacturer's required to machine a variety of part sizes. Conversion Faceplates can easily convert a system that can hold one 10" part or convert to 10 small systems that hold 20 4" parts.

Grippers

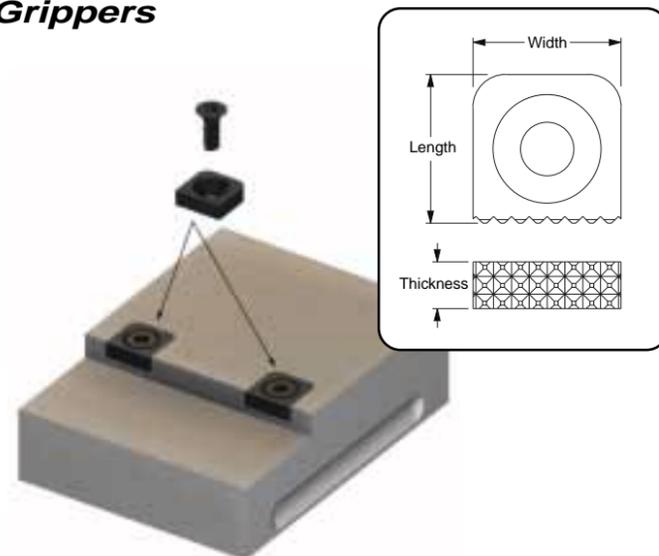
CHICK Grippers are ideal for heavy machining applications in which fixture wear is a major concern. The hardened steel surface provides a clamping interface that eliminates wearing caused by rough cast irons, tool steels, or other hard metals. The CHICK Grippers also increase the holding power of your fixture, since the serrated surface "bites" into the part, for more aggressive workpiece clamping.

Conversion Faceplates

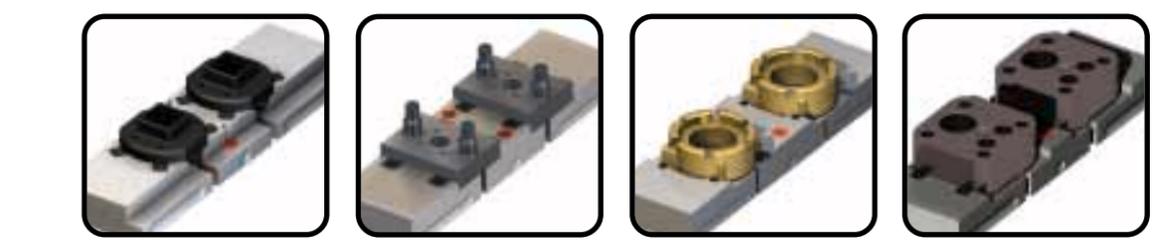


Dimensions include standard dual station 0520 QwikChange machinable jaws.

Grippers



| System Sizes | 1030 | 1040 | 1540 | 1550 |
|---|-----------------------|-----------------------|-----------------------|-----------------------|
| Vertical Conversion Faceplates | | | | |
| 2 Systems Order No. | NOT APPLICABLE | 5CF1040-20-02V | 5CF1540-20-02V | 5CF1550-20-02V |
| | | mm (inch) | mm (inch) | mm (inch) |
| Length | | 419 (16.50) | 419 (16.50) | 498 (19.61) |
| Width | | 99 (3.90) | 148 (5.83) | 148 (5.83) |
| Height | | 88 (3.46) | 98 (3.86) | 81 (3.19) |
| Holding Cap | | 85 (3.35) | 85 (3.35) | 85 (3.35) |
| Horizontal Conversion Faceplates | | | | |
| 6 Systems Order No. | 5CF1030-20-06H | NOT APPLICABLE | NOT APPLICABLE | NOT APPLICABLE |
| | mm (inch) | | | |
| Length | 298 (11.73) | | | |
| Width | 198 (7.80) | | | |
| Height | 88 (3.46) | | | |
| Holding Cap | 85 (3.35) | | | |
| 8 Systems Order No. | NOT APPLICABLE | 5CF1040-20-08H | 5CF1540-20-08H | NOT APPLICABLE |
| | | mm (inch) | mm (inch) | |
| Length | | 398 (15.67) | 398 (15.67) | |
| Width | | 198 (7.80) | 198 (7.80) | |
| Height | | 84 (3.31) | 84 (3.31) | |
| Holding Cap | | 85 (3.35) | 85 (3.35) | |
| 10 Systems Order No. | NOT APPLICABLE | NOT APPLICABLE | NOT APPLICABLE | 5CF1550-20-10H |
| | | | | mm (inch) |
| Length | | | | 498 (19.61) |
| Width | | | | 198 (7.80) |
| Height | | | | 81 (3.19) |
| Holding Cap | | | | 85 (3.35) |



| Grippers | Gripper #3 | Gripper #4 | Gripper #5 | Gripper #6 |
|---|-----------------|---------------------|-------------------|-------------------|
| Dimensions (Length x Width x Thickness) | 9mm x 9mm x 8mm | 12mm x 12mm x 4.6mm | 15mm x 15mm x 5mm | 19mm x 19mm x 6mm |
| Chick Gripper Plain | 005-2531 | 005-2541 | 005-2551 | 005-2561 |
| Chick Gripper Serrated | 005-2532 | 005-2542 | 005-2552 | 005-2562 |

Qwik-Loks Mounting

Qwik-Loks can mount either to CHICK's Foundation or to your T-Slotted table.

A

Foundation

Complete fixturing change over in minutes. Take advantage of CHICK's Round and Diamond Pin Set for location and then bolt the system in place.

B

T-Slotted Table

Select the appropriate Locating Keys and a set of Toe Clamps to mount to the machine's T-Slotted table.

C

Nested Subplates

The 50mm Qwik-Loks have an additional mounting option - - The Nested Subplate - - which gives the ability to mount five 50mm Qwik-Loks side by side.

A
Round and Diamond Pin Set

MPIN12S



Round and Diamond Pin Sets are used to locate Qwik-Loks Systems (pgs. 9-10) quickly and accurately. These $\varnothing 12\text{mm}$ pins utilize an expanding ball lock mechanism for fastening. When mounting directly to the foundation.
*50mm systems require an adapter (# 081-0900).

B¹
Toe Clamps

005-0254



CHICK Toe Clamps (four per set) provide the quickest and most secure means of mounting a Qwik-Lok to a T-Slotted VMC table. Toe clamps are designed to be used with either 1/2-13 or M12 socket head cap screws.

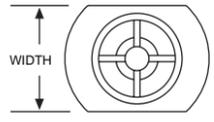
B²
Locating Keys

Order #' Below

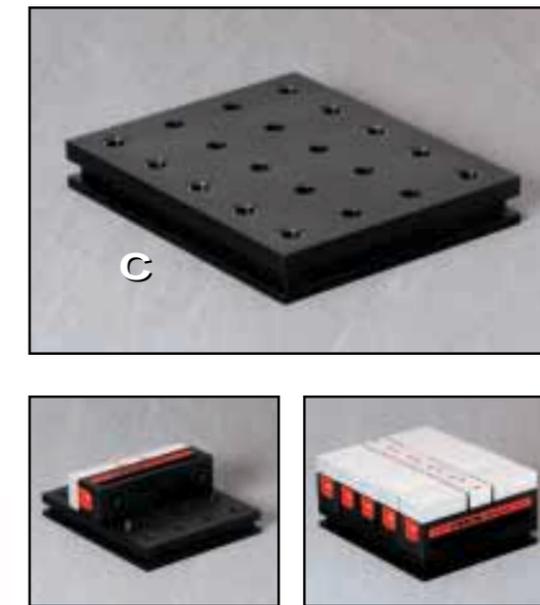


Locating Keys (two keys per set) are used to provide positive location when mounting Qwik-Loks to T-Slotted VMC tables. These keys utilize a ball lock mechanism to fasten on to the underside of all Qwik-Lok bases.

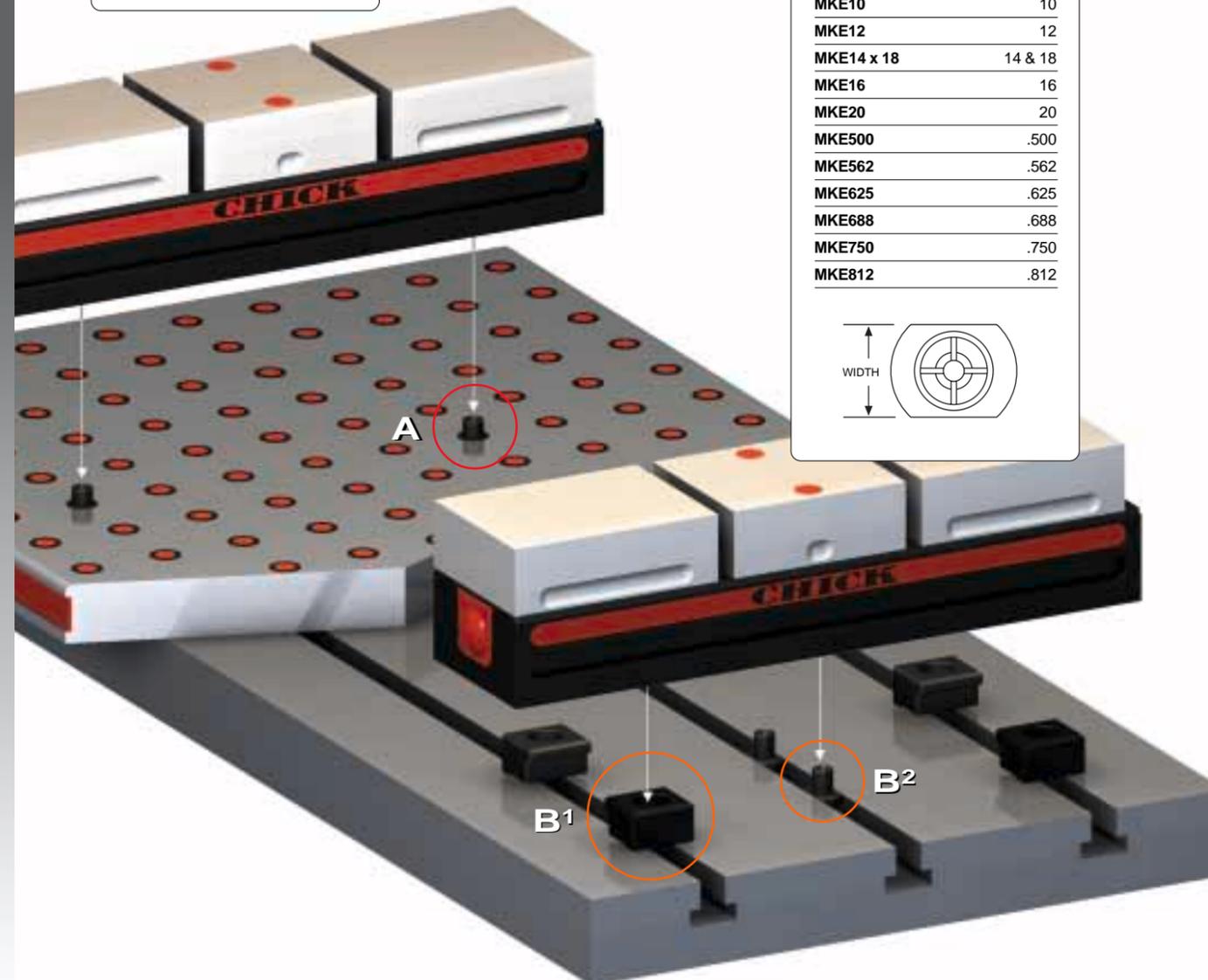
| Order No. | Width mm |
|------------|----------|
| MKE10 | 10 |
| MKE12 | 12 |
| MKE14 x 18 | 14 & 18 |
| MKE16 | 16 |
| MKE20 | 20 |
| MKE500 | .500 |
| MKE562 | .562 |
| MKE625 | .625 |
| MKE688 | .688 |
| MKE750 | .750 |
| MKE812 | .812 |



C
Nested Subplates

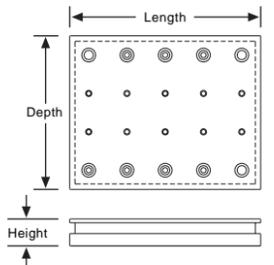


QwikChange™ five 50mm Qwik-Loks in minutes. Simply bolt the Qwik-Loks to the Subplate and mount the Subplate to either a CHICK Foundation or a T-Slotted table.



System Sizes

| | 0520 and 0525 | |
|------------|----------------------|-----------------|
| Order No. | 083-2305 | 083-2505 |
| Dimensions | mm (inch) | mm (inch) |
| Length | 250 (9.84) | 250 (9.84) |
| Depth | 200 (7.87) | 250 (9.84) |
| Height | 35 (1.38) | 35 (1.38) |

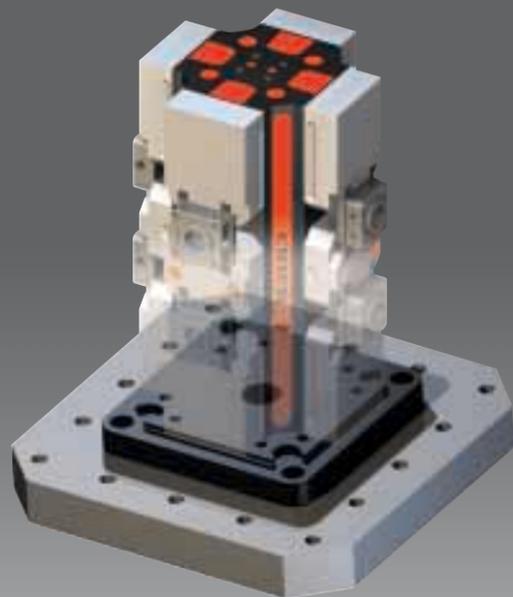


Multi-Loks (Baseplates)

All CHICK Multi-Loks require the use of a Baseplate.

Baseplates serve two purposes:

1. Rigidly securing a Multi-Lok to the pallet.
2. Positioning a Multi-Lok in the machine envelope.



027-0600



CHICK's Hoist Ring bolts to the top of the Multi-Lok to ease lifting of the Multi-Lok Assembly.

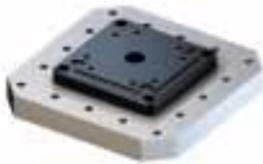
Custom Baseplates

CHICK offers Custom Baseplates designed to fit your application or machining center criteria. When ordering a Custom Baseplate you may want to consider the following:

Location



Edge

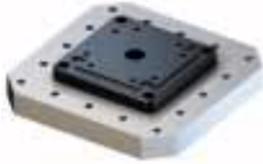


Center (Standard)

Pallet Coverage

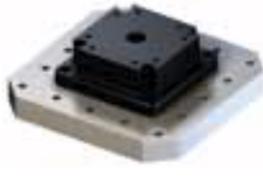


Full

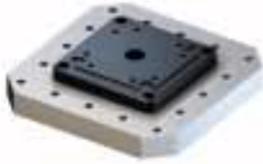


Partial (Standard)

Thickness



Raised for easy access

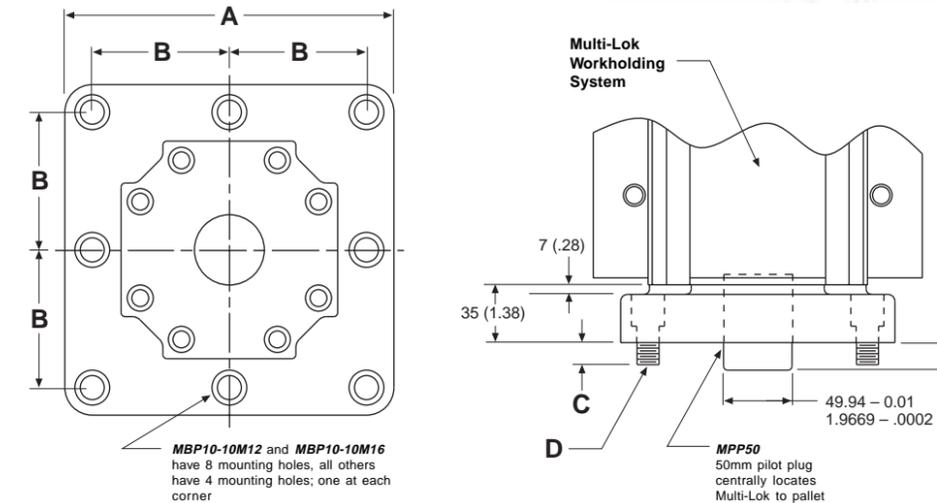


35mm (1.38") (Standard)

To order a Custom Baseplate, contact CHICK.

Standard Baseplates

CHICK offers a number of standard size Baseplates for 1030/1040 and 1540/1550 4 Sided Multi-Loks. These Baseplates are designed to interface with HMC pallets which follow JIS and DIN standards.



| System Sizes | For 1030 and 1040 4 Sided Multi-Loks | | | |
|--------------|--------------------------------------|-------------|-------------|-------------|
| Order No. | MBP10-08M12 | MBP10-08M16 | MBP10-10M12 | MBP10-10M16 |
| Dimensions | mm (inch) | mm (inch) | mm (inch) | mm (inch) |
| A | 200 (7.87) | 200 (7.87) | 240 (9.45) | 240 (9.45) |
| B | 80 (3.15) | 80 (3.15) | 100 (3.94) | 100 (3.94) |
| C | 16 (0.63) | 24 (0.93) | 16 (0.63) | 24 (0.93) |
| D | M12 X 25 | M16 X 35 | M12 X 25 | M16 X 35 |

| System Sizes | For 1540 and 1550 4 Sided Multi-Loks | | | |
|--------------|--------------------------------------|-------------|-------------|-------------|
| Order No. | 5BP15-08M12 | 5BP15-08M16 | 5BP15-10M12 | 5BP15-10M16 |
| Dimensions | mm (inch) | mm (inch) | mm (inch) | mm (inch) |
| A | 208 (8.19) | 208 (8.19) | 240 (9.45) | 240 (9.45) |
| B | 80 (3.15) | 80 (3.15) | 100 (3.94) | 100 (3.94) |
| C | 16 (0.63) | 24 (0.93) | 16 (0.63) | 24 (0.93) |
| D | M12 X 25 | M16 X 35 | M12 X 25 | M16 X 35 |