



CHICK

Efficiency Through Workholding Innovation



OneLOK™

OneLOK™

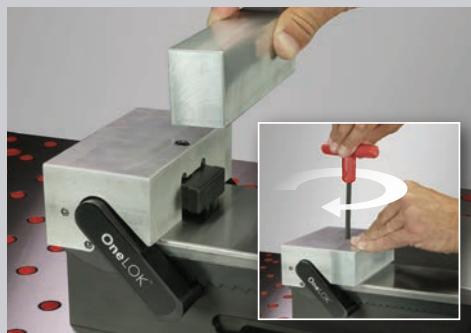
Setup and Go

Re-engineered from the ground up for vertical milling machines running fewer than 20 parts, the OneLOK's design captures dramatic improvements in speed, precision, and versatility.



Setup Quicker

Our BoltFast™ jaw system shaves valuable time off of jaw changes. One simple screw turn provides fast precise repeatability. Stop wrestling with buried screws, stop recutting jaws, and start saving time.



Operate Easier

We designed the OneLOK with the machinist in mind. At nearly half the weight of 1950 style vises and with an ergonomic handgrip, the OneLOK can be handled with ease.





Work Cleaner

OneLOK's sealed design eliminates "chip traps" for cleaner operation and less aggravation. This means no more messy part changes or lost small workpieces.



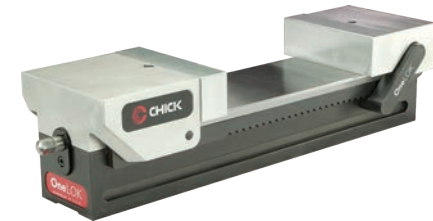
Clamp Faster

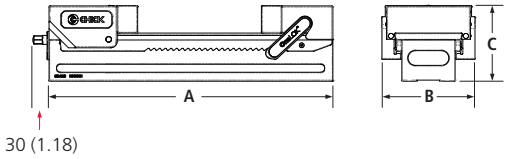
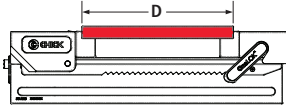
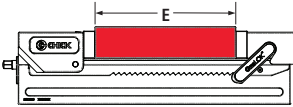
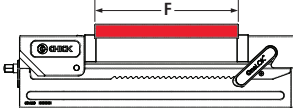
The QwikSlide movable jaw slides with ease for rapid setup and part changes. Boost operator speed and gain efficiency.



OneLOK™

System Information



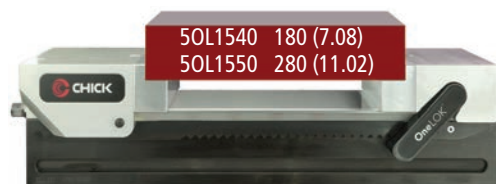
ORDER NUMBERS	50L1540	50L1550
Dimensions mm (inch)		
 <div> A Length </div> <div> B Width* </div> <div> C Height* </div>	400 (15.75)	500 (19.69)
	164 (6.46)	
	134 (5.28)	
Maximum Holding Capacity mm (inch)		
 <div>D Machinable Jaws</div>  <div>E Hard Jaws</div>  <div>F Step Jaws</div>	180 (7.08)	280 (11.02)
	158 (6.22)	258 (10.16)
	163 (6.42)	263 (10.35)
Additional Information on Jaws and Accessories	Pages 4-6	
Clamping Force @ Maximum Torque	26.5 kN @ 54 N•m 6000 lbs @ 40 ft•lbs	
System Weight	19.1 kg (42 lbs)	22.3 kg (49 lbs)

*All dimensions and systems include a standard BoltFast™ machinable jaw set.

OneLOK™

BoltFast™ Jaws

Machinable Jaw Set

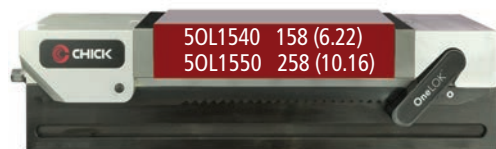


Material: High Strength Aluminum

Order Number Set includes 2 jaws	Width	Depth	Height
5BFSJ-150-50	152 (5.98)	36 (1.42)	48.5 (1.91)

Clamp workpieces securely and with precise repeatability, reducing setup time to seconds. Standard machinable jaws are included. Additional accessories include hard, step, and adapter jaws.

Hard Jaw Set

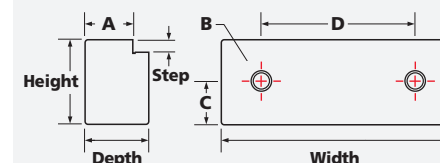


Material: Hard Steel

Order Number Set includes 2 jaws	Width	Depth	Height
5BFHJ-150	152 (5.98)	21 (.83)	50 (1.97)

Jaw Dimensions

Dimensions are in mm (inch)



Step Jaw Set



Material: Hard Steel

Order Number Set includes 2 jaws	Width	Depth	Height	A	Step
5BFST-150-06	152 (5.98)	21 (.83)	50 (1.97)	18.5 (.73)	6 (.24)

Basic Vise Adapter Jaw Set



Distance between the Adapter Jaws
50L1540 - 158 (6.22)
50L1550 - 258 (10.16)



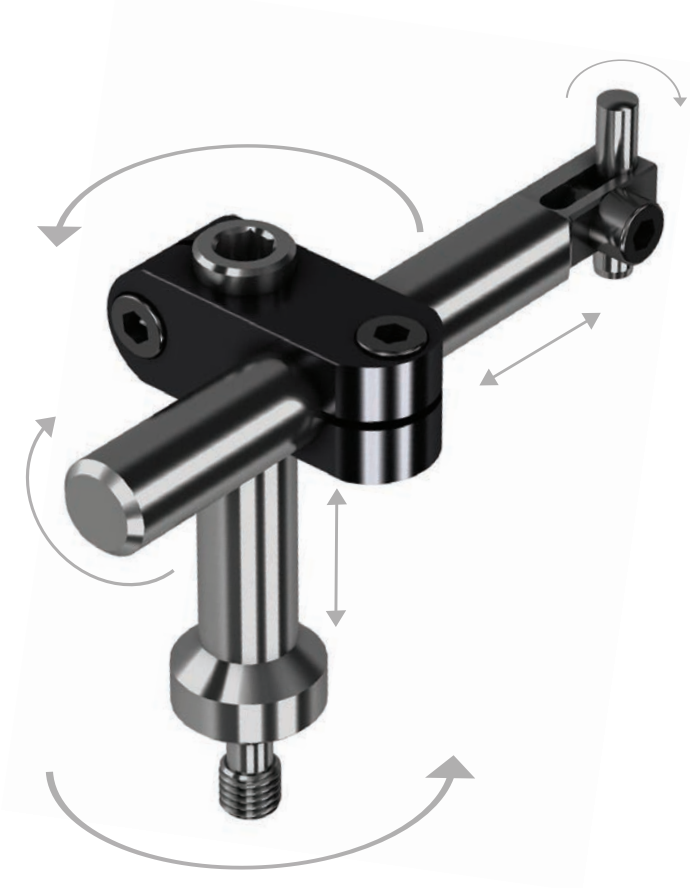
Material: Hard Steel

Order Number Set includes 2 jaws	Width	Depth	Height	Hole Dimensions		
				B	C	D
5BFAJ	152 (5.98)	21 (.83)	50 (1.97)	Ø14 (.55)	23.8 (.94)	98.43 (3.875)

OneLOK™

WorkStop

Brace yourself for a workstop solution that finally lets you make unlimited adjustments on the fly. Chick's WorkStop is versatile, with full 360-degree rotation and lateral calibrating. It's also rugged – built to handle accurate, repeatable locating, time and time again. Put stopping power where you need it. (Mounts to OneLOK, Foundation, and T-slotted tables.)



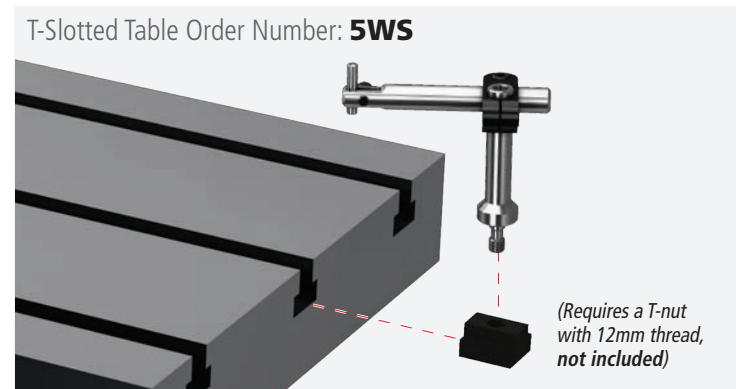
OneLOK Order Number: **5WS-OL**



Foundation Order Number: **5WS**



T-Slotted Table Order Number: **5WS**

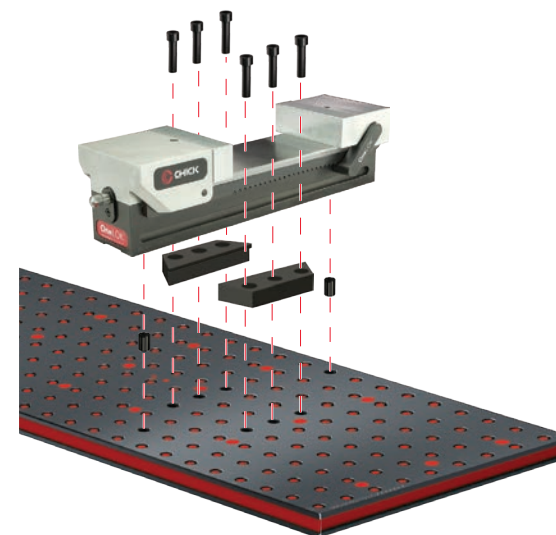
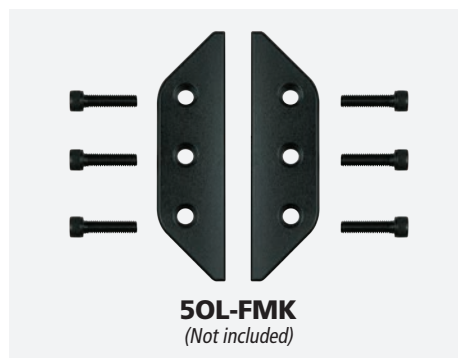


OneLOK™

Mounting Accessories

Mount to a Chick Foundation

Our advanced locating system ensures pinpoint-accurate mounting. Whether you're orienting your system in the X or the Y axis, simply place the OneLOK onto the Chick Foundation, and use the round and diamond pin interface to ensure precise locating accuracy and repeatability. Then, add Foundation Mounting Kit to secure the OneLOK.

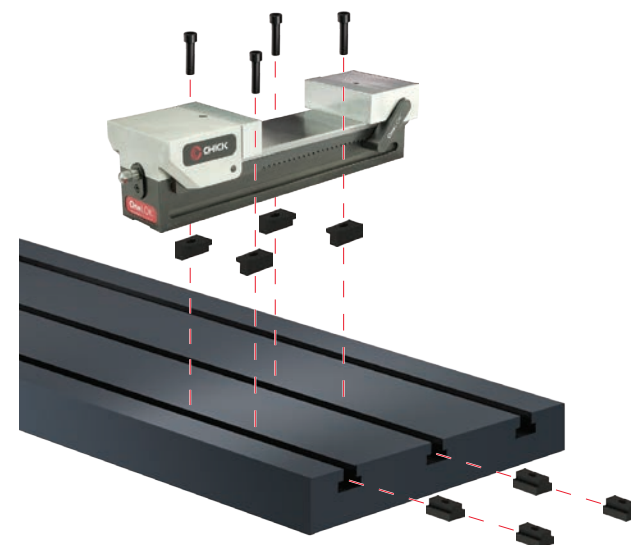


Mount to a T-Slotted Table

Alternatively, the OneLOK can be mounted to a T-slotted table with T-slot Toe Clamps.



Toe Clamps (four per set) mount a OneLOK to a T-slotted VMC table. Toe Clamps can be used with either a 1/2-13 or M12 socket-headed cap screw. (T-nuts and cap screws not included).





Chick Workholding Solutions, Inc.
500 Keystone Drive
Warrendale, PA 15086

Phone: 724.772.1644
Fax: 724.772.1633
Email: Sales@ChickWorkholding.com

ChickWorkholding.com