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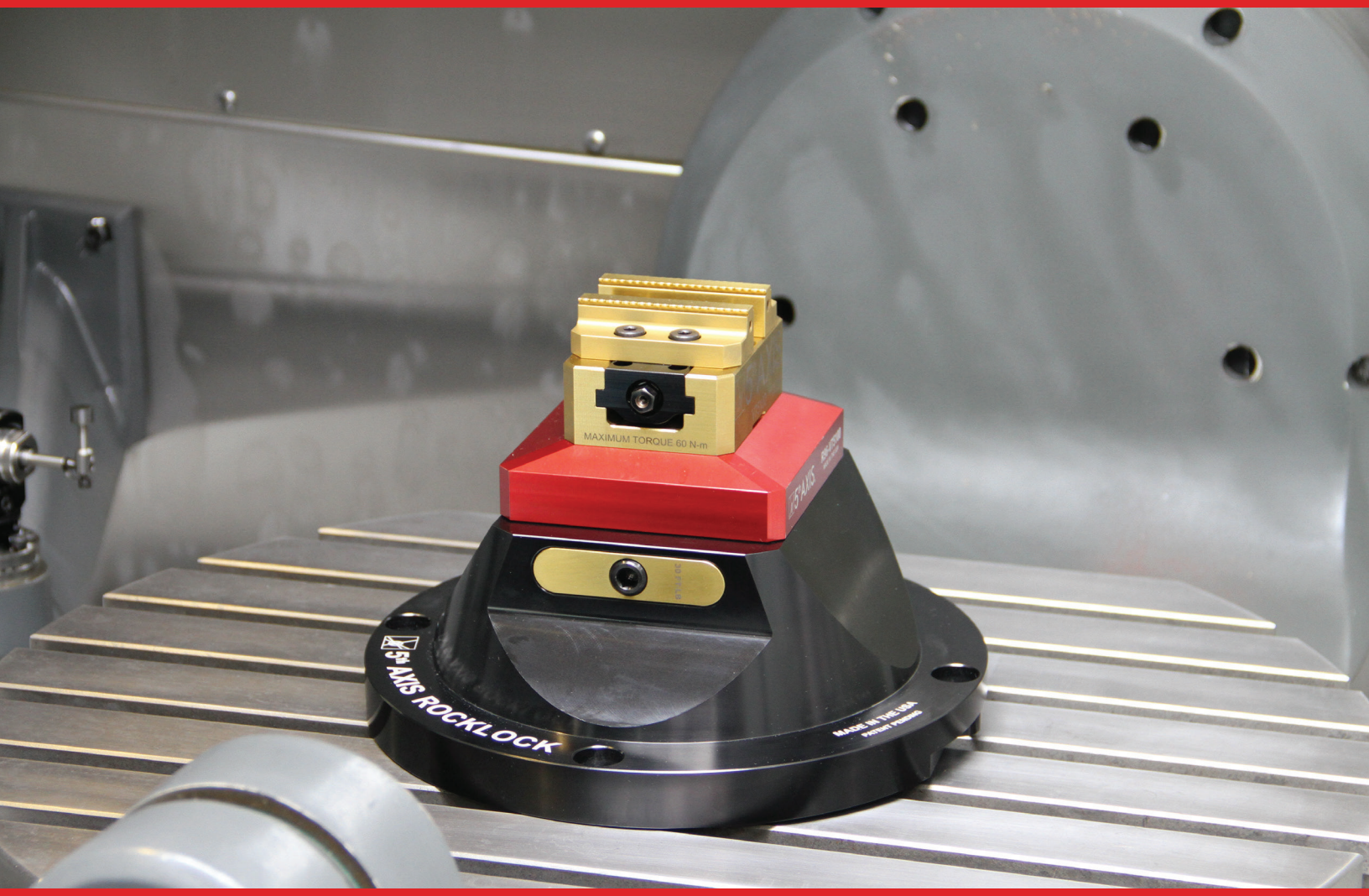
5th AXIS®

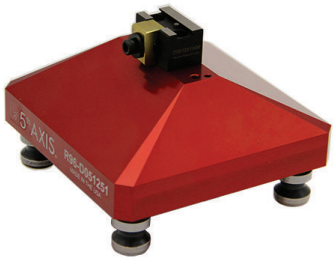
HAAS



HAAS Automation Workholding Solutions

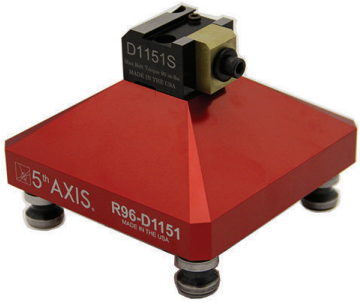
Top Tooling
96mm Compatible

ROCKLOCK™



R96-D05125
Dovetail Fixture
Stock under 1”

R96-D22
Dovetail Fixture
Stock 2” and above



R96-D115
Dovetail Fixture
Stock under 3”

R96-V75100
Small Self-Centering Vise

V552 / V552M
V562 / V562M
Medium Self-Centering Vise

V6105 / V6105M
Large Self-Centering Vise

DV56
5” x 6” Double
Station Vise

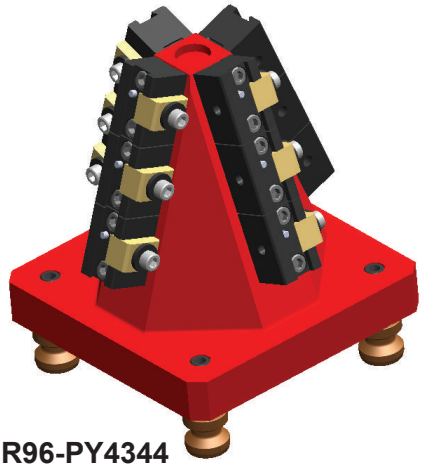
DV510
5” x 10” Double
Station Vise

PS20F Pull Studs sold separately for Medium, Large, and Double Station Vises

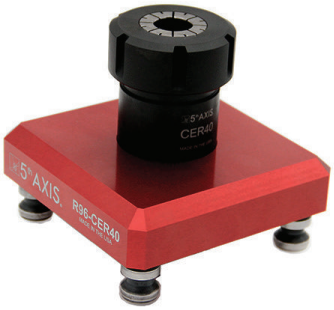
Issued & Pending Patents

ROCKLOCK™

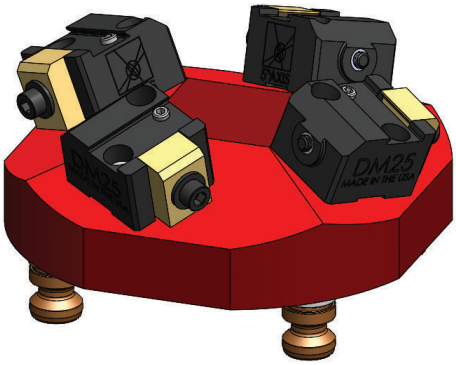
Pyramids & Fixture Adapters



R96-PY4344
12 Station Pyramid



R96-CER40
Clamp round stock
.125” to 1.125” Diameter



R96-PY6420
4 Station Pyramid

RL96-MP
Master Pallet

RL96-KD688
Kurt Vise Adapter

RL96A- 90DEG
90° Multi-Position Plate

Issued & Pending Patents

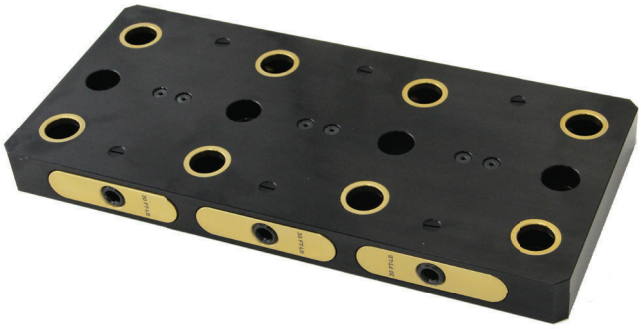
Vertical Mills

MINI MILLS

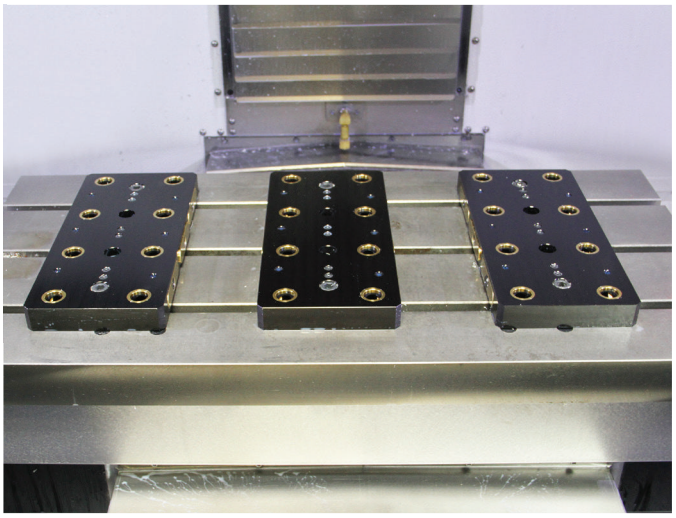
DM-1 / DM-2

VF-2

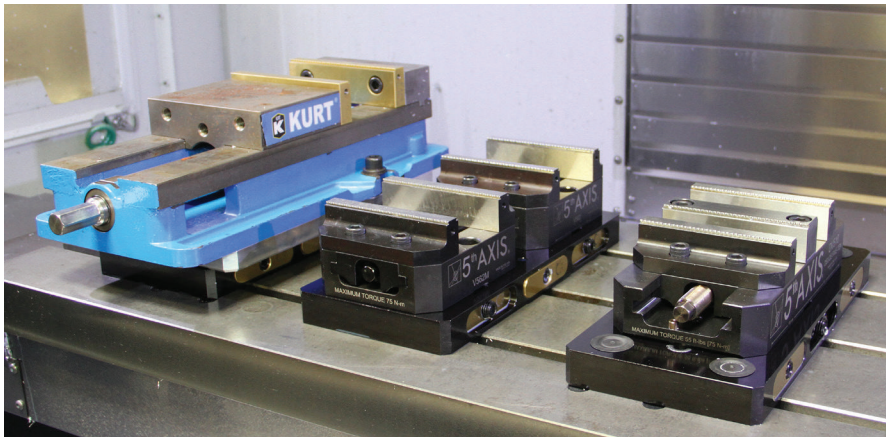
RockLock™ Base Compatibility



RL96A-3613S1
Multi-Position Plate
Mounting spaced for Mini Mills, DM-1, DM-2, and VF-2



Example Set-Up shown on VF-2



Example Set-Up shown on VF-2

RL96-KD688
Kurt Vise Adapter

Issued & Pending Patents

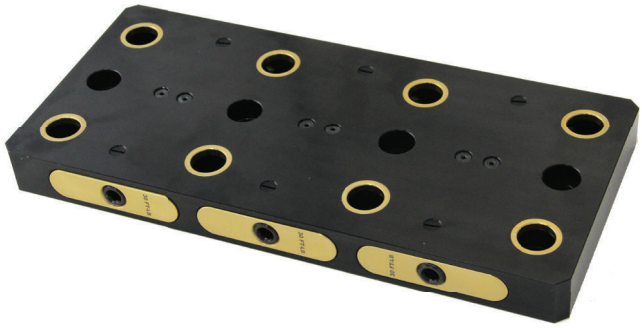
Vertical Mills

VF-3

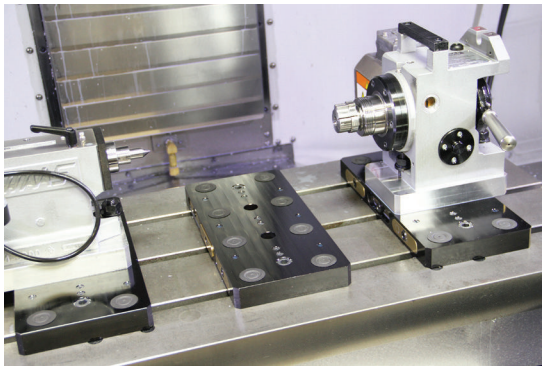
VF-4

VF-5

RockLock™ Base Compatibility

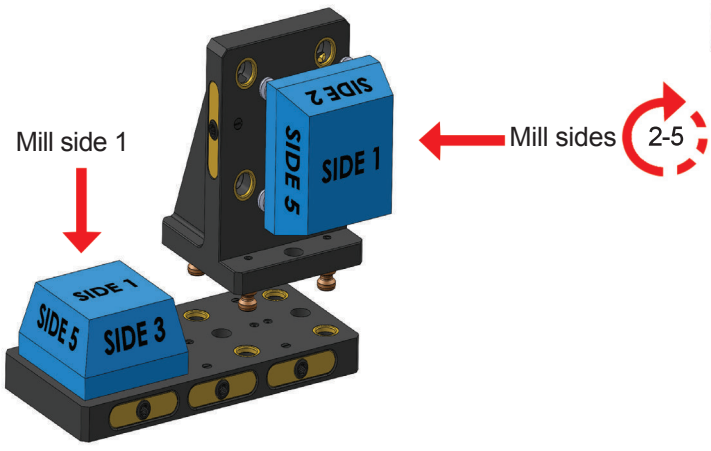


RL96A-3613S2
Multi-Position Plate
Mounting spaced for VF-3, VF-4 and VF-5

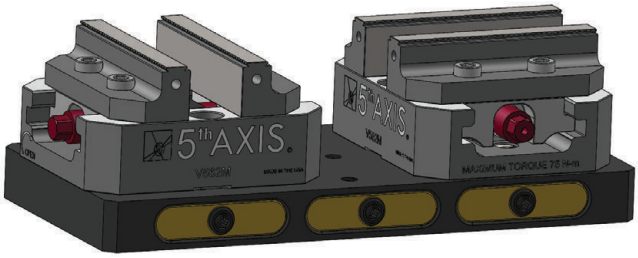


4th Axis quick change

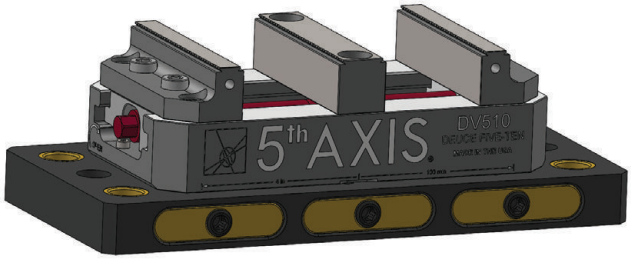
RL96A-90DEG



RL96A-3613S2



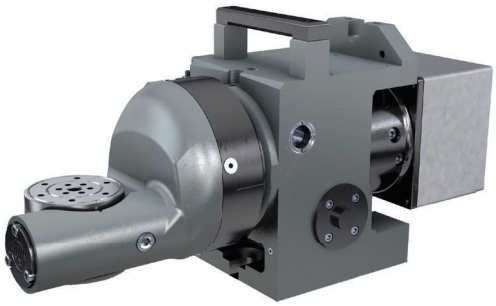
Multi-Position Plates for vertical / horizontal machines 2 to 5 position plates available



Span multiple positions for large part of vise

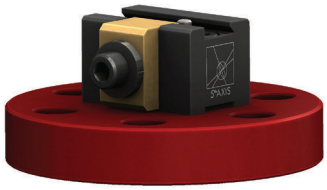
Issued & Pending Patents

Small Tilting Rotaries



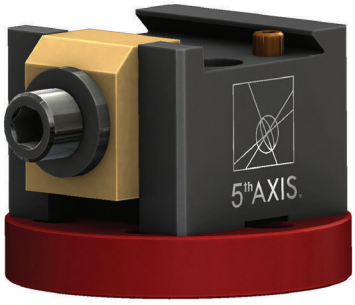
Haas TRT70

Haas TRT100

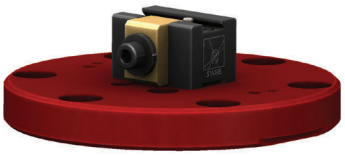


TRT70D05
Includes Adapter Plate and
Dovetail Fixture for stock under 1”

TRT70D115
Includes Adapter Plate and
Dovetail Fixture for stock under 3”

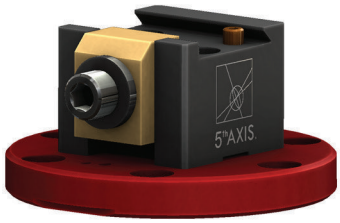


TRT70D22
Includes Adapter Plate and
Dovetail Fixture for stock 2” and above

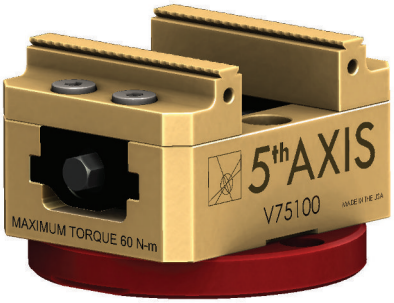


TRT100D05
Includes Adapter Plate and
Dovetail Fixture for stock under 1”

TRT100D115
Includes Adapter Plate and
Dovetail Fixture for stock under 3”



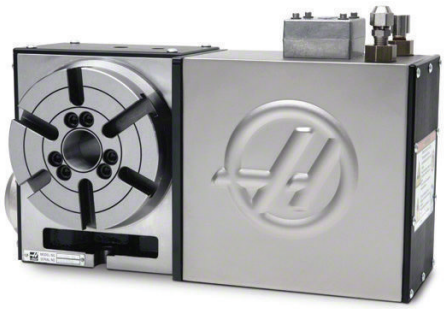
TRT100D22
Includes Adapter Plate and
Dovetail Fixture for stock 2” and above



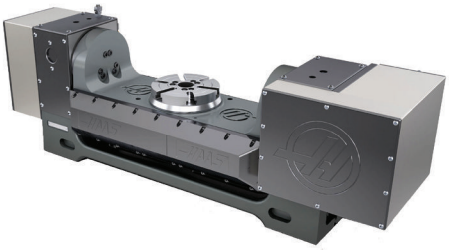
TRT100V75100
Includes Adapter Plate and
Small Self-Centering Vise

Issued & Pending Patents

Rotary 160 / 200 / 210 / 310 Rotaries & Trunnions



HRT160
HRT160SS
HRT160SP
HRC160

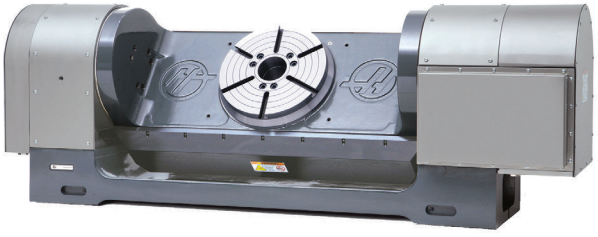


TR160
TRT160
TR200Y

RL96S-56 Steel,100mm / 4" bolt spacing
RL96A-56 Aluminum,100mm / 4" bolt spacing
6" x 5" x 1.18"

LK1500-RL
Mounting Hardware

HRT210
HRT210SP
HRT210M
HRC210
HRT210-2
HRT310
HRT310SP



TR210
TRT210
TR310

RL96S-6760 Steel, 60° bolt pattern
RL96A-6760 Aluminum, 60° bolt pattern
6" x 7" x 1.18"

LK2000-RL (210 models)
LK3250-RL (310 models)
Mounting Hardware

Issued & Pending Patents

5 Axis Universal Machine UMC-750 / SS

UMC-750 / SS

RockLock™ Base Compatibility

RL96A- 411 Aluminum, 90° bolt pattern
Integrated 11" Ø x 100mm height

PY20RL96-56
Includes 20° Pyramid Riser 15.5" Ø
with (3) RL96A-56

RL96A-4816
Multi-Position Plate (single / double)
100mm height

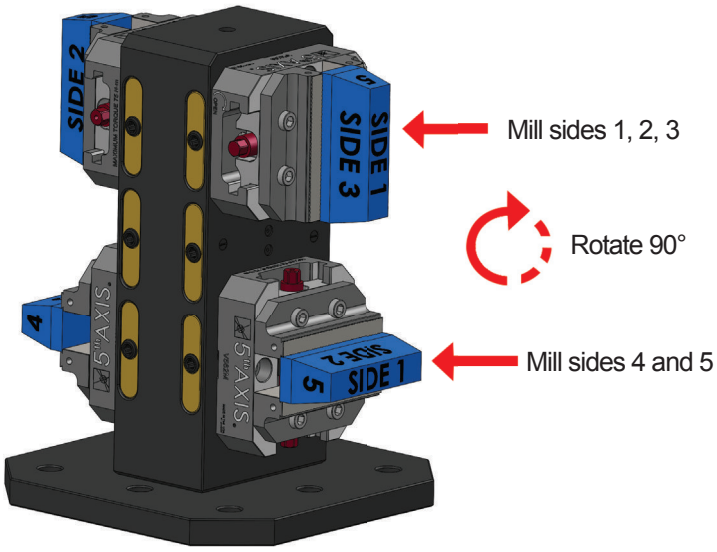
LKUMC-010M
Mounting Hardware

Issued & Pending Patents

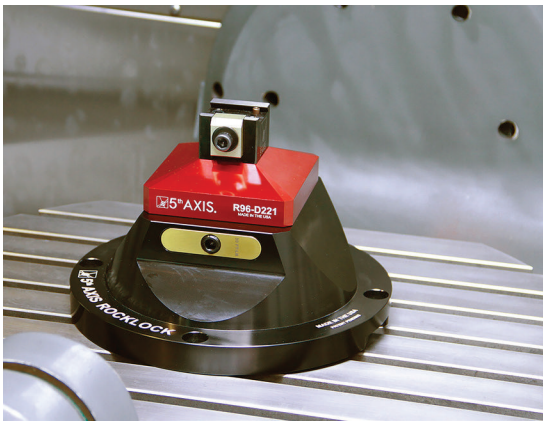
RL96A-3002
Aluminum Tombstone, 2 sided,
300mm base, 400mm height

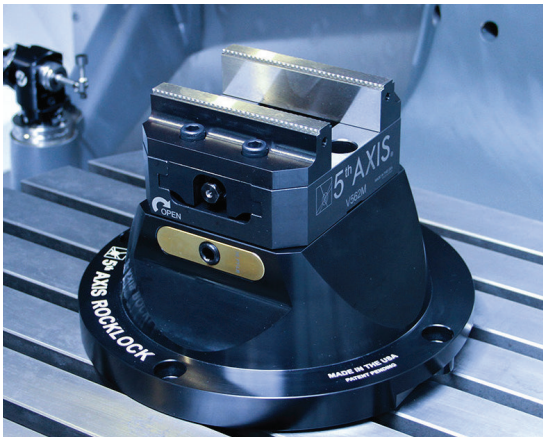
RL96A-3003
Aluminum Tombstone, 3 sided,
300mm base, 400mm height

Set-Up Examples



RL96A-3002
Tombstone





Issued & Pending Patents

Accessories

Machinable 6061 Aluminum Jaws

Inch

VAJ52 4.95” x 1.95” x 1.35” Compatible with V562 / V552
VAJ610 5.95” x 3.00” x 1.85” Compatible V6105

Metric

VAJ75 75 x 45 x 25 Compatible with V75100
VAJ52M 125 x 50 x 34 Compatible with V562M / V552M
VAJ610M 151 x 78 x 47 Compatible with V6105M

Machinable 1018 Steel Jaws

Inch

VSJ52 4.95” x 1.95” x 1.35” Compatible with V562 / V552
VSJ610 5.95” x 3.00” x 1.85” Compatible V6105

Metric

VSJ75 75 x 45 x 25 Compatible with V75100
VSJ52M 125 x 50 x 34 Compatible with V562M / V552M
VSJ610M 151 x 78 x 47 Compatible with V6105M

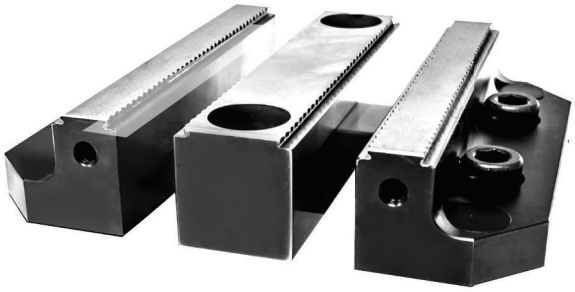
Dovetail Cutters

DC1750-45
45° Indexable Dovetail Cutter 1” shank

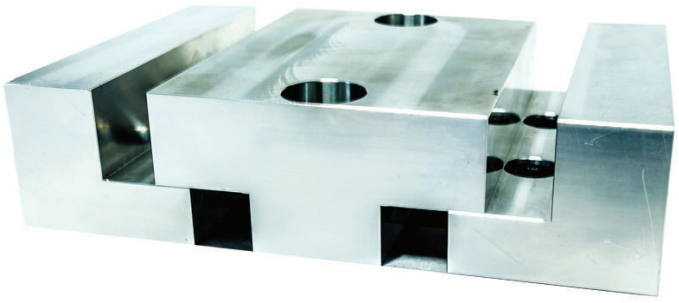
DC1750-60
60º Indexable Dovetail Cuter 1” Shank

*Compatible with Raptor and other 60º dovetail systems.

DC1750-B
Inserts for Dovetail Cutter

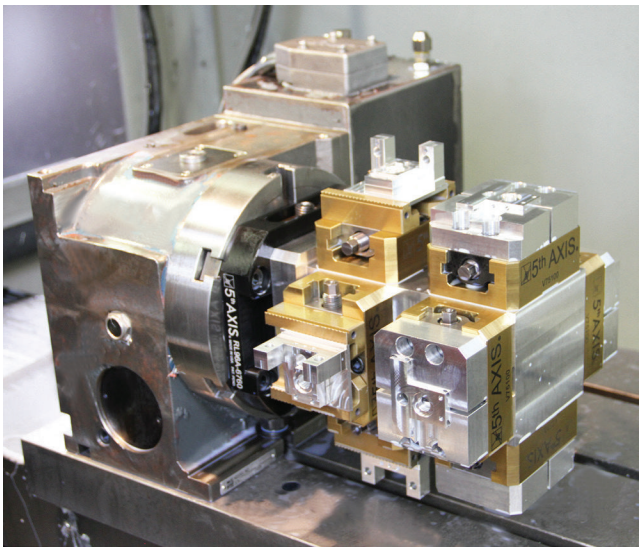


Double Station Hard Jaw Set
DV56-3R Compatible with DV556
DV510-3R Compatible with DV510
*Jaw sets are sold separately from vise base

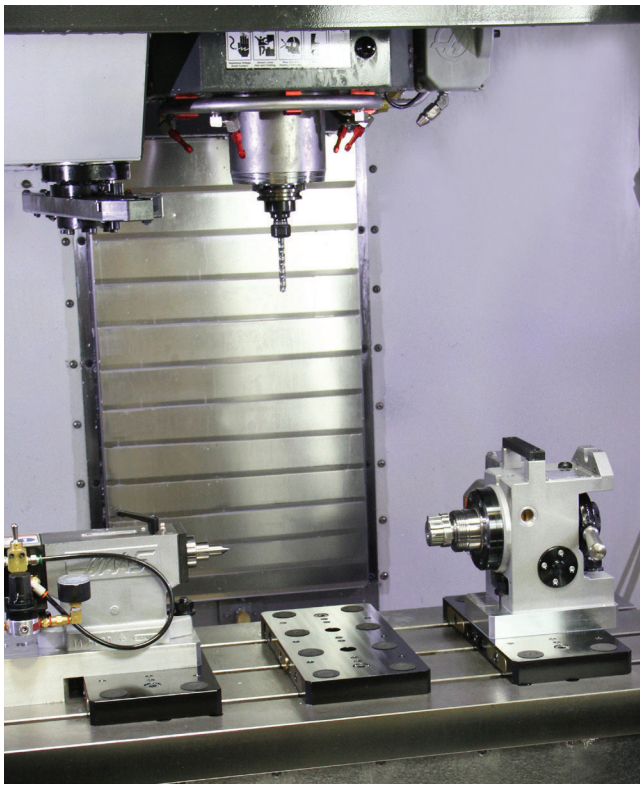


Double Station Machinable Jaw Set
DV56-MJ Compatible with DV556
DV510-MJ Compatible with DV510
*Jaw sets are sold separately from vise base

Examples

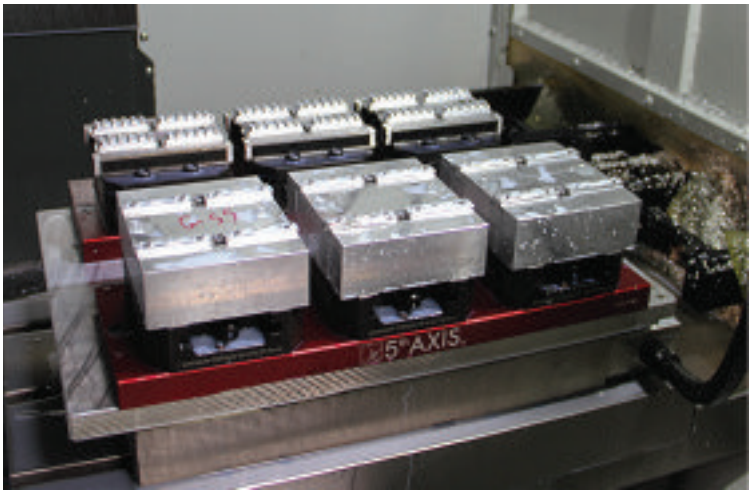


Mini Tombstone with (8) V75100 Vises
on an HRT210SS



Quick change HA5C rotary and tailstock with
(3) RockLock™ multi-position tooling plates

Example: **12 complete parts** including deburr: **23 seconds each**



Sample Job: 5 Slot MLOK rails

Shown are (6) DV56 vises
on Haas DM-2

(3) DV56 with hard jaws
(3) DV56 with machinable jaws

This example holds 24 parts.
Program produces 12 Op 1 parts
and 12 complete Op 2 parts.

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5th AXIS®

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e: workholding@5thaxis.com