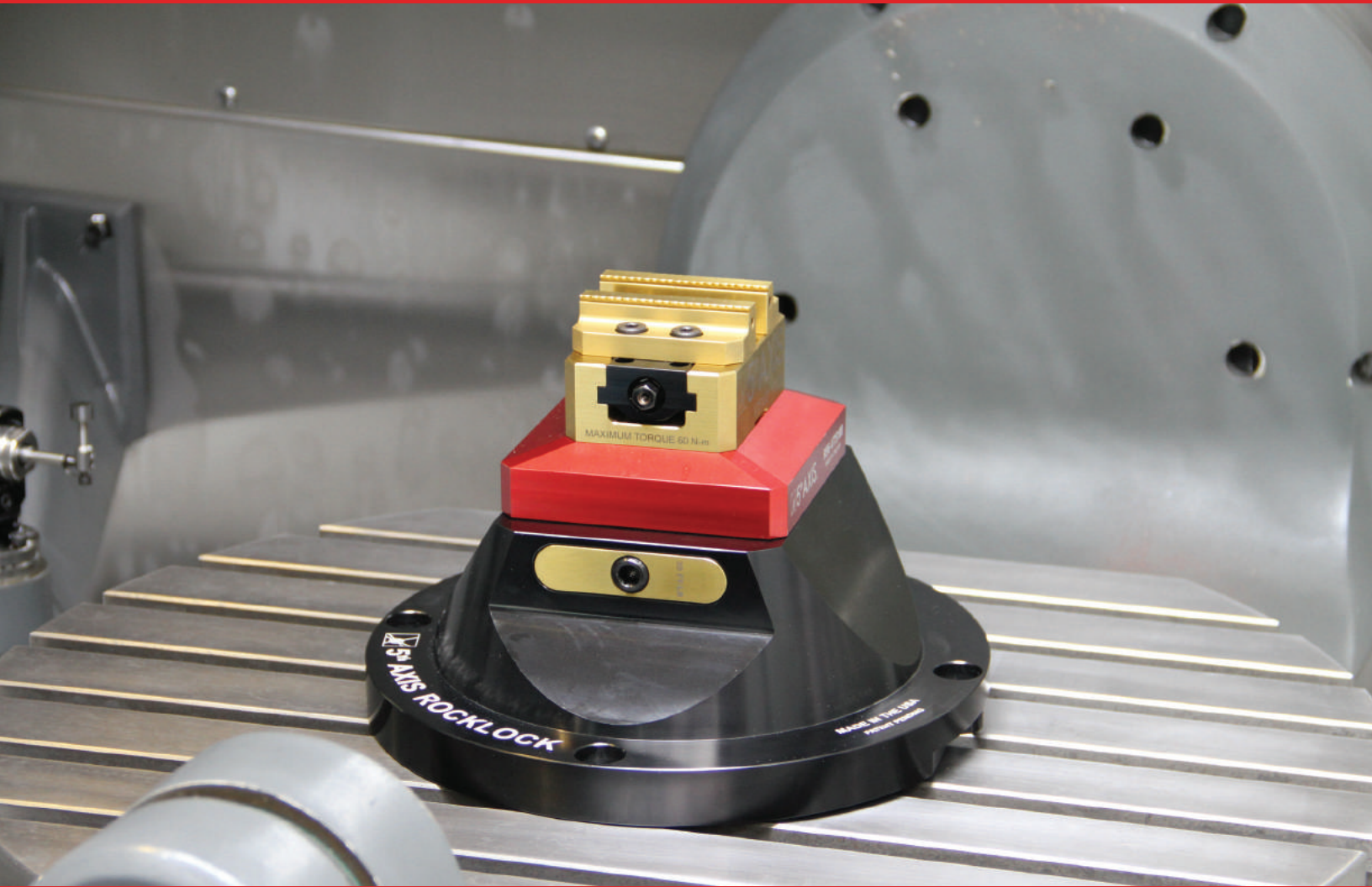
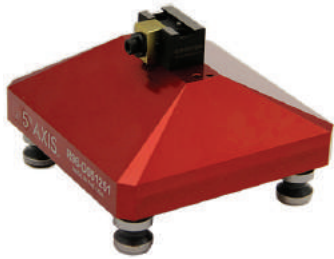




# 5<sup>th</sup> AXIS<sup>®</sup>



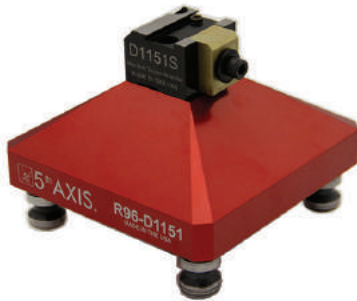
## HAAS Automation Workholding Solutions



**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



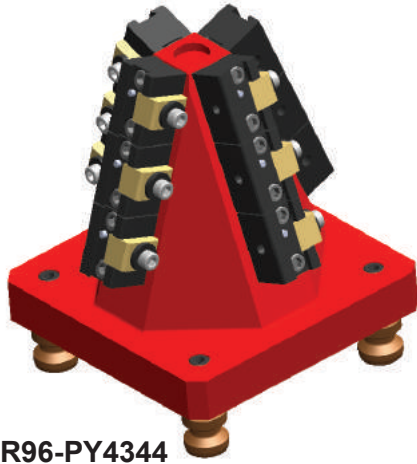
**DV56**  
5" x 6" Double  
Station Vise



**DV510**  
5" x 10" Double  
Station Vise



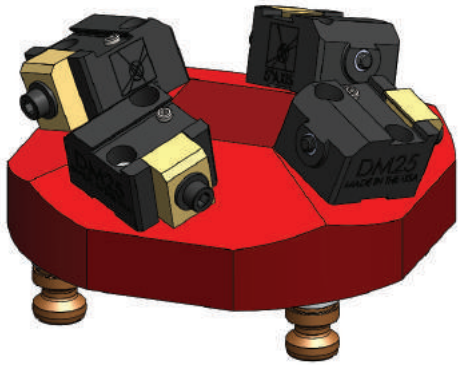
**PS20F** Pull Studs sold separately for Medium,  
Large, and Double Station Vises



**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

# Vertical Mills



**MINI MILLS**

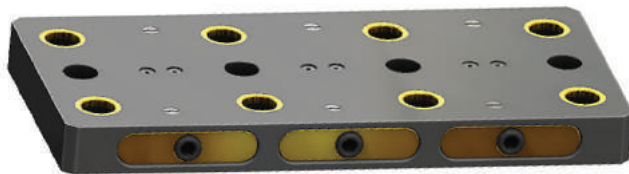


**DM-1 / DM-2**

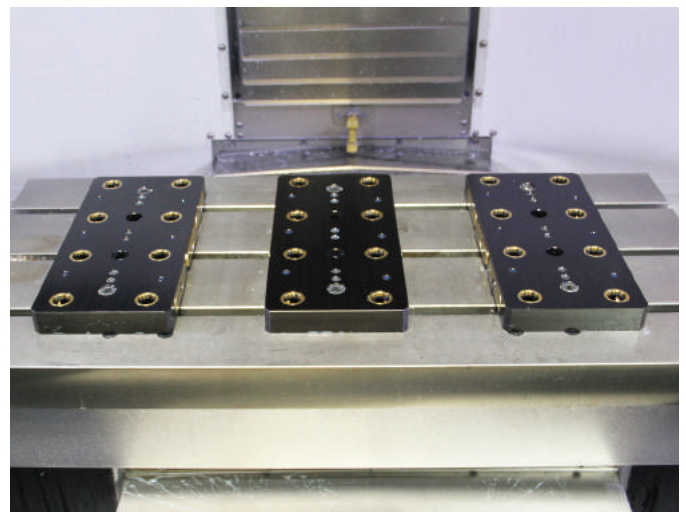


**VF-2**

## RockLock™ Base Compatibility



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

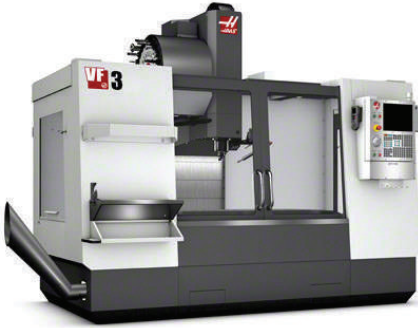


Example Set-Up



**RL96-KD688**  
Kurt Vise Adapter

Issued & Pending Patents



**VF-3**



**VF-4**

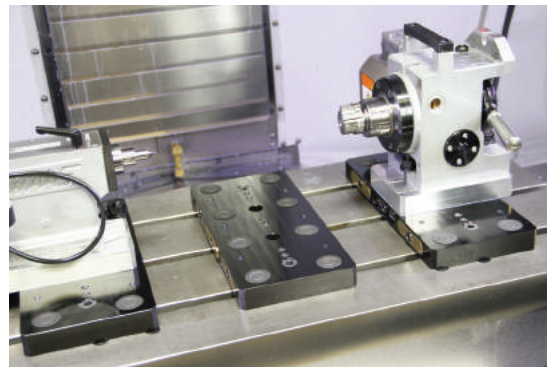


**VF-5**

## RockLock™ Base Compatibility

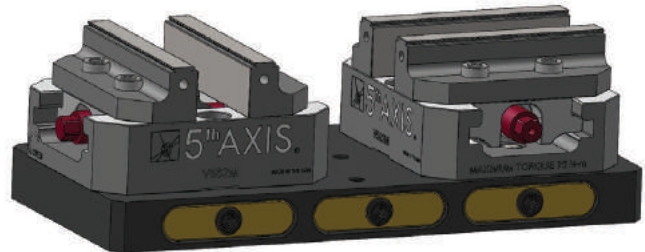


**RL96A-3613S2**  
Multi-Position Plate  
Mounting spaced for VF-3, VF-4 and VF-5

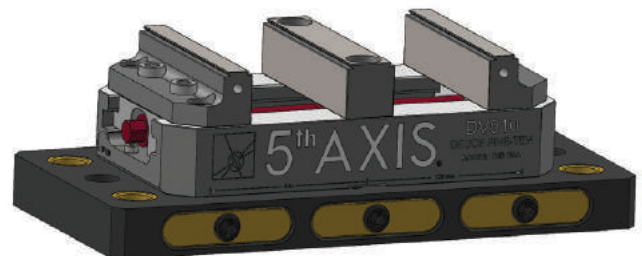
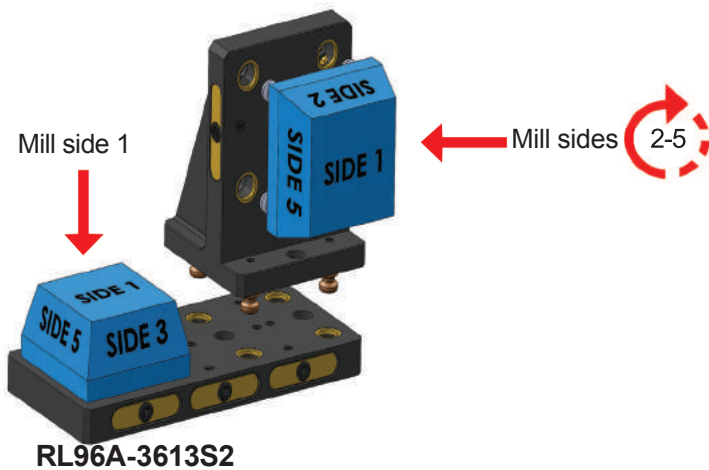


4th Axis quick change

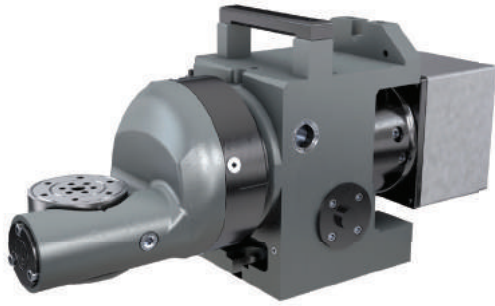
**RL96A-90DEG**



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



Span multiple positions for large part of vise



**Haas TRT70**



**Haas TRT100**



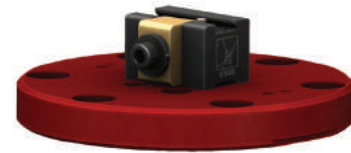
**TRT70D05**  
Includes Adapter Plate and  
Dovetail Fixture for stock under 1"



**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"



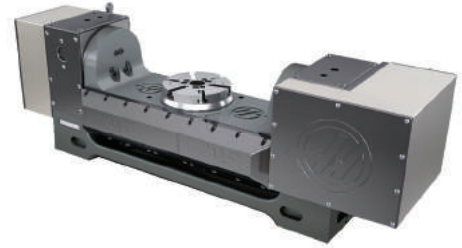
**TRT100D22**  
Includes Adapter Plate and  
Dovetail Fixture for stock 2" and above



**TRT100V75100**  
Includes Adapter Plate and  
Small Self-Centering Vise



**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



**UMC-750 / SS**

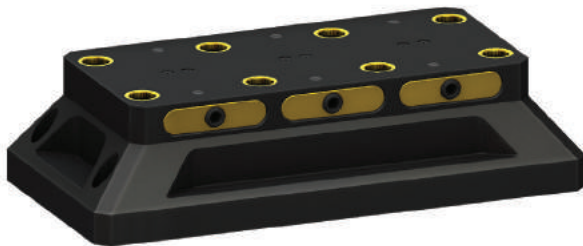
## RockLock™ Base Compatibility



**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

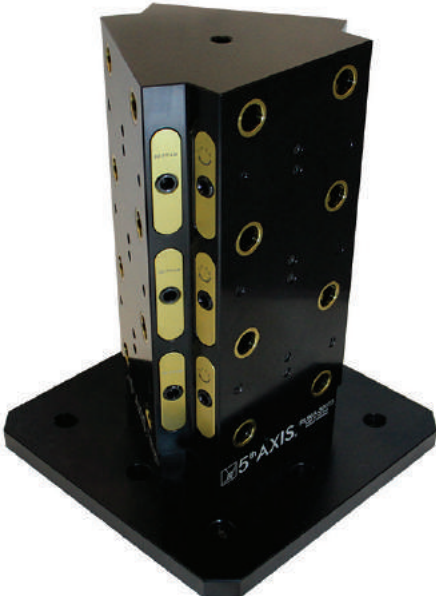


**LKUMC-010M**  
Mounting Hardware



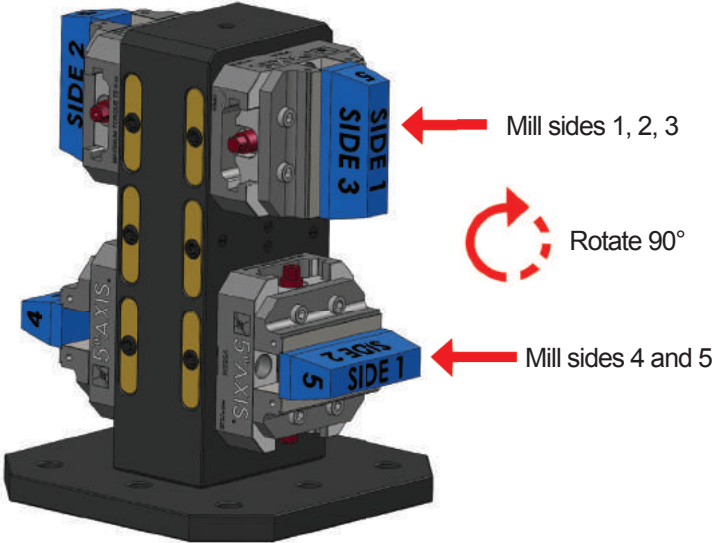


**RL96A-3002**  
Aluminum Tombstone, 2 sided,  
300mm base, 400mm height

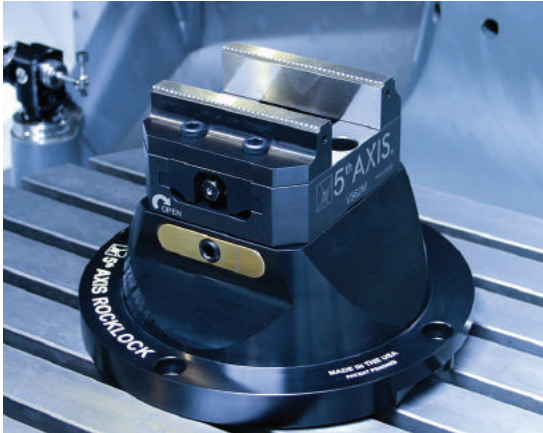


**RL96A-3003**  
Aluminum Tombstone, 3 sided,  
300mm base, 400mm height

### Set-Up Examples



**RL96A-3002**  
Tombstone



# 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**

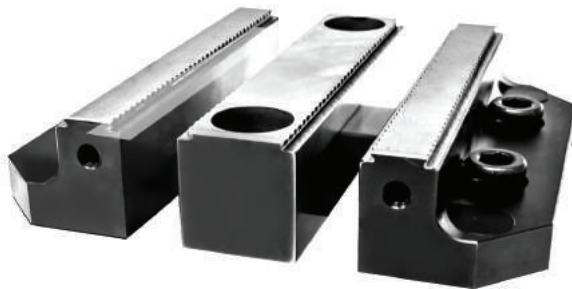
60° Indexable Dovetail Cutter 1" Shank

\*Compatible with Raptor and other 60° dovetail systems.



### **DC1750-B**

Inserts for Dovetail Cutter

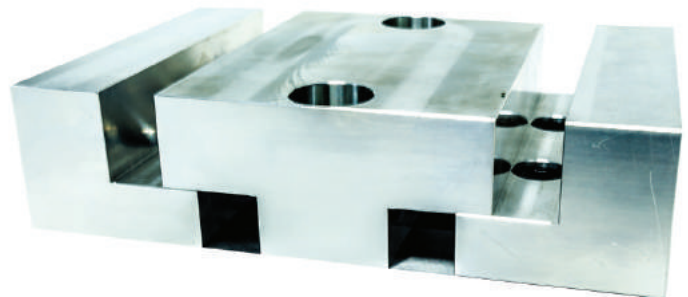


### **Double Station Hard Jaw Set**

**DV56-3R** Compatible with DV556

**DV510-3R** Compatible with DV510

\*Jaw sets are sold separately from vise base

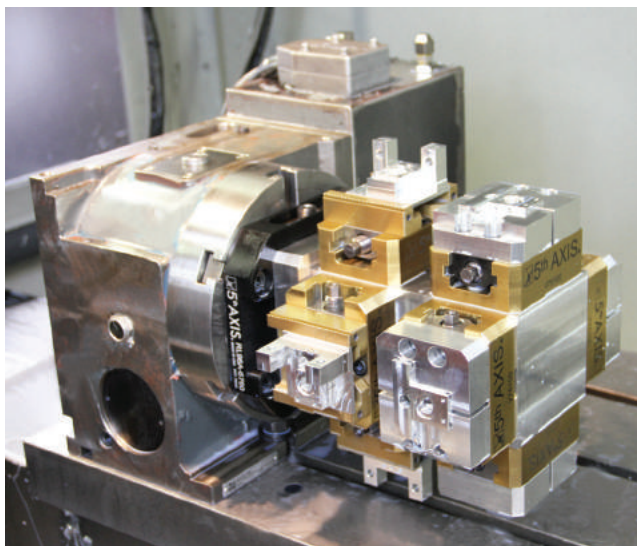


### **Double Station Machinable Jaw Set**

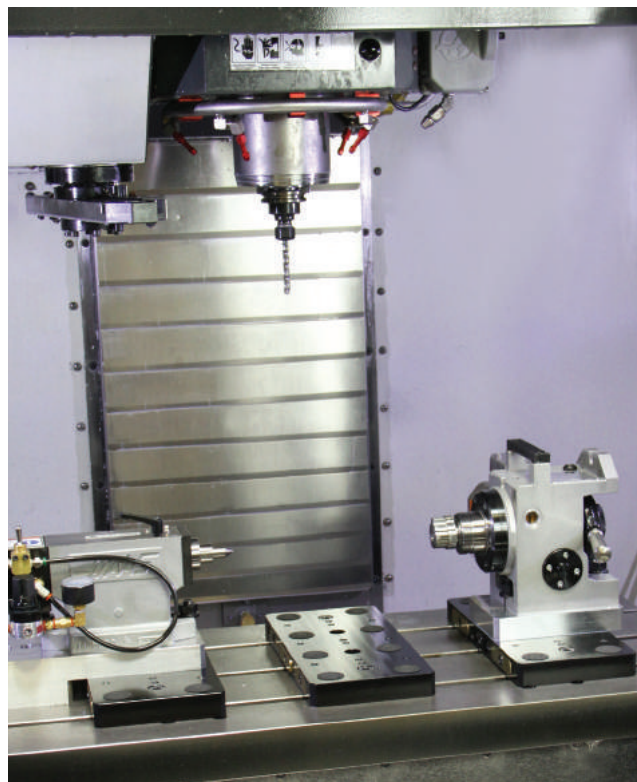
**DV56-MJ** Compatible with DV556

**DV510-MJ** Compatible with DV510

\*Jaw sets are sold separately from vise base



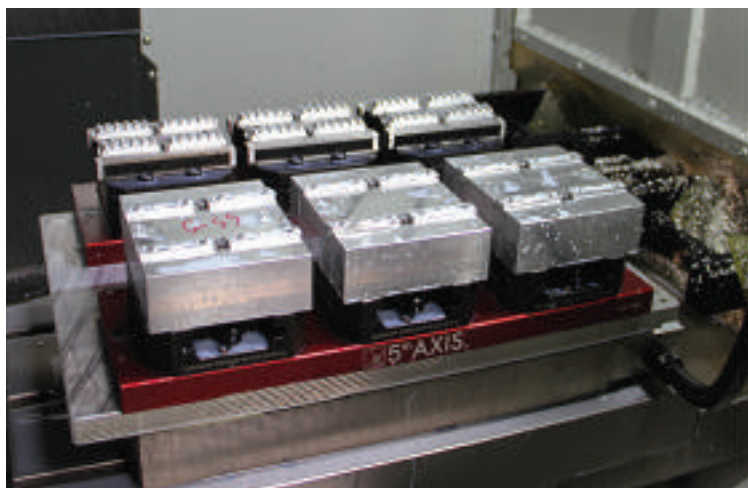
Mini Tombstone with (8) V75100 Vises  
on an HRT210SS



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

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

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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.



Innovative workholding  
designed for **Haas Automation**



[www.5thaxis.com](http://www.5thaxis.com)  
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