

# HARDINGE WORKHOLDING

Flex C Quick Change Collet Chucks



**NEW!**

**INTERACTIVE PDF**

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800-843-8801  
WWW.HARDINGE.COM



## WHY BUY A HARDINGE FLEXC QUICK CHANGE COLLET SYSTEM?

- 10X THE GRIP RANGE OF STANDARD COLLETS +/- .020"
- 2X AS ACCURATE (.0004 TIR)
- UP TO 19X FASTER CHANGEOVER COMPARED TO STANDARD COLLETS OR 3 JAW CHUCKS
- LIFETIME GUARANTEE ON COLLET VULCANIZATION
- FULLY INTERCHANGEABLE WITH COMPETITOR MODELS (42MM & 65MM)
- TRUE PARALLEL GRIPPING





**AMERICAN**  
— QUALITY —

# STYLE D – PULL-BACK WITH THRU-HOLE

## 42mm\* Style D Spindle Mount:

Pull-back style with thru-hole

Spindle Style	Part Number	D' - Diameter	D - Diameter	L' - Length	L - Length	Price
A2-5	<a href="#">V42 5D00300</a>	4.016" (102)	5.512" (140)	.846" (21.5)	3.543" (90)	\$2000
A2-6	<a href="#">V42 6D00400</a>	4.016" (102)	6.496" (165)	.846" (21.5)	3.543" (90)	\$2000
I40mm	<a href="#">V42 I40D01700</a>	4.016" (102)	5.906" (150)	.846" (21.5)	3.543" (90)	\$2000

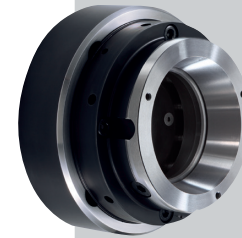
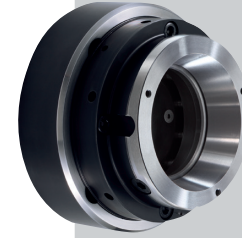
\* Limited to machine capacity. (millimeters in parentheses)

## 65mm\* Style D Spindle Mount

Pull-back style with thru-hole

Spindle Style	Part Number	D' - Diameter	D - Diameter	L' - Length	L - Length	Price
A2-5	<a href="#">V65 5D00500</a>	4.736" (120.3)	6.102" (155)	1.043" (26.5)	3.740" (95)	\$2300
A2-6	<a href="#">V65 6D00600</a>	4.736" (120.3)	6.496" (165)	1.043" (26.5)	3.740" (95)	\$2300
A2-8	<a href="#">V65 8D00700</a>	4.736" (120.3)	8.268" (210)	1.043" (26.5)	3.858" (98)	\$2300
I40mm	<a href="#">V65 I40D01900</a>	4.736" (120.3)	6.299" (160)	1.043" (26.5)	3.937" (100)	\$2300

\* Limited to machine capacity. Additional lengths available. (millimeters in parentheses)



## WHY YOU SHOULD CHOOSE FLEXC® PULL BACK CHUCKS

### MAIN SPINDLE APPLICATIONS

- Used on main spindle applications where the collet is pulled into the chuck sleeve to close on your part.

### ULTIMATE FLEXIBILITY

- Capable of accepting Hardinge Quick Change Adapters. (see page 8)

### COMPACT DESIGN

- Compact design allows for optimal tool clearances and maximum machining workspace.

### BETTER PART FINISH

- Collet chucks allow for higher RPMs than traditional 3-jaw chucks.

### QUALITY ASSURANCE

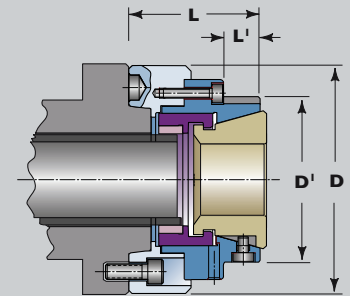
- Manufactured and assembled in the USA with top grade materials and inspection processes.

### ACCURACY IMPROVEMENTS

- .0002" TIR on the closing angle of the chuck.

### 10X THE GRIP RANGE

- Grip range of +/- .020" allowing for part size variation.



42 and 65mm systems

## BAR WORK



# STYLE A — PULL-BACK DESIGN WITH A DEAD-LENGTH® WORKSTOP



**42mm\*** Style A Spindle Mount:  
Pull-back style with removable dead-length work stop

Spindle Style	Part Number	D <sup>1</sup> - Diameter	D - Diameter	L <sup>1</sup> - Length	L - Length	Price
A2-5	<a href="#">V42 5A01000</a>	4.016" (102)	5.512" (140)	.610" (15.5)	4.764" (121)	\$3100
A2-6	<a href="#">V42 6A01100</a>	4.016" (102)	6.496" (165)	.610" (15.5)	4.764" (121)	\$3100
140mm	<a href="#">V42 140A01600</a>	4.016" (102)	5.906" (150)	.610" (15.5)	4.961" (126)	\$3100

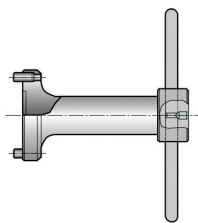
\* Limited to machine capacity. (millimeters in parentheses)



**65mm\*** Style A Spindle Mount:  
Pull-back style with removable dead-length work stop

Spindle Style	Part Number	D <sup>1</sup> - Diameter	D - Diameter	L <sup>1</sup> - Length	L - Length	Price
A2-5	<a href="#">V65 5A01200</a>	4.736" (120.3)	6.102" (155)	.728" (18.5)	5.118" (130)	\$3600
A2-6	<a href="#">V65 6A01300</a>	4.736" (120.3)	6.496" (165)	.728" (18.5)	5.118" (130)	\$3600
A2-8	<a href="#">V65 8A01400</a>	4.736" (120.3)	8.268" (210)	.728" (18.5)	5.315" (135)	\$3600
140mm	<a href="#">V65 140A02300</a>	4.736" (120.3)	6.299" (160)	.728" (18.5)	5.248" (133)	\$3600
170mm	<a href="#">V65 170A01800</a>	4.736" (120.3)	6.299" (160)	.728" (18.5)	5.118" (130)	\$3600

\* Limited to machine capacity. Additional lengths available. (millimeters in parentheses)



Work stop wrench V65-6DL05810 (65mm) is included with the 80mm spindle mount assembly to remove or install the work stop.



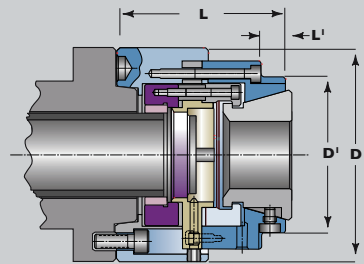
**80mm\*** Style A Spindle Mount:  
Pull-back style with removable dead-length work stop

Spindle Style	Part Number	D <sup>1</sup> - Diameter	D - Diameter	L <sup>1</sup> - Length	L - Length	Price
A2-5	<a href="#">V80 5A06600</a>	5.750" (146.1)	7.700" (195.6)	2.000" (50.8)	5.174" (131.4)	\$3800
A2-6	<a href="#">V80 6A06400</a>	5.750" (146.1)	7.700" (195.6)	2.000" (50.8)	5.174" (131.4)	\$3800
A2-8	<a href="#">V80 8A06500</a>	5.750" (146.1)	8.000" (203.2)	2.000" (50.8)	5.174" (131.4)	\$3800

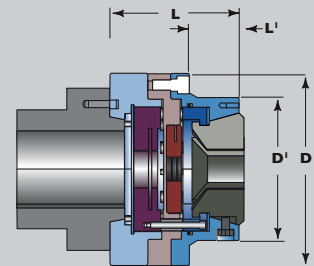
\* Limited to machine capacity. (millimeters in parentheses)

## BAR SLUG WORK

Dead Stop Included	<a href="#">V42 5A01006</a> (M12 X 1.75)
	<a href="#">V65 6A01206</a> (M12 X 1.75)
	<a href="#">V80 6A06407</a> (1" - 20)



42 and 65mm systems



80mm systems

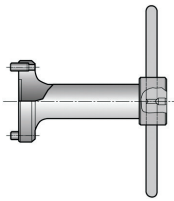
# STYLE DL – PUSH-TO-CLOSE DESIGN WITH A DEAD-LENGTH® WORKSTOP



## 42mm\* Style DL Spindle Mount: Push-to-Close with work stop

Spindle Style	Part Number	D' - Dia.	D - Dia.	L' - Length	L - Length	Price
A2-5 (1)	<a href="#">V42 5DL05400</a>	—	5.315" (135)	—	4.724" (120)	\$3400
A2-6 (2)	<a href="#">V42 6DL05500</a>	5.315" (135)	6.299" (160)	2.953" (75)	4.724" (120)	\$3400
I40mm (2)	<a href="#">V42 I40DL04400</a>	5.315" (135)	5.906 (150)	3.944 (100)	4.724" (120)	\$3400

\* Limited to machine capacity. (millimeters in parentheses)



Work stop wrench V42-5DL05410 (42mm) is included with the spindle mount assembly to remove or install the work stop.



## 65mm\* Style DL Low Profile Spindle Mount: Push-to-Close with work stop

Spindle Style	Part Number	D' - Dia.	D - Dia.	L' - Length	L - Length	Price
A2-5	<a href="#">V65 5DL05740</a>	5.404" (137.3)	6.299" (160)	1.448" (36.8)	4.845" (123)	\$3800
A2-6	<a href="#">V65 6DL05940</a>	5.404" (137.3)	6.299" (160)	1.448" (36.8)	4.845" (123)	\$3800
A2-8	<a href="#">V65 8DL06040</a>	5.404" (137.3)	8.268" (210)	1.448" (36.8)	5.345" (135.8)	\$3800
I40mm	<a href="#">V65 I40DL02440</a>	5.404" (137.3)	6.299" (160)	1.448" (36.8)	4.908" (124.6)	\$3800

\* Limited to machine capacity. (millimeters in parentheses)



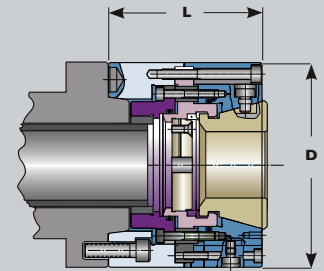
## 80mm\* Style DL Spindle Mount: Push-to-Close with work stop

Spindle Style	Part Number	D' - Dia.	D - Dia.	L' - Length	L - Length	Price
A2-5	<a href="#">V80 5DL06100</a>	5.950" (151.2)	7.700" (195.6)	1.354" (34.4)	4.957" (125.9)	\$4400
A2-6	<a href="#">V80 6DL06200</a>	5.950" (151.2)	7.700" (195.6)	1.354" (34.4)	4.957" (125.9)	\$4400
A2-8	<a href="#">V80 8DL06300</a>	5.950" (151.2)	8.250" (209.6)	1.354" (34.4)	5.207" (132.3)	\$4400
I40mm	<a href="#">V80 I40DL06400</a>	5.950" (151.2)	7.700" (195.6)	1.354" (34.4)	5.357" (136.1)	\$4400

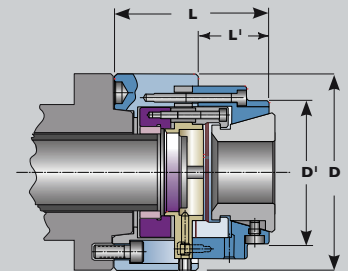
\* Limited to machine capacity. (millimeters in parentheses)

## BAR SLUG WORK

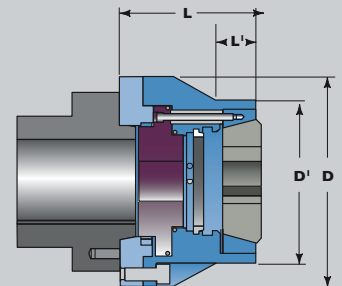
Dead Stop Included	<a href="#">V42 5DL05406</a> (M12 X 1.75)
	<a href="#">V65 6DL05836</a> (1" - 20 assembly)
	<a href="#">V80 6DL06213</a> (1" - 20 assembly)



Spindle Style 1



Spindle Style 2



65/80mm systems

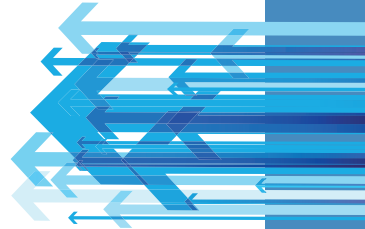
## QUALITY

Hardinge guarantees a collet head concentricity of .0002" (.005mm) TIR for round sizes after the segments are joined in the vulcanization process. Hardinge test results from repeated cycles of collet actuation assure long life of the Hardinge vulcanization process.

FlexC Capacity	Changing Wrench	Price
42mm	<a href="#">C_4200000-WREN</a>	\$495
65mm	<a href="#">C_65000-00-WREN</a>	\$495
80mm	<a href="#">C_80000-00-WREN</a>	\$550



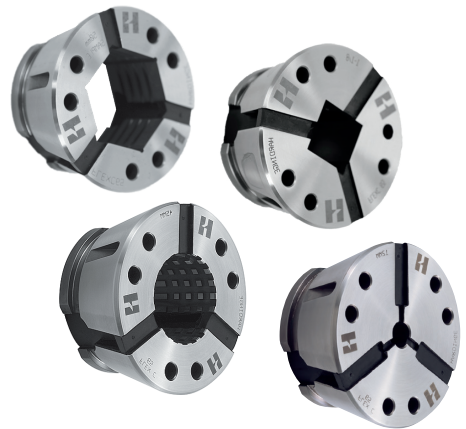
**LIFETIME  
GUARANTEE  
ON COLLET  
VULCANIZATION**



## FAST DELIVERY

Hardinge stocks an extensive inventory of finished collets for all common sizes. Semi-Finished inventory is also available allowing for decimal sized collets to be delivered in 5 days or less.

	Rated Capacity	Round Smooth/Serrated	Price	Hexagon Smooth/Serrated	Price	Square Smooth	Price
42mm	fractional	7/32 to 1 5/8"	\$242.25	5/16 to 1 3/8"	\$350	5/16 to 1 9/64"	\$350
	metric	5 to 42mm		8 to 36		8 to 29	
65mm	fractional	1/4 to 2 7/16"	\$297	5/16 to 2 1/8"	\$425	5/16 to 1 13/16"	\$425
	metric	5 to 65mm		8 to 56		8 to 46	
80mm	fractional	15/32 to 3 1/4"	\$414	15/32 to 2 3/4"	\$545	15/32 to 2 1/4"	\$545
	metric	12 to 82.5mm		12 to 69.9		12 to 57.2	



## CUSTOM MANUFACTURING

Hardinge's custom engineering department can design and manufacture special FlexC collets for any application. Sample applications include stepped holes, special shapes, off-center and more.



## EMERGENCY COLLETS

	Size / Pilot Hole	Part Number	Price	Boring Ring	Price
42mm	5mm Pilot	<a href="#">C0420000000005</a>	\$231	<a href="#">C042000000RING</a>	\$100
	15mm Pilot	<a href="#">C0420000000015</a>			
	30mm Pilot	<a href="#">C0420000000030</a>			
65mm	8mm Pilot	<a href="#">C0650000000008</a>	\$287	<a href="#">C065000000RING</a>	\$150
	20mm Pilot	<a href="#">C0650000000020</a>			
	40mm Pilot	<a href="#">C0650000000040</a>			
80mm	12mm Pilot	<a href="#">C0800000000012</a>	\$400	<a href="#">C080000000RING</a>	\$200
	25mm Pilot	<a href="#">C0800000000025</a>			
	40mm Pilot	<a href="#">C0800000000040</a>			



[C080000000RING](#)

# NEW ULTIMATE QUICK CHANGE FLEXIBILITY

FlexC 65 Adapters are ideal for shops looking for ultimate flexibility! Now in one setup a customer can use multiple workholding options, eliminating costly and time consuming changeovers!

In one setup you can use:

- FlexC Quick Change Collets
- 5C Collets
- Sure-Grip Expanding Collets
- 5C Step Chucks & Closers

## SINGLE SETUP

### FOR CNC LATHES



### MANUAL COLLET BLOCK




## FLEXC<sup>®</sup> COLLETS



When accuracy, grip range and grip strength is needed, FlexC collets are a perfect option. FlexC collets have .0002" TIR and +/- .020" grip range.

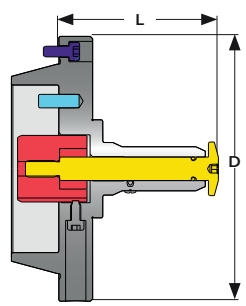
Capacity	Price
42mm	\$242
65mm	\$297
80mm	\$414

## STANDARD SURE-GRIP EXPANDING ADAPTERS



You can now utilize Hardinge's Sure-Grip expanding system in our FlexC 65 products! Hardinge<sup>®</sup> Sure-Grip<sup>®</sup> Expanding Collet Systems offer solutions to difficult machining problems where ID gripping is required. Sure-Grip collets have .015" expansion range and .0002" TIR.

Part Number*	Grip Range	D - Diameter	L - Length	Price
<a href="#">V65 2001000</a>	1/2" to 3/4"	4.891" (124.23)	2.087" (53.01)	\$600
<a href="#">V65 2501000</a>	3/4" to 1"	4.891" (124.23)	2.483" (63.07)	\$625
<a href="#">V65 3001000</a>	1" to 1 1/2"	4.891" (124.23)	2.947" (74.85)	\$650
<a href="#">V65 4001000</a>	1 1/2" to 2 1/4"	5.25" (133.35)	3.536" (89.81)	\$675
<a href="#">V65 5001000</a>	2 1/4" to 3"	5.25" (133.35)	4.274" (108.56)	\$700
<a href="#">V65 6001000</a>	3" to 4"	5.25" (133.35)	4.337" (110.16)	\$725



Sure-Grip Expanding Collet

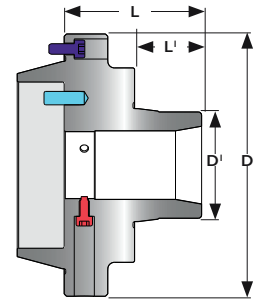
\* requires part number [V65 5C01000](#) for use.



# 5C COLLET ADAPTER



Hardinge's 5C Spindle tooling has been an industry standard for over 100 years. Customers can now utilize their 5C spindle tooling in our FlexC 65 system for applications that are ideally suited for these style collets. Ideal applications include extended nose, small hole, special shapes, Internal Gripping and more!

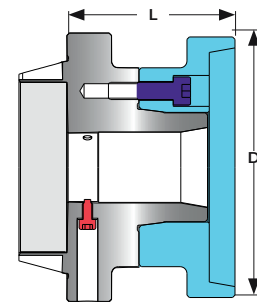
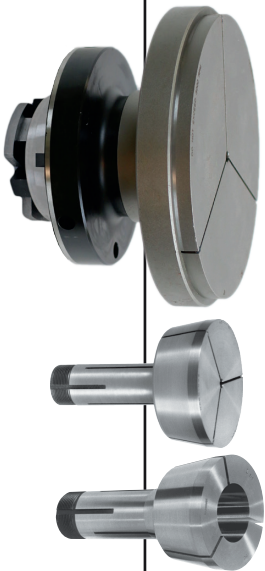


V65 5C01010

Item	Part Number	D <sup>1</sup> Diameter	D Diameter	L <sup>1</sup> Length	L Length	Price
5C Collet Adapter	<a href="#">V65 5C01010S</a>	1.984" (50.39)	4.891" (124.23)	1.25" (31.75)	2.5625" (65.09)	\$1600

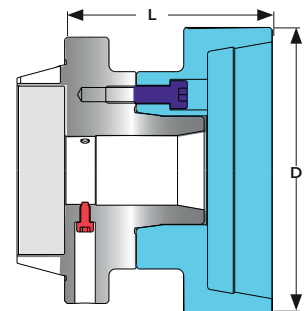
# STANDARD 5C STEP CHUCKS & A2-3 CLOSERS

Don't limit your machine setup to the capacity of the FlexC 65. With our 5C adapter, customers can now use Hardinge's Step Chucks and Closers allowing for part sizes of up to 6". Castings, moldings, stampings and machined parts are held rigidly and accurately. Tubing can be held without crushing or distorting. Accurate gripping, the same as with collets, is yours when you use regular and extra depth capacity step chucks for holding larger diameters.



A2-3 5C Adapter with 4 Closer

Item	Part Number	Step Chuck Size	D - Diameter	L - Length	Price
Regular Depth	<a href="#">V65 235C2RD</a>	2"	3.0625" (77.79)	3.0625" (77.79)	\$260
	<a href="#">V65 235C3RD</a>	3"	3.75" (95.25)	3.0625" (77.79)	\$280
	<a href="#">V65 235C4RD</a>	4"	4.75" (120.65)	3.0625" (77.79)	\$300
	<a href="#">V65 235C5RD</a>	5"	5.75" (146.05)	3.0625" (77.79)	\$350
	<a href="#">V65 235C6RD</a>	6"	6.75" (171.45)	3.0625" (77.79)	\$390



A2-3 5C Adapter with 4 ED Closer

Item	Part Number	A2-3 Closer Size	D - Diameter	L - Length	Price
Extra Depth	<a href="#">V65 235C2ED</a>	2"	3.625" (92.08)	3.8125" (96.84)	\$290
	<a href="#">V65 235C3ED</a>	3"	4.25" (107.95)	3.8125" (96.84)	\$310
	<a href="#">V65 235C4ED</a>	4"	5.25" (133.35)	3.8125" (96.84)	\$330
	<a href="#">V65 235C5ED</a>	5"	6.25" (158.75)	3.8125" (96.84)	\$380
	<a href="#">V65 235C6ED</a>	6"	7.25" (184.15)	3.8125" (96.84)	\$420

## MASTER COLLET & PADS

FlexC Style-S Master Collets	Part Number	Price	"S" Pad*	Round Smooth	Round Serrated	Hexagon Smooth	Square	Emergency	Semi-Hard
65mm	<a href="#">C0650S16MASTER</a>	\$275	S16	\$59.50	\$63	\$73.50	\$73.50	\$53.50	\$56.50
	<a href="#">C0650S20MASTER</a>	\$297	S20	\$79	\$83	\$102.50	\$102.50	\$74	\$76
	<a href="#">C0650S22MASTER</a>	\$320	S22	\$87	\$91.50	\$118	\$118	\$81	\$84
80mm	<a href="#">C0800S26MASTER</a>	\$414	S26	\$97.50	\$102	\$130	\$130	\$90.50	\$94.50
	<a href="#">C0800S30MASTER</a>	\$437	S30	\$131.50	\$144.50	\$163	\$163	\$125	\$128



	Part Number	Price
<b>S16, S20 and S26</b>		
B Clamp assy	<a href="#">7619</a>	\$7.20
B wrench	<a href="#">7637</a>	\$1.35
<b>S22 and S30</b>		
C Clamp assy	<a href="#">7627</a>	\$7.60
C wrench	<a href="#">7639</a>	\$2.30

## EJECTORS

### Hardinge Spring Part Ejectors

Hardinge's standard spring ejectors are used to push a part into the parts catcher or conveyor when finished. These standard spring ejectors have a limited amount of stroke and apply consistent force, regardless of part size.



Part Number	Chuck Model	Price
<a href="#">105700000042A</a>	42A	\$250
<a href="#">105700000042DL</a>	42DL	\$250
<a href="#">105700000065A</a>	65A	\$300
<a href="#">327300000065DL</a>	65DL	\$300
<a href="#">327300000080A</a>	80A	\$350
<a href="#">327300000080DL</a>	80DL	\$350

A= Pull back w/stop; DL= Dead length

### Long Stroke, Variable Speed Part Ejector

The Hardinge JL-Series Variable Speed Part Ejector is used when maximum stroke and flexibility is needed. This part ejector has 4.4" of stroke and allows users to adjust the rate of speed at which the ejection rod will push the part out, making sure the part is ejected exactly how you want every time!



Part Number	Chuck Model	Price
Long Stroke, Variable Speed		
<a href="#">JL 000100065A</a>	65A	\$1200
<a href="#">JL 000100065DL</a>	65DL	\$1200
<a href="#">JL 000100080A</a>	80A	\$1200
<a href="#">JL 000100080DL</a>	80DL	\$1200

A= Pull back w/stop; DL= Dead length

Patent Pending

### FlexC Part Stops

A part stop is used to accurately locate z-axis positioning of slug work within a collet. These easy to install stops are adjustable for desired part length. The rigid design of these part stops allows peace of mind knowing that your part length will remain consistent part to part.



Part Number	Chuck Model	Price
Solid Stops		
<a href="#">V42 5A01011</a>	42A	\$150
<a href="#">V42 5DL05411</a>	42DL	\$150
<a href="#">V65 6A01211</a>	65A	\$175
<a href="#">V65 6DL05836</a>	65DL	\$175
<a href="#">V80 6A06408</a>	80A	\$200
<a href="#">V80 6DL06213</a>	80DL	\$200

A= Pull back w/stop; DL= Dead length

## SAME-DAY SHIPPING

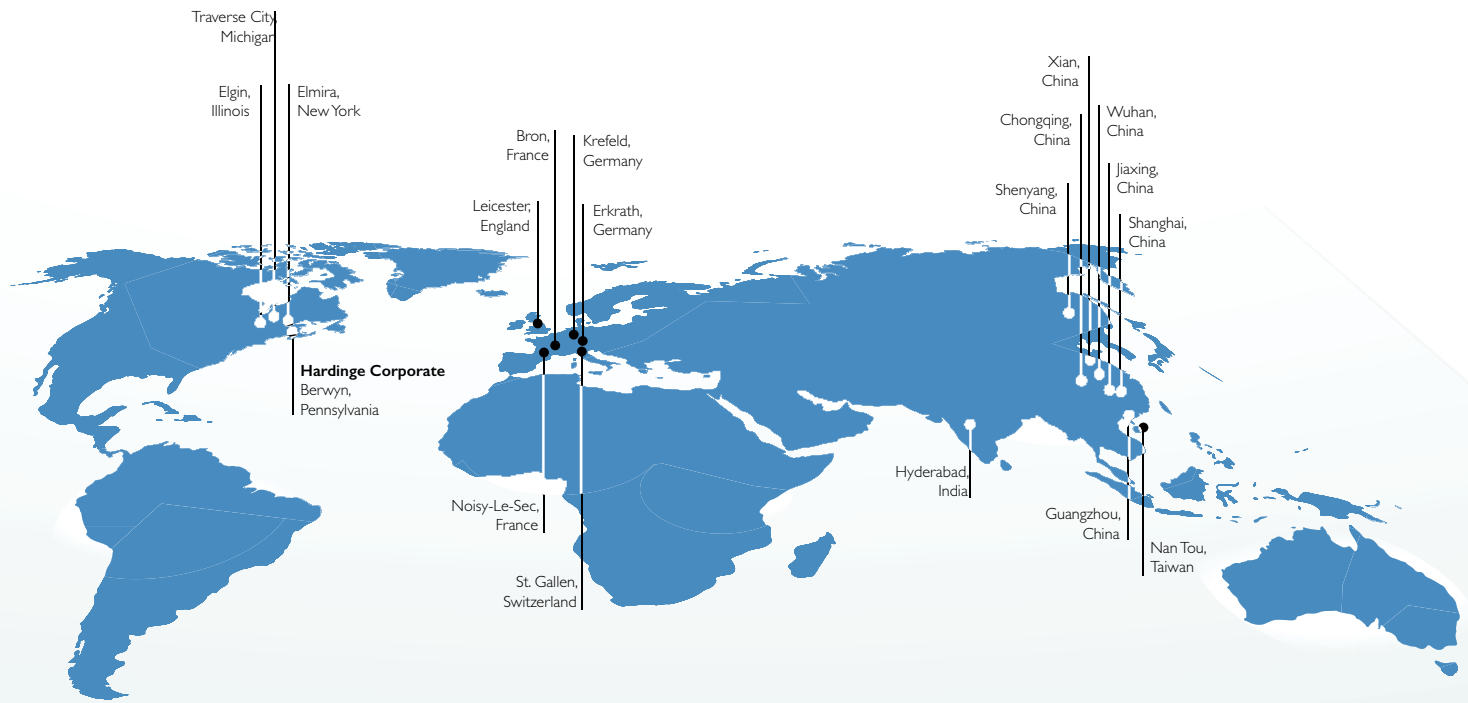
- Hardinge holds to a strict 95% same day ship rate for all standard Workholding products. Serving our customer requests quickly is our goal.
  - Hardinge stocks more than 15,000 Workholding SKUs in our in-house inventory. We ship every day, all day, to serve our customers.
- 

## CUSTOMER SUPPORT

- Our fully staffed team of experienced customer service representatives will help you from product identification to shipment.
- Accomplished Engineers, averaging over 20 years of service to the industry, making that special application easy for you.

# SHOPHARDINGE.COM





## HARDINGE COMPANIES WORLDWIDE

Hardinge is a leading international provider of advanced metal-cutting solutions. We provide a full spectrum of highly reliable CNC turning, milling, and grinding machines as well as technologically advanced workholding accessories.

The diverse products we offer enable us to support a variety of market applications in industries including aerospace, agricultural, automotive, construction, consumer products, defense, energy, medical, technology, transportation and more.

We've developed a strong global presence with manufacturing operations in North America, Europe, and Asia. Hardinge applies its engineering and applications expertise to provide your company with the right machine tool solution and support every time.

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