



WORKHOLDING

## HARDINGE Collet Chuck System



[www.hardinge.com](http://www.hardinge.com)

 **HARDINGE®**

## FlexC™ Collet Systems



# FlexC™

Collet changeover in less than **10 seconds**

Compare to your current changeover:

Standard Collet Chuck: 79 seconds

Chuck Jaws (3): 191 seconds

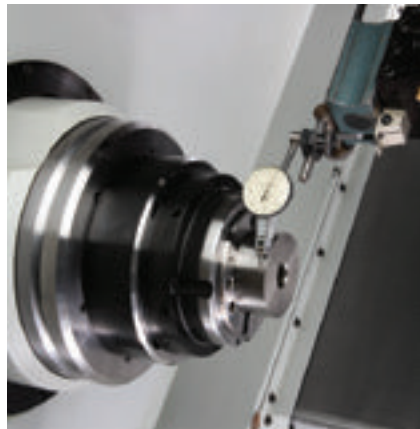
**We did the math**, now you make the profit.

### Gripping Range $\pm .020''$

A typical FlexC collet head has a gripping range of  $\pm .020''$  (.5mm) above and below its nominal size to allow variation in bar stock without having to change out the collet.

### Productivity Replacement for 3-jaw Chucks

When compared to a jaw chuck, the reduction in weight and the efficient design of the FlexC Collet System allow you to increase the spindle rpm without concern for centrifugal forces. Advanced cutting tools, along with faster speeds and feeds, can now be used to boost your productivity. The interferences associated with jaw chucks are nonexistent with the clean contours of the FlexC Collet System.



### Accuracy up to $.0004''$ TIR

Hardinge guarantees accuracy within  $.0004''$  (.010mm) TIR for the collet system models A and D and  $.0008''$  (.020mm) TIR for style DL.

The FlexC system offers quick-change flexibility without compromise.

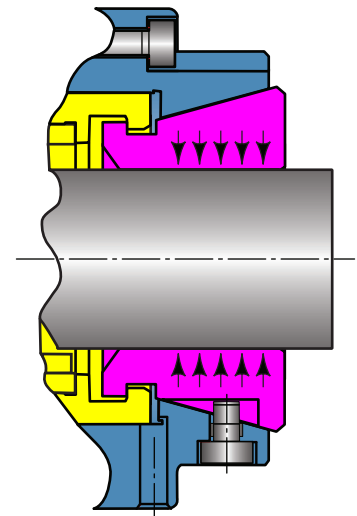
## QUICK CHANGE SYSTEM

### Machine Compatibility and Flexibility

The precision-engineered Hardinge® FlexC Collet Systems mount to A2-5, A2-6, A2-8 and select flat-back spindle noses. Pull-back thru-hole, pull-back dead-length® and push-to-close dead-length® styles are available for single and dual-spindle CNC lathes.

One spindle mount... a multitude of part diameters. Purchase one spindle mount and interchange vulcanized collet heads from job to job. Hardinge collet heads are fully interchangeable with competitor's models.

Out performs standard collet chucks and jaw chucks with faster job changeover.



### True Parallel Gripping

There is no collet shank. The collet segments remain parallel to the stock even when there are variations in the stock size minimizing "push back".

## Style D – pull-back with thru hole

### Style D is a pull-back design with a thru hole for bar work

Since there is no work stop in this design, this style is not recommended for chucking parts.



Spindle mount, collet and wrench each sold separately.  
A drawbar linkup must be machined to fit the drawbar of the lathe.



#### 42mm\* Style D Spindle Mount: Pull-back style with thru-hole

Spindle Style	Part Number	D' - Diameter	D - Diameter	L' - Length	L - Length
A2-5	V425 D00300	4.016" (102)	5.512" (140)	.846" (21.5)	3.543" (90)
A2-6	V426 D00400	4.016" (102)	6.496" (165)	.846" (21.5)	3.543" (90)
I40mm	V42140 D01700	4.016" (102)	5.906" (150)	.846" (21.5)	3.543" (90)

\* Limited to machine capacity.

(millimeters in parentheses)



#### 65mm\* Style D Spindle Mount: Pull-back style with thru-hole

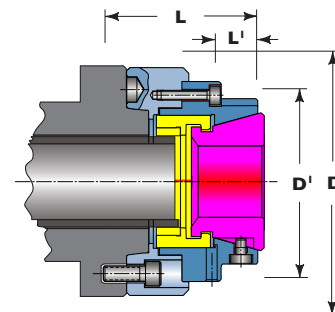
Spindle Style	Part Number	D' - Diameter	D - Diameter	L' - Length	L - Length
A2-5	V655 D00500	4.736" (120.3)	6.102" (155)	1.043" (26.5)	3.740" (95)
A2-6	V656 D00600	4.736" (120.3)	6.496" (165)	1.043" (26.5)	3.740" (95)
A2-8	V658 D00700	4.736" (120.3)	8.268" (210)	1.043" (26.5)	3.858" (98)
I40mm	V65140 D01900	4.736" (120.3)	6.299" (160)	1.043" (26.5)	3.937" (100)

\* Limited to machine capacity.

(millimeters in parentheses)

### Manufacturing process control for Hardinge FlexC Systems — Made in the U.S.A.

Hardinge spindle mounts are turned on a rugged Hardinge GS 200 turning center while the ODs and IDs are finish-ground on a high-precision Kellenberger® grinding machine. A time-proven heat treat process guarantees hardness and tempering for a long life without breakage.



## Style A – pull-back design

### Style A is a pull-back design with a Dead-length® workstop.

The collet draws in the part against a stationary workstop for part length control. You can easily “short grip” parts by machining a special work stop to the desired length. The Hardinge work stop is removable for bar work.



Spindle mount, collet and wrench each sold separately.  
A drawbar linkup must be machined to fit the drawbar of the lathe.



#### 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
A2-5	V425 A01000	4.016" (102)	5.512" (140)	.610" (15.5)	4.764" (121)
A2-6	V426 A01100	4.016" (102)	6.496" (165)	.610" (15.5)	4.764" (121)
140mm	V42140 A01600	4.016" (102)	5.906" (150)	.610" (15.5)	4.961" (126)

\* 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
A2-5	V655 A01200	4.736" (120.3)	6.102" (155)	.728" (18.5)	5.118" (130)
A2-6	V656 A01300	4.736" (120.3)	6.496" (165)	.728" (18.5)	5.118" (130)
A2-8	V658 A01400	4.736" (120.3)	8.268" (210)	.728" (18.5)	5.315" (135)
140mm	V65140 A02300	4.736" (120.3)	6.299" (160)	.728" (18.5)	5.248" (133)
170mm	V65170 A01800	4.736" (120.3)	6.299" (160)	.728" (18.5)	5.118" (130)

\* Limited to machine capacity.

(millimeters in parentheses)



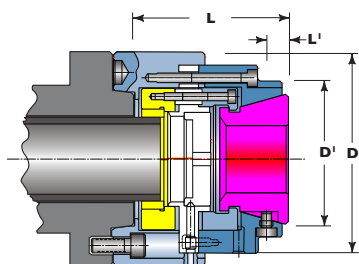
#### 80mm\* Style A Spindle Mount:

Pull-back style with removable dead-length work stop

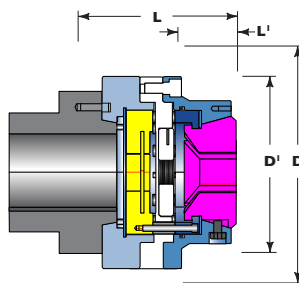
Spindle Style	Part Number	D <sup>1</sup> - Diameter	D - Diameter	L <sup>1</sup> - Length	L - Length
A2-6	V806 A06400	5.750" (146.1)	7.700" (195.6)	2.000" (50.8)	5.174" (131.4)
A2-8	V808 A06500	5.750" (146.1)	8.000" (203.2)	2.000" (50.8)	5.174" (131.4)

\* Limited to machine capacity.

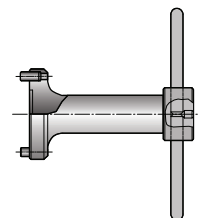
(millimeters in parentheses)



42 and 65mm systems



80mm systems



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



## Style DL – push-to-close design

### Style DL is a push-to-close design with a Dead-length® workstop.

The collet and work stop are both stationary in the style DL Dead-Length spindle mount design to provide precise length control of the workpiece. This feature makes it possible to accurately transfer parts from one spindle to the other within .0005" (.0127mm), eliminating problems such as drive default or drag marks on the part. \*\*Workstop is available but not included with the 80mm spindle mount.



Spindle mount, collet and wrench each sold separately.  
A drawbar linkup must be machined to fit the drawbar of the lathe.



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

Spindle Style	Part Number	D' - Dia.	D - Dia.	L' - Length	L - Length
A2-5 (1)	V425 DL05400	—	5.315" (135)	—	4.724" (120)
A2-6 (2)	V426 DL05500	5.315" (135)	6.299" (160)	2.953" (75)	4.724" (120)
140mm (2)	V42140 DL04400	5.315" (135)	5.906 (150)	3.944 (100)	4.724" (120)

\* Limited to machine capacity.

(millimeters in parentheses)



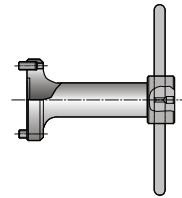
#### 65mm\* Style DL Spindle Mount: Push-to-Close with work stop

Spindle Style	Part Number	D' - Dia.	D - Dia.	L' - Length	L - Length
A2-5 (1)	V655 DL05700	—	6.299" (160)	—	4.921" (125))
A2-6 (1)	V656 DL05900	—	6.299" (160)	—	4.724" (120)
A2-8 (2)	V658 DL06000	6.299" (160)	8.268" (210)	2.402" (61)	4.921" (125)
140mm (1)	V65140 DL02400	—	6.299" (160)	—	5.157" (131)

\* Limited to machine capacity.

(millimeters in parentheses)

Work stop wrench V65-6DL05810 (65mm) or V42-5DL05410 (42mm) is included with the spindle mount assembly to remove or install the work stop.

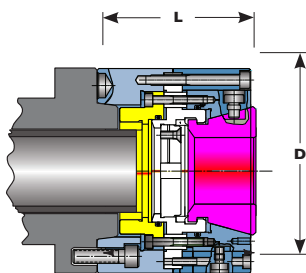


#### 80mm\* Style DL Spindle Mount: Push-to-Close

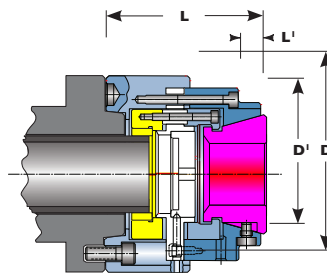
Spindle Style	Part Number	D' - Dia.	D - Dia.	L' - Length	L - Length
A2-6	V806 DL06200	5.950" (151.2)	7.700" (195.6)	1.354" (34.4)	4.957" (125.9)
A2-8	V808 DL06300	5.950" (151.2)	8.250" (209.6)	1.354" (34.4)	5.207" (132.3)

\* Limited to machine capacity.

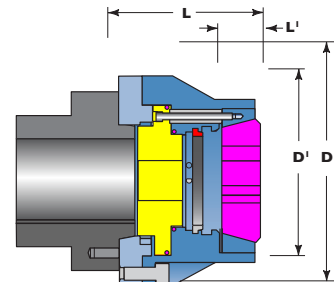
(millimeters in parentheses)



Spindle Style 1



Spindle Style 2

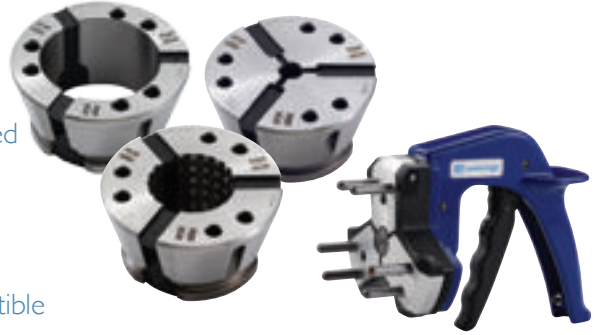


80mm systems

## FlexC™ Collets & Accessories



- Round smooth
- Round serrated
- Hexagon serrated
- Square smooth
- Emergency style
- Masters
- Industry Compatible



### Manufacturing process control in a dedicated work cell environment

Hardinge has invested in the latest vulcanizing machines made by DESMA, a world leader in injection molding technology. The vulcanization process joins the collet segments together as a one-piece unit. Vulcanized rubber has elasticity for repeated opening and closing over the life of the collet that makes it ideal for a quick-change product. It will not become brittle and is resistant to coolant. It also prevents chips from entering the collet system. Hardinge test results from repeated cycles of collet actuation assure long life of the Hardinge vulcanization process.

Hardinge guarantees a collet head concentricity of .0002" (.005mm) TIR for round sizes after the segments are joined in the vulcanization process. Collets change in just seconds!

FlexC Collets	Round Smooth	Round Serrated	Hexagon Serrated	Square Smooth	Manual Wrench
<b>42mm</b> Inch Part Numbers	C0-4200-19	C0-4200-59	C0-4200-69	C0-4200-39	C 4200000-WREN
$\frac{1}{16}$ " increments *	$\frac{7}{32}$ to $1\frac{5}{8}$ "	$\frac{7}{32}$ to $1\frac{5}{8}$ "	$\frac{5}{16}$ to $1\frac{3}{8}$ "	$\frac{5}{16}$ to $1\frac{3}{8}$ "	—
<b>42mm</b> Metric Part Numbers	C0-4200-17	C0-4200-57	C0-4200-67	C0-4200-37	C 4200000-WREN
1mm increments *	5 to 42	5 to 42	8 to 36	8 to 29	—
<b>65mm</b> Inch Part Numbers	C0-6500-19	C0-6500-59	C0-6500-69	C0-6500-39	C 6500000-WREN
$\frac{1}{16}$ " increments *	$\frac{1}{4}$ to $2\frac{9}{16}$ "	$\frac{1}{4}$ to $2\frac{9}{16}$ "	$\frac{5}{16}$ to $2\frac{1}{8}$ "	$\frac{5}{16}$ to $1\frac{13}{16}$ "	—
<b>65mm</b> Metric Part Numbers	C0-6500-17	C0-6500-57	C0-6500-67	C0-6500-37	C 6500000-WREN
1mm increments *	5 to 65	5 to 65	8 to 56	8 to 46	—
<b>80mm</b> Inch Part Numbers	C0-8000-19	C0-8000-59	C0-8000-69	C0-8000-39	C 8000000-WREN
$\frac{1}{16}$ " increments *	$\frac{15}{32}$ to $3\frac{1}{4}$ "	$\frac{3}{4}$ to $3\frac{1}{4}$ "	$\frac{15}{32}$ to $2\frac{3}{4}$ "	$\frac{15}{32}$ to $2\frac{1}{4}$ "	—
<b>80mm</b> Metric Part Numbers	C0-8000-17	C0-8000-57	C0-8000-67	C0-8000-37	C 8000000-WREN
1mm increments *	12 to 82.5	19 to 82.5	12 to 69.9	12 to 57.2	—

\* limited to maximum bar capacity of your machine for thru-hole bar work.

FlexC Style-S Master Collets	S16	S20	S22	S26	S30
<b>65mm</b>	C0650S16MASTER	C0650S20MASTER	C0650S22MASTER	—	—
<b>80mm</b>	—	—	—	C0800S26MASTER	C0800S30MASTER



Emergency Collets Size / Pilot Hole	Emergency Collet Part Number	Manual Wrench Part Number	Boring Ring Part Number
<b>42mm</b> / 5mm Pilot	C0420000000005	C 4200000 WREN	C0420000000RING
<b>42mm</b> / 15mm Pilot	C0420000000015	C 4200000 WREN	C0420000000RING
<b>42mm</b> / 30mm Pilot	C0420000000030	C 4200000 WREN	C0420000000RING
<b>65mm</b> / 8mm Pilot	C0650000000008	C 6500000 WREN	C0650000000RING
<b>65mm</b> / 20mm Pilot	C0650000000020	C 6500000 WREN	C0650000000RING
<b>65mm</b> / 40mm Pilot	C0650000000040	C 6500000 WREN	C0650000000RING
<b>80mm</b> / 12mm Pilot	C0800000000012	C 8000000 WREN	C0800000000RING
<b>80mm</b> / 25mm Pilot	C0800000000025	C 8000000 WREN	C0800000000RING
<b>80mm</b> / 40mm Pilot	C0800000000040	C 8000000 WREN	C0800000000RING

### Custom Manufacturing

Standard collets are stocked in round smooth, round serrated and hex shape. Square sizes are made to order. Anything between the size increments shown below can be custom manufactured. Other special applications include stepped holes, special shapes, off-center, etc. that can be made from stock blanks.

## Collet Adaptation Chucks

WHY WOULD I WANT TO USE COLLETS ON MY JAW-CHUCK LATHE?

### To Increase Productivity over 3-Jaw Chucks

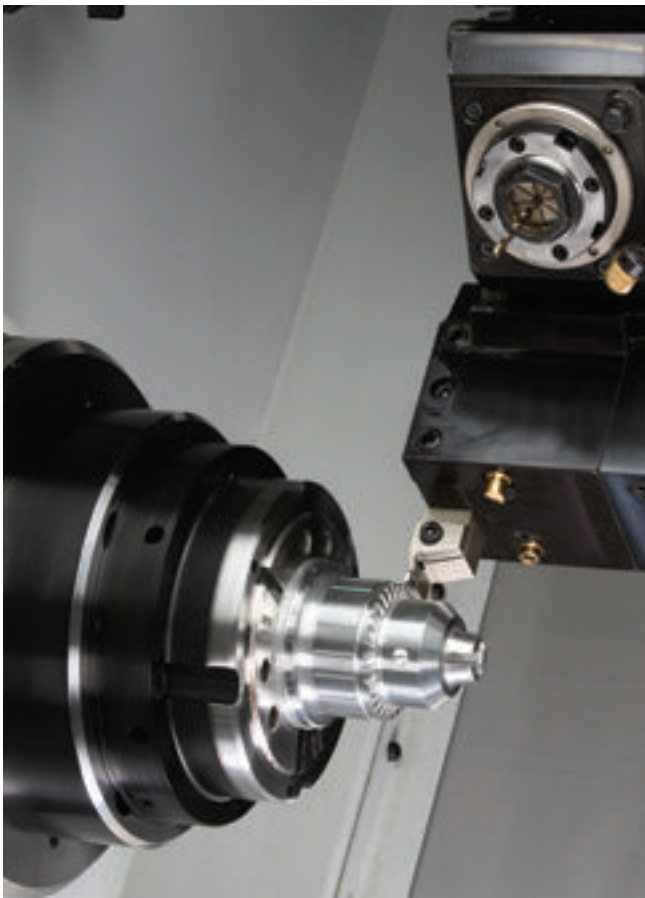
- Faster job changeover using collets:  
—5C, 16C, 3J, S15, S20, S26, S30
- Higher spindle speeds for reduced cycle times

### To Increase Capability over 3-Jaw Chucks

- More work envelope to machine longer workpieces
- Achieve higher precision
- Interchangeable Style “S” master pads accommodate a wide range of workpiece sizes and configurations

### To Increase Control over 3-Jaw Chucks

- Exact part length control
- Improved concentricity for optimum part roundness



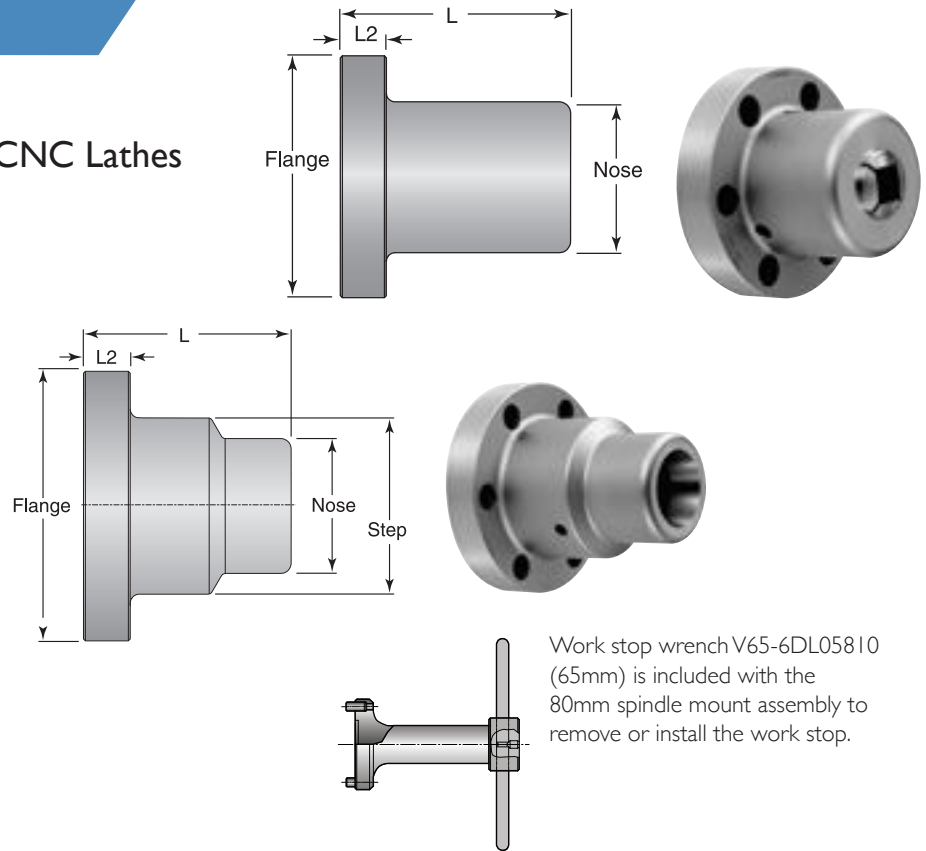
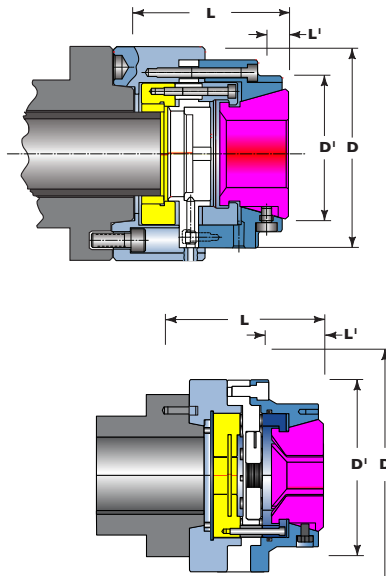
Additionally, centrifugal force is not an issue with Collet Adaptation Chucks. Your machine can operate at the maximum rpm your tooling will allow. Higher rpm means more pieces per hour and higher profits. Review our brochure and select the HCAC Collet Adaptation Chuck that best meets your requirements.

Link-ups can be designed to fit your specific machine. The same link-up can then be used for the entire line of workholding elements including internal Sure-Grip® Collet applications.

Custom-manufacturing available, please call 800-843-8801.

## Plain and Stepped Nose Dimensions

### Collet Adaptation Chucks for CNC Lathes



### Collet Adaptation Chucks Plain and Stepped - Dimensions

Spindle-to-Collet	Assembly Part Number	Spindle	Length L	Length L2	Flange OD	Step OD	Nose OD	Collet Thru-Capacity
A2-4 5C	97Z0000907176N	A2-4	3.500" (88.90)	0.937" (23.80)	4.250" (107.95)	—	2.500" (63.50)	1.0625" (26.98)
A2-5 5C-35	78010000000000	A2-5	3.500" (88.90)	1.000" (25.40)	5.250" (133.35)	—	3.250" (82.55)	1.0625" (26.98)
A2-5 5C-50	78030000000000	A2-5	5.000" (127.00)	1.000" (25.40)	5.250" (133.35)	—	3.250" (82.55)	1.0625" (26.98)
A2-5 16C-60	78170000000000	A2-5	6.000" (152.40)	1.000" (25.40)	5.250" (133.35)	—	3.250" (82.55)	1.625" (41.27)
A2-5 3J-55	78110000000000	A2-5	5.500" (139.70)	1.000" (25.40)	5.250" (133.35)	—	3.250" (82.55)	1.750" (44.45)
A2-6 5C-50	78050000000000	A2-6	5.000" (127.00)	1.125" (28.57)	6.500" (165.10)	4.250" (107.95)	3.250" (82.55)	1.0625" (26.98)
A2-6 5C-60	78070000000000	A2-6	6.000" (152.40)	1.125" (28.57)	6.500" (165.10)	4.250" (107.95)	3.250" (82.55)	1.0625" (26.98)
A2-6 16C*	97Z0000905659P	A2-6	4.750" (120.65)	1.125" (28.57)	6.500" (165.10)	4.250" (107.95)	3.250" (82.55)	1.625" (41.27)
A2-6 16C-60	78190000000000	A2-6	6.000" (152.40)	1.125" (28.57)	6.500" (165.10)	4.250" (107.95)	3.250" (82.55)	1.625" (41.27)
A2-6 3J-60	78130000000000	A2-6	6.000" (152.40)	1.125" (28.57)	6.500" (165.10)	4.250" (107.95)	3.250" (82.55)	1.750" (44.45)
A2-6 20C	97Z0000908289M	A2-6	8.000" (203.20)	1.125" (28.57)	6.500" (165.10)	—	4.250" (107.95)	2.000" (50.80)
A2-8 16C	97Z0000904853M	A2-8	6.500" (165.10)	1.250" (31.75)	8.250" (209.55)	5.500" (139.70)	3.250" (82.55)	1.625" (41.27)
A2-8 3J-60	78150000000000	A2-8	6.000" (152.40)	1.250" (31.75)	8.250" (209.55)	5.500" (139.70)	3.250" (82.55)	1.750" (44.45)
A2-8 20C	97Z0000905693P	A2-8	5.834" (148.18)	1.750" (44.45)	8.250" (209.55)	—	4.280" (108.71)	2.000" (50.80)
A2-8 20C	97Z0000908340N	A2-8	8.000" (203.20)	1.250" (31.75)	8.250" (209.55)	—	5.500" (139.70)	2.000" (50.80)
A2-8 25C	97Z0000906395N	A2-8	7.450" (189.23)	1.250" (31.75)	8.250" (209.55)	5.500" (139.70)	4.700" (119.38)	2.559" (64.99)

Note: A link-up adapter is required for these chucks. (Millimeters in Parentheses)

\* For sub-spindle application.

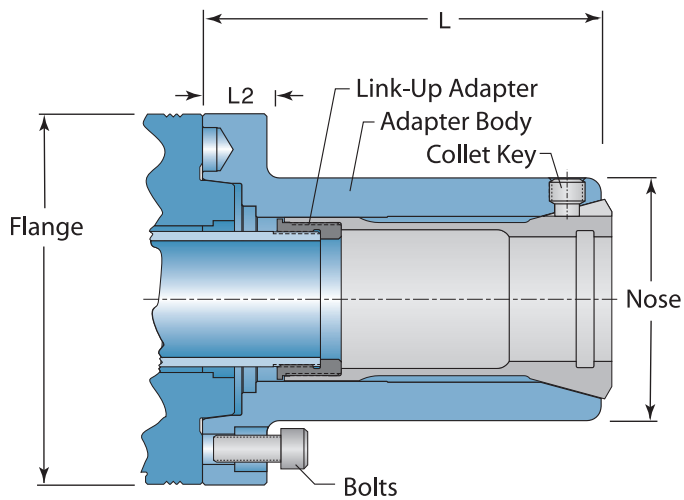
### Collet and Collet Slot Spanners

Collet Style	Precision-machined Round Collet Part No.	Collet Slot Spanner Part Number	Collet Spanner Replacement Finger Set
5C	10010019 Size	78990000000000	7899000000FNCR
16C	17170019 Size	79010000000003J	7901000000FNCR
20C	17010019 Size	79010000000020C	7901000000FNCR
25C	18010019 Size	79010000000025C	7901000000FNCR
3J	15930019 Size	79010000000003J	7901000000FNCR





## Collet Adaptation Chucks for CNC Lathes



Collets and pads sold separately unless indicated otherwise.

## Collet Adaptation Chucks Plain and Stepped - Dimensions

Spindle-to-Collet	Assembly Part Number	Spindle	Length L	Length L2	Flange OD	Nose OD	Collet Thru-Capacity
A2-5 S15-55	78230000000000	A2-5	5.500" (139.70)	1.000" (25.40)	5.250" (133.35)	3.250" (82.55)	1.500" (38.10)
A2-6 S20	783700000000200*	A2-6	5.500" (139.70)	1.125" (28.57)	6.500" (165.10)	4.250" (107.95)	2.000" (50.80)
A2-6 S20-65	97Z0000908332N	A2-6	6.500" (165.10)	1.125" (28.57)	6.500" (165.10)	4.250" (107.95)	2.000" (50.80)
A2-6 S20-70	97Z0000905798P	A2-6	7.000" (177.80)	1.125" (28.57)	6.500" (165.10)	4.250" (107.95)	2.000" (50.80)
A2-6 S20	97Z0000908955N	A2-6	8.000" (203.20)	1.125" (28.57)	6.500" (165.10)	4.250" (107.95)	2.000" (50.80)
A2-6 S26	97Z0000908460P*	A2-6	5.620" (142.74)	1.125" (28.57)	6.500" (165.10)	5.250" (133.35)	2.625" (66.67)
A2-6 S26-65	97Z0000909619N*	A2-6	6.500" (165.10)	1.125" (28.57)	6.500" (165.10)	5.250" (133.35)	2.625" (66.67)
A2-6 S26-75	97Z0000907028P*	A2-6	7.500" (190.50)	1.125" (28.57)	6.500" (165.10)	5.250" (133.35)	2.625" (66.67)
A2-6 S30	97Z0000907816N*	A2-6	7.125" (180.98)	1.125" (28.57)	6.500" (165.10)	5.500" (139.70)	3.000" (76.20)
A2-8 S26	783700000000300*	A2-8	6.250" (158.75)	1.250" (31.75)	8.250" (209.55)	5.500" (139.70)	2.625" (66.67)
A2-8 S26-75	97Z0000902170M	A2-8	7.500" (190.50)	1.250" (31.75)	8.250" (209.55)	5.500" (139.70)	2.625" (66.67)
A2-8 S26	97Z0000902557M	A2-8	8.500" (215.90)	1.250" (31.75)	8.250" (209.55)	5.500" (139.70)	2.625" (66.67)
A2-8 S30	97Z0000909352P*	A2-8	7.125" (180.97)	1.250" (31.75)	8.250" (209.55)	5.500" (139.70)	3.000" (76.20)
A2-11 S26	97Z0000906444P	A2-11	9.250" (234.95)	4.750" (120.65)	11.000" (279.40)	5.500" (139.70)	2.625" (66.67)

Note: Collet Chucks require a link-up.

\* Master collet included with collet adaptation chuck. Pads sold separately.  
(Millimeters in Parentheses)

## Collet Slot Spanners

Collet Style	Collet Slot Spanner Part Number	Collet Spanner Replacement Finger Set
S15	790100000000S15	7899000000015 FNG
S20	790100000000S20	79010000000S FNG
S26	790100000000S26	79010000000S FNG
S30	790100000000S30	79010000000S FNG

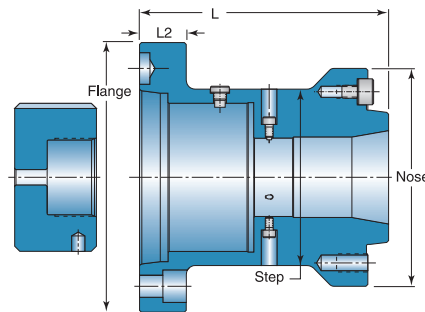


## Spindle-to-Spindle

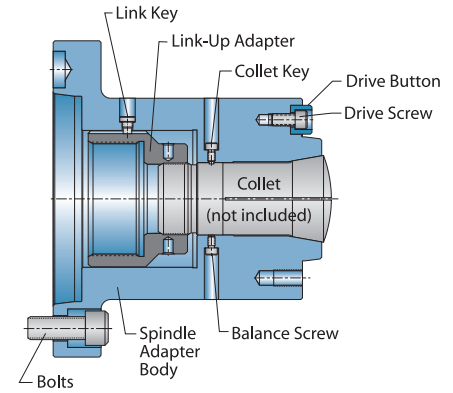
### Collet Adaptation Chucks for CNC Lathes



A2-6 to A2-5 16C  
Collets Sold Separately



A2-6 to A2-5 16C



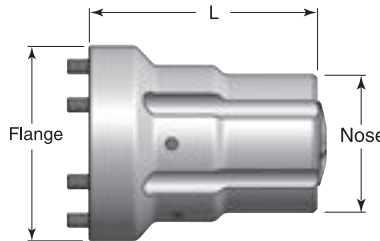
A2-8 to A2-5 16C

### Spindle-to-Spindle Collet Adaptation Chucks - Dimensions

Spindle-to- Collet	Assembly Part Number	Spindle	Length L	Length L2	Flange OD	Nose OD	Thru-Capacity
A2-5 to A2-5 16C	78330000000000	A2-5	6.125" (155.57)	—	5.250" (133.35)	—	1.625" (41.27)
A2-6 to A2-5 16C	79030000000000	A2-6	6.000" (152.40)	1.125" (28.57)	6.500" (165.10)	5.250" (133.35)	1.625" (41.27)
A2-6 to A2-6 20C	97Z0000900310M	A2-6	8.000" (203.20)	1.125" (28.57)	6.500" (165.10)	6.500" (165.10)	2.000" (50.80)
A2-6 to A2-6 20C	97Z0000906695K	A2-6	8.650" (219.71)	1.125" (28.57)	6.500" (165.10)	6.500" (165.10)	2.000" (50.80)
A2-8 to A2-5 16C	97Z0000900546N	A2-8	6.000" (152.40)	1.250" (31.75)	8.250" (209.55)	5.250" (133.35)	1.625" (41.27)
A2-8 to A2-5 16C	97Z0000908557P	A2-8	7.000" (177.80)	1.250" (31.75)	8.250" (209.55)	5.250" (133.35)	1.625" (41.27)

Note: Collet Chucks require a link-up.

(Millimeters in Parentheses)



### Dead-Length Collet Adaptation Chuck – Lathe Collets

Spindle-to-Collet	Assembly Part Number	Spindle	OAL L	Flange OD	Nose OD	Thru-Capacity
<b>5C Standard 5C Collets</b>						
A5-5C-DL	7803000000005HB	A2-5	5.250" (133.35)	5.250" (133.35)	2.500" (63.50)	1.062" (26.97)
A6-5C-DL	7805000000005HB	A2-6	5.750" (146.05)	6.500" (165.10)	2.500" (63.50)	1.062" (26.97)
<b>16C Standard 16C Collets</b>						
A6-16C-DL	7819000000005HB	A2-6	6.750" (171.45)	6.500" (165.10)	3.750" (95.25)	1.625" (41.27)
A8-16C-DL	7821000000005HB	A2-8	6.750" (171.45)	8.250" (209.55)	3.750" (95.25)	1.625" (41.27)
<b>16C Small Body, Standard 16C Collets</b>						
A5-16C-DLS	7817000000005HB	A2-5	6.125" (155.58)	5.250" (133.35)	3.375" (85.73)	1.625" (41.27)
<b>3J Standard 3J Collets</b>						
A6-3J-DL	7813000000005HB	A2-6	6.187" (157.14)	6.500" (165.10)	3.750" (95.25)	1.750" (44.45)
A8-3J-DL	7815000000005HB	A2-8	6.187" (157.14)	8.250" (209.55)	3.750" (95.25)	1.750" (44.45)
<b>3J Small Body, Standard 3J Collets</b>						
A5-3J-DLS	7811000000005HB	A2-5	5.562" (141.27)	5.250" (133.35)	3.750" (95.25)	1.750" (44.45)

Note: Overall Length (OAL) is for chuck assembly only. OAL may vary depending on spindle mount.

(Millimeters in Parentheses)

## Request for Machine Spindle and Drawbar Information

Drawbar Linkups are required for mounting Hardinge Chucks and Collet Adaptation Chucks including the FlexC™ Collet System to CNC lathes. Fill in the requested information and dimensions corresponding to the illustration if you would like Hardinge to machine the drawbar linkup for your specific application. You may contact Hardinge for a preliminary quote prior to filling out this form at 800-843-8801.

Company

Contact Name

Address

City, State, Zip

Phone

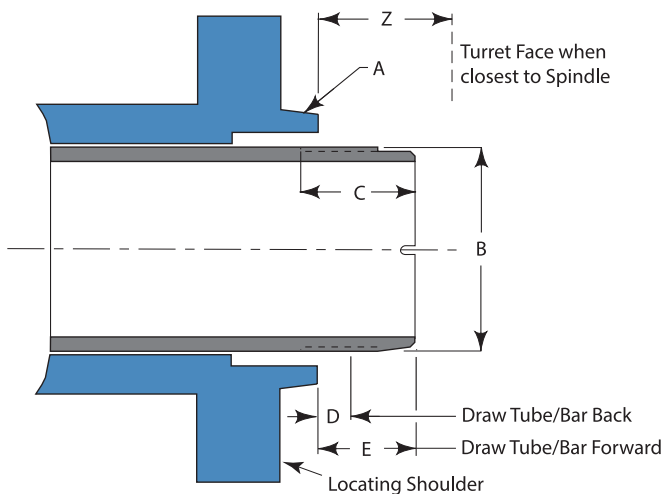
Fax

Machine Manufacturer

Machine Model

Actuator Manufacturer

FlexC™ System Part Number



A. Spindle Configuration

☐ A2-5 ☐ A2-6 ☐ A2-8

or other \_\_\_\_\_

B. Draw Tube / Bar Thread

☐ Left-hand or ☐ Right-hand  
☐ Internal or ☐ External Thread

C. Length of Thread \_\_\_\_\_

D/E. Distance from front of spindle to front of draw tube / bar when forward and retracted.

(Indicate positive {+} if the draw tube / bar is in front of the spindle face, or negative {-} if behind the spindle face)

D. Retracted (back) \_\_\_\_\_

E. Forward \_\_\_\_\_

Z. Turret Face when closest to Spindle \_\_\_\_\_

Email this form to [orders@hardinge.com](mailto:orders@hardinge.com) or fax to Hardinge Customer Service at 607.734.3886  
[www.ShopHardinge.com](http://www.ShopHardinge.com)  
 p. 800.843.8801



## HARDINGE COMPANIES WORLDWIDE

Over the years, The Hardinge Group™ steadily diversified both its product offerings and operations. Today, the company has grown into a globally diversified player with manufacturing operations in North America, Europe and Asia. In addition to designing and building turning centers, and collets, Hardinge is a world leader in grinding solutions with the addition of the Kellenberger, Jones & Shipman, Hauser, Tschudin, Usach and Voumard brands to the Hardinge family. The company also designs and manufactures Bridgeport machining centers and other industrial products for a wide range of material cutting, turnkey automation and workholding needs.

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