

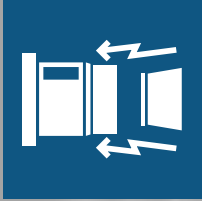


# QUICK CHANGE FLEX COLLETS

Engineered Workholding  
for Maximum Flexibility,  
Productivity & Efficiency!



# WHY QCFC?



**Fast Collet Changes**



**High Accuracy**



**Wide Clamping Range**



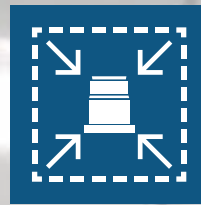
**Easy Mount Design**



**Less Change-over Time**



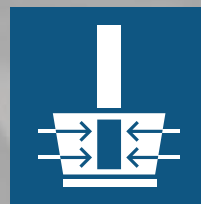
**High RPM**



**Compact Design**



**Durable, Wear  
Resistant Collets**



**Greater Clamping Forces**

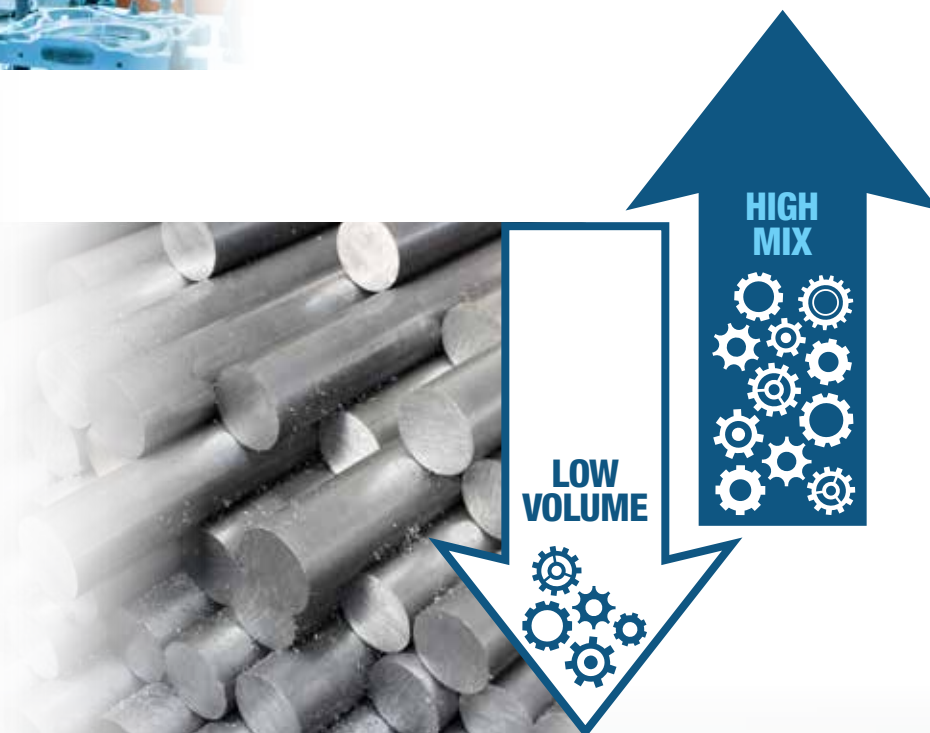
# ...WHY NOT QCFC?

# WHERE QCFC?



## PRODUCTION

- Bar Feeding
- Robot Loading



## JOB SHOP

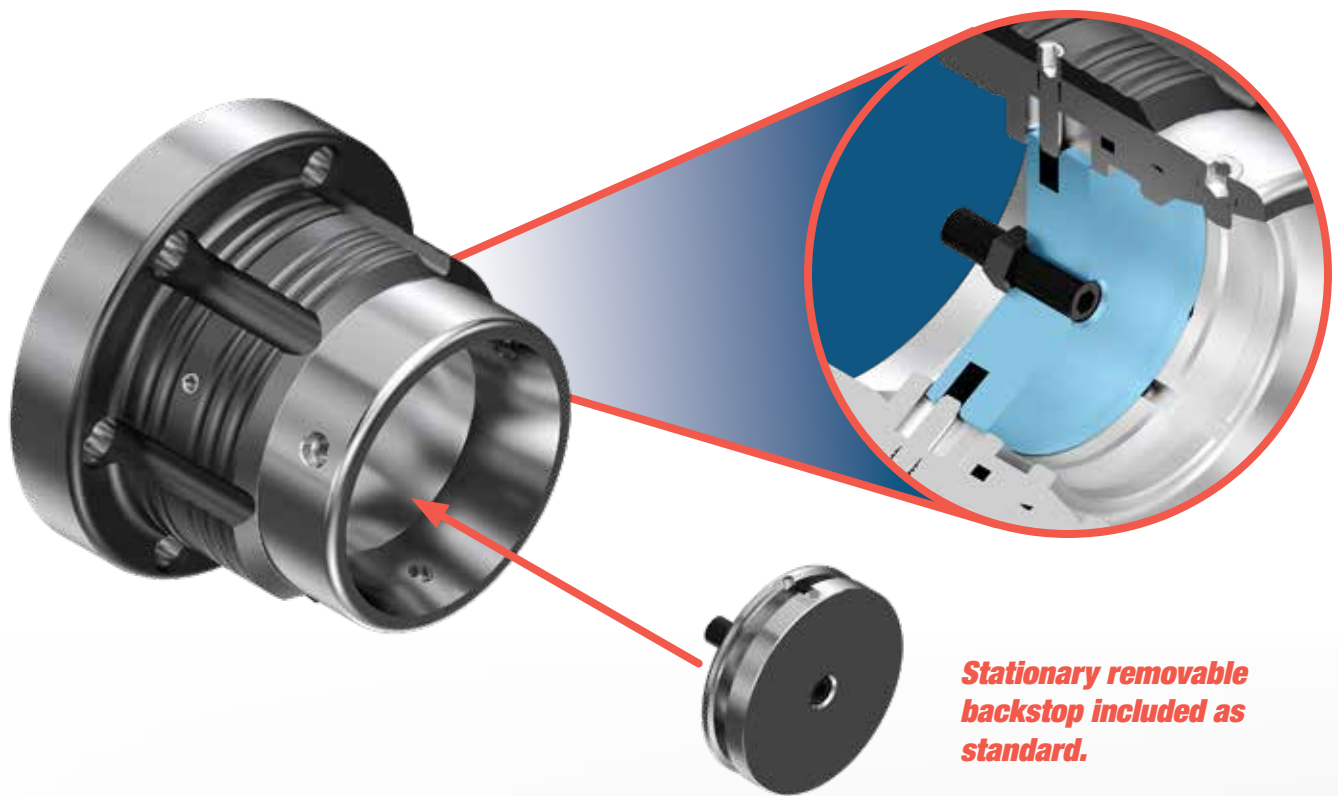
- Varying Size
- Varying Shape Material

# ...ANYWHERE QCFC!

# TYPES OF QCFC CHUCKS

## PULL **BACK-STOP** CHUCK

- This Pull Back-Stop Chuck offers typical axial collet movement.
- 1-piece body design provides easy installation with maximum accuracy and rigidity.
- **Flexibility of backstop or through-material applications.**
- **Stationary removable backstop included as standard.**



***Stationary removable  
backstop included as  
standard.***

# DEAD LENGTH MODULAR CHUCK

- This Dead Length Modular Chuck offers fixed axial collet location.
- Modular design allows for:
  - **Variable machine taper mounts** within the same series
  - Reduced weight during assembly
- Taper-to-Taper design provides easy installation with maximum accuracy.
- **Stationary removable backstop included as standard.**



**A2-5 Base**

**A2-6 Base**

**A2-8 Base**

**140mm Flat Back**

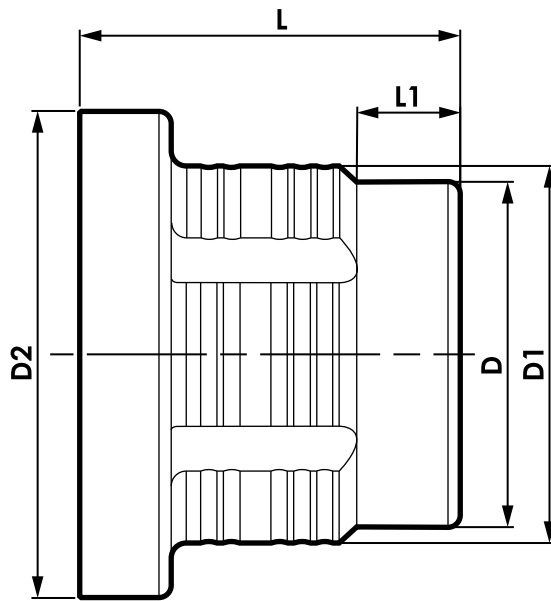
**170mm Flat Back**

***Stationary removable backstop included as standard.***



## QUICK CHANGE FLEX COLLET PULL BACK-STOP CHUCKS

- Optimized design for rigidity and clearance.
- 1/16 collet collapse range – ideal for bar feeding applications.
- Quick change (10 sec.)
- Fast assembly to reduce change over time.
- Balanced for High RPM.



**Stationary removable backstop included as standard.**

Part#	RPM (Max.)	Direct Mount	Pull Back-Stop Chuck Dimensions - Inches (millimeters)				
			D	D1	D2	L	L1
QCC-PB42-140	7,000	140mm flat back	3.701" (94)	3.937" (100)	6.693" (170)	3.740" (95)	1.338" (34)
QCC-PB42-A6		A2-6			6.496" (165)		
QCC-PB65-A6	6,000	A2-6	4.488" (114)	4.921" (125)	6.299" (160)	4.921" (125)	1.338" (34)
QCC-PB65-A8		A2-8			8.268" (210)		
QCC-PB80-A6	6,000	A2-6	4.921" (125)	5.118" (130)	6.496" (165)	4.921" (125)	1.220" (31)
QCC-PB80-A8		A2-8			8.071" (205)		

# PULL BACK-STOP CHUCK FEATURES



## DESIGN/CONSTRUCTION

- Optimized for Maximum Rigidity: Rough and finish as you would in a 3-jaw chuck
- Wear Resistant Hardened Chromium Steel
- Small Nose Diameter for Increased Tool Clearance

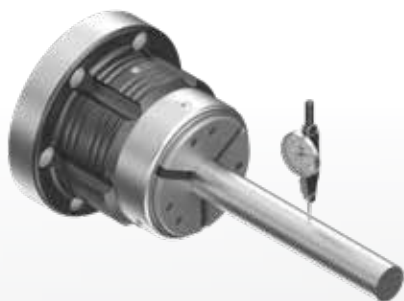


## SET-UP

- Quick & Easy Installation: Switch from a 3-jaw chuck to a Collet Chuck in under 10 minutes
- Fast Collet Changes: swap collets in 10 seconds
- Removable Backstop to allow for through-material applications

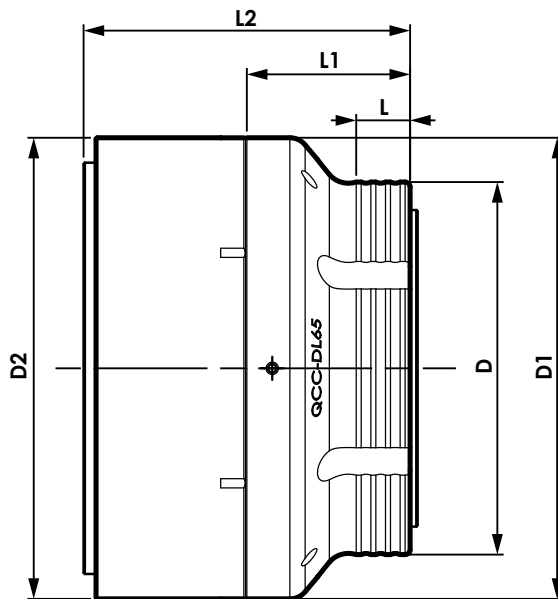
## PERFORMANCE

- High Accuracy by Design
- Maximum Gripping Range (0.062"): Accommodates oversized/undersized material
- High RPM for Production Flexibility



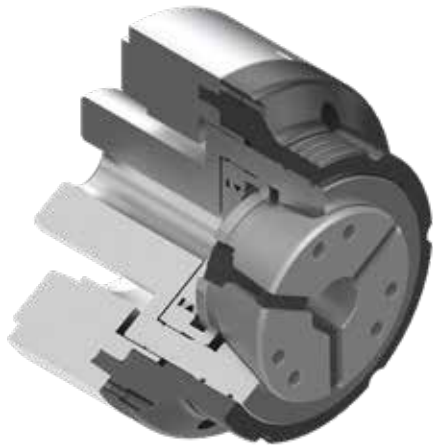
## QUICK CHANGE FLEX COLLET DEAD LENGTH MODULAR CHUCKS

- Optimized design for rigidity and clearance.
- 1/16 collet collapse range – ideal for bar feeding applications.
- Quick change (10 sec.)
- Fast assembly to reduce change over time.
- Balanced for High RPM.
- Taper interface to ensure accuracy.



Part #	RPM (Max.)	Direct Mount	Dead Length Modular Chuck Dimensions - Inches (millimeters)					
			D	D1	D2	L	L1	L2
QCC-DL65-140	6,000	140mm flat back	5.905" (150)	7.283" (185)	7.283" (185)	0.866" (22)	2.598" (66)	4.764" (121)
QCC-DL65-A5		A2-5						
QCC-DL65-A6		A2-6						
QCC-DL65-A8		A2-8			8.268" (210)			
QCC-DL80-170	5,500	170mm flat back	6.299" (160)	8.071" (205)	8.071" (205)	0.984" (25)	2.953" (75)	4.803" (122)
QCC-DL80-A6		A2-6						4.646" (118)
QCC-DL80-A8		A2-8						

# DEAD LENGTH MODULAR CHUCK FEATURES



## DESIGN/CONSTRUCTION

- Modular Design: 2 piece design allows for modular flexibility of the collet chuck
- Wear Resistant Hardened Chromium Steel
- Small Nose Diameter for Increased Tool Clearance

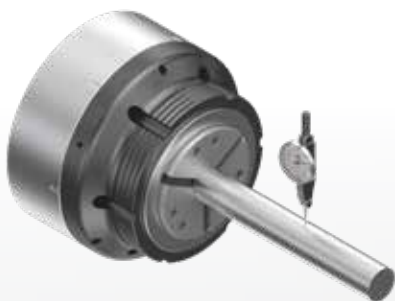


## SET-UP

- Quick & Easy Installation: Switch from a 3-jaw chuck to a Collet Chuck in under 10 minutes
- Fast Collet Changes: swap collets in 10 seconds

## PERFORMANCE

- High Accuracy by Design
- Maximum Gripping Range (0.062"): Accommodates oversized/undersized material
- High RPM for Production Flexibility



## QUICK CHANGE FLEX COLLETS

- **Quick set-up time:** Collet can be switched to any size within seconds, not minutes.
- **Increased Precision:** Collet accuracy is 0.0004" or better.
- **Increased Grip Force:** Collet collapses parallel to work piece, not angular.
- **Increased Clamping Range:** Quick Change Flex collets allow work pieces to be up to +/- 0.031" from nominal diameter.

### SMOOTH COLLETS



- Heat Treated Alloy Structural Steel
- Ground Cam Relief allows for precision repeatability and accuracy of .0004" or better
- Collets are precision paired before rubber vulcanization process to optimize roundness and cylindrical accuracy

### Emergency Collets\*

8mm	QCFC42-08M-EMR
15mm	QCFC42-15M-EMR
30mm	QCFC42-30M-EMR



\*Emergency Collets require a Boring Ring (QCFC42-EMR-RING) not included and sold separately.

SERIES 42 SMOOTH COLLETS			WRENCH PART#: QCFC42-WRENCH		
SIZE	PART NUMBER	GRIP RANGE	SIZE	PART NUMBER	GRIP RANGE
1/4"	QCFC42-016-SMO	0.219" - 0.281"	31/32"	QCFC42-062-SMO	0.938" - 1.000"
9/32"	QCFC42-018-SMO	0.250" - 0.312"	1"	QCFC42-064-SMO	0.969" - 1.031"
5/16"	QCFC42-020-SMO	0.282" - 0.344"	1.1/32"	QCFC42-066-SMO	1.000" - 1.062"
11/32"	QCFC42-022-SMO	0.313" - 0.375"	1.1/16"	QCFC42-068-SMO	1.032" - 1.094"
3/8"	QCFC42-024-SMO	0.344" - 0.406"	1.3/32"	QCFC42-070-SMO	1.063" - 1.125"
13/32"	QCFC42-026-SMO	0.375" - 0.437"	1.1/8"	QCFC42-072-SMO	1.094" - 1.156"
7/16"	QCFC42-028-SMO	0.407" - 0.469"	1.5/32"	QCFC42-074-SMO	1.125" - 1.187"
15/32"	QCFC42-030-SMO	0.438" - 0.500"	1.3/16"	QCFC42-076-SMO	1.157" - 1.219"
1/2"	QCFC42-032-SMO	0.469" - 0.531"	1.7/32"	QCFC42-078-SMO	1.188" - 1.250"
17/32"	QCFC42-034-SMO	0.500" - 0.562"	1.1/4"	QCFC42-080-SMO	1.219" - 1.281"
9/16"	QCFC42-036-SMO	0.532" - 0.594"	1.9/32"	QCFC42-082-SMO	1.250" - 1.312"
19/32"	QCFC42-038-SMO	0.563" - 0.625"	1.5/16"	QCFC42-084-SMO	1.282" - 1.344"
5/8"	QCFC42-040-SMO	0.594" - 0.656"	1.11/32"	QCFC42-086-SMO	1.313" - 1.375"
21/32"	QCFC42-042-SMO	0.625" - 0.687"	1.3/8"	QCFC42-088-SMO	1.344" - 1.406"
11/16"	QCFC42-044-SMO	0.657" - 0.719"	1.13/32"	QCFC42-090-SMO	1.375" - 1.437"
23/32"	QCFC42-046-SMO	0.688" - 0.750"	1.7/16"	QCFC42-092-SMO	1.407" - 1.469"
3/4"	QCFC42-048-SMO	0.719" - 0.781"	1.15/32"	QCFC42-094-SMO	1.438" - 1.500"
25/32"	QCFC42-050-SMO	0.750" - 0.812"	1.1/2"	QCFC42-096-SMO	1.469" - 1.531"
13/16"	QCFC42-052-SMO	0.782" - 0.844"	1.17/32"	QCFC42-098-SMO	1.500" - 1.562"
27/32"	QCFC42-054-SMO	0.813" - 0.875"	1.9/16"	QCFC42-100-SMO	1.532" - 1.594"
7/8"	QCFC42-056-SMO	0.844" - 0.906"	1.19/32"	QCFC42-102-SMO	1.563" - 1.625"
29/32"	QCFC42-058-SMO	0.875" - 0.937"	1.5/8"	QCFC42-104-SMO	1.594" - 1.656"
15/16"	QCFC42-060-SMO	0.907" - 0.969"			

Series 42, 65 & 80 metric sizes are available upon request. Contact us for details.

## SERRATED COLLETS



- Hardened serrations provide strong gripping strength for aggressive roughing of material
- Lyndex-Nikken serration lengths inside the bore are longer than the competition, providing much stronger gripping force
- Collets are precision paired before rubber vulcanization process to optimize roundness and cylindrical accuracy
- Ideal for bar feeding applications

SERIES 42 SERRATED COLLETS			WRENCH PART#: QCFC42-WRENCH		
SIZE	PART NUMBER	GRIP RANGE	SIZE	PART NUMBER	GRIP RANGE
1/4"	QCFC42-016-SER	0.219" - 0.281"	31/32"	QCFC42-062-SER	0.938" - 1.000"
9/32"	QCFC42-018-SER	0.250" - 0.312"	1"	QCFC42-064-SER	0.969" - 1.031"
5/16"	QCFC42-020-SER	0.282" - 0.344"	1.1/32"	QCFC42-066-SER	1.000" - 1.062"
11/32"	QCFC42-022-SER	0.313" - 0.375"	1.1/16"	QCFC42-068-SER	1.032" - 1.094"
3/8"	QCFC42-024-SER	0.344" - 0.406"	1.3/32"	QCFC42-070-SER	1.063" - 1.125"
13/32"	QCFC42-026-SER	0.375" - 0.437"	1.1/8"	QCFC42-072-SER	1.094" - 1.156"
7/16"	QCFC42-028-SER	0.407" - 0.469"	1.5/32"	QCFC42-074-SER	1.125" - 1.187"
15/32"	QCFC42-030-SER	0.438" - 0.500"	1.3/16"	QCFC42-076-SER	1.157" - 1.219"
1/2"	QCFC42-032-SER	0.469" - 0.531"	1.7/32"	QCFC42-078-SER	1.188" - 1.250"
17/32"	QCFC42-034-SER	0.500" - 0.562"	1.1/4"	QCFC42-080-SER	1.219" - 1.281"
9/16"	QCFC42-036-SER	0.532" - 0.594"	1.9/32"	QCFC42-082-SER	1.250" - 1.312"
19/32"	QCFC42-038-SER	0.563" - 0.625"	1.5/16"	QCFC42-084-SER	1.282" - 1.344"
5/8"	QCFC42-040-SER	0.594" - 0.656"	1.11/32"	QCFC42-086-SER	1.313" - 1.375"
21/32"	QCFC42-042-SER	0.625" - 0.687"	1.3/8"	QCFC42-088-SER	1.344" - 1.406"
11/16"	QCFC42-044-SER	0.657" - 0.719"	1.13/32"	QCFC42-090-SER	1.375" - 1.437"
23/32"	QCFC42-046-SER	0.688" - 0.750"	1.7/16"	QCFC42-092-SER	1.407" - 1.469"
3/4"	QCFC42-048-SER	0.719" - 0.781"	1.15/32"	QCFC42-094-SER	1.438" - 1.500"
25/32"	QCFC42-050-SER	0.750" - 0.812"	1.1/2"	QCFC42-096-SER	1.469" - 1.531"
13/16"	QCFC42-052-SER	0.782" - 0.844"	1.17/32"	QCFC42-098-SER	1.500" - 1.562"
27/32"	QCFC42-054-SER	0.813" - 0.875"	1.9/16"	QCFC42-100-SER	1.532" - 1.594"
7/8"	QCFC42-056-SER	0.844" - 0.906"	1.19/32"	QCFC42-102-SER	1.563" - 1.625"
29/32"	QCFC42-058-SER	0.875" - 0.937"	1.5/8"	QCFC42-104-SER	1.594" - 1.656"
15/16"	QCFC42-060-SER	0.907" - 0.969"			

SERIES 42 SERRATED QUICK CHANGE COLLETS

# QUICK CHANGE FLEX COLLETS

## SMOOTH COLLETS



- Heat Treated Alloy Structural Steel
- Ground Cam Relief allows for precision repeatability and accuracy of .0004" or better
- Collets are precision paired before rubber vulcanization process to optimize roundness and cylindrical accuracy

### Emergency Collets\*

8mm	QCFC65-08M-EMR
20mm	QCFC65-20M-EMR
30mm	QCFC65-30M-EMR
40mm	QCFC65-40M-EMR



\*Emergency Collets require a Boring Ring (QCFC65-EMR-RING) not included & sold separately.

SERIES 65 SMOOTH COLLETS			WRENCH PART # QCFC65-WRENCH		
SIZE	PART NUMBER	GRIP RANGE	SIZE	PART NUMBER	GRIP RANGE
1/4"	QCFC65-016-SMO	0.219" - 0.281"	1.7/16"	QCFC65-092-SMO	1.407" - 1.469"
9/32"	QCFC65-018-SMO	0.250" - 0.312"	1.15/32"	QCFC65-094-SMO	1.438" - 1.500"
5/16"	QCFC65-020-SMO	0.282" - 0.344"	1.1/2"	QCFC65-096-SMO	1.469" - 1.531"
11/32"	QCFC65-022-SMO	0.313" - 0.375"	1.17/32"	QCFC65-098-SMO	1.500" - 1.562"
3/8"	QCFC65-024-SMO	0.344" - 0.406"	1.9/16"	QCFC65-100-SMO	1.532" - 1.594"
13/32"	QCFC65-026-SMO	0.375" - 0.437"	1.19/32"	QCFC65-102-SMO	1.563" - 1.625"
7/16"	QCFC65-028-SMO	0.407" - 0.469"	1.5/8"	QCFC65-104-SMO	1.594" - 1.656"
15/32"	QCFC65-030-SMO	0.438" - 0.500"	1.21/32"	QCFC65-106-SMO	1.625" - 1.687"
1/2"	QCFC65-032-SMO	0.469" - 0.531"	1.11/16"	QCFC65-108-SMO	1.657" - 1.719"
17/32"	QCFC65-034-SMO	0.500" - 0.562"	1.23/32"	QCFC65-110-SMO	1.688" - 1.750"
9/16"	QCFC65-036-SMO	0.532" - 0.594"	1.3/4"	QCFC65-112-SMO	1.719" - 1.781"
19/32"	QCFC65-038-SMO	0.563" - 0.625"	1.25/32"	QCFC65-114-SMO	1.750" - 1.812"
5/8"	QCFC65-040-SMO	0.594" - 0.656"	1.13/16"	QCFC65-116-SMO	1.782" - 1.844"
21/32"	QCFC65-042-SMO	0.625" - 0.687"	1.27/32"	QCFC65-118-SMO	1.813" - 1.875"
11/16"	QCFC65-044-SMO	0.657" - 0.719"	1.7/8"	QCFC65-120-SMO	1.844" - 1.906"
23/32"	QCFC65-046-SMO	0.688" - 0.750"	1.29/32"	QCFC65-122-SMO	1.875" - 1.937"
3/4"	QCFC65-048-SMO	0.719" - 0.781"	1.15/16"	QCFC65-124-SMO	1.907" - 1.939"
25/32"	QCFC65-050-SMO	0.750" - 0.812"	1.31/32"	QCFC65-126-SMO	1.938" - 2.000"
13/16"	QCFC65-052-SMO	0.782" - 0.844"	2"	QCFC65-128-SMO	1.969" - 2.031"
27/32"	QCFC65-054-SMO	0.813" - 0.875"	2.1/32"	QCFC65-130-SMO	2.000" - 2.062"
7/8"	QCFC65-056-SMO	0.844" - 0.906"	2.1/16"	QCFC65-132-SMO	2.032" - 2.094"
29/32"	QCFC65-058-SMO	0.875" - 0.937"	2.3/32"	QCFC65-134-SMO	2.063" - 2.125"
15/16"	QCFC65-060-SMO	0.907" - 0.969"	2.1/8"	QCFC65-136-SMO	2.094" - 2.156"
31/32"	QCFC65-062-SMO	0.938" - 1.000"	2.5/32"	QCFC65-138-SMO	2.125" - 2.187"
1"	QCFC65-064-SMO	0.969" - 1.031"	2.3/16"	QCFC65-140-SMO	2.157" - 2.219"
1.1/32"	QCFC65-066-SMO	1.000" - 1.062"	2.7/32"	QCFC65-142-SMO	2.188" - 2.250"
1.1/16"	QCFC65-068-SMO	1.032" - 1.094"	2.1/4"	QCFC65-144-SMO	2.219" - 2.281"
1.3/32"	QCFC65-070-SMO	1.063" - 1.125"	2.9/32"	QCFC65-146-SMO	2.250" - 2.312"
1.1/8"	QCFC65-072-SMO	1.094" - 1.156"	2.5/16"	QCFC65-148-SMO	2.282" - 2.344"
1.5/32"	QCFC65-074-SMO	1.125" - 1.187"	2.11/32"	QCFC65-150-SMO	2.313" - 2.375"
1.3/16"	QCFC65-076-SMO	1.157" - 1.219"	2.3/8"	QCFC65-152-SMO	2.344" - 2.406"
1.7/32"	QCFC65-078-SMO	1.188" - 1.250"	2.13/32"	QCFC65-154-SMO	2.375" - 2.437"
1.1/4"	QCFC65-080-SMO	1.219" - 1.281"	2.7/16"	QCFC65-156-SMO	2.407" - 2.469"
1.9/32"	QCFC65-082-SMO	1.250" - 1.312"	2.15/32"	QCFC65-158-SMO	2.438" - 2.500"
1.5/16"	QCFC65-084-SMO	1.282" - 1.344"	2.1/2"	QCFC65-160-SMO	2.469" - 2.531"
1.11/32"	QCFC65-086-SMO	1.313" - 1.375"	2.17/32"	QCFC65-162-SMO	2.500" - 2.562"
1.3/8"	QCFC65-088-SMO	1.344" - 1.406"	2.9/16"	QCFC65-164-SMO	2.532" - 2.594"
1.13/32"	QCFC65-090-SMO	1.375" - 1.437"			

Series 42, 65 & 80 metric sizes are available upon request. Contact us for details.

## SERRATED COLLETS



- Hardened serrations provide strong gripping strength for aggressive roughing of material
- Lyndex-Nikken serration lengths inside the bore are longer than the competition, providing much stronger gripping force
- Collets are precision paired before rubber vulcanization process to optimize roundness and cylindrical accuracy
- Ideal for bar feeding applications

SERIES 65 SERRATED COLLETS			WRENCH PART # QCFC65-WRENCH		
SIZE	PART NUMBER	GRIP RANGE	SIZE	PART NUMBER	GRIP RANGE
1/4"	QCFC65-016-SER	0.219" - 0.281"	1.7/16"	QCFC65-092-SER	1.407" - 1.469"
9/32"	QCFC65-018-SER	0.250" - 0.312"	1.15/32"	QCFC65-094-SER	1.438" - 1.500"
5/16"	QCFC65-020-SER	0.282" - 0.344"	1.1/2"	QCFC65-096-SER	1.469" - 1.531"
11/32"	QCFC65-022-SER	0.313" - 0.375"	1.17/32"	QCFC65-098-SER	1.500" - 1.562"
3/8"	QCFC65-024-SER	0.344" - 0.406"	1.9/16"	QCFC65-100-SER	1.532" - 1.594"
13/32"	QCFC65-026-SER	0.375" - 0.437"	1.19/32"	QCFC65-102-SER	1.563" - 1.625"
7/16"	QCFC65-028-SER	0.407" - 0.469"	1.5/8"	QCFC65-104-SER	1.594" - 1.656"
15/32"	QCFC65-030-SER	0.438" - 0.500"	1.21/32"	QCFC65-106-SER	1.625" - 1.687"
1/2"	QCFC65-032-SER	0.469" - 0.531"	1.11/16"	QCFC65-108-SER	1.657" - 1.719"
17/32"	QCFC65-034-SER	0.500" - 0.562"	1.23/32"	QCFC65-110-SER	1.688" - 1.750"
9/16"	QCFC65-036-SER	0.532" - 0.594"	1.3/4"	QCFC65-112-SER	1.719" - 1.781"
19/32"	QCFC65-038-SER	0.563" - 0.625"	1.25/32"	QCFC65-114-SER	1.750" - 1.812"
5/8"	QCFC65-040-SER	0.594" - 0.656"	1.13/16"	QCFC65-116-SER	1.782" - 1.844"
21/32"	QCFC65-042-SER	0.625" - 0.687"	1.27/32"	QCFC65-118-SER	1.813" - 1.875"
11/16"	QCFC65-044-SER	0.657" - 0.719"	1.7/8"	QCFC65-120-SER	1.844" - 1.906"
23/32"	QCFC65-046-SER	0.688" - 0.750"	1.29/32"	QCFC65-122-SER	1.875" - 1.937"
3/4"	QCFC65-048-SER	0.719" - 0.781"	1.15/16"	QCFC65-124-SER	1.907" - 1.939"
25/32"	QCFC65-050-SER	0.750" - 0.812"	1.31/32"	QCFC65-126-SER	1.938" - 2.000"
13/16"	QCFC65-052-SER	0.782" - 0.844"	2"	QCFC65-128-SER	1.969" - 2.031"
27/32"	QCFC65-054-SER	0.813" - 0.875"	2.1/32"	QCFC65-130-SER	2.000" - 2.062"
7/8"	QCFC65-056-SER	0.844" - 0.906"	2.1/16"	QCFC65-132-SER	2.032" - 2.094"
29/32"	QCFC65-058-SER	0.875" - 0.937"	2.3/32"	QCFC65-134-SER	2.063" - 2.125"
15/16"	QCFC65-060-SER	0.907" - 0.969"	2.1/8"	QCFC65-136-SER	2.094" - 2.156"
31/32"	QCFC65-062-SER	0.938" - 1.000"	2.5/32"	QCFC65-138-SER	2.125" - 2.187"
1"	QCFC65-064-SER	0.969" - 1.031"	2.3/16"	QCFC65-140-SER	2.157" - 2.219"
1.1/32"	QCFC65-066-SER	1.000" - 1.062"	2.7/32"	QCFC65-142-SER	2.188" - 2.250"
1.1/16"	QCFC65-068-SER	1.032" - 1.094"	2.1/4"	QCFC65-144-SER	2.219" - 2.281"
1.3/32"	QCFC65-070-SER	1.063" - 1.125"	2.9/32"	QCFC65-146-SER	2.250" - 2.312"
1.1/8"	QCFC65-072-SER	1.094" - 1.156"	2.5/16"	QCFC65-148-SER	2.282" - 2.344"
1.5/32"	QCFC65-074-SER	1.125" - 1.187"	2.11/32"	QCFC65-150-SER	2.313" - 2.375"
1.3/16"	QCFC65-076-SER	1.157" - 1.219"	2.3/8"	QCFC65-152-SER	2.344" - 2.406"
1.7/32"	QCFC65-078-SER	1.188" - 1.250"	2.13/32"	QCFC65-154-SER	2.375" - 2.437"
1.1/4"	QCFC65-080-SER	1.219" - 1.281"	2.7/16"	QCFC65-156-SER	2.407" - 2.469"
1.9/32"	QCFC65-082-SER	1.250" - 1.312"	2.15/32"	QCFC65-158-SER	2.438" - 2.500"
1.5/16"	QCFC65-084-SER	1.282" - 1.344"	2.1/2"	QCFC65-160-SER	2.469" - 2.531"
1.11/32"	QCFC65-086-SER	1.313" - 1.375"	2.17/32"	QCFC65-162-SER	2.500" - 2.562"
1.3/8"	QCFC65-088-SER	1.344" - 1.406"	2.9/16"	QCFC65-164-SER	2.532" - 2.594"
1.13/32"	QCFC65-090-SER	1.375" - 1.437"			

SERIES 65 SERRATED & HEX QUICK CHANGE COLLETS

## HEX COLLETS



- Precision broached to optimize centering of hex bar stock
- Heat Treated Alloy Structural Steel
- Collets are precision paired before rubber vulcanization process to optimize roundness and cylindrical accuracy
- Ideal for bar feeding any hex material

SERIES 65 HEX COLLETS			WRENCH PART # QCFC65-WRENCH		
SIZE	PART NUMBER	GRIP RANGE	SIZE	PART NUMBER	GRIP RANGE
5/16"	QCFC65-020-HEX	0.282" - 0.344"	15/16"	QCFC65-060-HEX	0.907" - 0.969"
3/8"	QCFC65-024-HEX	0.344" - 0.406"	1"	QCFC65-064-HEX	0.969" - 1.031"
7/16"	QCFC65-028-HEX	0.407" - 0.469"	1.1/8"	QCFC65-072-HEX	1.094" - 1.156"
1/2"	QCFC65-032-HEX	0.469" - 0.531"	1.1/4"	QCFC65-080-HEX	1.219" - 1.281"
9/16"	QCFC65-036-HEX	0.532" - 0.594"	1.3/8"	QCFC65-088-HEX	1.344" - 1.406"
5/8"	QCFC65-040-HEX	0.594" - 0.656"	1.1/2"	QCFC65-096-HEX	1.469" - 1.531"
11/16"	QCFC65-044-HEX	0.657" - 0.719"	1.5/8"	QCFC65-104-HEX	1.594" - 1.656"
3/4"	QCFC65-048-HEX	0.719" - 0.781"	1.3/4"	QCFC65-112-HEX	1.719" - 1.781"
13/16"	QCFC65-052-HEX	0.782" - 0.844"	1.7/8"	QCFC65-120-HEX	1.844" - 1.906"
7/8"	QCFC65-056-HEX	0.844" - 0.906"	2"	QCFC65-128-HEX	1.969" - 2.031"

# QUICK CHANGE FLEX COLLETS

## SMOOTH COLLETS



- Heat Treated to 60 HRC
- Wear Resistant Alloy Carbon Steel
- Ground Cam Relief allows for precision repeatability and accuracy of .0004" or better
- Collets are precision paired before rubber vulcanization process to optimize roundness and cylindrical accuracy

SERIES 80 SMOOTH COLLETS			WRENCH PART # QCFC80-WRENCH		
SIZE	PART NUMBER	GRIP RANGE	SIZE	PART NUMBER	GRIP RANGE
3/8"	QCFC80-024-SMO	0.344" - 0.406"	1.7/8"	QCFC80-120-SMO	1.844" - 1.906"
1/2"	QCFC80-032-SMO	0.469" - 0.531"	2"	QCFC80-128-SMO	1.969" - 2.031"
5/8"	QCFC80-040-SMO	0.594" - 0.656"	2.1/8"	QCFC80-136-SMO	2.094" - 2.156"
3/4"	QCFC80-048-SMO	0.719" - 0.781"	2.1/4"	QCFC80-144-SMO	2.219" - 2.281"
7/8"	QCFC80-056-SMO	0.844" - 0.906"	2.3/8"	QCFC80-152-SMO	2.344" - 2.406"
1"	QCFC80-064-SMO	0.969" - 1.031"	2.1/2"	QCFC80-160-SMO	2.469" - 2.531"
1.1/8"	QCFC80-072-SMO	1.094" - 1.156"	2.5/8"	QCFC80-168-SMO	2.594" - 2.656"
1.1/4"	QCFC80-080-SMO	1.219" - 1.281"	2.3/4"	QCFC80-176-SMO	2.719" - 2.781"
1.3/8"	QCFC80-088-SMO	1.344" - 1.406"	2.7/8"	QCFC80-184-SMO	2.844" - 2.906"
1.1/2"	QCFC80-096-SMO	1.469" - 1.531"	3"	QCFC80-192-SMO	2.969" - 3.031"
1.5/8"	QCFC80-104-SMO	1.594" - 1.656"	3.1/8"	QCFC80-200-SMO	3.094" - 3.156"
1.3/4"	QCFC80-112-SMO	1.719" - 1.781"	3.1/4"	QCFC80-208-SMO	3.219" - 3.281"

## SERRATED COLLETS



- Hardened serrations provide strong gripping strength for aggressive roughing of material
- Lyndex-Nikken serration lengths inside the bore are longer than the competition, providing much stronger gripping force
- Collets are precision paired before rubber vulcanization process to optimize roundness and cylindrical accuracy
- Ideal for bar feeding applications

SERIES 80 SERRATED COLLETS			WRENCH PART # QCFC80-WRENCH		
SIZE	PART NUMBER	GRIP RANGE	SIZE	PART NUMBER	GRIP RANGE
5/8"	QCFC80-040-SER	0.594" - 0.656"	2"	QCFC80-128-SER	1.969" - 2.031"
3/4"	QCFC80-048-SER	0.719" - 0.781"	2.1/8"	QCFC80-136-SER	2.094" - 2.156"
7/8"	QCFC80-056-SER	0.844" - 0.906"	2.1/4"	QCFC80-144-SER	2.219" - 2.281"
1"	QCFC80-064-SER	0.969" - 1.031"	2.3/8"	QCFC80-152-SER	2.344" - 2.406"
1.1/8"	QCFC80-072-SER	1.094" - 1.156"	2.1/2"	QCFC80-160-SER	2.469" - 2.531"
1.1/4"	QCFC80-080-SER	1.219" - 1.281"	2.5/8"	QCFC80-168-SER	2.594" - 2.656"
1.3/8"	QCFC80-088-SER	1.344" - 1.406"	2.3/4"	QCFC80-176-SER	2.719" - 2.781"
1.1/2"	QCFC80-096-SER	1.469" - 1.531"	2.7/8"	QCFC80-184-SER	2.844" - 2.906"
1.5/8"	QCFC80-104-SER	1.594" - 1.656"	3"	QCFC80-192-SER	2.969" - 3.031"
1.3/4"	QCFC80-112-SER	1.719" - 1.781"	3.1/8"	QCFC80-200-SER	3.094" - 3.156"
1.7/8"	QCFC80-120-SER	1.844" - 1.906"	3.1/4"	QCFC80-208-SER	3.219" - 3.281"

Series 42, 65 & 80 metric sizes are available upon request. Contact us for details.

## HEX COLLETS



- Heat Treated Alloy Structural Steel
- Ground Cam Relief allows for precision repeatability and accuracy of .0004" or better
- Collets are precision paired before rubber vulcanization process to optimize roundness and cylindrical accuracy

### Emergency Collets\*

3/4"	QCFC80-048-EMR
1.1/2"	QCFC80-096-EMR
2.1/2"	QCFC80-160-EMR



\*Emergency Collets require a Boring Ring (QCFC80-EMR-RING) not included & sold separately.

SERIES 80 HEX COLLETS			WRENCH PART # QCFC80-WRENCH		
SIZE	PART NUMBER	GRIP RANGE	SIZE	PART NUMBER	GRIP RANGE
3/4"	QCFC80-048-HEX	0.719" - 0.781"	1.7/8"	QCFC80-120-HEX	1.844" - 1.906"
7/8"	QCFC80-056-HEX	0.844" - 0.906"	2"	QCFC80-128-HEX	1.969" - 2.031"
1"	QCFC80-064-HEX	0.969" - 1.031"	2.1/8"	QCFC80-136-HEX	2.094" - 2.156"
1.1/8"	QCFC80-072-HEX	1.094" - 1.156"	2.1/4"	QCFC80-144-HEX	2.219" - 2.281"
1.1/4"	QCFC80-080-HEX	1.219" - 1.281"	2.3/8"	QCFC80-152-HEX	2.344" - 2.406"
1.3/8"	QCFC80-088-HEX	1.344" - 1.406"	2.1/2"	QCFC80-160-HEX	2.469" - 2.531"
1.1/2"	QCFC80-096-HEX	1.469" - 1.531"	2.5/8"	QCFC80-168-HEX	2.594" - 2.656"
1.5/8"	QCFC80-104-HEX	1.594" - 1.656"	2.3/4"	QCFC80-176-HEX	2.719" - 2.781"
1.3/4"	QCFC80-112-HEX	1.719" - 1.781"			

SERIES 80 HEX QUICK CHANGE COLLETS

## TAPER-TO-TAPER CHUCK ADAPTERS PRODUCT FEATURES

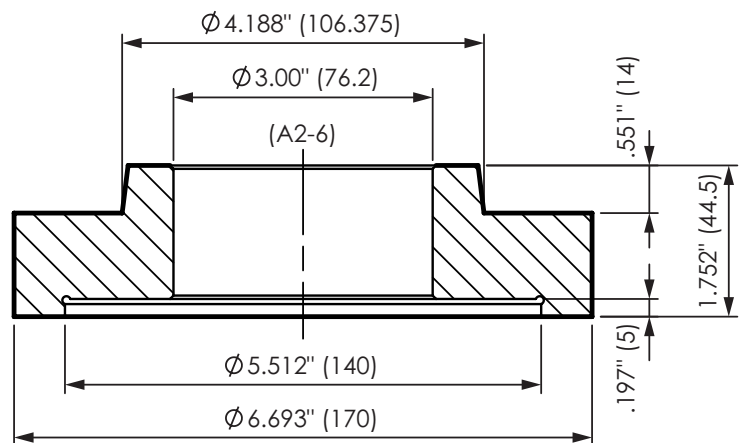
- Add another level of flexibility to your set-up.
- Made from 8620 Alloy Steel.
- Hardened to 50~55 HRC.
- All adapter plates made per ISO 702.
- Precision ground for high accuracy.



140 FLAT TO A2-6



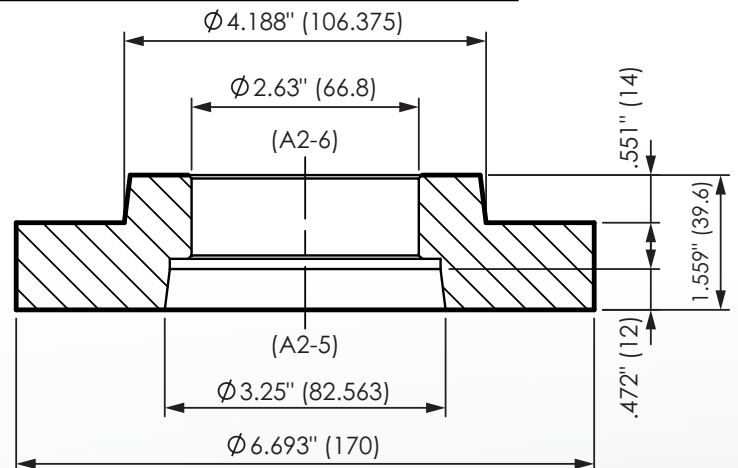
Part # QCC-ADAPTER-140-A6



A2-5 TO A2-6



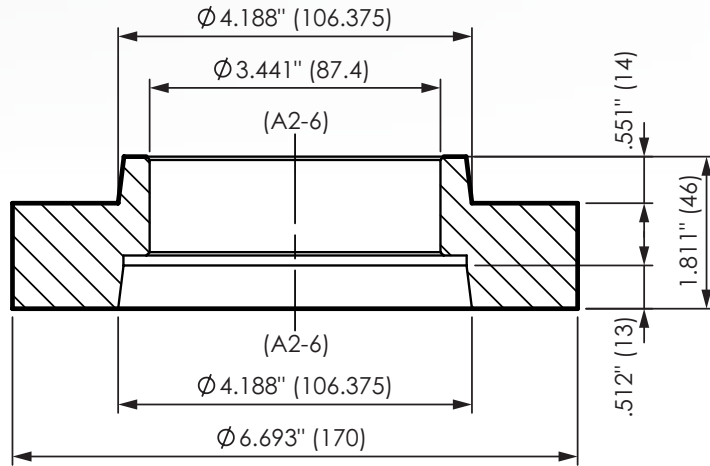
Part # QCC-ADAPTER-A5-A6



## A2-6 TO A2-6 EXTENSION



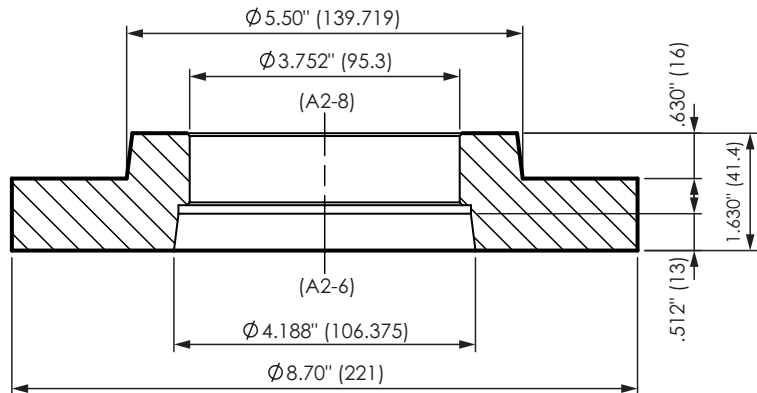
### Part # QCC-ADAPTER-A6-A6



## A2-6 TO A2-8



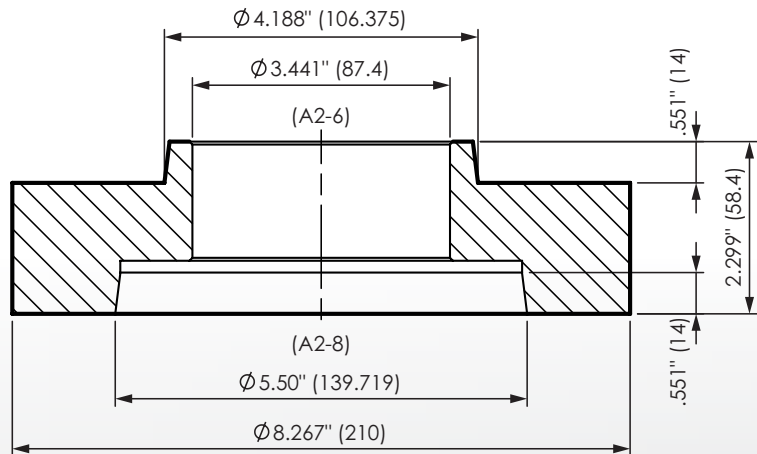
### Part # QCC-ADAPTER-A6-A8



## A2-8 TO A2-6

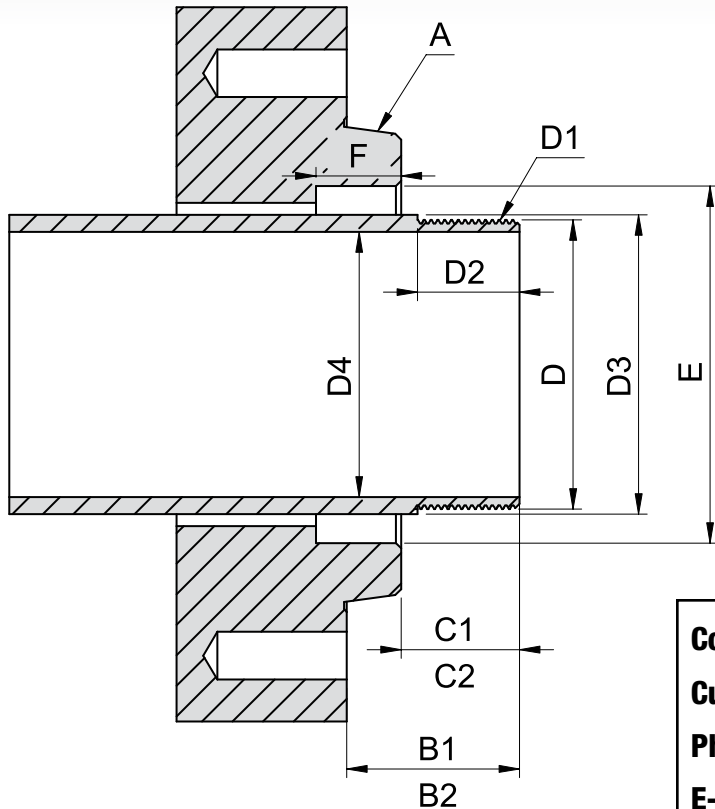


### Part # QCC-ADAPTER-A8-A6



TAPER TO TAPER CHUCK ADAPTERS

# LATHE SPINDLE INFORMATION FORM



A custom draw tube adapter is needed to connect your new chuck to the machine. To make this adapter we will need some measurements from the machine to ensure the proper fit and stroke is achieved.

Remove the existing chuck from the spindle face prior to taking measurements. Make sure the draw tube is fully seated in the actuator prior to taking measurements. If you have any questions regarding taking these measurements, please contact us.

**For more detailed information or support, please contact one of our applications engineers at (847) 367-4800.**

<b>Company:</b> _____
<b>Customer Name:</b> _____
<b>Phone Number:</b> _____
<b>E-mail:</b> _____

**Machine (Make & Model):** \_\_\_\_\_

**D1 - Pitch:** \_\_\_\_\_

**Actuator (Make & Model):** \_\_\_\_\_

**D2 - Length of Thread:** \_\_\_\_\_

**A - Spindle Type & Size:** \_\_\_\_\_

**Internal / External:** \_\_\_\_\_

**B1 (Extended):** \_\_\_\_\_

**D3 - Draw Tube O.D.:** \_\_\_\_\_

**B2 (Retracted):** \_\_\_\_\_

**D4 - Draw Tube I.D.:** \_\_\_\_\_

**C1 (Extended):** \_\_\_\_\_

**E - Counterbore I.D.:** \_\_\_\_\_

**C2 (Retracted):** \_\_\_\_\_

**F - Counterbore Depth:** \_\_\_\_\_

**D - Thread Diameter:** \_\_\_\_\_

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**HIGH QUALITY. HIGH DURABILITY. HIGH PRECISION**

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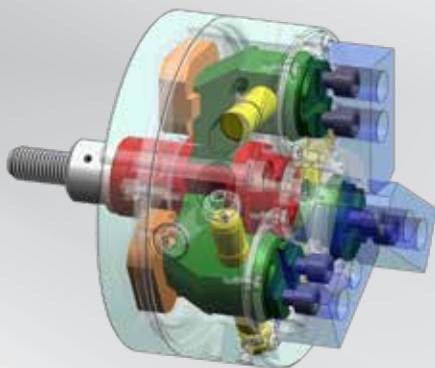


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## HYDRAULIC POWER CHUCK FEATURES

- Low maintenance, high performance
- Capable of clamping over workpieces with uneven surfaces and a large range of diameters
- Maintains powerful clamping at high RPM
- Large through hole bores available for bar feeding
- Fully sealed structure reduces frequent greasing and prevents coolant leaks



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For more information, call 847.367.4800



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