

# Flex - interchangeable inserts



## APPLICATION

For counter-clamping workpieces on turning and grinding machines.

## TYPE

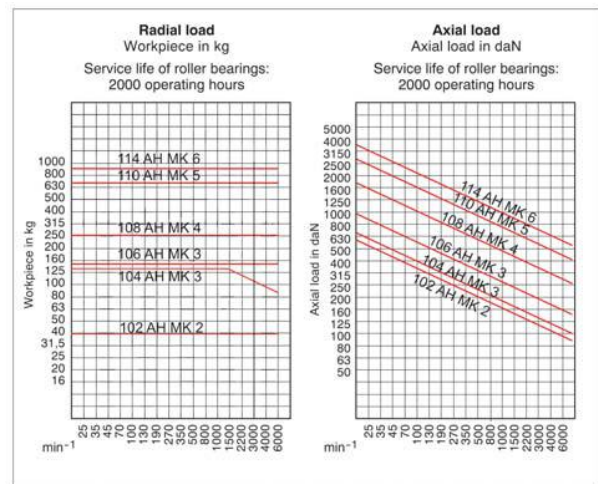
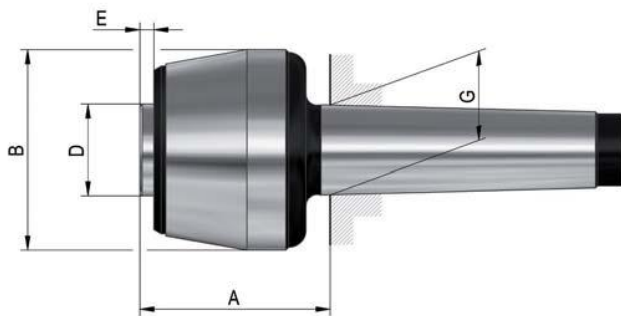
With interchangeable inserts made of wear-resistant tool steel for maximum flexibility.

## CUSTOMER BENEFITS

- ⊕ Wide range of applications thanks to interchangeable inserts
- ⊕ Quick change of interchangeable inserts

## TECHNICAL FEATURES

- Body hardened and ground
- Inserts through-hardened and ground



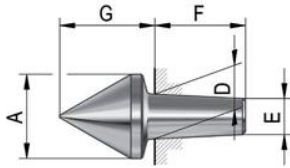
A06  
Flex for **interchangeable inserts**, body hardened and ground

| Item no.                        | 061030 | 061031 | 061032 | 061038 | 061039 | 061040 |
|---------------------------------|--------|--------|--------|--------|--------|--------|
| Mount MT                        | 2      | 3      | 3      | 4      | 5      | 6      |
| Size                            | 102    | 104    | 106    | 108    | 110    | 114    |
| A mm                            | 45     | 48     | 55     | 67     | 85     | 101    |
| B mm                            | 43     | 48,5   | 58,5   | 68,5   | 88,5   | 102,5  |
| D mm                            | 20     | 22     | 25     | 32     | 40     | 50     |
| E mm                            | 4      | 4      | 5,5    | 5      | 6      | 6      |
| G mm                            | 17,78  | 23,825 | 23,825 | 31,267 | 44,399 | 63,348 |
| Concentricity deviation max. mm | 0,01   | 0,01   | 0,01   | 0,01   | 0,01   | 0,015  |
| Speed max. min <sup>-1</sup>    | 7000   | 6300   | 5000   | 3800   | 3000   | 2600   |
| Workpiece weight max. kg        | 40     | 130    | 150    | 250    | 650    | 900    |
| Weight without inserts          | 440    | 750    | 1100   | 1900   | 4400   | 8600   |
| Weight g                        | 900    | 1700   | 2200   | 3700   | 8000   | -      |
| Spare live spindle              | 009836 | 009838 | 009843 | 009870 | 009872 | 009874 |

# Interchangeable inserts

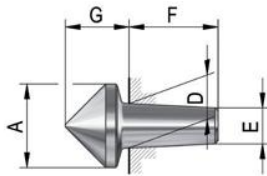
Live centres

A06  
Interchangeable inserts 60°



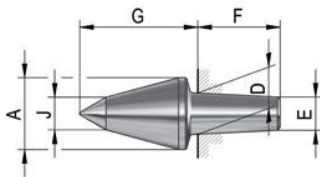
| Item no. | Size | A mm | D mm | E mm | F mm | G mm |
|----------|------|------|------|------|------|------|
| 070725   | 102  | 16   | 7    | 5,2  | 18   | 20   |
| 070728   | 104  | 20   | 12   | 9,6  | 24   | 24   |
| 070731   | 106  | 24   | 12   | 9,6  | 24   | 27,5 |
| 070734   | 108  | 28   | 15   | 12   | 30   | 31,5 |
| 070737   | 110  | 38   | 22   | 18,5 | 35   | 43   |
| 070740   | 114  | 50   | 28   | 24   | 40   | 54   |

A06  
Interchangeable inserts 90°



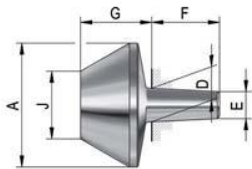
| Item no. | Size | A mm | D mm | E mm | F mm | G mm |
|----------|------|------|------|------|------|------|
| 070727   | 102  | 16   | 7    | 5,2  | 18   | 14,5 |
| 070730   | 104  | 20   | 12   | 9,6  | 24   | 16,5 |
| 070733   | 106  | 24   | 12   | 9,6  | 24   | 19   |
| 070736   | 108  | 28   | 15   | 12   | 30   | 21,5 |
| 070739   | 110  | 38   | 22   | 18,5 | 35   | 29   |
| 070742   | 114  | 50   | 28   | 24   | 40   | 36   |

A06  
Interchangeable inserts 60°VL



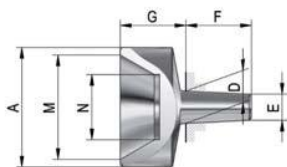
| Item no. | Size     | A mm | D mm | E mm | F mm | G mm | J mm |
|----------|----------|------|------|------|------|------|------|
| 070719   | 102      | 14   | 7    | 5,2  | 18   | 25   | 6    |
| 070720   | 104; 106 | 18   | 12   | 9,6  | 24   | 30   | 8    |
| 070721   | 108      | 26   | 15   | 12   | 30   | 43   | 12   |
| 070722   | 110      | 32   | 22   | 18,5 | 35   | 55   | 13   |
| 070723   | 114      | 42   | 28   | 24   | 40   | 70   | 18,5 |

A06  
Interchangeable inserts for tubular workpieces 60°



| Item no. | Size | A mm | D mm | E mm | F mm | G mm | J mm |
|----------|------|------|------|------|------|------|------|
| 070700   | 102  | 25   | 7    | 5,2  | 18   | 21   | 10   |
| 070701   | 104  | 35   | 12   | 9,6  | 24   | 26   | 15   |
| 070702   | 106  | 45   | 12   | 9,6  | 24   | 27   | 25   |
| 070703   | 108  | 55   | 15   | 12   | 30   | 31,5 | 30   |
| 070704   | 110  | 70   | 22   | 18,5 | 35   | 39   | 40   |
| 070705   | 114  | 100  | 28   | 24   | 40   | 52   | 55   |

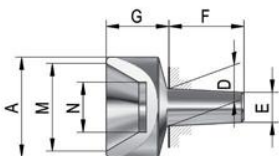
A06  
Interchangeable inserts A for centreless workpieces 60°



| Item no. | Size | A mm | D mm | E mm | F mm | G mm | M mm | N mm |
|----------|------|------|------|------|------|------|------|------|
| 070707   | 102  | 25   | 7    | 5,2  | 18   | 18   | 20   | 10   |
| 070708   | 104  | 35   | 12   | 9,6  | 24   | 24   | 30   | 15   |
| 070709   | 106  | 45   | 12   | 9,6  | 24   | 25   | 40   | 25   |
| 070710   | 108  | 55   | 15   | 12   | 30   | 30   | 48   | 30   |
| 070711   | 110  | 70   | 22   | 18,5 | 35   | 39   | 63   | 40   |
| 070712   | 114  | 100  | 28   | 24   | 40   | 52   | 90   | 55   |

# Interchangeable inserts

A06  
Interchangeable inserts **B** for centreless workpieces **60°**



| Item no. | Size | A mm | D mm | E mm | F mm | G mm | M mm | N mm |
|----------|------|------|------|------|------|------|------|------|
| 228620   | 102  | 16   | 7    | 5,2  | 18   | 12   | 12   | 6    |
| 228621   | 106  | 22   | 12   | 9,6  | 24   | 16   | 18   | 10   |
| 228622   | 108  | 40   | 15   | 12   | 30   | 25   | 35   | 20   |
| 308632   | 110  | 52   | 22   | 18,5 | 35   | 30   | 45   | 30   |

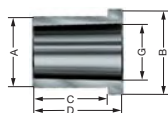
Live centres

A06  
**Extractor**



| Item no. | For size    |
|----------|-------------|
| 061707   | 102         |
| 061708   | 104/106/108 |
| 061709   | 110/114     |

A14  
**Mounting sleeve** for clamping the face driver in the rotary chuck



| Item no. | MT inside | A mm | B mm | C mm | D mm | G mm   |
|----------|-----------|------|------|------|------|--------|
| 085033   | 3         | 32   | 39   | 32   | 40   | 23,825 |
| 085034   | 4         | 40   | 47   | 42   | 50   | 31,267 |
| 085035   | 5         | 55   | 62   | 52   | 60   | 44,399 |
| 085036   | 6         | 75   | 83   | 62   | 70   | 63,448 |

# Flex - interchangeable inserts

Live centres



### APPLICATION

For counter-clamping workpieces on turning and grinding machines.

### TYPE

With interchangeable inserts made of wear-resistant tool steel for maximum flexibility.

### CUSTOMER BENEFITS

- ⌚ Wide range of applications thanks to interchangeable inserts
- ⌚ Quick change of interchangeable inserts

### TECHNICAL FEATURES

- Body hardened and ground
- Inserts through-hardened and ground

### Included in scope of delivery:

- 1 basic body for interchangeable inserts
- 1 extractor
- 1 insert 60°, 90°, 60°VL
- 1 insert or tubular workpieces 60°
- 2 inserts for centreless workpieces 60°
- Inclusive wooden case

A06

**Complete** with all inserts in a sturdy wooden case

| Item no.                 | 061702 | 061703 | 061704 | 061705 | 061706 |
|--------------------------|--------|--------|--------|--------|--------|
| Mount MT                 | 2      | 3      | 3      | 4      | 5      |
| Size                     | 102    | 104    | 106    | 108    | 110    |
| Workpiece weight max. kg | 40     | 130    | 150    | 250    | 650    |
| Weight g                 | 900    | 1700   | 2200   | 3700   | 8000   |