



ROYAL QG COMBO CHUCK

Easily Switch Between OD, ID, and 5C Applications

The Best of Both Worlds

The Royal QG Combo Chuck represents the next generation of our best-selling Accu-Length™ CNC Collet Chucks – it's a Quick-Grip™ Collet Chuck, I.D. Workholding System, and 5C Collet Chuck All-in-One!

- ✓ At its core, this is a Quick-Grip™ Accu-Length™ Collet Chuck, and because there is no z-axis movement of the collet or workpiece, the chuck is perfectly suited for both main and sub-spindle applications.
- ✓ The chuck can also be quickly converted to an I.D. workholding system simply by attaching the nose cap and mandrel. Changeover time takes just minutes and no adjusting of the prox switches is required.
- ✓ For very small diameter work, a 5C collet nose is also available (pullback actuation).

NEW



**Customer comment –
“No need to adjust the prox switches because the chuck is always in the push mode. It is a real game-changer!”**

Accu-Length™ Operation – A Very Important Royal Advantage!

Unlike other combination chucks that are based upon a pullback collet design, the Royal QG Combo Chuck is modeled on our Accu-Length™ design, ensuring precise part transfers from main to sub with no risk of z-axis part movement. This makes the Royal QG Combo chuck a much better solution for sub-spindle applications compared to the pullback models offered by others.

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Lightning-Fast Collet Changes

Changing collets on a Royal Quick-Grip™ collet chuck takes just a few seconds. A unique hook and groove design for securing the collet is used instead of traditional threads.

Widest Collet Gripping Range

With a gripping range of 0.062" per collet, you don't need to worry if your stock is off-size.

Accu-Length™ Design – A Very Important Royal Advantage

Unlike other combination chucks that are based upon a pullback collet design, the Royal QG Combo Chuck is based on our Accu-Length™ design, ensuring precise part transfer from main to sub with no risk of z-axis part movement. This makes the Royal QG Combo chuck **a much better solution for sub-spindle applications** compared to the pullback models offered by others.

Extreme Accuracy

Like all Royal QG Collet Chucks, accuracy is guaranteed to be within 0.0002" TIR when being used as a collet chuck, and the I.D. mandrel can be dialed in to almost absolute zero when being used as an I.D. system.



Parallel Workpiece Gripping

With all Royal QG Collet Chucks, the collet segments always remain parallel to the workpiece for full-length part engagement, enabling **much more aggressive chip removal**.

Heavy-Duty Construction

All chuck components, except for the drawtube connector, are hardened to Rc 61-63 for high rigidity and durability.

An included anodized aluminum ring protects the precision locating taper from chip exposure when using as a conventional collet chuck.

Coolant Slinger

The chuck body incorporates an oversized flange to protect the machine tool spindle bearings from coolant penetration.

Bolt and Go™

The special nose cap that houses the I.D. mandrel is based upon a **precision face/taper interface to ensure near-perfect repeatability during changeovers**. The mounting taper is located on the back side of the nose and is protected from chips by an aluminum ring when the I.D. system is not being used.

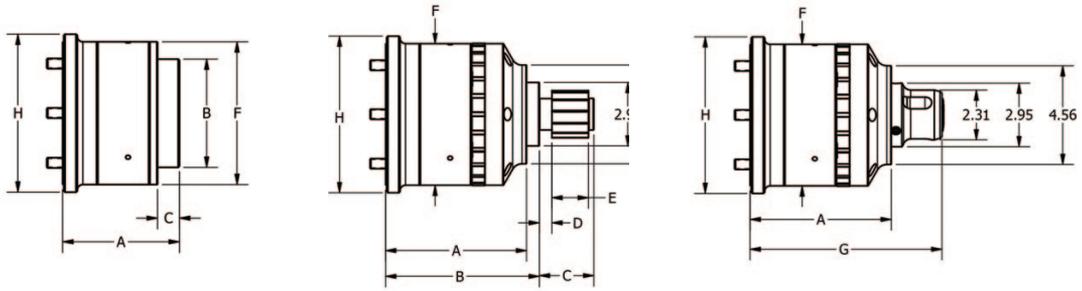
Simple Installation

All Royal QG Collet Chucks include a custom-machined drawtube connector and all mounting hardware for hassle-free installation.



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Chuck Only

SPINDLE TYPE	COLLET TYPE	CHUCK STYLE	A	B	C	F	H	CHUCK WEIGHT (lbs.)	MAX DRAWBAR FORCE (lbs.)	MAX CLAMPING FORCE (lbs.)	MAX RPM
A2-5	QG-52	C	4.80	4.37	0.87	6.10	6.85	28	7,865	17,980	6,000
A2-5	QG-52	UC	4.20	4.37	0.87	6.10	6.10	22	7,865	17,980	6,000
A2-6	QG-52	UC	4.60	4.37	0.87	6.15	7.25	26	7,865	17,980	6,000
110 MM	QG-52	UC	4.20	4.37	0.87	6.10	6.10	24	7,865	17,980	6,000
115 MM	QG-52	UC	4.40	4.37	0.87	6.10	6.10	24	7,865	17,980	6,000
140 MM	QG-52	UC	4.20	4.37	0.87	6.10	6.10	23	7,865	17,980	6,000
A2-5	QG-65	C	4.80	4.96	1.00	6.55	7.25	30	10,115	23,600	6,000
A2-5	QG-65	UC	4.50	4.96	1.00	6.55	6.55	27	10,115	23,600	6,000
A2-6	QG-65	C	5.33	4.96	1.00	6.55	7.25	34	10,115	23,600	6,000
A2-6	QG-65	UC	4.65	4.96	1.00	6.55	7.25	27	10,115	23,600	6,000
A2-6	QG-65	EL	7.00	4.96	1.00	6.55	7.25	48	10,115	23,600	6,000
A2-8	QG-65	C	5.50	4.96	1.00	6.55	9.45	48	10,115	23,600	6,000
110 MM	QG-65	UC	4.45	4.96	1.00	6.55	6.55	28	10,115	23,600	6,000
140 MM	QG-65	UC	4.80	4.96	1.00	6.55	7.45	32	10,115	23,600	6,000
A2-5	QG-80	C	4.95	5.68	1.00	7.45	7.45	40	11,240	25,850	5,000
A2-6	QG-80	C	4.95	5.68	1.00	7.45	7.45	40	11,240	25,850	5,000
A2-6	QG-80	EL	7.00	5.68	1.00	7.45	7.45	64	11,240	25,850	5,000
A2-8	QG-80	C	5.20	5.68	1.00	7.45	7.45	50	11,240	25,850	5,000
140 MM	QG-80	C	4.95	5.68	1.00	7.45	7.45	40	11,240	25,850	5,000

Chuck with I.D. Gripping Setup

SPINDLE TYPE	COLLET TYPE	CHUCK STYLE	A	B	C	D	E	WEIGHT (lbs.)
A2-5	QG-52	C	6.12	6.70				42
A2-5	QG-52	UC	5.52	6.10				36
A2-6	QG-52	UC	5.92	6.51				40
110 MM	QG-52	UC	5.72	6.30				38
115 MM	QG-52	UC	5.72	6.30				38
140 MM	QG-52	UC	5.72	6.30				38
A2-5	QG-65	C	5.99	6.57				45
A2-5	QG-65	UC	5.69	6.27				42
A2-6	QG-65	C	6.52	7.10				49
A2-6	QG-65	UC	5.84	6.43				42
A2-6	QG-65	EL	8.19	8.77				63
A2-8	QG-65	C	6.69	7.27				63
110 MM	QG-65	UC	5.64	6.22				43
140 MM	QG-65	UC	5.99	6.57				47
A2-5	QG-80	C	6.14	6.72				59
A2-6	QG-80	C	6.14	6.72				59
A2-6	QG-80	EL	8.19	8.77				83
A2-8	QG-80	C	6.39	6.97				68
140 MM	QG-80	C	6.14	6.72				59

SEE
MANDREL
CHART

Chuck with 5C Setup

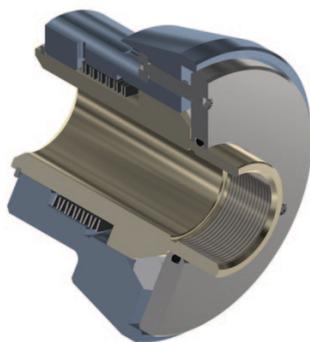
SPINDLE TYPE	COLLET TYPE	CHUCK STYLE	A	F	G	H	WEIGHT (lbs.)
A2-5	QG-52	C	6.12	6.10	8.45	6.85	44
A2-5	QG-52	UC	5.52	6.10	7.85	6.10	38
A2-6	QG-52	UC	5.92	6.15	8.25	7.25	42
110 MM	QG-52	UC	5.72	6.10	8.05	6.10	40
115 MM	QG-52	UC	5.72	6.10	8.05	6.10	40
140 MM	QG-52	UC	5.72	6.10	8.05	6.10	40
A2-5	QG-65	C	5.99	6.55	8.32	7.25	47
A2-5	QG-65	UC	5.69	6.55	8.02	6.55	44
A2-6	QG-65	C	6.52	6.55	8.85	7.25	51
A2-6	QG-65	UC	5.84	6.55	8.17	7.25	44
A2-6	QG-65	EL	8.19	6.55	10.52	7.25	65
A2-8	QG-65	C	6.69	6.55	9.02	9.45	65
110 MM	QG-65	UC	5.64	6.55	7.97	6.55	45
140 MM	QG-65	UC	5.99	6.55	8.32	7.45	49
A2-5	QG-80	C	6.14	7.45	8.47	7.45	61
A2-6	QG-80	C	6.14	7.45	8.47	7.45	61
A2-6	QG-80	EL	8.19	7.45	10.52	7.45	85
A2-8	QG-80	C	6.39	7.45	8.72	9.45	71
140 MM	QG-80	C	6.14	7.45	8.47	7.45	62

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How It Works



To maintain precise z-axis positioning of the workpiece, the collet in a Royal Accu-Length™ Collet Chuck is fixed to the body and the chuck's closing sleeve pushes forward over the collet to compress it. The collet, and therefore the workpiece, remains fixed in the z-position.

With our I.D. Workholding System, the mandrel is fixed to the chuck body and a tapered pin is pulled back into the sleeve to expand it.

The Royal QG Combo Chuck uses a **clever motion reversal adapter** that converts the push-forward action of the closing sleeve to pullback motion that actuates the I.D. system via a series of hardened wedges. Simple, effective, and extremely durable!

Note – Actuator pressure may need to be adjusted to achieve optimal clamping force. Visit royalproducts.com for clamping force information.

Flexibility for Today's Jobs – and Tomorrow's!



By choosing the Royal QG Combo Chuck, you're minimizing changeover time between jobs and guaranteeing yourself tremendous flexibility.

The QG Combo Chuck operates exactly as a standard Royal QG Accu-Length™ Collet Chuck does, while offering a ton of additional functionality.

To add I.D. or 5C capabilities, simply install the nose cap and push/pull adapter (sold separately) and affix Royal's I.D. mandrels/sleeves found on pages 84-85, or our 5C collet adapter.

The chuck body never needs to be removed from the lathe spindle, so changing between jobs is fast, easy, and safe.

- ✓ Available in Models QG-52, 65, and 80
- ✓ All Models In Stock for Same-Day Shipping



Check out the Royal QG Combo Chuck Video at www.royalproducts.com



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How To Order

1. Choose the appropriate collet chuck based upon lathe spindle nose and desired collet range:
 - GG-52 – 2.03" round capacity
 - QG-65 – 2.66" round capacity
 - QG-80 – 3.28" round capacity
2. To add I.D. gripping or 5C gripping, order nose cap and push/pull adapter assembly for your specific Combo Chuck.
3. Order I.D. workholding components (including expanding rod adapters) and/or 5C collet nose as needed.

NEW



Quick-Grip™ Combo CNC Collet Chucks

SPINDLE TYPE	COLLET TYPE	PART NUMBER	PRICE
A2-5	QG-52	65110	\$5,840
A2-5	QG-52	65111	5,840
A2-6	QG-52	65112	5,840
110 MM	QG-52	65113	5,840
115 MM	QG-52	65109	5,840
140 MM	QG-52	65114	5,840
A2-5	QG-65	65115	6,270
A2-5	QG-65	65116	6,270
A2-6	QG-65	65117	6,270
A2-6	QG-65	65118	6,270
A2-6	QG-65	65119	6,270
A2-8	QG-65	65120	7,050
110 MM	QG-65	65121	6,840
140 MM	QG-65	65122	6,840
A2-5	QG-80	65123	7,270
A2-6	QG-80	65124	7,270
A2-6	QG-80	65125	7,270
A2-8	QG-80	65126	7,270
140 MM	QG-80	65127	7,270

QG Combo Chuck Accessories

Nose Cap with Push/Pull Adapter

Required for I.D. and/or 5C Gripping

FITS COMBO CHUCK MODEL	PART NUMBER	PRICE
QG-52	65132	\$3,940
QG-65	65133	4,190
QG-80	65134	4,850

Expanding Rod Adapters

Required for I.D. Gripping

FITS MANDREL MODEL	PART NUMBER	PRICE
A	65140	\$415
B & C	65141	415
D	65142	415
E	65143	415

5C Collet Nose

PART NUMBER	PRICE
65138	\$1,235