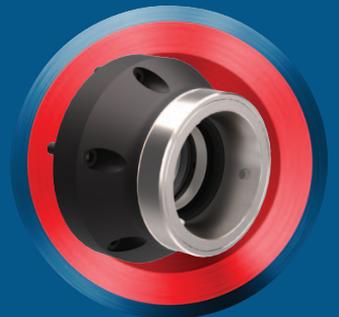
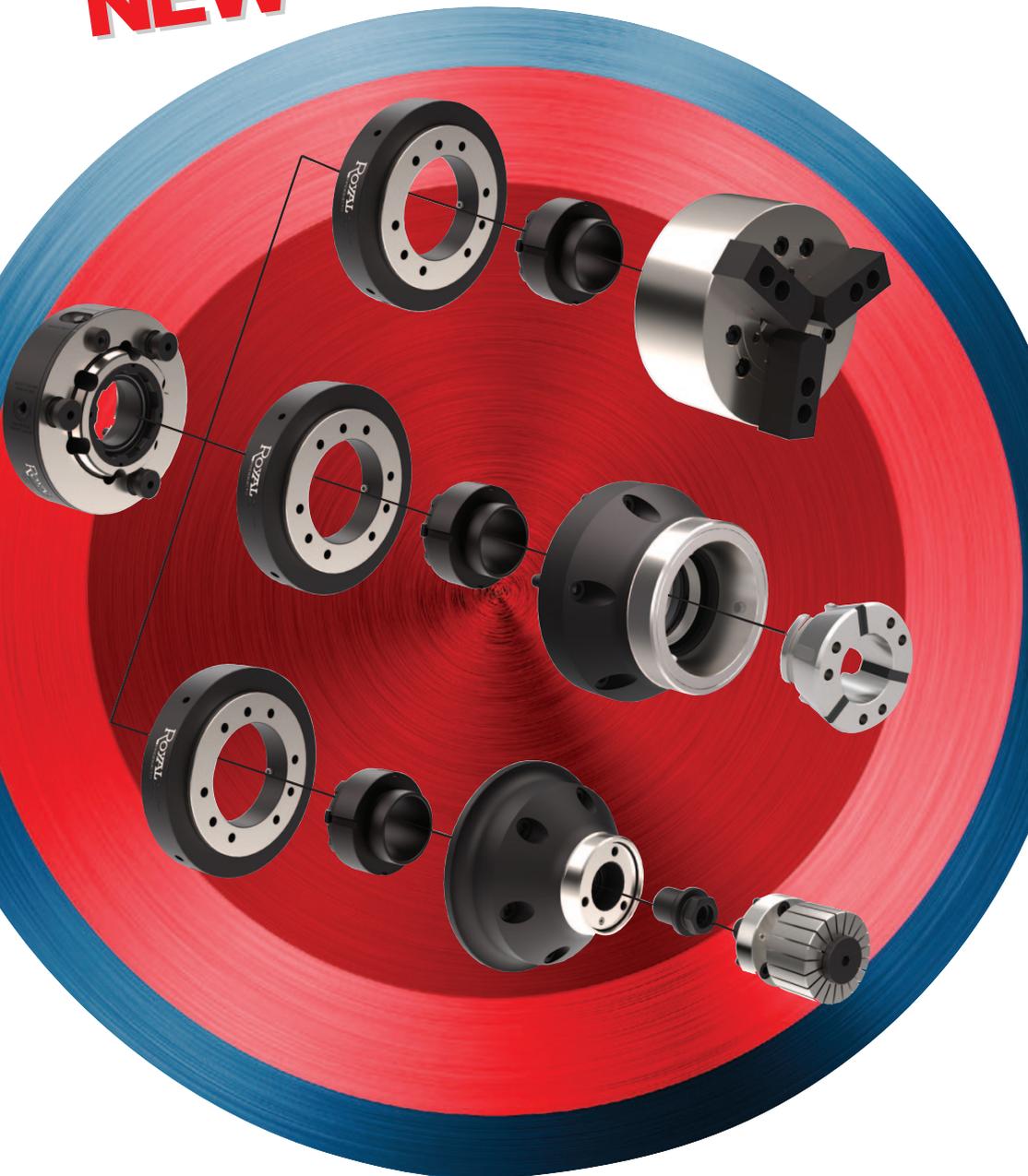




# RCS™ RAPID CHANGE SYSTEM

A MASTER RECEIVER COMBINED WITH  
QUICK-CHANGE SUBPLATES ENABLES YOUR  
CNC LATHE WORKHOLDING TO BE CHANGED  
QUICKLY, EASILY AND SAFELY.

**NEW**





# ROYAL RCS™ RAPID CHANGE SYSTEM

## The Royal RCS™ Brings Quick-Change Workholding to Your Existing CNC Lathes and Enables You to Use the Chucks You Already Own

**NEW**

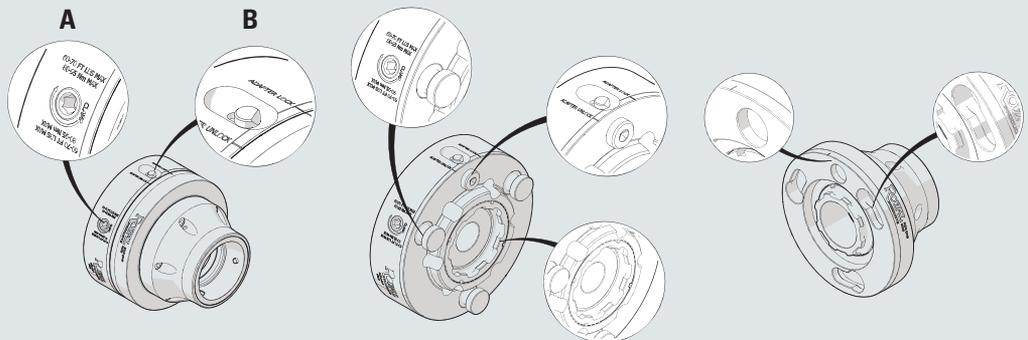


- Changing out the workholding on your CNC lathes as jobs demand can be a time-consuming hassle.
- The Royal RCS™ greatly simplifies and speeds up CNC Lathe workholding changeovers via a master receiver that mounts to the lathe spindle and quick-change subplates with integral bayonet couplers.
- The Royal Rapid Change System is **the perfect solution for job shops** because it eliminates the need to schedule work through specific machines based upon how a machine's workholding is already configured.
- Addresses workforce challenges faced by many manufacturers by simplifying the process of chuck changeovers.
- With the RCS™ you aren't locked into Royal's workholding – we can adapt the subplates and bayonet couplers to any jaw chuck, collet chuck, ID system, etc. so you can continue to use the workholding you already own, like, and trust.
- Don't wait to integrate this system into your next CNC lathe – **it's the perfect solution for increasing throughput and profitability on the machines you already own.**

### Change Chucks in Less Than Five Minutes!

#### Here's How it Works:

1. Release cams (3) "A"
2. Push release button "B"
3. Rotate chuck 25 degrees counterclockwise
4. Remove chuck
5. Install next chuck
6. Rotate chuck 25 degrees clockwise
7. Lock cams



# ROYAL RCS™ RAPID CHANGE SYSTEM



## Master Receiver

Once the master receiver is mounted to the lathe spindle it never needs to be removed.

## Precision Repeatability

Guaranteed to 0.0002".



Proudly  
Made  
in U.S.A.

## Exceptional Strength

Hardened, ground, and engineered to work with both push and pull workholding devices.

## Flexible and Adaptable

Easily integrates with your existing jaw chucks, collet chucks, ID workholding, etc.



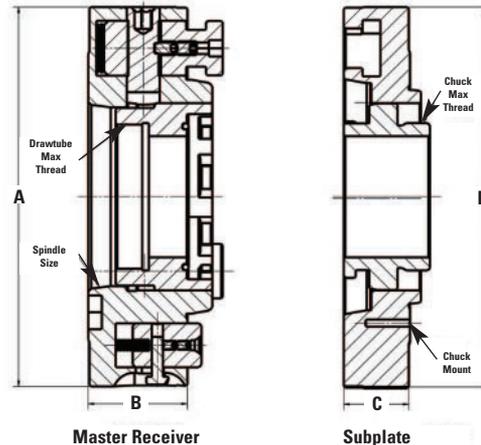
Check out the Royal RCS™ Rapid Change System Video at [www.royalproducts.com](http://www.royalproducts.com)



# ROYAL RCS™ RAPID CHANGE SYSTEM

## How to Order

1. Choose the master receiver based upon your lathe spindle nose and chuck diameters. This component always remains bolted to the lathe spindle and includes a custom machined drawtube connector with bayonet interface.
2. Order the appropriate subplates corresponding to the receiver model. Each subplate includes a custom machined bayonet coupler matched to the chuck that will be mounted to it.



## Royal RCS™ Receivers\*

LATHE SPINDLE TYPE	DESCRIPTION	MAX BAR CAPACITY	A	B	DRAWTUBE MAX THREAD	MAX DRAWTUBE FORCE (lbs.)		MAX RPM	WEIGHT (lbs.)	PART NUMBER	PRICE*
						PULL	PUSH				
A2-6	RCS-8 Receiver with A2-6 Mount	3.00	8.63	2.25	M85	12,000	11,500	5,000	32	65202	\$9,985
A2-6	RCS-10 Receiver with A2-6 Mount	3.31	9.94	2.25	M95	15,000	15,000	4,200	43	65204	9,985
A2-8	RCS-10 Receiver with A2-8 Mount	3.31	9.94	2.25	M95	15,000	15,000	4,200	41	65206	9,985

\* Includes custom machined drawtube connector with bayonet interface.

## Royal RCS™ Subplates with Couplers

RCS™ RECEIVER MODEL	DESCRIPTION	MAX BAR CAPACITY	C	D	CHUCK MAX THREAD	MAX DRAWTUBE FORCE (lbs.)		MAX RPM	WEIGHT (lbs.)	PART NUMBER	PRICE*
						PULL	PUSH				
RCS-8	RCS-8 to QG-65 Subplate with Coupler	2.60	1.50	8.63	N/A	12,000	10,115	5,000	18	65215	\$6,285
RCS-8	RCS-8 to QG-80 Subplate with Coupler	3.19	1.50	8.63	N/A	12,000	11,240	5,000	19	65216	6,285
RCS-8	RCS-8 to A2-6 Subplate with Coupler	3.00	2.25	8.63	M90	12,000	11,500	5,000	23	65220	7,185
RCS-8	RCS-8 to 170MM Mount 8" 3-Jaw Chuck Subplate with Coupler	3.00	1.81	8.63	M105	12,000	11,500	5,000	24	65210	6,735
RCS-8	RCS-8 to 220MM Mount 10/12" 3-Jaw Chuck Subplate with Coupler	3.00	1.81	8.66	M105	12,000	11,500	5,000	23	65211	6,735
RCS-10	RCS-10 to QG-65 Subplate with Coupler	2.60	1.50	9.94	N/A	15,000	10,115	4,200	25	65217	6,735
RCS-10	RCS-10 to QG-80 Subplate with Coupler	3.19	1.50	9.94	N/A	15,000	11,240	4,200	25	65218	6,735
RCS-10	RCS-10 to A2-6 Subplate with Coupler	3.00	2.94	9.94	M90	15,000	15,000	4,200	35	65221	7,185
RCS-10	RCS-10 to A2-8 Subplate with Coupler	3.31	1.31	9.94	M120	15,000	15,000	4,200	22	65222	7,185
RCS-10	RCS-10 to 170MM Mount 8" 3-Jaw Chuck Subplate with Coupler	3.31	2.81	9.94	M100	15,000	15,000	4,200	39	65212	7,185
RCS-10	RCS-10 to 220MM Mount 10/12" 3-Jaw Chuck Subplate with Coupler	3.31	1.75	9.94	M120	15,000	15,000	4,200	28	65213	7,185

\*Includes bayonet coupler.

**NOTE** – Royal stocks all receivers and subplates. However, the bayonet couplers need to be customized for each specific chuck. Royal will contact you if dimensional information is required. Please allow 6 weeks for delivery.