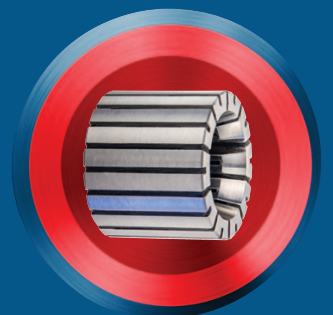
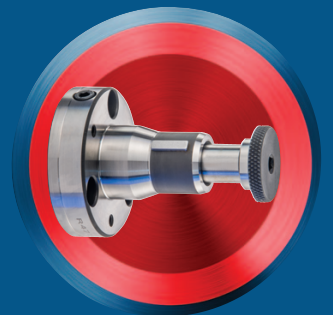
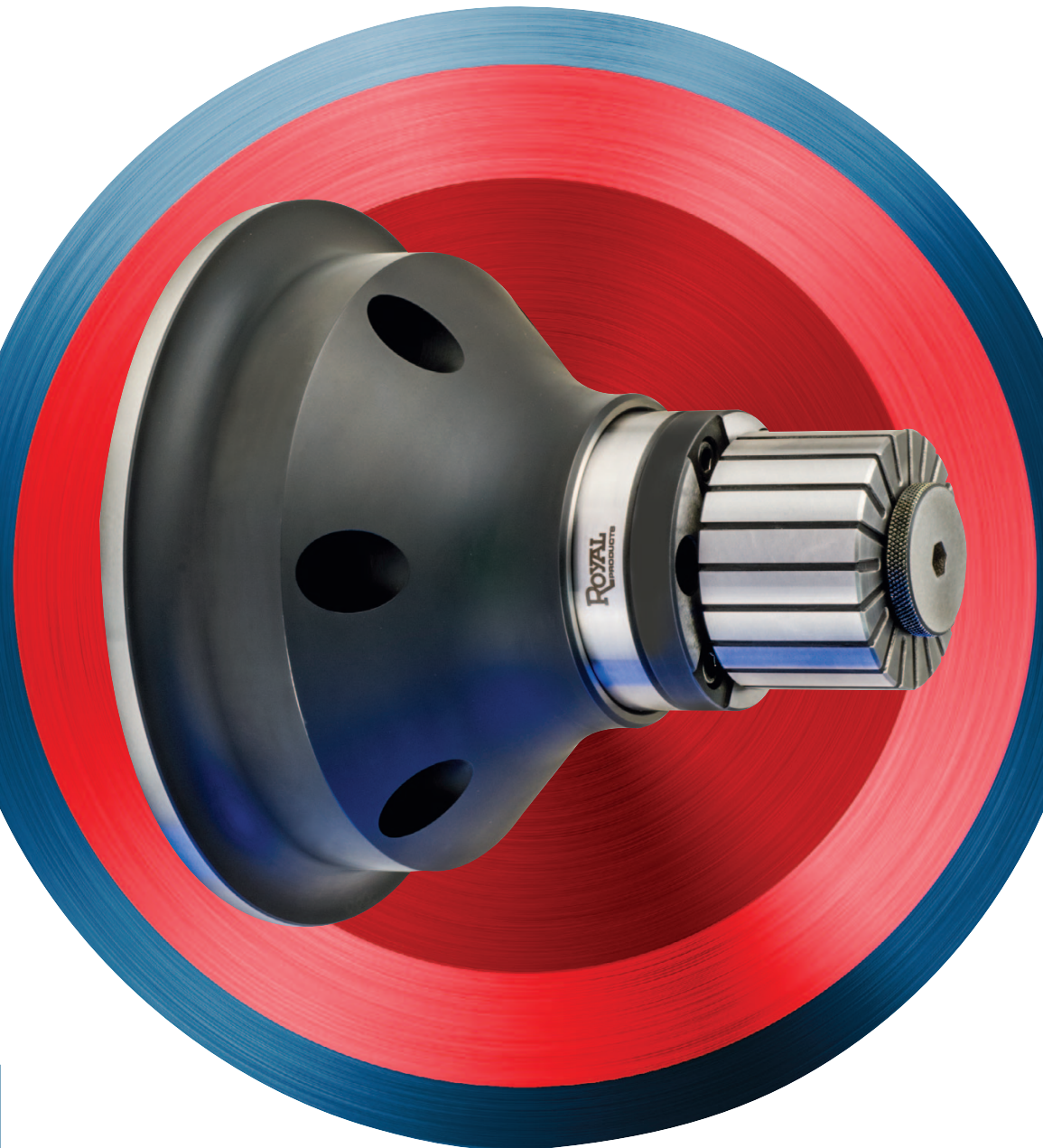




I.D. WORKHOLDING

- I.D. CLAMPING OFFERS FULL O.D. PART ACCESS
- PARALLEL EXPANSION FOR OPTIMUM ACCURACY AND GRIP FORCE
- LARGE RANGE IN STOCK FOR IMMEDIATE SHIPMENT





ROYAL I.D. WORKHOLDING SYSTEMS

Royal Offers Three Standard Off-the-Shelf I.D. Workholding Systems Designed to Suit a Wide Range of Applications:



CNC

- For use on all CNC Lathes.
- Actuated via machine's drawtube.
- Accu-Length™ design makes this system **a great sub-spindle workholding option.**
- Includes a custom-machined drawtube connector to fit your specific lathe.



Power-Block™

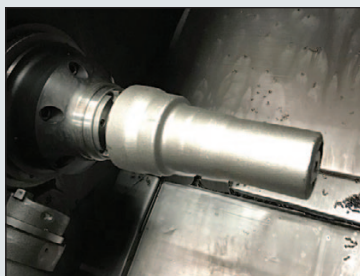
- For use on all Machining Centers.
- Can be used in both **stationary and 4th/5th -axis applications.**
- Hydraulic or pneumatic actuation.
- Well suited to auto-load applications.



Key-Operated

- Universal – can be used in virtually any turning, milling, or grinding application.
- 1-1/2" dia. shank is quickly and easily gripped in a chuck or collet.
- **Manual actuation** makes this model best suited to non-production applications.

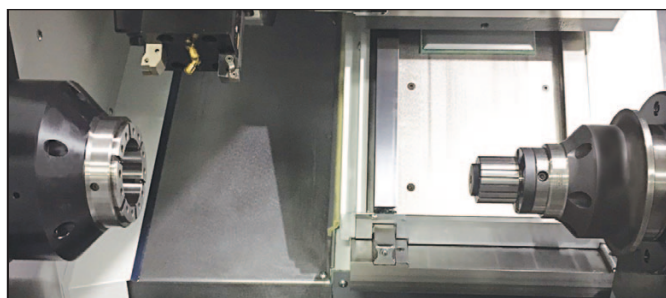
I.D. Gripping is Often Overlooked as a Workholding Option, Yet in Many Situations it is the Best Choice



Shown here, a long casting is gripped via the I.D. bore so the full O.D. can be machined in a single operation.

- ✓ A part's full length can be turned in a single operation, guaranteeing perfect concentricity of all O.D. features.
- ✓ I.D. gripping offers an alternative to gripping on a finished O.D. surface, reducing the risk of part damage.
- ✓ For many parts, the engagement-length of an internal bore can be greater than what is available for external gripping, resulting in superior rigidity and torque transmission.
- ✓ I.D. systems provide optimal tool clearance, making them a great option for lathes with live tooling.

Perfect Combination – A Royal Quick-Grip™ CNC Collet Chuck on the main spindle and a Royal CNC I.D. Workholding System on the sub.



ROYAL CNC I.D. WORKHOLDING

For Turning Applications



Bolt & Go™

Royal's exclusive Bolt & Go™ mounting feature **ensures maximum accuracy and rigidity** with no adjusting required. Other systems require the mandrel to be trammed in – a hassle that wastes valuable machining time.

Oversized Flange

Borrowing from the winning design of our CNC Collet Chucks, all bodies feature an oversized flange to protect the machine tool spindle bearings from coolant penetration.

Z-Axis Repeatability

Pullback action draws the workpiece securely against a ground locating plate for maximum **"dual-contact" rigidity** and consistent z-axis repeatability.

Easy Installation

Royal CNC I.D. Workholding Systems include all mounting hardware, wrenches, and a custom-machined drawtube connector to ensure **hassle-free installation**.

Heavy-Duty Construction

Royal consistently builds products that outlast the competition, especially in the most demanding environments. Bodies, mandrels, and expanding rods are all hardened to Rc 61-63 for maximum durability.

Same-Day Shipping

Royal maintains a huge inventory of standard bodies, mandrels, and sleeves to help us achieve our goal of same-day shipping on all orders.

Ultra-Precision Accuracy

System runout guaranteed to be **0.0005" TIR or better**.

Modular Design

Mandrel models A-E all have a common mounting interface with the body so the system can grow with your needs.

Wide Gripping Range

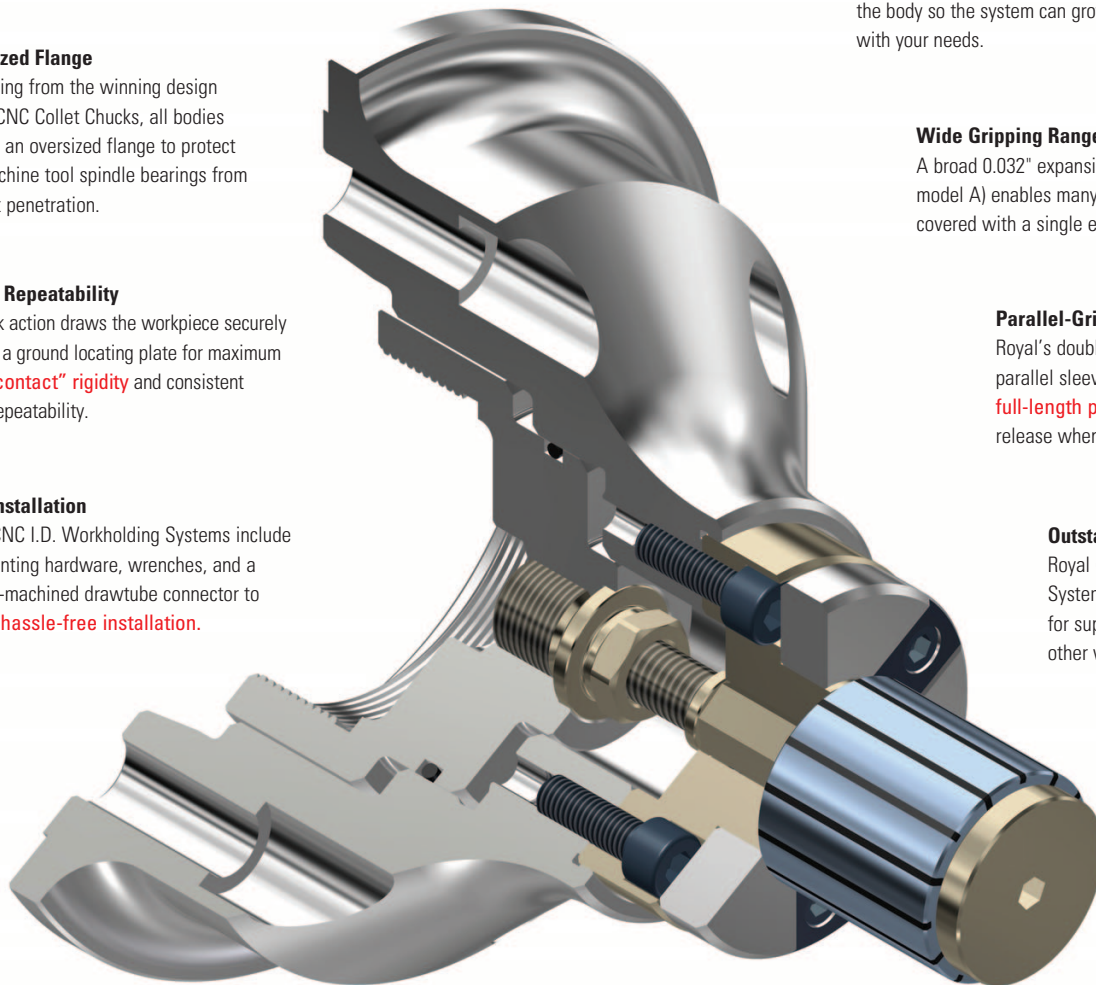
A broad 0.032" expansion range (0.020" for model A) enables many bore sizes to be covered with a single expanding sleeve.

Parallel-Grip

Royal's double-angle design provides parallel sleeve expansion, ensuring **full-length part contact** and positive release when the part is unclamped.

Outstanding Tool Clearance

Royal CNC I.D. Workholding Systems have been optimized for superior tool clearance over other workholding systems.



Custom Systems

If our standard line doesn't meet your needs, give us a call to discuss your special requirements.

Capabilities include:

- Larger sizes – up to 25" diameter
- Extended-length systems
- Multi-step systems for locating on multiple bore diameters
- Automation enhancements such as ejector rings, part confirmation, etc.

Completely Sealed

All expanding sleeve slots are sealed to prevent contaminants from accumulating on the mandrel surface – **ensuring years of trouble-free service**. An internal O-ring on the drawtube connector offers additional protection.



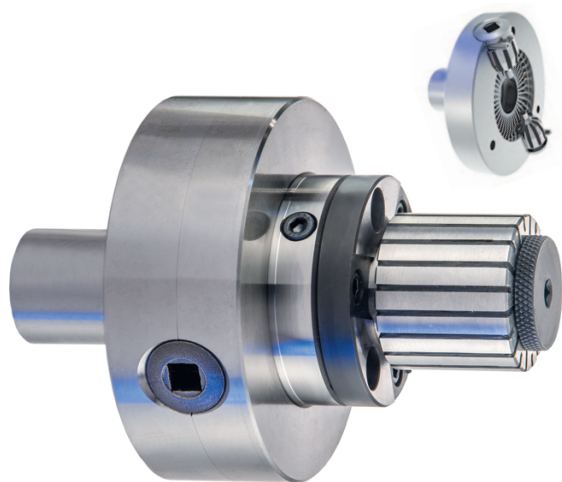
ROYAL POWER-BLOCK™ I.D. WORKHOLDING For Milling Applications



- ❑ The Royal Power-Block™ I.D. Workholding System enables secure gripping on the internal bore of a workpiece for full external machining access.
- ❑ Pullback action draws workpiece securely against a ground locator for precise, consistent z-axis positioning.
- ❑ Unit can be **mounted to a traditional machining center table and can also be used in 4th and 5th -axis applications.**
- ❑ Fixture is designed to be actuated via hydraulic pressure and may also be actuated pneumatically for lighter-duty applications (contact Royal for details).
- ❑ For use with all Royal precision mandrels, stops, and sleeves. These items are sold separately – please see pages 84-85.
- ❑ Heavy-duty all steel construction with a large double-acting piston provides high clamping force.
- ❑ Configured with both side and bottom ports for plumbing flexibility.
- ❑ Multiple units can be plumbed in series for single-source actuation.
- ❑ Ideal for high-production applications on vertical, horizontal, and five-axis machining centers.
- ❑ Tombstone and angle plate compatible.



ROYAL KEY-OPERATED I.D. WORKHOLDING For Turning, Milling and Grinding Applications



- ❑ Royal's Key-Operated I.D. Workholding System incorporates a precision-ground 1-1/2" diameter straight shank that enables the unit to be held in any collet or jaw chuck, **reducing setup times by eliminating the need to change out the machine's workholding device.**
- ❑ For use with all Royal precision mandrels, stops, and sleeves. These items are sold separately – please see pages 84-85.
- ❑ Side-actuated with an included square-drive key means that this unit can accommodate parts with blind bores.
- ❑ Precision-ground square and concentric within 0.0005". If higher accuracy is needed the mandrel can be clocked-in once the unit is gripped in a chuck.
- ❑ Universal straight shank mount enables this I.D. workholding system to be easily moved from machine to machine as jobs require.
- ❑ A great option for low-volume I.D. gripping.
- ❑ When ordering, be sure to also order the appropriate threaded expanding rod adapters sold separately.

ROYAL I.D. WORKHOLDING SYSTEMS

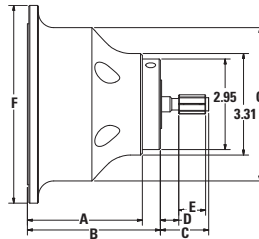
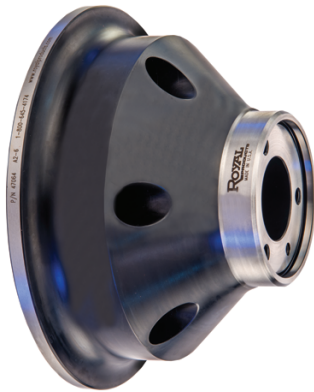


How to Order:

1. Choose the appropriate body assembly based upon your application.
2. Choose the appropriate mandrel (models A-E) based upon the diameter you need to grip. All mandrels and bodies share a common mounting interface for full interchangeability.
3. If required, choose the appropriate part locator to provide a ground banking surface for the workpiece.
4. Choose the appropriate expanding sleeve based upon the mandrel and diameter you need to grip.

Step 1 - Choose Body Assembly

CNC BODY – For CNC Lathes



Dimensions

Note – dimensions shown without optional part locator.

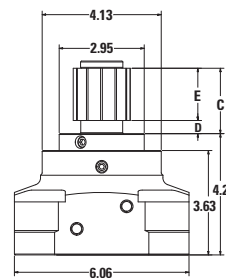
SPINDLE MOUNT	A	B	C	D	E	F	G
A2-5	3.75	4.34	See Mandrel Chart			6.45	5.00
A2-6	4.00	4.59				7.45	6.25
140mm	3.90	4.49				7.45	6.25
A2-8	5.00	5.59				9.45	8.00

- ❑ This body provides a precision interface for mounting the system to a CNC lathe spindle.
- ❑ CNC body assembly includes the hardened steel body, a **custom-machined drawtube connector for hassle-free installation**, and all mounting hardware.
- ❑ Order mandrels, locators, and sleeves separately.

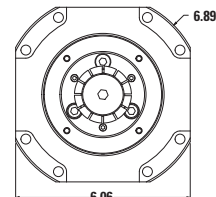
Royal CNC I.D. Body Assemblies

SPINDLE TYPE	PART NUMBER	PRICE
A2-5	47060	\$1,970
A2-6	47064	2,390
140mm	47068	2,550
A2-8	47072	3,190

POWER-BLOCK™ BODY – For Machining Centers



Note – dimensions shown without optional part locator. See mandrel chart for dimensions C, D, and E.



- ❑ This body can be **mounted to any machining center table, 4th/5th-axis rotary tables, angle plates, tombstones, etc.**
- ❑ Body weight is 22 lbs.
- ❑ Order mandrels, locators, and sleeves separately.

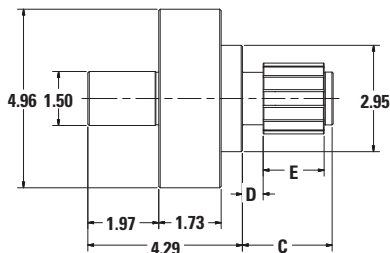
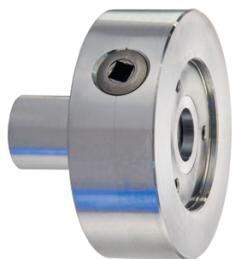
Royal Power-Block™ I.D. Assembly

DESCRIPTION	PART NUMBER	PRICE
Power-Block™ I.D. Body Assembly	47080	\$3,870



ROYAL I.D. WORKHOLDING SYSTEMS

KEY-OPERATED BODY – Universal



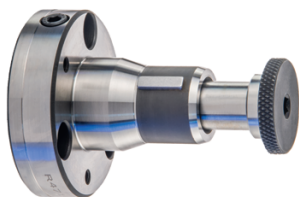
Note – dimensions shown without optional part locator.
See mandrel chart for dimensions C, D, and E.

- This unit has a precision-ground shaft that can be held in any jaw chuck or 1.5" dia. collet, eliminating the need to change out the workholding and **enabling the system to be moved from machine to machine as jobs require.**
- Order mandrels, expanding rod adapters, locators, and sleeves separately.

Royal Key-Operated I.D. Body Assemblies

DESCRIPTION	PART NUMBER	PRICE
Key-Operated I.D. Body Assembly	47300	\$6,010
Expanding Rod Adapter – Fits Model A Mandrels	47310	450
Expanding Rod Adapter – Fits Models B&C Mandrels	47315	450
Expanding Rod Adapter – Fits Model D Mandrels	47325	450
Expanding Rod Adapter – Fits Model E Mandrels	47330	450

Step 2 - Choose Mandrel

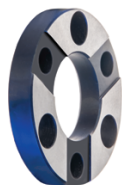


- Choose appropriate mandrel model according to gripping range.
- All Royal mandrels have a common precision ground interface for **complete compatibility with all Royal I.D. body assemblies.**
- Order body assembly, locators, and sleeves separately.

Royal Mandrels

MANDREL MODEL	GRIPPING RANGE	C	D	E	MAX AXIAL FORCE (lbs.)	MAX CLAMPING FORCE (lbs.)	PART NUMBER	PRICE
A	0.479–0.640	1.57	0.57	0.87	1570	2670	47100	\$2,140
B	0.620 –0.901	1.81	0.59	1.06	2245	3820	47101	2,140
C	0.870 –1.151	2.05	0.61	1.26	2695	4580	47102	2,140
D	1.120 –1.651	2.32	0.60	1.50	4045	6875	47103	2,140
E	1.620 –3.276	2.52	0.58	1.69	5170	8785	47104	2,140

Step 3 - Choose Part Locator



- Optional part locator bolts to the front of the mandrel and provides a **precision banking surface** for the workpiece to locate against.
- Order body assembly, mandrels, and sleeves separately.

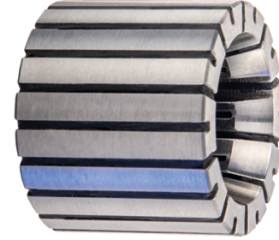
Royal Part Locators

FITS MANDREL MODEL	WIDTH	OUTER DIAMETER	PART NUMBER	PRICE
A	0.47	1.57	47110	\$432
B	0.47	1.57	47111	432
C	0.47	2.95	47112	497
D	0.47	2.95	47113	497
E	0.47	2.95	47114	497



Step 4 - Choose Expanding Sleeve

- Order expanding sleeves according to mandrel models A thru E.
- Royal expanding sleeves are fully sealed against coolant and chip penetration.
- Parallel grip ensures **full-length part contact for optimum accuracy and grip force.**
- All sleeves collapse 0.005" below nominal ground size to ensure easy part loading and unloading.
- Order body assembly, mandrels, and locators separately.



Royal Expanding Sleeves

MODEL A	NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
	31/64"	0.479–0.499	47120*	\$627
	1/2"	0.495–0.515	47121*	627
	33/64"	0.510–0.530	47122	627
	17/32"	0.526–0.546	47123	627

NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
35/64"	0.542–0.562	47124	\$627
9/16"	0.558–0.578	47125	627
37/64"	0.573–0.593	47119	627
19/32"	0.589–0.601	47127	627

NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
39/64"	0.604–0.624	47126	\$627
5/8"	0.620–0.640	47129	627
41/64"	0.636–0.656	47128	627

MODEL B	NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
	5/8"	0.620–0.651	47130*	\$683
	27/32"	0.651–0.682	47131	683
	11/16"	0.683–0.714	47132	683

NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
23/32"	0.714–0.745	47133	\$683
3/4"	0.745–0.776	47134	683
25/32"	0.776–0.807	47135	683

NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
13/16"	0.808–0.839	47136	\$683
27/32"	0.830–0.870	47137	683
7/8"	0.870–0.901	47138	683

MODEL C	NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
	7/8"	0.870–0.901	47140	\$683
	29/32"	0.901–0.932	47141	683
	15/16"	0.933–0.964	47142	683

NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
37/32"	0.964–0.995	47143	\$683
1"	0.995–1.026	47144	683
1 1/32"	1.026–1.057	47145	683

NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
1 1/16"	1.058–1.089	47146	\$683
1 1/32"	1.089–1.120	47147	683
1 1/8"	1.120–1.151	47148	683

MODEL D	NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
	1 1/8"	1.120–1.151	47150	\$745
	1 5/32"	1.151–1.182	47151	745
	1 3/16"	1.183–1.214	47152	745
	1 7/32"	1.214–1.245	47153	745
	1 1/4"	1.145–1.276	47154	745
	1 9/32"	1.276–1.317	47155	745

NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
1 5/16"	1.308–1.339	47156	\$745
1 11/32"	1.339–1.370	47157	745
1 3/8"	1.370–1.401	47158	745
1 13/32"	1.401–1.432	47159	745
1 7/16"	1.433–1.464	47160	745
1 15/32"	1.464–1.495	47161	745

NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
1 1/2"	1.495–1.526	47162	\$745
1 17/32"	1.526–1.557	47163	745
1 9/16"	1.558–1.589	47164	745
1 19/32"	1.589–1.620	47165	745
1 5/8"	1.620–1.651	47166	745

MODEL E	NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
	1 5/8"	1.620–1.651	47170	\$908
	1 21/32"	1.651–1.682	47171	908
	1 11/16"	1.683–1.714	47172	908
	1 23/32"	1.714–1.745	47173	908
	1 3/4"	1.745–1.776	47174	908
	1 25/32"	1.776–1.807	47175	908
	1 13/16"	1.808–1.839	47176	908
	1 27/32"	1.839–1.870	47177	908
	1 7/8"	1.870–1.901	47178	908
	1 29/32"	1.901–1.932	47179	908
	1 15/16"	1.933–1.964	47180	908
	1 31/32"	1.964–1.995	47181	908
	2"	1.995–2.026	47182	908
	2 1/32"	2.026–2.057	47183	908
	2 1/16"	2.058–2.089	47184	908
	2 3/32"	2.089–2.120	47185	908
	2 1/8"	2.120–2.151	47186	908
	2 5/32"	2.151–2.182	47187	908

NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
2 3/16"	2.183–2.214	47188	\$908
2 7/32"	2.214–2.245	47189	908
2 1/4"	2.245–2.276	47190	908
2 9/32"	2.276–2.307	47191	908
2 5/16"	2.308–2.339	47192	908
2 11/32"	2.339–2.370	47193	908
2 3/8"	2.370–2.401	47194	908
2 13/32"	2.401–2.432	47195	908
2 7/16"	2.433–2.464	47196	908
2 15/32"	2.464–2.495	47197	908
2 1/2"	2.495–2.526	47198	908
2 17/32"	2.526–2.557	47199	1,030
2 9/16"	2.558–2.589	47200	1,030
2 19/32"	2.589–2.620	47201	1,030
2 5/8"	2.620–2.651	47202	1,030
2 21/32"	2.651–2.682	47203	1,030
2 11/16"	2.683–2.714	47204	1,030
2 23/32"	2.714–2.745	47205	1,030

NOMINAL SLEEVE DIAMETER	GRIPPING RANGE	PART NUMBER	PRICE
2 3/4"	2.745–2.776	47206	\$1,030
2 25/32"	2.776–2.807	47207	1,030
2 13/16"	2.808–2.839	47208	1,030
2 27/32"	2.839–2.870	47209	1,030
2 7/8"	2.870–2.901	47210	1,030
2 29/32"	2.901–2.932	47211	1,030
2 15/16"	2.933–2.964	47212	1,030
2 31/32"	2.964–2.995	47213	1,030
3"	2.995–3.026	47214	1,030
3 1/32"	3.026–3.057	47215	1,030
3 1/16"	3.058–3.089	47216	1,030
3 3/32"	3.089–3.120	47217	1,030
3 1/8"	3.120–3.151	47218	1,030
3 5/32"	3.151–3.182	47219	1,030
3 3/16"	3.183–3.214	47220	1,030
3 7/32"	3.214–3.245	47221	1,030
3 1/4"	3.245–3.276	47222	1,030

*Not sealed due to limited wall thickness.

Note – sleeves larger than 2-1/2" dia. are 0.28" longer than dimension E and terminate flush with the face of the expanding rod.



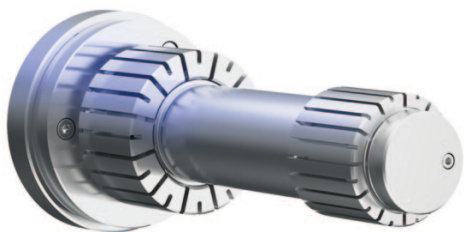
ROYAL CUSTOM I.D. WORKHOLDING

When a standard off-the-shelf I.D. workholding system won't quite work for your application, Royal has the expertise to design and build **custom systems that are optimized for your requirements.**

Below are some examples of some of the more common custom systems that we regularly supply.

Dual-Sleeve

Typically starting at \$15,000

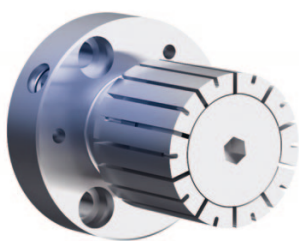


Commonly used for:

- ☐ Long parts that need extra support.
- ☐ Very aggressive machining – sometimes incorporates knurled sleeves for castings and forgings.
- ☐ Large diameter-to-length ratios.

“Pressure Angle” Design

Typically starting at \$8,500

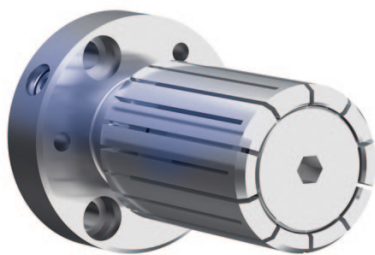


Commonly used for:

- ☐ Parts with short or blind bores.
- ☐ Very aggressive machining.
- ☐ Note that with this design, the head of expanding rod is recessed behind sleeve face to maximize grip-length.
- ☐ This design applies extra gripping torque along its length to keep the workpiece firmly seated.

Extended Sleeve

Typically starting at \$8,900



Commonly used for:

- ☐ Long parts that need extra support.
- ☐ Large diameter-to-length ratios.
- ☐ Great for thin-wall cylinder applications - load is distributed over a larger area to reduce risk of distortion.

Please keep in mind that in addition to the above systems, many other custom solutions/features are also available, including:

- Part ejectors
- Part confirmation
- Non-round bores
- Splined sleeves
- Radial orientation
- Positive-drive pins
- Center hole for tailstock support
- Custom locators
- Large diameters – up to 24”
- Surface-treated sleeves
- Knurled sleeves for castings and forgings
- Wide-range sleeves – to clear a small bore and expand into a larger bore