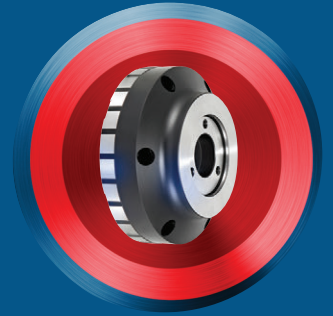
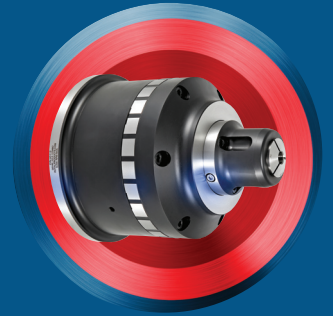
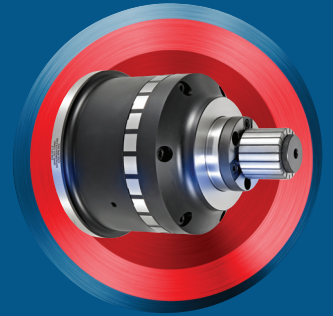




# QG-65 COMBO CHUCK

- QUICK O.D. TO I.D. CHANGEOVER
- FEATURING DEAD-LENGTH OPERATION
- PERFECT FOR SUB-SPINDLES!



**ROYAL**  
PRODUCTS  
Optimize everything.



## ROYAL QG COMBO CHUCK

### Easily Switch Between O.D. and I.D. Applications

#### The Best of Both Worlds

The Royal QG Combo Chuck represents the next generation of our best-selling QG-65 Accu-Length™ CNC Collet Chuck - it's both a Quick-Grip™ Collet Chuck and an I.D. Workholding System All-in-One!

**NEW**

- ✓ 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.
- ✓ A For very small diameter work, a 5C collet nose is also available (pullback actuation).



#### 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.





# ROYAL QG COMBO CHUCK

## Easily Switch Between O.D. and I.D. Applications

### 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.

### 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.

### 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 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.

### 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.

### 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.

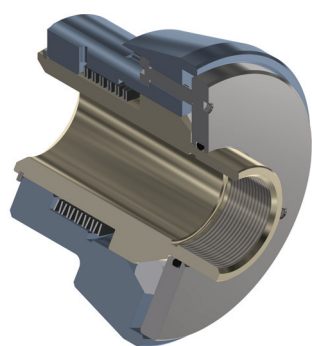
### Coolant Slinger

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



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

## 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!

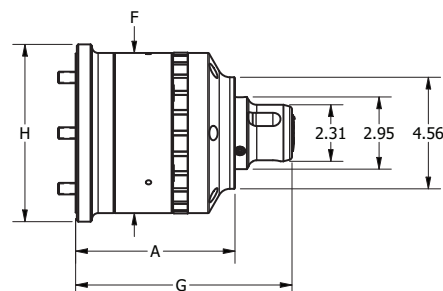
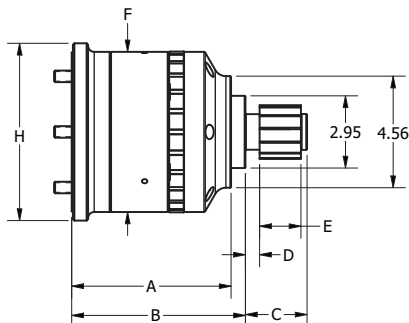
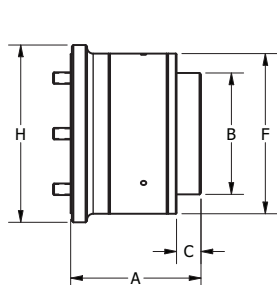
**Note** – Actuator pressure may need to be adjusted to achieve optimal clamping force.



# ROYAL QG COMBO CHUCK

## Easily Switch Between O.D. and I.D. Applications

### Dimensions



**Chuck Only**  
(O.D. Gripping with QG Collets)

|   |      |
|---|------|
| A | 5.33 |
| B | 4.96 |
| C | 1.00 |
| F | 6.55 |
| H | 7.25 |

**Chuck Setup for I.D. Gripping**  
(Cap, Mandrel, Expanding Rod Adapter, and Sleeve)

|   |                                      |
|---|--------------------------------------|
| A | 6.52                                 |
| B | 7.10                                 |
| C | See Mandrel Chart<br>in Full Catalog |
| D |                                      |
| E |                                      |
| F | 6.55                                 |
| H | 7.25                                 |

**Chuck Setup for 5C Gripping**  
(Cap and 5C Collet Adapter)

|   |      |
|---|------|
| A | 6.52 |
| F | 6.55 |
| G | 8.85 |
| H | 7.25 |

### How To Order

**NEW**



### Royal QG Combo Chucks

| SPINDLE NOSE | COLLET TYPE | CHUCK STYLE | PART NUMBER | PRICE*         |
|--------------|-------------|-------------|-------------|----------------|
| A2-5         | QG-65       | C           | 65115       | <b>\$5,940</b> |
| A2-5         | QG-65       | UC          | 65116       | <b>5,940</b>   |
| A2-6         | QG-65       | C           | 65117       | <b>5,940</b>   |
| A2-6         | QG-65       | UC          | 65118       | <b>5,940</b>   |
| A2-6         | QG-65       | EL          | 65119       | <b>5,940</b>   |
| A2-8         | QG-65       | C           | 65120       | <b>6,680</b>   |
| 110 MM       | QG-65       | UC          | 65121       | <b>6,480</b>   |
| 140 MM       | QG-65       | UC          | 65122       | <b>6,480</b>   |

\*Custom-machined drawtube connector included. Order QG collets separately.

### Royal QG Combo Chuck Optional Components

| DESCRIPTION   | PART NUMBER | PRICE           |
|---|-------------|-----------------|
| QG-65 Combo Chuck Nose Cap and Push/Pull Adapter for I.D. Workholding | 65133       | <b>\$3,980*</b> |
| Expanding Rod Adapter for Mandrel A                                   | 65140       | <b>393</b>      |
| Expanding Rod Adapter for Mandrel B & C                               | 65141       | <b>393</b>      |
| Expanding Rod Adapter for Mandrel D                                   | 65142       | <b>393</b>      |
| Expanding Rod Adapter for Mandrel E                                   | 65143       | <b>393</b>      |
| 5C Collet Adapter with 75mm dia. flange                               | 65138       | <b>1,170</b>    |

\*Order mandrels, sleeves, and expanding rod adapters separately (see full catalog)