



# QG COMBO CHUCK

- QUICK O.D. TO I.D. TO 5C CHANGEOVER
- FEATURING DEAD-LENGTH OPERATION
- PERFECT FOR SUB-SPINDLES!

**NEW**



P/N 6S115  
QG-65, A2-5, COMBO  
ROYALPRODUCTS.COM  
6,000 RPM MAX.

**ROYAL**  
PRODUCTS  
Optimize everything.



## 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.

### Accu-Length™ Design – A Very Important Royal Advantage

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### 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.

### 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**.

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

### Heavy-Duty Construction

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

### 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.

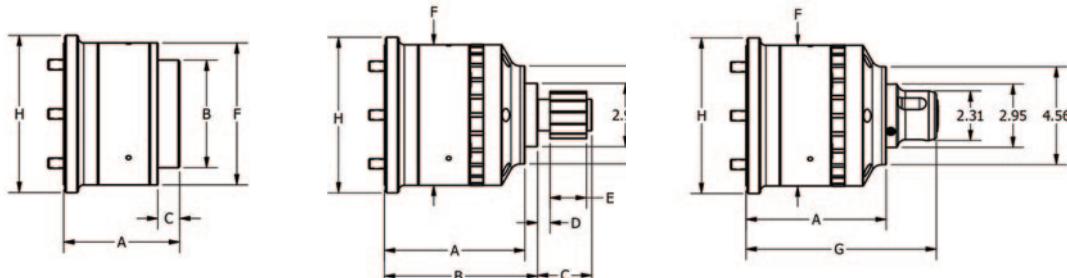
### Simple Installation

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](http://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](http://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	<b>\$5,840</b>
A2-5	QG-52	65111	<b>\$5,840</b>
A2-6	QG-52	65112	<b>\$5,840</b>
110 MM	QG-52	65113	<b>5,840</b>
115 MM	QG-52	65109	<b>5,840</b>
140 MM	QG-52	65114	<b>5,840</b>
A2-5	QG-65	65115	<b>6,270</b>
A2-5	QG-65	65116	<b>6,270</b>
A2-6	QG-65	65117	<b>6,270</b>
A2-6	QG-65	65118	<b>6,270</b>
A2-6	QG-65	65119	<b>6,270</b>
A2-8	QG-65	65120	<b>7,050</b>
110 MM	QG-65	65121	<b>6,840</b>
140 MM	QG-65	65122	<b>6,840</b>
A2-5	QG-80	65123	<b>7,270</b>
A2-6	QG-80	65124	<b>7,270</b>
A2-6	QG-80	65125	<b>7,270</b>
A2-8	QG-80	65126	<b>7,270</b>
140 MM	QG-80	65127	<b>7,270</b>

### 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	<b>\$3,940</b>
QG-65	65133	<b>4,190</b>
QG-80	65134	<b>4,850</b>

#### Expanding Rod Adapters

Required for I.D. Gripping

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

#### 5C Collet Nose

PART NUMBER	PRICE
65138	<b>\$1,235</b>