



# ROYAL CUSTOM ID WORKHOLDING

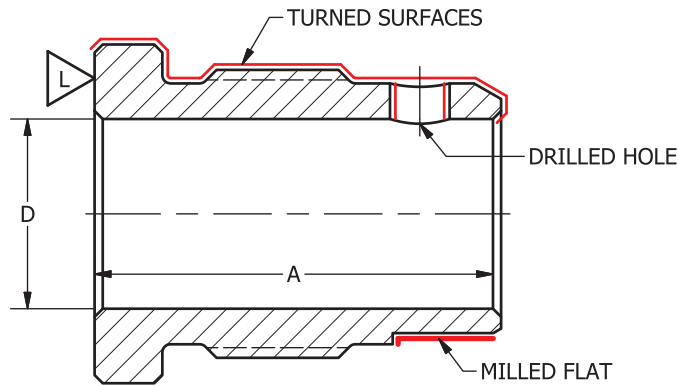
Many common ID workholding applications are easily handled by Royal's large inventory of off-the-shelf expanding mandrels and sleeves. However, **sometimes the parameters of the workpiece and/or process are such that a custom ID workholding system is a better choice.**

In order for Royal's engineering team to make the best recommendation for your specific application, a number of parameters must be considered. If you would like our input on an **ID workholding system that is optimized for your needs**, please take a minute to consider the information outlined below and provide a solid model or drawing of your part that visually identifies these parameters.

Company Name _____	Contact Name _____
Contact Email _____	Contact Phone _____
Description or Ref Number of Part to be Gripped _____	Typical Run Size _____
Workpiece Material _____	How is part Loaded? _____
Machine Make and Model _____	Orientation – vertical or horizontal? _____

**Be sure that your drawing includes the parameters listed below.  
The more info you supply – the better we will be able to help you.**

**Example:**



Note that in this example, a cross-drilled hole breaks into the gripping area. Some might assume that this would require the use of a short sleeve. However, an alternative solution could be a full-length sleeve with a clearance hole or slot machined into it.

**We've seen it all – give us a call!**

_____ Diameter to be gripped, including tolerance (D).	Description of machining processes to be performed, tooling clearance requirements, etc.: _____ _____ _____ _____
_____ Max bore length available to grip (A).	
_____ Blind bore (Y/N)?	
_____ Locating surface (L) - if applicable.	
_____ Max diameter of machined surfaces.	
_____ Max depth of cut.	
_____ Max rpm.	

**Email this form and your part drawing to [orders@royalproducts.com](mailto:orders@royalproducts.com)**