



# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

**Full Range of Metric Sizes  
Now Available from Stock**



## These Extremely Advanced Collets Will Revolutionize Your Workholding

- ❑ **Industry-leading 0.062" Gripping Range (0.080" for QG-100)** – greater than other quick-change collets on the market and more than 12X that of traditional spring collets (see page 8).
- ❑ Royal Quick-Grip Collets are precision-ground to nominal size, with a gripping range of  $\pm 0.31"$  to handle undersized/oversized stock ( $\pm 0.40"$  for QG-100).
 

**Example** – a ½" QG-65 collet is ground to 0.500" dia., and can hold any part ranging in size from 0.469" – 0.531" dia.
- ❑ **Ultra-Precision Accuracy – 0.0002" TIR** or better guaranteed on round-bores (see page 8). Total system accuracy (chuck + collet) guaranteed to 0.0004" or better.
- ❑ All Royal Quick-Grip™ Collets are designed for minimal projection beyond the chuck face ( $\leq 0.020"$ ) for optimum rigidity and machine work-zone utilization.
- ❑ All models have a smooth gripping surface, but round-bores are also available from stock in a double-serrated version for very aggressive first-op machining.
- ❑ Vulcanized rubber between the hardened steel collet segments provides outstanding protection against coolant and chip penetration, and **Royal's advanced vulcanization process carries a lifetime guarantee against failure.**
- ❑ Collets can be counter-bored for increased capacity (see page 38).
- ❑ S-type master collets available for QG-65 and QG-80 chuck models – see page 40.
- ❑ Royal Quick-Grip™ Collets are compatible with some other brands of quick-change chucks, but note that the QG-80 and QG-100 models have a six-slot design (for increased gripping torque) that requires the use of a Royal installation tool. Call us to verify compatibility.
- ❑ Custom sizes and shapes available as **quick-ship specials**. Collet segments can also be carbide-coated for extremely harsh applications. Contact one of our applications engineers at 1-800-645-4174 to discuss your requirements.

## Royal Ultra-Precision Quick-Grip™ Collet Specifications

| COLLET MODEL | COLLET RANGE | NUMBER OF SLOTS | ROUND                 |                                       | HEX                   | SQUARE                | EMERGENCY COLLETS AVAILABLE | CUSTOM SIZES AND SHAPES AVAILABLE | CARBIDE COATING AVAILABLE |
|--------------|--------------|-----------------|-----------------------|---------------------------------------|-----------------------|-----------------------|-----------------------------|-----------------------------------|---------------------------|
|              |              |                 | MAXIMUM THRU CAPACITY | MAXIMUM CAPACITY WHEN COUNTER-BORED** | MAXIMUM THRU CAPACITY | MAXIMUM THRU CAPACITY |                             |                                   |                           |
| QG-42        | 0.062        | 3               | 1.66                  | 2.62                                  | 1.40                  | 1.15                  | Y                           | Y                                 | Y                         |
| QG-52        | 0.062        | 3               | 2.03                  | 2.57                                  | 1.78                  | 1.41                  | Y                           | Y                                 | Y                         |
| QG-65        | 0.062        | 3               | 2.66                  | 3.40                                  | 2.28                  | 1.78                  | Y                           | Y                                 | Y                         |
| QG-80        | 0.062        | 6*              | 3.28                  | 4.00                                  | 2.78                  | 2.03                  | Y                           | Y                                 | Y                         |
| QG-100       | 0.080        | 6*              | 4.03                  | 5.15                                  | 3.28                  | 2.78                  | Y                           | Y                                 | Y                         |

\* The unique six-slot design of the Royal QG-80 and QG-100 Quick-Grip™ collets provides increased workpiece contact over the entire gripping range for superior gripping torque over other brands.

\*\* Counter-boring collets is a special operation and it is important to note that the maximum counter-bore diameter varies with depth. For more information, please see page 38 or contact Royal.

# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS



## Why Do Top Manufacturers Insist on Royal Quick-Grip™ Collets?

**Industry-Leading 0.062" Gripping Range (0.080" for QG-100) Covers More Diameters with Fewer Collets**

**Ultra-Precision Accuracy – 0.0002" TIR or Better**

**Vulcanization Guaranteed for Life**

**Parallel-Grip Maintains Full-Length Part Engagement**



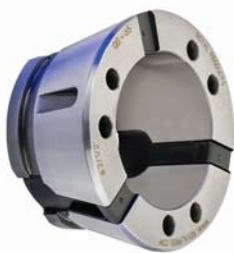
**Exceptional Grip-Force Enables Very Aggressive Cutting**

**Exclusive Royal Risk-Free Performance Guarantee**

**Fast Delivery on Custom Shapes and Sizes – See Page 39**

**Special Slot Relief Grinding Eliminates "Collet Popping" and Minimizes Chuck Wear**

**Order Today – Have it Tomorrow**



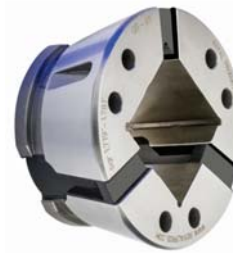
Round – Smooth



Round – Serrated



Hex



Square



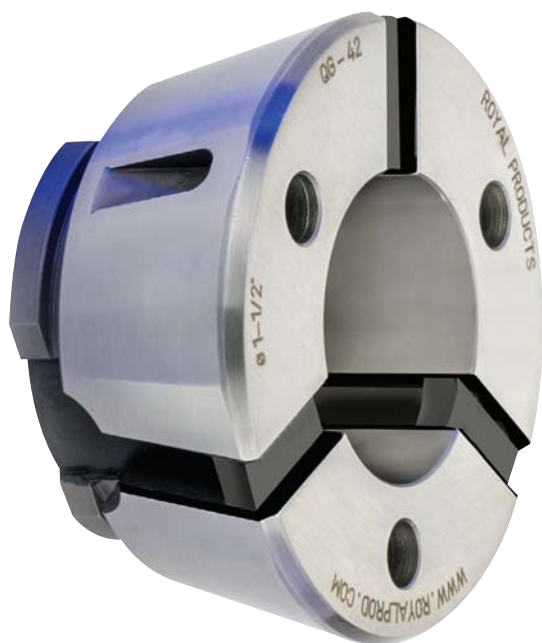
Emergency

**Thousands of Round, Hex, Square and Emergency Collets  
IN-STOCK for SAME-DAY SHIPPING!**



# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

## QG-42

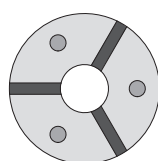


### QG-42 CAPACITY

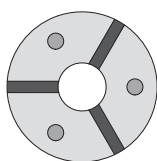
|                |                |
|----------------|----------------|
| Bar Diameter   | 1.66" (42.8mm) |
| Slug Diameter* | 2.62" (66.5mm) |

\* See page 38 for details.

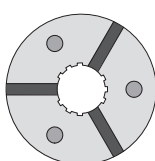
- Huge inventory of Round, Hex, Square, and Emergency styles always in stock, ready for same-day shipping.
- Smooth and serrated versions for round-bore models (all others smooth only).
- **Industry-leading 0.062" gripping range** covers a wide range of part diameters. Collets are ground to nominal size and have a range of +/- 0.031".
- Parallel-grip ensures full-length part contact for maximum grip force, rigidity, and accuracy.
- Can be counter-bored for increased part capacity up to 2.62" – see page 38 for details.
- Quick-ship specials available for custom shapes.
- Can utilize manual and pneumatic changing tools.



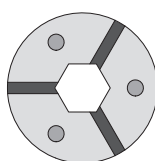
Round Inch



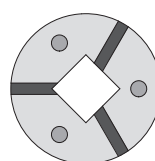
Round Metric



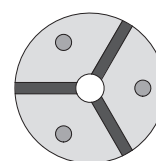
Serrated



Hex



Square



Emergency

## Royal QG-42 **Round** Collets (Inch) – \$239 Each

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 3/16"        | 0.157–0.219    | 44101              | N/A                  |
| 7/32"        | 0.188–0.250    | 44102              | N/A                  |
| 1/4"         | 0.219–0.281    | 44103              | N/A                  |
| 9/32"        | 0.250–0.312    | 44104              | N/A                  |
| 5/16"        | 0.282–0.344    | 44105              | N/A                  |
| 11/32"       | 0.313–0.375    | 44106              | 44155                |
| 3/8"         | 0.344–0.406    | 44107              | 44156                |
| 13/32"       | 0.375–0.437    | 44108              | 44157                |
| 7/16"        | 0.407–0.469    | 44109              | 44158                |
| 15/32"       | 0.438–0.500    | 44110              | 44159                |
| 1/2"         | 0.469–0.531    | 44111              | 44160                |
| 17/32"       | 0.500–0.562    | 44112              | 44161                |
| 9/16"        | 0.532–0.594    | 44113              | 44162                |
| 19/32"       | 0.563–0.625    | 44114              | 44163                |
| 5/8"         | 0.594–0.656    | 44115              | 44164                |
| 27/32"       | 0.625–0.687    | 44116              | 44165                |

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 11/16"       | 0.657–0.719    | 44117              | 44166                |
| 23/32"       | 0.688–0.750    | 44118              | 44167                |
| 3/4"         | 0.719–0.781    | 44119              | 44168                |
| 25/32"       | 0.750–0.812    | 44120              | 44169                |
| 13/16"       | 0.782–0.844    | 44121              | 44170                |
| 27/32"       | 0.813–0.875    | 44122              | 44171                |
| 7/8"         | 0.844–0.906    | 44123              | 44172                |
| 29/32"       | 0.875–0.937    | 44124              | 44173                |
| 15/16"       | 0.907–0.969    | 44125              | 44174                |
| 31/32"       | 0.938–1.000    | 44126              | 44175                |
| 1"           | 0.969–1.031    | 44127              | 44176                |
| 1 1/32"      | 1.000–1.062    | 44128              | Call                 |
| 1 1/16"      | 1.032–1.094    | 44129              | 44177                |
| 1 1/8"       | 1.063–1.125    | 44130              | Call                 |
| 1 1/4"       | 1.094–1.156    | 44131              | 44178                |
| 1 1/2"       | 1.125–1.187    | 44132              | Call                 |

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 1 3/16"      | 1.157–1.219    | 44133              | 44179                |
| 1 7/32"      | 1.188–1.250    | 44134              | Call                 |
| 1 1/4"       | 1.219–1.281    | 44135              | 44180                |
| 1 9/32"      | 1.250–1.312    | 44136              | Call                 |
| 1 5/16"      | 1.282–1.344    | 44137              | 44181                |
| 1 11/32"     | 1.313–1.375    | 44138              | Call                 |
| 1 3/8"       | 1.344–1.406    | 44139              | 44182                |
| 1 13/32"     | 1.375–1.437    | 44140              | Call                 |
| 1 7/16"      | 1.407–1.469    | 44141              | 44183                |
| 1 15/32"     | 1.438–1.500    | 44142              | Call                 |
| 1 1/2"       | 1.469–1.531    | 44143              | 44184                |
| 1 17/32"     | 1.500–1.562    | 44144              | Call                 |
| 1 9/16"      | 1.532–1.594    | 44145              | 44185                |
| 1 19/32"     | 1.563–1.625    | 44146              | Call                 |
| 1 5/8"       | 1.594–1.656    | 44147              | 44186                |

# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

## QG-42



### Royal QG-42 Round Collets (Metric) – \$239 Each

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|
| 4mm          | 3.25–4.75   | 62100              | N/A                  |
| 5mm          | 4.25–5.75   | 62102              | N/A                  |
| 6mm          | 5.25–6.75   | 62104              | N/A                  |
| 7mm          | 6.25–7.75   | 62106              | N/A                  |
| 8mm          | 7.25–8.75   | 62108              | N/A                  |
| 9mm          | 8.25–9.75   | 62110              | 62200                |
| 10mm         | 9.25–10.75  | 62112              | 62201                |
| 11mm         | 10.25–11.75 | 62114              | 62202                |
| 12mm         | 11.25–12.75 | 62116              | 62203                |
| 13mm         | 12.25–13.75 | 62118              | 62204                |
| 14mm         | 13.25–14.75 | 62120              | 62205                |
| 15mm         | 14.25–15.75 | 62122              | 62206                |
| 16mm         | 15.25–16.75 | 62124              | 62207                |

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|
| 17mm         | 16.25–17.75 | 62126              | 62208                |
| 18mm         | 17.25–18.75 | 62128              | 62209                |
| 19mm         | 18.25–19.75 | 62130              | 62210                |
| 20mm         | 19.25–20.75 | 62132              | 62211                |
| 21mm         | 20.25–21.75 | 62134              | 62212                |
| 22mm         | 21.25–22.75 | 62136              | 62213                |
| 23mm         | 22.25–23.75 | 62138              | 62214                |
| 24mm         | 23.25–24.75 | 62140              | 62215                |
| 25mm         | 24.25–25.75 | 62142              | 62216                |
| 26mm         | 25.25–26.75 | 62144              | 62217                |
| 27mm         | 26.25–27.75 | 62146              | 62218                |
| 28mm         | 27.25–28.75 | 62148              | 62219                |
| 29mm         | 28.25–29.75 | 62150              | 62220                |

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|
| 30mm         | 29.25–30.75 | 62152              | 62221                |
| 31mm         | 30.25–31.75 | 62154              | 62222                |
| 32mm         | 31.25–32.75 | 62156              | 62223                |
| 33mm         | 32.25–33.75 | 62158              | 62224                |
| 34mm         | 33.25–34.75 | 62160              | 62225                |
| 35mm         | 34.25–35.75 | 62162              | 62226                |
| 36mm         | 35.25–36.75 | 62164              | 62227                |
| 37mm         | 36.25–37.75 | 62166              | 62228                |
| 38mm         | 37.25–38.75 | 62168              | 62229                |
| 39mm         | 38.25–39.75 | 62170              | 62230                |
| 40mm         | 39.25–40.75 | 62172              | 62231                |
| 41mm         | 40.25–41.75 | 62174              | 62232                |
| 42mm         | 41.25–42.75 | 62176              | 62233                |

### Royal QG-42 Hex Collets – \$329 Each

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1/4"         | 0.219–0.281    | 44375       |
| 3/8"         | 0.344–0.406    | 44377       |
| 1/2"         | 0.469–0.531    | 44379       |
| 5/8"         | 0.594–0.656    | 44381       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 3/4"         | 0.719–0.781    | 44383       |
| 7/8"         | 0.844–0.906    | 44385       |
| 1"           | 0.969–1.031    | 44387       |
| 1 1/8"       | 1.094–1.156    | 44389       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1 1/4"       | 1.219–1.281    | 44391       |
| 1 3/8"       | 1.344–1.406    | 44393       |

### Royal QG-42 Square Collets – \$329 Each

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1/4"         | 0.219–0.281    | 44670       |
| 3/8"         | 0.344–0.406    | 44672       |
| 1/2"         | 0.469–0.531    | 44674       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 5/8"         | 0.594–0.656    | 44676       |
| 3/4"         | 0.719–0.781    | 44678       |
| 7/8"         | 0.844–0.906    | 44680       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1"           | 0.969–1.031    | 44682       |
| 1 1/8"       | 1.094–1.156    | 44684       |

### Royal QG-42 Emergency Collets – \$280 Each – See Page 38



Check out the Royal Quick-Grip™ CNC Collet Chuck Video at [www.colletchucks.com](http://www.colletchucks.com)



# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

## QG-52

**NEW**

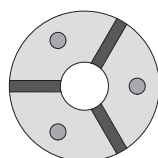


### QG-52 CAPACITY

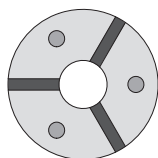
|                |                |
|----------------|----------------|
| Bar Diameter   | 2.03" (51.6mm) |
| Slug Diameter* | 2.57" (64.3mm) |

\* See page 38 for details.

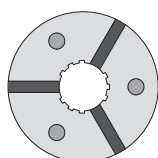
- Huge inventory of Round, Hex, Square, and Emergency styles always in stock, ready for same-day shipping.
- Smooth and serrated versions for round-bore models (all others smooth only).
- **Industry-leading 0.062" gripping range** covers a wide range of part diameters. Collets are ground to nominal size and have a range of +/- 0.031".
- Parallel-grip ensures full-length part contact for maximum grip force, rigidity, and accuracy.
- Can be counter-bored for increased part capacity up to 2.57" – see page 38 for details.
- Quick-ship specials available for custom shapes.
- Can utilize manual and pneumatic changing tools.



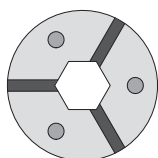
Round Inch



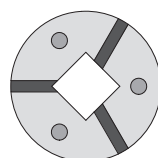
Round Metric



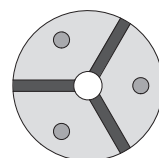
Serrated



Hex



Square



Emergency

## Royal QG-52 **Round** Collets (Inch) – \$239 Each

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 3/16"        | 0.157–0.219    | 45600              | N/A                  |
| 7/32"        | 0.188–0.250    | 45601              | N/A                  |
| 1/4"         | 0.219–0.281    | 45602              | N/A                  |
| 9/32"        | 0.250–0.312    | 45603              | N/A                  |
| 5/16"        | 0.282–0.344    | 45604              | N/A                  |
| 11/32"       | 0.313–0.375    | 45605              | 45665                |
| 3/8"         | 0.344–0.406    | 45606              | 45666                |
| 13/32"       | 0.375–0.437    | 45607              | 45667                |
| 7/16"        | 0.407–0.469    | 45608              | 45668                |
| 15/32"       | 0.438–0.500    | 45609              | 45669                |
| 1/2"         | 0.469–0.531    | 45610              | 45670                |
| 17/32"       | 0.500–0.562    | 45611              | 45671                |
| 9/16"        | 0.532–0.594    | 45612              | 45672                |
| 19/32"       | 0.563–0.625    | 45613              | 45673                |
| 5/8"         | 0.594–0.656    | 45614              | 45674                |
| 21/32"       | 0.625–0.687    | 45615              | 45675                |
| 11/16"       | 0.657–0.719    | 45616              | 45676                |
| 23/32"       | 0.688–0.750    | 45617              | 45677                |
| 3/4"         | 0.719–0.781    | 45618              | 45678                |
| 25/32"       | 0.750–0.812    | 45619              | 45679                |

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 13/16"       | 0.782–0.844    | 45620              | 45680                |
| 27/32"       | 0.813–0.875    | 45621              | 45681                |
| 7/8"         | 0.844–0.906    | 45622              | 45682                |
| 29/32"       | 0.875–0.937    | 45623              | 45683                |
| 15/16"       | 0.907–0.969    | 45624              | 45684                |
| 31/32"       | 0.938–1.000    | 45625              | 45685                |
| 1"           | 0.969–1.031    | 45626              | 45686                |
| 1 1/32"      | 1.000–1.062    | 45627              | N/A                  |
| 1 1/16"      | 1.032–1.094    | 45628              | 45687                |
| 1 3/32"      | 1.063–1.125    | 45629              | N/A                  |
| 1 1/8"       | 1.094–1.156    | 45630              | 45688                |
| 1 5/32"      | 1.125–1.187    | 45631              | N/A                  |
| 1 3/16"      | 1.157–1.219    | 45632              | 45689                |
| 1 7/32"      | 1.188–1.250    | 45633              | N/A                  |
| 1 1/4"       | 1.219–1.281    | 45634              | 45690                |
| 1 9/32"      | 1.250–1.312    | 45635              | N/A                  |
| 1 5/16"      | 1.282–1.344    | 45636              | 45691                |
| 1 11/32"     | 1.313–1.375    | 45637              | N/A                  |
| 1 3/8"       | 1.344–1.406    | 45638              | 45692                |
| 1 13/32"     | 1.375–1.437    | 45639              | N/A                  |

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 1 7/16"      | 1.407–1.469    | 45640              | 45693                |
| 1 15/32"     | 1.438–1.500    | 45641              | N/A                  |
| 1 1/2"       | 1.469–1.531    | 45642              | 45694                |
| 1 17/32"     | 1.500–1.562    | 45643              | N/A                  |
| 1 9/16"      | 1.532–1.594    | 45644              | 45695                |
| 1 19/32"     | 1.563–1.625    | 45645              | N/A                  |
| 1 5/8"       | 1.594–1.656    | 45646              | 45696                |
| 1 21/32"     | 1.625–1.687    | 45647              | N/A                  |
| 1 11/16"     | 1.657–1.719    | 45648              | 45697                |
| 1 23/32"     | 1.688–1.750    | 45649              | N/A                  |
| 1 3/4"       | 1.719–1.781    | 45650              | 45698                |
| 1 25/32"     | 1.750–1.812    | 45651              | N/A                  |
| 1 13/16"     | 1.782–1.844    | 45652              | 45699                |
| 1 27/32"     | 1.813–1.875    | 45653              | N/A                  |
| 1 7/8"       | 1.844–1.906    | 45654              | 45700                |
| 1 29/32"     | 1.875–1.937    | 45655              | N/A                  |
| 1 15/16"     | 1.907–1.969    | 45656              | 45701                |
| 1 31/32"     | 1.938–2.000    | 45657              | N/A                  |
| 2"           | 1.969–2.031    | 45658              | 45702                |

# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

## QG-52



**NEW**

### Royal QG-52 Round Collets (Metric) – \$239 Each

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|
| 4mm          | 3.25–4.75   | 63200              | N/A                  |
| 5mm          | 4.25–5.75   | 63201              | N/A                  |
| 6mm          | 5.25–6.75   | 63202              | N/A                  |
| 7mm          | 6.25–7.75   | 63203              | N/A                  |
| 8mm          | 7.25–8.75   | 63204              | N/A                  |
| 9mm          | 8.25–9.75   | 63205              | 63250                |
| 10mm         | 9.25–10.75  | 63206              | 63251                |
| 11mm         | 10.25–11.75 | 63207              | 63252                |
| 12mm         | 11.25–12.75 | 63208              | 63253                |
| 13mm         | 12.25–13.75 | 63209              | 63254                |
| 14mm         | 13.25–14.75 | 63210              | 63255                |
| 15mm         | 14.25–15.75 | 63211              | 63256                |
| 16mm         | 15.25–16.75 | 63212              | 63257                |
| 17mm         | 16.25–17.75 | 63213              | 63258                |
| 18mm         | 17.25–18.75 | 63214              | 63259                |
| 19mm         | 18.25–19.75 | 63215              | 63260                |
| 20mm         | 19.25–20.75 | 63216              | 63261                |

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|
| 21mm         | 20.25–21.75 | 63217              | 63262                |
| 22mm         | 21.25–22.75 | 63218              | 63263                |
| 23mm         | 22.25–23.75 | 63219              | 63264                |
| 24mm         | 23.25–24.75 | 63220              | 63265                |
| 25mm         | 24.25–25.75 | 63221              | 63266                |
| 26mm         | 25.25–26.75 | 63222              | 63267                |
| 27mm         | 26.25–27.75 | 63223              | 63268                |
| 28mm         | 27.25–28.75 | 63224              | 63269                |
| 29mm         | 28.25–29.75 | 63225              | 63270                |
| 30mm         | 29.25–30.75 | 63226              | 63271                |
| 31mm         | 30.25–31.75 | 63227              | 63272                |
| 32mm         | 31.25–32.75 | 63228              | 63273                |
| 33mm         | 32.25–33.75 | 63229              | 63274                |
| 34mm         | 33.25–34.75 | 63230              | 63275                |
| 35mm         | 34.25–35.75 | 63231              | 63276                |
| 36mm         | 35.25–36.75 | 63232              | 63277                |
| 37mm         | 36.25–37.75 | 63233              | 63278                |

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|
| 38mm         | 37.25–38.75 | 63234              | 63279                |
| 39mm         | 38.25–39.75 | 63235              | 63280                |
| 40mm         | 39.25–40.75 | 63236              | 63281                |
| 41mm         | 40.25–41.75 | 63237              | 63282                |
| 42mm         | 41.25–42.75 | 63238              | 63283                |
| 43mm         | 42.25–43.75 | 63239              | 63284                |
| 44mm         | 43.25–44.75 | 63240              | 63285                |
| 45mm         | 44.25–45.75 | 63241              | 63286                |
| 46mm         | 45.25–46.75 | 63242              | 63287                |
| 47mm         | 46.25–47.75 | 63243              | 63288                |
| 48mm         | 47.25–48.75 | 63244              | 63289                |
| 49mm         | 48.25–49.75 | 63245              | 63290                |
| 50mm         | 49.25–50.75 | 63246              | 63291                |
| 51mm         | 50.25–51.75 | 63247              | 63292                |
| 52mm         | 51.25–52.75 | 63248              | 63293                |

### Royal QG-52 Hex Collets – \$329 Each

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1/4"         | 0.219–0.281    | 45710       |
| 5/16"        | 0.282–0.344    | 45711       |
| 3/8"         | 0.344–0.406    | 45712       |
| 7/16"        | 0.407–0.469    | 45713       |
| 1/2"         | 0.469–0.531    | 45714       |
| 9/16"        | 0.532–0.594    | 45715       |
| 5/8"         | 0.594–0.656    | 45716       |
| 11/16"       | 0.657–0.719    | 45717       |
| 3/4"         | 0.719–0.781    | 45718       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 13/16"       | 0.782–0.844    | 45719       |
| 7/8"         | 0.844–0.906    | 45720       |
| 15/16"       | 0.907–0.969    | 45721       |
| 1"           | 0.969–1.031    | 45722       |
| 1 1/16"      | 1.032–1.094    | 45723       |
| 1 1/8"       | 1.094–1.156    | 45724       |
| 1 1/4"       | 1.156–1.219    | 45725       |
| 1 1/2"       | 1.219–1.281    | 45726       |
| 1 5/8"       | 1.281–1.344    | 45727       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1 3/8"       | 1.344–1.406    | 45728       |
| 1 1/2"       | 1.406–1.469    | 45729       |
| 1 5/8"       | 1.469–1.531    | 45730       |
| 1 3/4"       | 1.531–1.594    | 45731       |
| 1 7/8"       | 1.594–1.656    | 45732       |
| 1 15/16"     | 1.656–1.719    | 45733       |
| 1 3/4"       | 1.719–1.781    | 45734       |

### Royal QG-52 Square Collets – \$329 Each

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1/4"         | 0.219–0.281    | 45740       |
| 3/8"         | 0.344–0.406    | 45742       |
| 1/2"         | 0.469–0.531    | 45744       |
| 5/8"         | 0.594–0.656    | 45746       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 3/4"         | 0.719–0.781    | 45748       |
| 7/8"         | 0.844–0.906    | 45750       |
| 1"           | 0.969–1.031    | 45752       |
| 1 1/8"       | 1.094–1.156    | 45754       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1 1/4"       | 1.219–1.281    | 45756       |
| 1 3/8"       | 1.344–1.406    | 45758       |

### Royal QG-52 Emergency Collets – \$280 Each – See Page 38



Check out the Royal Quick-Grip™ CNC Collet Chuck Video at [www.colletchucks.com](http://www.colletchucks.com)



# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

## QG-65

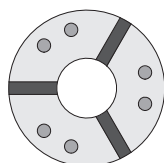


### QG-65 CAPACITY

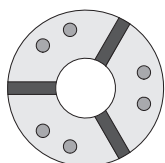
|                |                |
|----------------|----------------|
| Bar Diameter   | 2.66" (65.8mm) |
| Slug Diameter* | 3.40" (86.4mm) |

\* See page 38 for details.

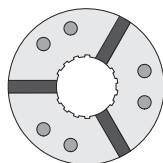
- Huge inventory of Round, Hex, Square, and Emergency styles always in stock, ready for same-day shipping.
- Industry-leading 0.062" gripping range covers a wide range of part diameters. Collets are ground to nominal size and have a range of +/- 0.031".
- Parallel-grip ensures **full-length part contact for maximum grip force, rigidity, and accuracy.**
- Can be counter-bored for increased part capacity up to 3.40" – see page 38 for details.
- Quick-ship specials available for custom shapes.
- Can utilize manual and pneumatic changing tools.



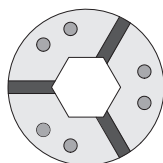
Round Inch



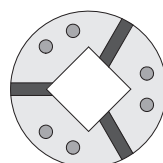
Round Metric



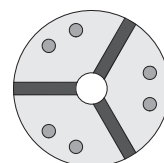
Serrated



Hex



Square



Emergency

## Royal QG-65 Round Collets (Inch) – \$293 Each

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 3/16"        | 0.157–0.219    | 44201              | N/A                  |
| 7/32"        | 0.188–0.250    | 44202              | N/A                  |
| 1/4"         | 0.219–0.281    | 44203              | N/A                  |
| 9/32"        | 0.250–0.312    | 44204              | N/A                  |
| 5/16"        | 0.282–0.344    | 44205              | N/A                  |
| 11/32"       | 0.313–0.375    | 44206              | 44306                |
| 3/8"         | 0.344–0.406    | 44207              | 44307                |
| 13/32"       | 0.375–0.437    | 44208              | 44308                |
| 7/16"        | 0.407–0.469    | 44209              | 44309                |
| 15/32"       | 0.438–0.500    | 44210              | 44310                |
| 1/2"         | 0.469–0.531    | 44211              | 44311                |
| 17/32"       | 0.500–0.562    | 44212              | 44312                |
| 9/16"        | 0.532–0.594    | 44213              | 44313                |
| 19/32"       | 0.563–0.625    | 44214              | 44314                |
| 5/8"         | 0.594–0.656    | 44215              | 44315                |
| 21/32"       | 0.625–0.687    | 44216              | 44316                |
| 11/16"       | 0.657–0.719    | 44217              | 44317                |
| 23/32"       | 0.688–0.750    | 44218              | 44318                |
| 3/4"         | 0.719–0.781    | 44219              | 44319                |
| 25/32"       | 0.750–0.812    | 44220              | 44320                |
| 13/16"       | 0.782–0.844    | 44221              | 44321                |
| 27/32"       | 0.813–0.875    | 44222              | 44322                |
| 7/8"         | 0.844–0.906    | 44223              | 44323                |
| 29/32"       | 0.875–0.937    | 44224              | 44324                |
| 15/16"       | 0.907–0.969    | 44225              | 44325                |
| 31/32"       | 0.938–1.000    | 44226              | 44326                |
| 1"           | 0.969–1.031    | 44227              | 44327                |

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 1 1/32"      | 1.000–1.062    | 44228              | Call                 |
| 1 1/16"      | 1.032–1.094    | 44229              | 44328                |
| 1 3/32"      | 1.063–1.125    | 44230              | Call                 |
| 1 1/8"       | 1.094–1.156    | 44231              | 44329                |
| 1 5/32"      | 1.125–1.187    | 44232              | Call                 |
| 1 3/16"      | 1.157–1.219    | 44233              | 44330                |
| 1 7/32"      | 1.188–1.250    | 44234              | Call                 |
| 1 1/4"       | 1.219–1.281    | 44235              | 44331                |
| 1 9/32"      | 1.250–1.312    | 44236              | Call                 |
| 1 5/16"      | 1.282–1.344    | 44237              | 44332                |
| 1 11/32"     | 1.313–1.375    | 44238              | Call                 |
| 1 3/8"       | 1.344–1.406    | 44239              | 44333                |
| 1 13/32"     | 1.375–1.437    | 44240              | Call                 |
| 1 7/16"      | 1.407–1.469    | 44241              | 44334                |
| 1 15/32"     | 1.438–1.500    | 44242              | Call                 |
| 1 1/2"       | 1.469–1.531    | 44243              | 44335                |
| 1 17/32"     | 1.500–1.562    | 44244              | Call                 |
| 1 9/16"      | 1.532–1.594    | 44245              | 44336                |
| 1 19/32"     | 1.563–1.625    | 44246              | Call                 |
| 1 5/8"       | 1.594–1.656    | 44247              | 44337                |
| 1 21/32"     | 1.625–1.687    | 44248              | Call                 |
| 1 11/16"     | 1.657–1.719    | 44249              | 44338                |
| 1 23/32"     | 1.688–1.750    | 44250              | Call                 |
| 1 3/4"       | 1.719–1.781    | 44251              | 44339                |
| 1 25/32"     | 1.750–1.812    | 44252              | Call                 |
| 1 13/16"     | 1.782–1.844    | 44253              | 44340                |
| 1 27/32"     | 1.813–1.875    | 44254              | Call                 |

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 1 7/8"       | 1.844–1.906    | 44255              | 44341                |
| 1 29/32"     | 1.875–1.937    | 44256              | Call                 |
| 1 15/16"     | 1.907–1.969    | 44257              | 44342                |
| 1 31/32"     | 1.938–2.000    | 44279              | Call                 |
| 2"           | 1.969–2.031    | 44258              | 44343                |
| 2 1/32"      | 2.000–2.062    | 44259              | Call                 |
| 2 1/16"      | 2.032–2.094    | 44260              | 44344                |
| 2 3/32"      | 2.063–2.125    | 44261              | Call                 |
| 2 1/8"       | 2.094–2.156    | 44262              | 44345                |
| 2 5/32"      | 2.125–2.187    | 44263              | Call                 |
| 2 3/16"      | 2.157–2.219    | 44264              | 44346                |
| 2 7/32"      | 2.188–2.250    | 44265              | Call                 |
| 2 1/4"       | 2.219–2.281    | 44266              | 44347                |
| 2 9/32"      | 2.250–2.312    | 44267              | Call                 |
| 2 5/16"      | 2.282–2.344    | 44268              | 44348                |
| 2 11/32"     | 2.313–2.375    | 44269              | Call                 |
| 2 3/8"       | 2.344–2.406    | 44270              | 44349                |
| 2 13/32"     | 2.375–2.437    | 44271              | Call                 |
| 2 7/16"      | 2.407–2.469    | 44272              | 44350                |
| 2 15/32"     | 2.438–2.500    | 44273              | Call                 |
| 2 1/2"       | 2.469–2.531    | 44274              | 44351                |
| 2 17/32"     | 2.500–2.562    | 44275              | Call                 |
| 2 9/16"      | 2.532–2.594    | 44276              | 44352                |
| 2 19/32"     | 2.563–2.625    | 44277              | N/A                  |
| 2 5/8"       | 2.594–2.656    | 44278              | N/A                  |

# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

## QG-65



### Royal QG-65 Round Collets (Metric) – \$293 Each

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|
| 4mm          | 3.25–4.75   | 62300              | N/A                  |
| 5mm          | 4.25–5.75   | 62302              | N/A                  |
| 6mm          | 5.25–6.75   | 62304              | N/A                  |
| 7mm          | 6.25–7.75   | 62306              | N/A                  |
| 8mm          | 7.25–8.75   | 62308              | N/A                  |
| 9mm          | 8.25–9.75   | 62310              | 62500                |
| 10mm         | 9.25–10.75  | 62312              | 62501                |
| 11mm         | 10.25–11.75 | 62314              | 62502                |
| 12mm         | 11.25–12.75 | 62316              | 62503                |
| 13mm         | 12.25–13.75 | 62318              | 62504                |
| 14mm         | 13.25–14.75 | 62320              | 62505                |
| 15mm         | 14.25–15.75 | 62322              | 62506                |
| 16mm         | 15.25–16.75 | 62324              | 62507                |
| 17mm         | 16.25–17.75 | 62326              | 62508                |
| 18mm         | 17.25–18.75 | 62328              | 62509                |
| 19mm         | 18.25–19.75 | 62330              | 62510                |
| 20mm         | 19.25–20.75 | 62332              | 62511                |
| 21mm         | 20.25–21.75 | 62334              | 62512                |
| 22mm         | 21.25–22.75 | 62336              | 62513                |
| 23mm         | 22.25–23.75 | 62338              | 62514                |
| 24mm         | 23.25–24.75 | 62340              | 62515                |

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|
| 25mm         | 24.25–25.75 | 62342              | 62516                |
| 26mm         | 25.25–26.75 | 62344              | 62517                |
| 27mm         | 26.25–27.75 | 62346              | 62518                |
| 28mm         | 27.25–28.75 | 62348              | 62519                |
| 29mm         | 28.25–29.75 | 62350              | 62520                |
| 30mm         | 29.25–30.75 | 62352              | 62521                |
| 31mm         | 30.25–31.75 | 62354              | 62522                |
| 32mm         | 31.25–32.75 | 62356              | 62523                |
| 33mm         | 32.25–33.75 | 62358              | 62524                |
| 34mm         | 33.25–34.75 | 62360              | 62525                |
| 35mm         | 34.25–35.75 | 62362              | 62526                |
| 36mm         | 35.25–36.75 | 62364              | 62527                |
| 37mm         | 36.25–37.75 | 62366              | 62528                |
| 38mm         | 37.25–38.75 | 62368              | 62529                |
| 39mm         | 38.25–39.75 | 62370              | 62530                |
| 40mm         | 39.25–40.75 | 62372              | 62531                |
| 41mm         | 40.25–41.75 | 62374              | 62532                |
| 42mm         | 41.25–42.75 | 62376              | 62533                |
| 43mm         | 42.25–43.75 | 62378              | 62534                |
| 44mm         | 43.25–44.75 | 62380              | 62535                |
| 45mm         | 44.25–45.75 | 62382              | 62536                |

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|
| 46mm         | 45.25–46.75 | 62384              | 62537                |
| 47mm         | 46.25–47.75 | 62386              | 62538                |
| 48mm         | 47.25–48.75 | 62388              | 62539                |
| 49mm         | 48.25–49.75 | 62390              | 62540                |
| 50mm         | 49.25–50.75 | 62392              | 62541                |
| 51mm         | 50.25–51.75 | 62394              | 62542                |
| 52mm         | 51.25–52.75 | 62396              | 62543                |
| 53mm         | 52.25–53.75 | 62398              | 62544                |
| 54mm         | 53.25–54.75 | 62400              | 62545                |
| 55mm         | 54.25–55.75 | 62402              | 62546                |
| 56mm         | 55.25–56.75 | 62404              | 62547                |
| 57mm         | 56.25–57.75 | 62406              | 62548                |
| 58mm         | 57.25–58.75 | 62408              | 62549                |
| 59mm         | 58.25–59.75 | 62410              | 62550                |
| 60mm         | 59.25–60.75 | 62412              | N/A                  |
| 61mm         | 60.25–61.75 | 62414              | N/A                  |
| 62mm         | 61.25–62.75 | 62416              | N/A                  |
| 63mm         | 62.25–63.75 | 62418              | N/A                  |
| 64mm         | 63.25–64.75 | 62420              | N/A                  |
| 65mm         | 64.25–65.75 | 62422              | N/A                  |

### Royal QG-65 Hex Collets – \$439 Each

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 5/16"        | 0.282–0.344    | 44700       |
| 3/8"         | 0.344–0.406    | 44701       |
| 7/16"        | 0.407–0.469    | 44702       |
| 1/2"         | 0.469–0.531    | 44703       |
| 9/16"        | 0.532–0.594    | 44704       |
| 5/8"         | 0.594–0.656    | 44705       |
| 11/16"       | 0.657–0.719    | 44706       |
| 3/4"         | 0.719–0.781    | 44707       |
| 13/16"       | 0.782–0.844    | 44708       |
| 7/8"         | 0.844–0.906    | 44709       |
| 15/16"       | 0.907–0.969    | 44710       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1"           | 0.969–1.031    | 44711       |
| 1 1/16"      | 1.032–1.094    | 44712       |
| 1 1/8"       | 1.094–1.156    | 44713       |
| 1 3/16"      | 1.156–1.219    | 44714       |
| 1 1/4"       | 1.219–1.281    | 44715       |
| 1 5/16"      | 1.281–1.344    | 44716       |
| 1 3/8"       | 1.344–1.406    | 44717       |
| 1 7/16"      | 1.406–1.469    | 44718       |
| 1 1/2"       | 1.469–1.531    | 44719       |
| 1 9/16"      | 1.531–1.594    | 44720       |
| 1 5/8"       | 1.594–1.656    | 44721       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1 11/16"     | 1.656–1.719    | 44722       |
| 1 3/4"       | 1.719–1.781    | 44723       |
| 1 13/16"     | 1.781–1.844    | 44724       |
| 1 7/8"       | 1.844–1.906    | 44725       |
| 1 15/16"     | 1.906–1.969    | 44726       |
| 2"           | 1.969–2.031    | 44727       |
| 2 1/16"      | 2.031–2.094    | 44728       |
| 2 1/8"       | 2.094–2.156    | 44729       |
| 2 3/16"      | 2.156–2.219    | 44730       |
| 2 1/4"       | 2.219–2.281    | 44731       |

### Royal QG-65 Square Collets – \$439 Each

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 3/8"         | 0.344–0.406    | 44787       |
| 1/2"         | 0.469–0.531    | 44734       |
| 5/8"         | 0.594–0.656    | 44788       |
| 3/4"         | 0.719–0.781    | 44735       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 7/8"         | 0.844–0.906    | 44789       |
| 1"           | 0.969–1.031    | 44736       |
| 1 1/8"       | 1.094–1.156    | 44790       |
| 1 1/4"       | 1.219–1.281    | 44737       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1 3/8"       | 1.344–1.406    | 44791       |
| 1 1/2"       | 1.469–1.531    | 44738       |
| 1 5/8"       | 1.594–1.656    | 44792       |
| 1 3/4"       | 1.719–1.781    | 44739       |

### Royal QG-65 Emergency Collets – \$315 Each – See Page 38



# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

## QG-80

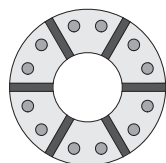


### QG-80 CAPACITY

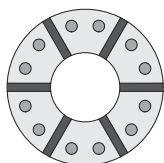
|                |                 |
|----------------|-----------------|
| Bar Diameter   | 3.28" (80.8mm)  |
| Slug Diameter* | 4.00" (101.6mm) |

\* See page 38 for details.

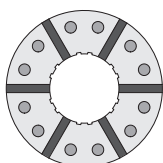
- Huge inventory of Round, Hex, Square, and Emergency styles **always in stock, ready for same-day shipping.**
- **Industry-leading 0.062" gripping range** covers a wide range of part diameters. Collets are ground to nominal size and have a range of +/- 0.031".
- Parallel-grip ensures full-length part contact for maximum grip force, rigidity, and accuracy.
- Six-segment design further increases gripping torque.
- Can be counter-bored for increased part capacity up to 4.00" – see page 38 for details.
- Can utilize manual and pneumatic changing tools.



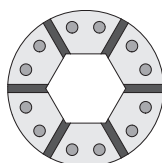
Round Inch



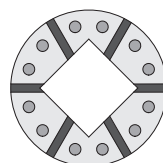
Round Metric



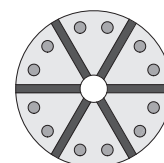
Serrated



Hex



Square



Emergency

## Royal QG-80 **Round** Collets\* (Inch) – \$458 Each

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 1/4"         | 0.219–0.281    | 44403              | N/A                  |
| 5/16"        | 0.282–0.344    | 44405              | N/A                  |
| 3/8"         | 0.344–0.406    | 44407              | N/A                  |
| 7/16"        | 0.407–0.469    | 44409              | 44509                |
| 1/2"         | 0.469–0.531    | 44411              | 44511                |
| 9/16"        | 0.532–0.594    | 44413              | 44513                |
| 5/8"         | 0.594–0.656    | 44415              | 44515                |
| 11/16"       | 0.657–0.719    | 44417              | 44517                |
| 3/4"         | 0.719–0.781    | 44419              | 44519                |
| 13/16"       | 0.782–0.844    | 44421              | 44521                |
| 7/8"         | 0.844–0.906    | 44423              | 44523                |
| 15/16"       | 0.907–0.969    | 44425              | 44525                |
| 1"           | 0.969–1.031    | 44427              | 44527                |
| 1 1/16"      | 1.032–1.094    | 44429              | 44529                |
| 1 1/8"       | 1.094–1.156    | 44431              | 44531                |
| 1 3/16"      | 1.157–1.219    | 44433              | 44533                |
| 1 1/4"       | 1.219–1.281    | 44435              | 44535                |

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 1 5/16"      | 1.282–1.344    | 44437              | 44537                |
| 1 3/8"       | 1.344–1.406    | 44439              | 44539                |
| 1 7/16"      | 1.407–1.469    | 44441              | 44541                |
| 1 1/2"       | 1.469–1.531    | 44443              | 44543                |
| 1 9/16"      | 1.532–1.594    | 44445              | 44545                |
| 1 5/8"       | 1.594–1.656    | 44447              | 44547                |
| 1 11/16"     | 1.657–1.719    | 44449              | 44549                |
| 1 3/4"       | 1.719–1.781    | 44451              | 44551                |
| 1 13/16"     | 1.782–1.844    | 44453              | 44553                |
| 1 7/8"       | 1.844–1.906    | 44455              | 44555                |
| 1 15/16"     | 1.907–1.969    | 44457              | 44557                |
| 2"           | 1.969–2.031    | 44459              | 44559                |
| 2 1/16"      | 2.032–2.094    | 44461              | 44561                |
| 2 1/8"       | 2.094–2.156    | 44463              | 44563                |
| 2 3/16"      | 2.157–2.219    | 44465              | 44565                |
| 2 1/4"       | 2.219–2.281    | 44467              | 44567                |
| 2 5/16"      | 2.282–2.344    | 44469              | 44569                |

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 2 3/8"       | 2.344–2.406    | 44471              | 44571                |
| 2 7/16"      | 2.407–2.469    | 44473              | 44573                |
| 2 1/2"       | 2.469–2.531    | 44475              | 44575                |
| 2 9/16"      | 2.532–2.594    | 44477              | 44577                |
| 2 5/8"       | 2.594–2.656    | 44479              | 44579                |
| 2 11/16"     | 2.657–2.719    | 44481              | 44581                |
| 2 3/4"       | 2.719–2.781    | 44483              | 44583                |
| 2 13/16"     | 2.782–2.844    | 44485              | 44585                |
| 2 7/8"       | 2.844–2.906    | 44487              | 44587                |
| 2 15/16"     | 2.907–2.969    | 44489              | 44589                |
| 3"           | 2.969–3.031    | 44491              | 44591                |
| 3 1/16"      | 3.032–3.094    | 44493              | N/A                  |
| 3 3/8"       | 3.094–3.156    | 44495              | N/A                  |
| 3 7/16"      | 3.157–3.219    | 44497              | N/A                  |
| 3 1/4"       | 3.219–3.281    | 44499              | N/A                  |

\*Royal QG-80 collets have six segments instead of three for increased gripping torque.

# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

## QG-80



### Royal QG-80 Round Collets\* (Metric) – \$458 Each

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER | NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER | NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|--------------|-------------|--------------------|----------------------|--------------|-------------|--------------------|----------------------|
| 7mm          | 6.25–7.75   | 62600              | N/A                  | 32mm         | 31.25–32.75 | 62650              | 62821                | 57mm         | 56.25–57.75 | 62700              | 62846                |
| 8mm          | 7.25–8.75   | 62602              | N/A                  | 33mm         | 32.25–33.75 | 62652              | 62822                | 58mm         | 57.25–58.75 | 62702              | 62847                |
| 9mm          | 8.25–9.75   | 62604              | N/A                  | 34mm         | 33.25–34.75 | 62654              | 62823                | 59mm         | 58.25–59.75 | 62704              | 62848                |
| 10mm         | 9.25–10.75  | 62606              | N/A                  | 35mm         | 34.25–35.75 | 62656              | 62824                | 60mm         | 59.25–60.75 | 62706              | 62849                |
| 11mm         | 10.25–11.75 | 62608              | 62800                | 36mm         | 35.25–36.75 | 62658              | 62825                | 61mm         | 60.25–61.75 | 62708              | 62850                |
| 12mm         | 11.25–12.75 | 62610              | 62801                | 37mm         | 36.25–37.75 | 62660              | 62826                | 62mm         | 61.25–62.75 | 62710              | 62851                |
| 13mm         | 12.25–13.75 | 62612              | 62802                | 38mm         | 37.25–38.75 | 62662              | 62827                | 63mm         | 62.25–63.75 | 62712              | 62852                |
| 14mm         | 13.25–14.75 | 62614              | 62803                | 39mm         | 38.25–39.75 | 62664              | 62828                | 64mm         | 63.25–64.75 | 62714              | 62853                |
| 15mm         | 14.25–15.75 | 62616              | 62804                | 40mm         | 39.25–40.75 | 62666              | 62829                | 65mm         | 64.25–65.75 | 62716              | 62854                |
| 16mm         | 15.25–16.75 | 62618              | 62805                | 41mm         | 40.25–41.75 | 62668              | 62830                | 66mm         | 65.25–66.75 | 62718              | 62855                |
| 17mm         | 16.25–17.75 | 62620              | 62806                | 42mm         | 41.25–42.75 | 62670              | 62831                | 67mm         | 66.25–67.75 | 62720              | 62856                |
| 18mm         | 17.25–18.75 | 62622              | 62807                | 43mm         | 42.25–43.75 | 62672              | 62832                | 68mm         | 67.25–68.75 | 62722              | 62857                |
| 19mm         | 18.25–19.75 | 62624              | 62808                | 44mm         | 43.25–44.75 | 62674              | 62833                | 69mm         | 68.25–69.75 | 62724              | 62858                |
| 20mm         | 19.25–20.75 | 62626              | 62809                | 45mm         | 44.25–45.75 | 62676              | 62834                | 70mm         | 69.25–70.75 | 62726              | 62859                |
| 21mm         | 20.25–21.75 | 62628              | 62810                | 46mm         | 45.25–46.75 | 62678              | 62835                | 71mm         | 70.25–71.75 | 62728              | 62860                |
| 22mm         | 21.25–22.75 | 62630              | 62811                | 47mm         | 46.25–47.75 | 62680              | 62836                | 72mm         | 71.25–72.75 | 62730              | 62861                |
| 23mm         | 22.25–23.75 | 62632              | 61812                | 48mm         | 47.25–48.75 | 62682              | 62837                | 73mm         | 72.25–73.75 | 62732              | 62862                |
| 24mm         | 23.25–24.75 | 62634              | 62813                | 49mm         | 48.25–49.75 | 62684              | 62838                | 74mm         | 73.25–74.75 | 62734              | 62863                |
| 25mm         | 24.25–25.75 | 62636              | 62814                | 50mm         | 49.25–50.75 | 62686              | 62839                | 75mm         | 74.25–75.75 | 62736              | 62864                |
| 26mm         | 25.25–26.75 | 62638              | 62815                | 51mm         | 50.25–51.75 | 62688              | 62840                | 76mm         | 75.25–76.75 | 62738              | 62865                |
| 27mm         | 26.25–27.75 | 62640              | 62816                | 52mm         | 51.25–52.75 | 62690              | 62841                | 77mm         | 76.25–77.75 | 62740              | 62866                |
| 28mm         | 27.25–28.75 | 62642              | 62817                | 53mm         | 52.25–53.75 | 62692              | 62842                | 78mm         | 77.25–78.75 | 62742              | N/A                  |
| 29mm         | 28.25–29.75 | 62644              | 62818                | 54mm         | 53.25–54.75 | 62694              | 62843                | 79mm         | 78.25–79.75 | 62744              | N/A                  |
| 30mm         | 29.25–30.75 | 62646              | 62819                | 55mm         | 54.25–55.75 | 62696              | 62844                | 80mm         | 79.25–80.75 | 62746              | N/A                  |
| 31mm         | 30.25–31.75 | 62648              | 62820                | 56mm         | 55.25–56.75 | 62698              | 62845                |              |             |                    |                      |

\*Royal QG-80 collets have six segments instead of three for increased gripping torque.

### Royal QG-80 Hex Collets\* – \$559 Each

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER | NOMINAL SIZE | RANGE (INCHES) | PART NUMBER | NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|--------------|----------------|-------------|--------------|----------------|-------------|
| 7/16"        | 0.407–0.469    | 44740       | 1 1/4"       | 1.219–1.281    | 44753       | 2 1/16"      | 2.031–2.094    | 44766       |
| 1/2"         | 0.469–0.531    | 44741       | 1 5/16"      | 1.281–1.344    | 44754       | 2 3/8"       | 2.094–2.156    | 44767       |
| 9/16"        | 0.532–0.594    | 44742       | 1 3/8"       | 1.344–1.406    | 44755       | 2 1/2"       | 2.156–2.219    | 44768       |
| 5/8"         | 0.594–0.656    | 44743       | 1 7/16"      | 1.406–1.469    | 44756       | 2 1/4"       | 2.219–2.281    | 44769       |
| 1 1/16"      | 0.657–0.719    | 44744       | 1 1/2"       | 1.469–1.531    | 44757       | 2 5/16"      | 2.281–2.344    | 44770       |
| 3/4"         | 0.719–0.781    | 44745       | 1 9/16"      | 1.531–1.594    | 44758       | 2 3/8"       | 2.344–2.406    | 44771       |
| 13/16"       | 0.782–0.844    | 44746       | 1 5/8"       | 1.594–1.656    | 44759       | 2 7/16"      | 2.406–2.469    | 44772       |
| 7/8"         | 0.844–0.906    | 44747       | 1 11/16"     | 1.656–1.719    | 44760       | 2 1/2"       | 2.469–2.531    | 44773       |
| 15/16"       | 0.907–0.969    | 44748       | 1 3/4"       | 1.719–1.781    | 44761       | 2 9/16"      | 2.531–2.594    | 44774       |
| 1"           | 0.969–1.031    | 44749       | 1 13/16"     | 1.781–1.844    | 44762       | 2 5/8"       | 2.594–2.656    | 44775       |
| 1 1/16"      | 1.032–1.094    | 44750       | 1 7/8"       | 1.844–1.906    | 44763       | 2 11/16"     | 2.656–2.719    | 44776       |
| 1 1/8"       | 1.094–1.156    | 44751       | 1 15/16"     | 1.906–1.969    | 44764       | 2 3/4"       | 2.719–2.781    | 44777       |
| 1 1/16"      | 1.156–1.219    | 44752       | 2"           | 1.969–2.031    | 44765       |              |                |             |

\*Royal QG-80 collets have six segments instead of three for increased gripping torque.

### Royal QG-80 Square Collets\* – \$644 Each

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER | NOMINAL SIZE | RANGE (INCHES) | PART NUMBER | NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|--------------|----------------|-------------|--------------|----------------|-------------|
| 3/8"         | 0.344–0.406    | 44793       | 1"           | 0.969–1.031    | 44782       | 1 5/8"       | 1.594–1.656    | 44798       |
| 1/2"         | 0.469–0.531    | 44780       | 1 1/8"       | 1.094–1.156    | 44796       | 1 3/4"       | 1.719–1.781    | 44785       |
| 5/8"         | 0.594–0.656    | 44794       | 1 1/4"       | 1.219–1.281    | 44783       | 1 7/8"       | 1.844–1.906    | 44799       |
| 3/4"         | 0.719–0.781    | 44781       | 1 3/8"       | 1.344–1.406    | 44797       | 2"           | 1.969–2.031    | 44786       |
| 7/8"         | 0.844–0.906    | 44795       | 1 1/2"       | 1.469–1.531    | 44784       |              |                |             |

\*Royal QG-80 collets have six segments instead of three for increased gripping torque.

### Royal QG-80 Emergency Collets – \$475 Each – See Page 38



# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

## QG-100

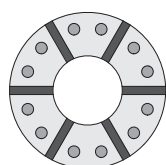


### QG-100 CAPACITY

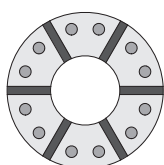
|                |                 |
|----------------|-----------------|
| Bar Diameter   | 4.03" (100.8mm) |
| Slug Diameter* | 5.15" (130.8mm) |

\* See page 38 for details.

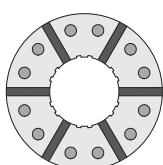
- Huge inventory of Round, Hex, Square, and Emergency styles always in stock, ready for same-day shipping.
- Smooth and serrated versions for round-bore models (all others smooth only).
- **Industry-leading 0.080" gripping range** covers a wide range of part diameters. Collets are ground to nominal size and have a range of +/- 0.040".
- Parallel-grip ensures full-length part contact for maximum grip force, rigidity, and accuracy.
- Six-segment design further increases gripping torque.
- Can be counter-bored for increased part capacity up to 5.15" – see page 38 for details.
- Quick-ship specials available for custom shapes.
- Utilizes pneumatic changing tool.



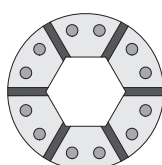
Round Inch



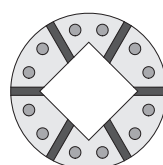
Round Metric



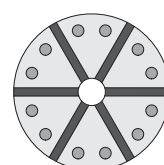
Serrated



Hex



Square



Emergency

## Royal QG-100 **Red** Collets\* (Inch) – \$675 Each

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 5/8"         | 0.585–0.665    | 45012              | N/A                  |
| 11/16"       | 0.648–0.728    | 45013              | N/A                  |
| 3/4"         | 0.710–0.790    | 45014              | N/A                  |
| 13/16"       | 0.773–0.853    | 45015              | N/A                  |
| 7/8"         | 0.835–0.915    | 45016              | N/A                  |
| 15/16"       | 0.898–0.978    | 45017              | N/A                  |
| 1"           | 0.960–1.040    | 45018              | N/A                  |
| 1 1/16"      | 1.023–1.103    | 45019              | N/A                  |
| 1 1/8"       | 1.085–1.165    | 45020              | N/A                  |
| 1 1/4"       | 1.184–1.228    | 45021              | N/A                  |
| 1 1/2"       | 1.210–1.290    | 45022              | N/A                  |
| 1 5/8"       | 1.273–1.353    | 45023              | N/A                  |
| 1 3/4"       | 1.335–1.415    | 45024              | N/A                  |
| 1 7/8"       | 1.398–1.478    | 45025              | N/A                  |
| 1 1/2"       | 1.460–1.540    | 45026              | 45201                |
| 1 9/16"      | 1.523–1.603    | 45027              | 45202                |
| 1 5/8"       | 1.585–1.665    | 45028              | 45203                |
| 1 11/16"     | 1.648–1.728    | 45029              | 45204                |
| 1 3/4"       | 1.710–1.790    | 45030              | 45205                |

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 1 13/16"     | 1.773–1.853    | 45031              | 45206                |
| 1 7/8"       | 1.835–1.915    | 45032              | 45207                |
| 1 15/16"     | 1.898–1.978    | 45033              | 45208                |
| 2"           | 1.960–2.040    | 45034              | 45209                |
| 2 1/16"      | 2.023–2.103    | 45035              | 45210                |
| 2 1/8"       | 2.085–2.165    | 45036              | 45211                |
| 2 3/16"      | 2.148–2.228    | 45037              | 45212                |
| 2 1/4"       | 2.210–2.290    | 45038              | 45213                |
| 2 5/16"      | 2.273–2.353    | 45039              | 45214                |
| 2 3/8"       | 2.335–2.415    | 45040              | 45215                |
| 2 7/16"      | 2.398–2.478    | 45041              | 45216                |
| 2 1/2"       | 2.460–2.540    | 45042              | 45217                |
| 2 9/16"      | 2.523–2.603    | 45043              | 45218                |
| 2 5/8"       | 2.585–2.665    | 45044              | 45219                |
| 2 11/16"     | 2.648–2.728    | 45045              | 45220                |
| 2 3/4"       | 2.710–2.790    | 45046              | 45221                |
| 2 13/16"     | 2.773–2.853    | 45047              | 45222                |
| 2 7/8"       | 2.835–2.915    | 45048              | 45223                |
| 2 15/16"     | 2.898–2.978    | 45049              | 45224                |

| NOMINAL SIZE | RANGE (INCHES) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|----------------|--------------------|----------------------|
| 3"           | 2.960–3.040    | 45050              | 45225                |
| 3 1/16"      | 3.023–3.103    | 45051              | 45226                |
| 3 1/8"       | 3.085–3.165    | 45052              | 45227                |
| 3 3/16"      | 3.148–3.228    | 45053              | 45228                |
| 3 1/4"       | 3.210–3.290    | 45054              | 45229                |
| 3 5/16"      | 3.273–3.353    | 45055              | 45230                |
| 3 3/8"       | 3.335–3.415    | 45056              | 45231                |
| 3 7/16"      | 3.398–3.478    | 45057              | 45232                |
| 3 1/2"       | 3.460–3.540    | 45058              | 45233                |
| 3 9/16"      | 3.523–3.603    | 45059              | 45234                |
| 3 5/8"       | 3.585–3.665    | 45060              | 45235                |
| 3 11/16"     | 3.648–3.728    | 45061              | 45236                |
| 3 3/4"       | 3.710–3.790    | 45062              | 45237                |
| 3 13/16"     | 3.773–3.853    | 45063              | N/A                  |
| 3 7/8"       | 3.835–3.915    | 45064              | N/A                  |
| 3 15/16"     | 3.898–3.978    | 45065              | N/A                  |
| 4"           | 3.960–4.040    | 45066              | N/A                  |

\*Royal QG-100 collets have six segments instead of three for increased gripping torque.

# ROYAL ULTRA-PRECISION QUICK-GRIP™ COLLETS

## QG-100



### Royal QG-100 Round Collets\* (Metric) – \$675 Each

| NOMINAL SIZE | RANGE (mm) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|------------|--------------------|----------------------|
| 16mm         | 15.0–17.0  | 62900              | N/A                  |
| 17mm         | 16.0–18.0  | 62902              | N/A                  |
| 18mm         | 17.0–19.0  | 62904              | N/A                  |
| 19mm         | 18.0–20.0  | 62906              | N/A                  |
| 20mm         | 19.0–21.0  | 62908              | N/A                  |
| 21mm         | 20.0–22.0  | 62910              | N/A                  |
| 22mm         | 21.0–23.0  | 62912              | N/A                  |
| 23mm         | 22.0–24.0  | 62914              | N/A                  |
| 24mm         | 23.0–25.0  | 62916              | N/A                  |
| 25mm         | 24.0–26.0  | 62918              | N/A                  |
| 26mm         | 25.0–27.0  | 62920              | N/A                  |
| 27mm         | 26.0–28.0  | 62922              | N/A                  |
| 28mm         | 27.0–29.0  | 62924              | N/A                  |
| 29mm         | 28.0–30.0  | 62926              | N/A                  |
| 30mm         | 29.0–31.0  | 62928              | N/A                  |
| 31mm         | 30.0–32.0  | 62930              | N/A                  |
| 32mm         | 31.0–33.0  | 62932              | N/A                  |
| 33mm         | 32.0–34.0  | 62934              | N/A                  |
| 34mm         | 33.0–35.0  | 62936              | N/A                  |
| 35mm         | 34.0–36.0  | 62938              | N/A                  |
| 36mm         | 35.0–37.0  | 62940              | N/A                  |
| 37mm         | 36.0–38.0  | 62942              | N/A                  |
| 38mm         | 37.0–39.0  | 62944              | 63100                |
| 39mm         | 38.0–40.0  | 62946              | 63101                |
| 40mm         | 39.0–41.0  | 62948              | 63102                |
| 41mm         | 40.0–42.0  | 62950              | 62103                |
| 42mm         | 41.0–43.0  | 62952              | 63104                |
| 43mm         | 42.0–44.0  | 62954              | 63105                |
| 44mm         | 43.0–45.0  | 62956              | 63106                |

| NOMINAL SIZE | RANGE (mm) | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|------------|--------------------|----------------------|
| 45mm         | 44.0–46.0  | 62958              | 63107                |
| 46mm         | 45.0–47.0  | 62960              | 63108                |
| 47mm         | 46.0–48.0  | 62962              | 63109                |
| 48mm         | 47.0–49.0  | 62964              | 63110                |
| 49mm         | 48.0–50.0  | 62966              | 63111                |
| 50mm         | 49.0–51.0  | 62968              | 63112                |
| 51mm         | 50.0–52.0  | 62970              | 63113                |
| 52mm         | 51.0–53.0  | 62972              | 63114                |
| 53mm         | 52.0–54.0  | 62974              | 63115                |
| 54mm         | 53.0–55.0  | 62976              | 63116                |
| 55mm         | 54.0–56.0  | 62978              | 63117                |
| 56mm         | 55.0–57.0  | 62980              | 63118                |
| 57mm         | 56.0–58.0  | 62982              | 63119                |
| 58mm         | 57.0–59.0  | 62984              | 63120                |
| 59mm         | 58.0–60.0  | 62986              | 63121                |
| 60mm         | 59.0–61.0  | 62988              | 63122                |
| 61mm         | 60.0–62.0  | 62990              | 63123                |
| 62mm         | 61.0–63.0  | 62992              | 63124                |
| 63mm         | 62.0–64.0  | 62994              | 63125                |
| 64mm         | 63.0–65.0  | 62996              | 63126                |
| 65mm         | 64.0–66.0  | 62998              | 63127                |
| 66mm         | 65.0–67.0  | 63000              | 63128                |
| 67mm         | 66.0–68.0  | 63002              | 63129                |
| 68mm         | 67.0–69.0  | 63004              | 63130                |
| 69mm         | 68.0–70.0  | 63006              | 63131                |
| 70mm         | 69.0–71.0  | 63008              | 63132                |
| 71mm         | 70.0–72.0  | 63010              | 63133                |
| 72mm         | 71.0–73.0  | 63012              | 63134                |
| 73mm         | 72.0–74.0  | 63014              | 63135                |

| NOMINAL SIZE | RANGE (mm)  | SMOOTH PART NUMBER | SERRATED PART NUMBER |
|--------------|-------------|--------------------|----------------------|
| 74mm         | 73.0–75.0   | 63016              | 63136                |
| 75mm         | 74.0–76.0   | 63018              | 63137                |
| 76mm         | 75.0–77.0   | 63020              | 63138                |
| 77mm         | 76.0–78.0   | 63022              | 63139                |
| 78mm         | 77.0–79.0   | 63024              | 63140                |
| 79mm         | 78.0–80.0   | 63026              | 63141                |
| 80mm         | 79.0–81.0   | 63028              | 63142                |
| 81mm         | 80.0–82.0   | 63030              | 63143                |
| 82mm         | 81.0–83.0   | 63032              | 63144                |
| 83mm         | 82.0–84.0   | 63034              | 63145                |
| 84mm         | 83.0–85.0   | 63036              | 63146                |
| 85mm         | 84.0–86.0   | 63038              | 63147                |
| 86mm         | 85.0–87.0   | 63040              | 63148                |
| 87mm         | 86.0–88.0   | 63042              | 63149                |
| 88mm         | 87.0–89.0   | 63044              | 63150                |
| 89mm         | 88.0–90.0   | 63046              | 63151                |
| 90mm         | 89.0–91.0   | 63048              | 63152                |
| 91mm         | 90.0–92.0   | 63050              | 63153                |
| 92mm         | 91.0–93.0   | 63052              | 63154                |
| 93mm         | 92.0–94.0   | 63054              | 63155                |
| 94mm         | 93.0–95.0   | 63056              | 63156                |
| 95mm         | 94.0–96.0   | 63058              | 63157                |
| 96mm         | 95.0–97.0   | 63060              | 63158                |
| 97mm         | 96.0–98.0   | 63062              | 63159                |
| 98mm         | 97.0–99.0   | 63064              | 63160                |
| 99mm         | 98.0–100.0  | 63066              | 63161                |
| 100mm        | 99.0–101.00 | 63068              | 63162                |

\*Royal QG-100 collets have six segments instead of three for increased gripping torque.

### Royal QG-100 Hex Collets\* – \$875 Each

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 3/4"         | 0.710–0.790    | 44904       |
| 7/8"         | 0.835–0.915    | 44906       |
| 1"           | 0.960–1.040    | 44908       |
| 1 1/8"       | 1.085–1.165    | 44910       |
| 1 1/4"       | 1.210–1.290    | 44912       |
| 1 3/8"       | 1.335–1.415    | 44914       |
| 1 1/2"       | 1.460–1.540    | 44916       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1 5/8"       | 1.585–1.665    | 44918       |
| 1 3/4"       | 1.710–1.790    | 44920       |
| 1 7/8"       | 1.835–1.915    | 44922       |
| 2"           | 1.960–2.040    | 44924       |
| 2 1/8"       | 2.085–2.165    | 44926       |
| 2 1/4"       | 2.210–2.290    | 44928       |
| 2 3/8"       | 2.335–2.415    | 44930       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 2 1/2"       | 2.460–2.540    | 44932       |
| 2 5/8"       | 2.585–2.665    | 44934       |
| 2 3/4"       | 2.710–2.790    | 44936       |
| 2 7/8"       | 2.835–2.915    | 44938       |
| 3"           | 2.960–3.040    | 44940       |
| 3 1/8"       | 3.085–3.165    | 44942       |
| 3 1/4"       | 3.210–3.290    | 44944       |

\*Royal QG-100 collets have six segments instead of three for increased gripping torque.

### Royal QG-100 Square Collets\* – \$875 Each

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1"           | 0.960–1.040    | 44950       |
| 1 1/8"       | 1.085–1.165    | 44952       |
| 1 1/4"       | 1.210–1.290    | 44954       |
| 1 3/8"       | 1.335–1.415    | 44956       |
| 1 1/2"       | 1.460–1.540    | 44958       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 1 5/8"       | 1.585–1.665    | 44960       |
| 1 3/4"       | 1.710–1.790    | 44962       |
| 1 7/8"       | 1.835–1.915    | 44964       |
| 2"           | 1.960–2.040    | 44966       |
| 2 1/8"       | 2.085–2.165    | 44968       |

| NOMINAL SIZE | RANGE (INCHES) | PART NUMBER |
|--------------|----------------|-------------|
| 2 1/4"       | 2.210–2.290    | 44970       |
| 2 3/8"       | 2.335–2.415    | 44972       |
| 2 1/2"       | 2.460–2.540    | 44974       |
| 2 5/8"       | 2.585–2.665    | 44976       |
| 2 3/4"       | 2.710–2.790    | 44978       |

\*Royal QG-100 collets have six segments instead of three for increased gripping torque.

### Royal QG-100 Emergency Collets\* – \$795 Each – See Page 38



# ROYAL QUICK-GRIP™ EMERGENCY COLLETS



- Semi-hard Quick-Grip™ emergency collets are designed to be machined in-place by the user to **accommodate special sizes, shapes, steps, etc.**
- Available in assorted pilot hole sizes to minimize machining time.
- Collets can be counter-bored beyond standard capacity, **eliminating the need for a three-jaw chuck on many jobs.** The chart below provides some basic counter-bore guidelines, but many other diameter/depth combinations are possible. Please contact Royal for additional information.
- Boring fixture holds collet segments firmly in-place and puts collet under slight compression to ensure accuracy and roundness during machining. Order fixture separately.

## Royal Quick-Grip™ Emergency Collets

| FITS CHUCK MODEL | PILOT HOLE SIZE | PART NUMBER | PRICE        |
|------------------|-----------------|-------------|--------------|
| QG-42            | 5mm (0.20")     | 44187       | <b>\$280</b> |
|                  | 15mm (0.59")    | 44188       | <b>280</b>   |
| QG-52            | 8mm (0.31")     | 44395       | <b>280</b>   |
|                  | 15mm (0.59")    | 44396       | <b>280</b>   |
| QG-65            | 8mm (0.31")     | 44353       | <b>315</b>   |
|                  | 20mm (0.79")    | 44354       | <b>315</b>   |
|                  | 30mm (1.18")    | 44355       | <b>315</b>   |
| QG-80            | 8mm (0.31")     | 44360       | <b>475</b>   |
|                  | 20mm (0.79")    | 44361       | <b>475</b>   |
|                  | 40mm (1.57")    | 44362       | <b>475</b>   |
| QG-100           | 30mm (1.18")    | 44367       | <b>795</b>   |
|                  | 45mm (1.77")    | 44368       | <b>795</b>   |
|                  | 65mm (2.56")    | 44369       | <b>795</b>   |

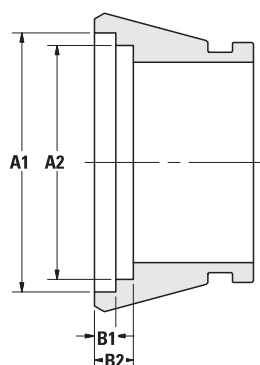
**NEW**



## Royal Boring Fixtures

| COLLET MODEL | PART NUMBER | PRICE        |
|--------------|-------------|--------------|
| QG-42        | 44082       | <b>\$203</b> |
| QG-52        | 44094       | <b>203</b>   |
| QG-65        | 44083       | <b>286</b>   |
| QG-80        | 44088       | <b>468</b>   |
| QG-100       | 44089       | <b>562</b>   |

## Royal Quick-Grip™ Collet Counter-Bore Guidelines



- The parameters shown represent a sampling of counter-bore possibilities. Other diameter/depth combinations are possible. Please contact Royal with your specific requirements.
- For precise z-axis positioning, best practice is to use a Royal stop.
- Users can counter-bore their own emergency collets, or **order to size as hardened and ground specials.**
- For a better understanding of counter-bore collets and their use, please contact one of our applications engineers at 1-800-645-4174.

| COLLET MODEL | A1   | B1   | A2   | B2   |
|--------------|------|------|------|------|
| QG-42        | 2.62 | 0.28 | 2.53 | 0.39 |
| QG-52        | 2.57 | 0.28 | 2.49 | 0.50 |
| QG-65        | 3.40 | 0.28 | 3.07 | 0.51 |
| QG-80        | 4.00 | 0.28 | 3.66 | 0.51 |
| QG-100       | 5.15 | 0.28 | 4.61 | 0.79 |

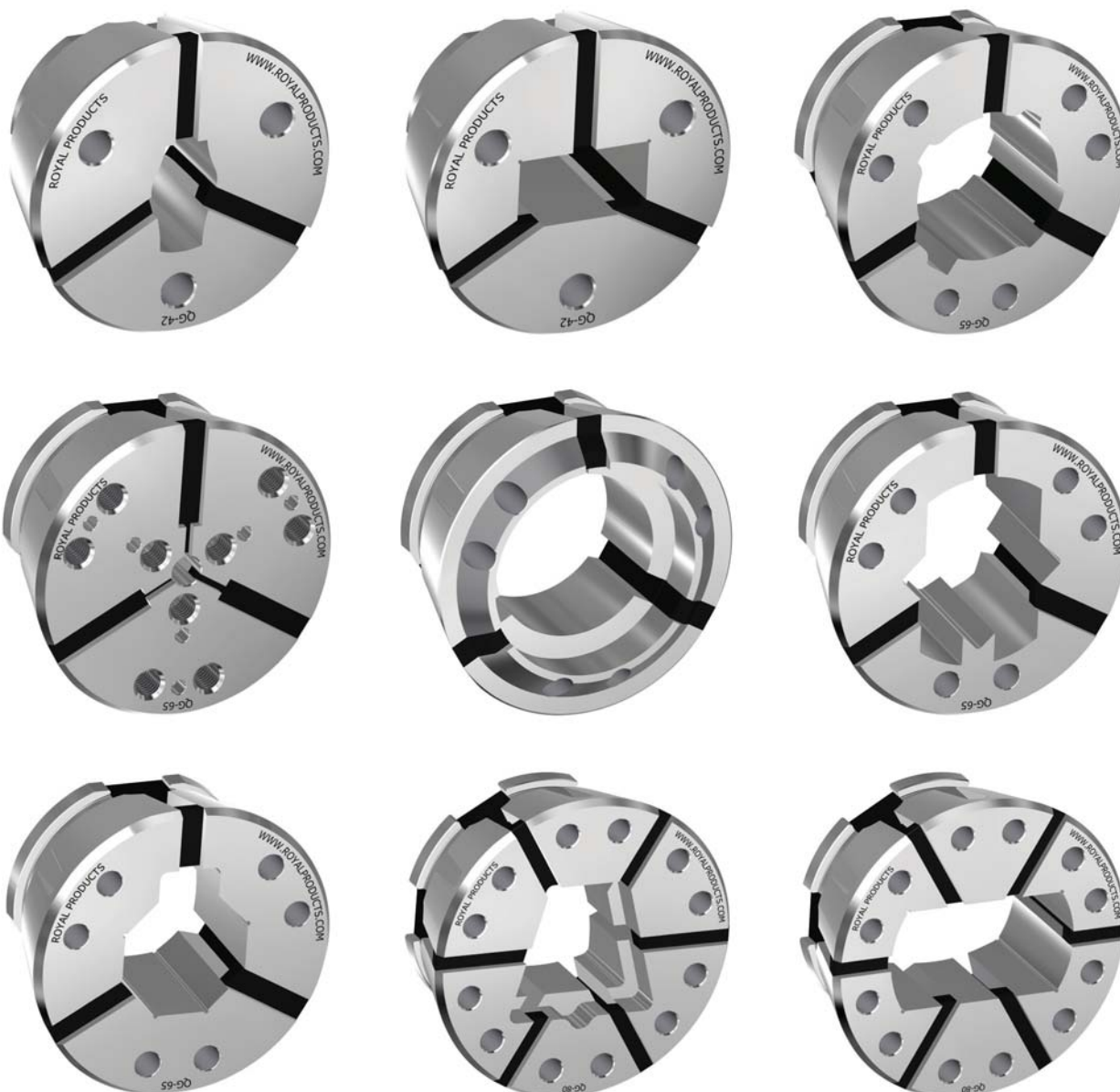
# ROYAL CUSTOM QUICK-GRIP™ COLLETS



In addition to the thousands of standard Quick-Grip™ Collets we stock for same-day shipping, Royal also offers extensive design and manufacturing services for **custom collets to suit unique workpiece shapes**. The two main applications for custom collets are:

- Second-op turning where the gripping surface is not cylindrical.
- Milling applications where a Royal Power-Block™ Collet Fixture provides a superior workholding solution over conventional vises and prismatic fixtures.

Shown below are a few examples to highlight some of our capabilities. Please give one of our applications engineers a call today to discuss how **custom Quick-Grip™ Collets** can help optimize your manufacturing processes.



**Have a Question? Give One of Our Engineers a Call at 1-800-645-4174**



## ROYAL QUICK-GRIP™ S-TYPE MASTER COLLETS

Occasionally, customers express interest in using S-type collet pads to grip their parts. Although this outdated technology is typically not the best choice for most workholding applications, S-type collet pads can be utilized with Royal Quick-Grip™ CNC Collet Chucks via our Quick-Grip™ S-Type Master Collets. These master collets are available for Royal QG-65 and QG-80 chuck models, and are capable of accepting S-20, S-26, and S-30 collet pads.



- ❑ Three master collet models to choose from:
  - QG-65 Master Collet – accepts S-20 collet pads (2" capacity)
  - QG-80 Master Collet – accepts S-26 collet pads (2-5/8" capacity)
  - QG-80 Master Collet – accepts S-30 collet pads (3" capacity)
- ❑ **It is important to note that the master collet must be installed in the chuck prior to pad installation, thereby mitigating the system's quick-change advantage.**
- ❑ Royal QG-80 master collets contain four segments instead of our traditional six, requiring the use of a special four-segment changing tool (sold separately below). The model 65 utilizes the same installation tool as our standard QG-65 collets.
- ❑ Due to the stacking of tolerances and complex geometry, **the use of S-type collet pads will result in a significant reduction in accuracy.** Most S-pad manufacturers will not guarantee their pads to run better than 0.001" – 0.0025" TIR. By contrast, Royal hardened and ground Quick-Grip™ collets are guaranteed accurate to 0.0002" TIR.
- ❑ The use of S-type pads reduces overall Quick-Grip™ chucking capacity. See chart below.

### The Bottom Line

Using S-Type Collet Pads in a Royal Quick-Grip™ Collet Chuck may come in handy for some jobs, but their use will eliminate the quick-change feature and cause a reduction in both gripping capacity and overall system accuracy.

For the highest accuracy, best performance, and full Quick-Grip™ functionality, it is always best to utilize hardened and ground Royal Quick-Grip™ Collets.



### Royal Quick-Grip™ S-Type Master Collets

| CHUCK MODEL | S-TYPE PAD MODEL | MAXIMUM PAD CAPACITY* | MASTER COLLET PART NUMBER | PRICE**      |
|-------------|------------------|-----------------------|---------------------------|--------------|
| QG-65       | S-20             | 2.00                  | 44196                     | <b>\$439</b> |
| QG-80       | S-26             | 2.63                  | 44197                     | <b>631</b>   |
| QG-80       | S-30             | 3.00                  | 44198                     | <b>631</b>   |

\*Please note – normal thru-capacity is reduced when using S-type master collets and pads.

\*\*S-type pads not included with master collet. Order pads separately through your local tooling supplier.

### Royal Collet Installation Tool For Use With Quick-Grip™ S-Type Master Collets

| MASTER COLLET MODEL | NUMBER OF SEGMENTS | PART NUMBER | PRICE        |
|---------------------|--------------------|-------------|--------------|
| QG-65               | 3                  | 44098       | <b>\$550</b> |
| QG-80               | 4*                 | 44199*      | <b>589</b>   |

\*Please note that the model 80 installation tool is not the same as the one offered for our regular QG-80 collets because our hardened and ground QG-80 collets have six segments while the QG-80 master collet has four segments.



44199 shown



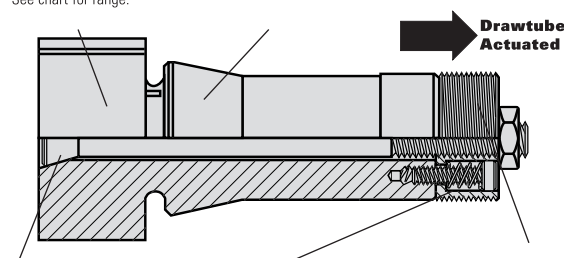
## ROYAL 5C EXPANDING COLLETS

- ❑ Unlike chucks and most collets that grip the OD of a workpiece, 5C expanding collets are designed to grip on the ID of a part.
- ❑ Accu-length design ensures **precise workpiece positioning** — no z-axis movement.
- ❑ Collet head is easily machined to required size. Can be re-machined as necessary.
- ❑ Concentricities of  $\pm 0.0002$ " can typically be achieved using Royal 5C expanding collets.
- ❑ Made from 1144 steel that can be hardened after machining for wear resistance.
- ❑ Additional head lengths and diameters available. Contact us for information.



Head is easily machined to required size by customer. See chart for range.

**Precision ground body** for excellent workpiece concentricity.



Expanding rod is hardened and ground for strength and durability.

Internal spring provides positive release.

Rear threaded section is separate from collet body. When this section is pulled back by the drawtube, it pulls the tapered expanding rod back, causing the head to expand.

### Royal 5C Internal Expanding Collets

| NOMINAL HEAD DIAMETER | HEAD LENGTH | MACHINABLE RANGE MIN-MAX | PART NUMBER | PRICE        |
|-----------------------|-------------|--------------------------|-------------|--------------|
| 3/4"                  | 1"          | 1/4"–1 1/16"             | 20100       | <b>\$204</b> |
| 1"                    | 1"          | 7/16"–1 5/16"            | 20101       | <b>204</b>   |
| 1 1/2"                | 1"          | 3/4"–1 7/16"             | 20102       | <b>194</b>   |
| 1 1/2"                | 1 1/2"      | 3/4"–1 7/16"             | 20103       | <b>213</b>   |
| 1 1/2"                | 2"          | 3/4"–1 7/16"             | 20104       | <b>214</b>   |
| 2"                    | 1"          | 3/4"–1 15/16"            | 20107       | <b>224</b>   |
| 2"                    | 1 1/2"      | 3/4"–1 15/16"            | 20108       | <b>237</b>   |
| 2"                    | 2"          | 3/4"–1 15/16"            | 20109       | <b>271</b>   |
| 2 1/2"                | 1"          | 3/4"–2 7/16"             | 20112       | <b>274</b>   |
| 3"                    | 1"          | 3/4"–2 15/16"            | 20117       | <b>301</b>   |
| 5"                    | 2"          | 3/4"–4 15/16"            | 20127       | <b>578</b>   |



### Replacement Expanding Rods

| HEAD DIA. | HEAD LENGTH | PART NUMBER | PRICE       |
|-----------|-------------|-------------|-------------|
| 3/4"      | 1"          | 20135       | <b>\$60</b> |
| 1"        | 1"          | 20136       | <b>55</b>   |
| 1 1/2"–5" | 1"          | 20130       | <b>42</b>   |
| 1 1/2"–5" | 1 1/2"      | 20131       | <b>44</b>   |
| 1 1/2"–5" | 2"          | 20132       | <b>45</b>   |



## ROYAL 5C STEP COLLETS



- ❑ Royal step collets allow large diameter parts to be held in a 5C collet.
- ❑ Head can be easily bored out by customer to required size.
- ❑ Three dowel pins are supplied to **ensure accurate machining**.
- ❑ 1 1/4" thick head allows for 1" bore depth.
- ❑ Collets are made from 1144 steel and can be hardened for wear resistance.

### Royal 5C Step Collets

| HEAD DIA.* | PILOT HOLE | PIN DIA. | PART NUMBER | PRICE        |
|------------|------------|----------|-------------|--------------|
| 2"         | 1/4"       | 1/8"     | 20020       | <b>\$184</b> |
| 3"         | 5/16"      | 1/4"     | 20022       | <b>244</b>   |
| 4"         | 5/16"      | 1/4"     | 20024       | <b>381</b>   |
| 5"         | 5/16"      | 1/4"     | 20025       | <b>493</b>   |

\*We recommend ordering a collet with a head diameter at least 1/2" larger than workpiece diameter.

**Note** — these step collets close on the 10° angle, not the head OD. When using, be sure part is sufficiently clamped.

# ROYAL ULTRA-PRECISION ER COLLETS – 0.0002" TIR



## Inch and Metric Sizes

Royal ER Collets are available in both **inch and metric sizes**. This optimizes the surface contact between the collet and cutting tool and results in higher accuracies, stronger grip force, better part finishes, and longer cutting tool life.

## Extremely Accurate

Runout is guaranteed to be 6 microns (**0.0002" TIR**), or better. Each collet is inspected to this standard prior to shipping.

## Heavy Duty Construction

Royal ER Collets are made from high-grade steels imported from Germany and are hardened for long life.



## Sealed Models Available

For precise coolant delivery to the tip of the cutting tool.

## Large Inventory

All sizes are **in-stock**, ready for immediate shipment.

## Wide Gripping Range

Royal standard ER Collets contain 16 slots, providing a larger gripping range than other brands.

## Great Value

Very **competitive prices** make these high-quality ER Collets the best value in the industry.

## ROYAL **SEALED** ULTRA-PRECISION ER COLLETS

Short slots block flow, ensuring that all coolant is delivered thru the cutting tool.

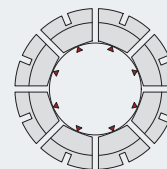


- ❑ Ultra-Precision Accuracy – 0.0002" TIR guaranteed.
- ❑ **High-pressure approved to 1400 psi.**
- ❑ Unique design is mechanically sealed by virtue of the rear slots terminating prior to the annular groove, completely blocking the path of coolant flow to the front of the collet.
- ❑ When using thru-coolant cutting tools, these collets ensure **100% coolant delivery** to the tip of the cutting tool.
- ❑ Superior to collets sealed with silicone/rubber plugs because plugs are limited to lower operating pressures and are subject to wear.
- ❑ Unlike standard ER collets, sealed models do not have a wide collapsibility range, requiring the collet bore to be matched to the cutting tool shank diameter.

## A Perfect Match to Your Cutting Tool Diameter

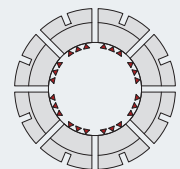
All Royal ER Collets are available from stock in both inch and metric sizes. This is very important because it enables you to select a collet that has been ground to your precise cutting tool size.

Using a collet that is **perfectly matched to the cutting tool diameter** ensures that full surface contact is achieved, resulting in higher gripping force, better accuracy, less vibration, better surface finishes, and longer tool life.



### Other Brands

Single Point Contact when Using Metric Collets to Hold Inch-Sized Tooling, or Vice Versa



### Royal Brand

Full Surface Contact Because Royal ER Collets are Ground to Exact Inch and Metric Sizes



## ULTRA-PRECISION ER COLLETS – 0.0002" TIR

### Standard and Sealed

### Inch Sizes



**ER-11**

**\$29 / \$32**



**ER-16**

**\$29 / \$32**



**ER-20**

**\$32 / \$37**



**ER-25**

**\$34 / \$39**



**ER-32**

**\$36 / \$43**



**ER-40**

**\$39 / \$49**

### Royal Ultra-Precision ER Collets (Inch)

| DRILL/ENDMILL<br>DIAMETER | STANDARD<br>COLLET GRIP<br>RANGE* | ER-11*           |                | ER-16            |                | ER-20            |                | ER-25            |                | ER-32            |                | ER-40            |                |
|---------------------------|-----------------------------------|------------------|----------------|------------------|----------------|------------------|----------------|------------------|----------------|------------------|----------------|------------------|----------------|
|                           |                                   | Standard<br>\$29 | Sealed<br>\$32 | Standard<br>\$29 | Sealed<br>\$32 | Standard<br>\$32 | Sealed<br>\$37 | Standard<br>\$34 | Sealed<br>\$39 | Standard<br>\$36 | Sealed<br>\$43 | Standard<br>\$39 | Sealed<br>\$49 |
| 1/16"                     | .062 – .043                       | 53002            |                | 53020            |                | 53050            |                | 53090            |                |                  |                |                  |                |
| 3/32"                     | .093 – .054                       | 53004            |                | 53022            |                | 53052            |                | 53092            |                | 53140            |                |                  |                |
| 1/8"                      | .125 – .086                       | 53006            | 56006          | 53024            | 56024          | 53054            | 56054          | 53094            | 56094          | 53142            |                | 53200            |                |
| 5/32"                     | .156 – .117                       | 53008            | 56008          | 53026            | 56026          | 53056            | 56056          | 53096            | 56096          | 53144            | 56144          | 53202            | 56202          |
| 3/16"                     | .187 – .148                       | 53010            | 56010          | 53028            | 56028          | 53058            | 56058          | 53098            | 56098          | 53146            | 56146          | 53204            | 56204          |
| 7/32"                     | .218 – .179                       | 53012            | 56012          | 53030            | 56030          | 53060            | 56060          | 53100            | 56100          | 53148            | 56148          | 53206            | 56206          |
| 1/4"                      | .250 – .211                       | 53014            | 56014          | 53032            | 56032          | 53062            | 56062          | 53102            | 56102          | 53150            | 56150          | 53208            | 56208          |
| 9/32"                     | .281 – .242                       |                  |                | 53034            | 56034          | 53064            | 56064          | 53104            | 56104          | 53152            | 56152          | 53210            | 56210          |
| 5/16"                     | .312 – .273                       |                  |                | 53036            | 56036          | 53066            | 56066          | 53106            | 56106          | 53154            | 56154          | 53212            | 56212          |
| 11/32"                    | .343 – .304                       |                  |                | 53038            | 56038          | 53068            | 56068          | 53108            | 56108          | 53156            | 56156          | 53214            | 56214          |
| 3/8"                      | .375 – .336                       |                  |                | 53040            | 56040          | 53070            | 56070          | 53110            | 56110          | 53158            | 56158          | 53216            | 56216          |
| 13/32"                    | .406 – .367                       |                  |                | 53042            | 56042          | 53072            | 56072          | 53112            | 56112          | 53160            | 56160          | 53218            | 56218          |
| 7/16"                     | .437 – .398                       |                  |                |                  |                | 53074            | 56074          | 53114            | 56114          | 53162            | 56162          | 53220            | 56220          |
| 15/32"                    | .468 – .429                       |                  |                |                  |                | 53076            | 56076          | 53116            | 56116          | 53164            | 56164          | 53222            | 56222          |
| 1/2"                      | .500 – .461                       |                  |                |                  |                | 53078            | 56078          | 53118            | 56118          | 53166            | 56166          | 53224            | 56224          |
| 17/32"                    | .531 – .492                       |                  |                |                  |                |                  |                | 53120            | 56120          | 53168            | 56168          | 53226            | 56226          |
| 9/16"                     | .562 – .523                       |                  |                |                  |                |                  |                | 53122            | 56122          | 53170            | 56170          | 53228            | 56228          |
| 19/32"                    | .593 – .554                       |                  |                |                  |                |                  |                | 53124            | 56124          | 53172            | 56172          | 53230            | 56230          |
| 5/8"                      | .625 – .586                       |                  |                |                  |                |                  |                | 53126            | 56126          | 53174            | 56174          | 53232            | 56232          |
| 21/32"                    | .656 – .617                       |                  |                |                  |                |                  |                |                  |                | 53176            | 56176          | 53234            | 56234          |
| 11/16"                    | .687 – .648                       |                  |                |                  |                |                  |                |                  |                | 53178            | 56178          | 53236            | 56236          |
| 23/32"                    | .718 – .679                       |                  |                |                  |                |                  |                |                  |                | 53180            | 56180          | 53238            | 56238          |
| 3/4"                      | .750 – .711                       |                  |                |                  |                |                  |                |                  |                | 53182            | 56182          | 53240            | 56240          |
| 25/32"                    | .781 – .742                       |                  |                |                  |                |                  |                |                  |                | 53184            | 56184          | 53242            | 56242          |
| 13/16"                    | .812 – .773                       |                  |                |                  |                |                  |                |                  |                | 53186            | 56186          | 53244            | 56244          |
| 27/32"                    | .843 – .804                       |                  |                |                  |                |                  |                |                  |                |                  |                | 53246            | 56246          |
| 7/8"                      | .875 – .836                       |                  |                |                  |                |                  |                |                  |                |                  |                | 53248            | 56248          |
| 29/32"                    | .906 – .867                       |                  |                |                  |                |                  |                |                  |                |                  |                | 53250            | 56250          |
| 15/16"                    | .937 – .898                       |                  |                |                  |                |                  |                |                  |                |                  |                | 53252            | 56252          |
| 31/32"                    | .969 – .930                       |                  |                |                  |                |                  |                |                  |                |                  |                | 53254            | 56254          |
| 1"                        | 1.000 – .961                      |                  |                |                  |                |                  |                |                  |                |                  |                | 53256            | 56256          |

\* Gripping range for ER-11 is 1/64". Sealed collets have no range – must be sized exactly.

# ULTRA-PRECISION ER COLLETS – 0.0002" TIR

## Standard and Sealed



### Metric Sizes



### Royal Ultra-Precision ER Collets (Metric)

| DRILL/ENDMILL<br>DIAMETER | STANDARD<br>COLLET GRIP<br>RANGE* | ER-11*           |                | ER-16            |                | ER-20            |                | ER-25            |                | ER-32            |                | ER-40            |                |
|---------------------------|-----------------------------------|------------------|----------------|------------------|----------------|------------------|----------------|------------------|----------------|------------------|----------------|------------------|----------------|
|                           |                                   | Standard<br>\$29 | Sealed<br>\$32 | Standard<br>\$29 | Sealed<br>\$32 | Standard<br>\$32 | Sealed<br>\$37 | Standard<br>\$34 | Sealed<br>\$39 | Standard<br>\$36 | Sealed<br>\$43 | Standard<br>\$39 | Sealed<br>\$49 |
| 1 mm                      | 1 – 0.5                           | 53402            |                | 53430            |                |                  |                |                  |                |                  |                |                  |                |
| 2 mm                      | 2 – 1                             | 53404            |                | 53432            |                | 53460            |                | 53502            |                |                  |                |                  |                |
| 3 mm                      | 3 – 2                             | 53406            | 56406          | 53434            | 56434          | 53462            | 56462          | 53504            | 56504          | 53550            |                |                  |                |
| 4 mm                      | 4 – 3                             | 53408            | 56408          | 53436            | 56436          | 53464            | 56464          | 53506            | 56506          | 53552            | 56552          | 53602            | 56602          |
| 5 mm                      | 5 – 4                             | 53410            | 56410          | 53438            | 56438          | 53466            | 56466          | 53508            | 56508          | 53554            | 56554          | 53604            | 56604          |
| 6 mm                      | 6 – 5                             | 53412            | 56412          | 53440            | 56440          | 53468            | 56468          | 53510            | 56510          | 53556            | 56556          | 53606            | 56606          |
| 7 mm                      | 7 – 6                             | 53414            | 56414          | 53442            | 56442          | 53470            | 56470          | 53512            | 56512          | 53558            | 56558          | 53608            | 56608          |
| 8 mm                      | 8 – 7                             |                  |                | 53444            | 56444          | 53472            | 56472          | 53514            | 56514          | 53560            | 56560          | 53610            | 56610          |
| 9 mm                      | 9 – 8                             |                  |                | 53446            | 56446          | 53474            | 56474          | 53516            | 56516          | 53562            | 56562          | 53612            | 56612          |
| 10 mm                     | 10 – 9                            |                  |                | 53448            | 56448          | 53476            | 56476          | 53518            | 56518          | 53564            | 56564          | 53614            | 56614          |
| 11 mm                     | 11 – 10                           |                  |                |                  |                | 53478            | 56478          | 53520            | 56520          | 53566            | 56566          | 53616            | 56616          |
| 12 mm                     | 12 – 11                           |                  |                |                  |                | 53480            | 56480          | 53522            | 56522          | 53568            | 56568          | 53618            | 56618          |
| 13 mm                     | 13 – 12                           |                  |                |                  |                | 53482            | 56482          | 53524            | 56524          | 53570            | 56570          | 53620            | 56620          |
| 14 mm                     | 14 – 13                           |                  |                |                  |                |                  |                | 53526            | 56526          | 53572            | 56572          | 53622            | 56622          |
| 15 mm                     | 15 – 14                           |                  |                |                  |                |                  |                | 53528            | 56528          | 53574            | 56574          | 53624            | 56624          |
| 16 mm                     | 16 – 15                           |                  |                |                  |                |                  |                | 53530            | 56530          | 53576            | 56576          | 53626            | 56626          |
| 17 mm                     | 17 – 16                           |                  |                |                  |                |                  |                |                  |                | 53578            | 56578          | 53628            | 56628          |
| 18 mm                     | 18 – 17                           |                  |                |                  |                |                  |                |                  |                | 53580            | 56580          | 53630            | 56630          |
| 19 mm                     | 19 – 18                           |                  |                |                  |                |                  |                |                  |                | 53582            | 56582          | 53632            | 56632          |
| 20 mm                     | 20 – 19                           |                  |                |                  |                |                  |                |                  |                | 53584            | 56584          | 53634            | 56634          |
| 21 mm                     | 21 – 20                           |                  |                |                  |                |                  |                |                  |                |                  |                | 53636            | 56636          |
| 22 mm                     | 22 – 21                           |                  |                |                  |                |                  |                |                  |                |                  |                | 53638            | 56638          |
| 23 mm                     | 23 – 22                           |                  |                |                  |                |                  |                |                  |                |                  |                | 53640            | 56640          |
| 24 mm                     | 24 – 23                           |                  |                |                  |                |                  |                |                  |                |                  |                | 53642            | 56642          |
| 25 mm                     | 25 – 24                           |                  |                |                  |                |                  |                |                  |                |                  |                | 53644            | 56644          |
| 26 mm                     | 26 – 25                           |                  |                |                  |                |                  |                |                  |                |                  |                | 53646            | 56646          |

\* Gripping range for ER-11 is 0.5 mm. Sealed collets have no range – must be sized exactly.



## ROYAL ULTRA-PRECISION ER COLLET SETS

### Standard and Sealed



- 0.0002" TIR guaranteed.
- Convenient sets include all popular sizes.
- Available in inch, metric, standard, and sealed models.

#### Royal ER Collet Sets (Inch – Standard)

| COLLET SERIES | RANGE              | NUMBER OF COLLETS IN SET | PART NUMBER | PRICE        |
|---------------|--------------------|--------------------------|-------------|--------------|
| ER-11         | 1/16"–1/4" x 32nds | 7                        | 53300       | <b>\$203</b> |
| ER-16         | 1/16"–3/8" x 32nds | 11                       | 53302       | <b>319</b>   |
| ER-20         | 5/32"–1/2" x 32nds | 12                       | 53304       | <b>384</b>   |
| ER-25         | 5/32"–5/8" x 32nds | 16                       | 53306       | <b>544</b>   |
| ER-32         | 7/32"–3/4" x 32nds | 18                       | 53308       | <b>648</b>   |
| ER-40         | 1/8"–1" x 16ths    | 15                       | 53310       | <b>585</b>   |

#### Royal ER Collet Sets (Metric – Standard)

| COLLET SERIES | RANGE          | NUMBER OF COLLETS IN SET | PART NUMBER | PRICE        |
|---------------|----------------|--------------------------|-------------|--------------|
| ER-11         | 1–7 mm x 1 mm  | 7                        | 53700       | <b>\$203</b> |
| ER-16         | 1–10 mm x 1 mm | 10                       | 53702       | <b>290</b>   |
| ER-20         | 2–13 mm x 1 mm | 12                       | 53704       | <b>384</b>   |
| ER-25         | 2–16 mm x 1 mm | 15                       | 53706       | <b>510</b>   |
| ER-32         | 3–20 mm x 1 mm | 18                       | 53708       | <b>648</b>   |
| ER-40         | 4–26 mm x 1 mm | 23                       | 53710       | <b>897</b>   |

#### Royal ER Collet Sets (Inch – Sealed\*)

| COLLET SERIES | RANGE              | NUMBER OF COLLETS IN SET | PART NUMBER | PRICE        |
|---------------|--------------------|--------------------------|-------------|--------------|
| ER-16         | 1/8"–3/8" x 32nds  | 9                        | 56302       | <b>\$288</b> |
| ER-20         | 5/32"–1/2" x 32nds | 12                       | 56304       | <b>444</b>   |
| ER-25         | 5/32"–5/8" x 32nds | 16                       | 56306       | <b>624</b>   |
| ER-32         | 7/32"–3/4" x 32nds | 18                       | 56308       | <b>774</b>   |
| ER-40         | 3/16"–1" x 16ths   | 14                       | 56310       | <b>686</b>   |

\* Unlike standard ER collets, sealed models do not have a wide collapsibility range and therefore must be sized to the cutting tool diameter.

#### Royal ER Collet Sets (Metric – Sealed\*)

| COLLET SERIES | RANGE          | NUMBER OF COLLETS IN SET | PART NUMBER | PRICE        |
|---------------|----------------|--------------------------|-------------|--------------|
| ER-16         | 3–10 mm x 1 mm | 8                        | 56702       | <b>\$256</b> |
| ER-20         | 3–13 mm x 1 mm | 11                       | 56704       | <b>407</b>   |
| ER-25         | 3–16 mm x 1 mm | 14                       | 56706       | <b>546</b>   |
| ER-32         | 4–20 mm x 1 mm | 17                       | 56708       | <b>731</b>   |
| ER-40         | 4–26 mm x 1 mm | 23                       | 56710       | <b>1,127</b> |

\* Unlike standard ER collets, sealed models do not have a wide collapsibility range and therefore must be sized to the cutting tool diameter.