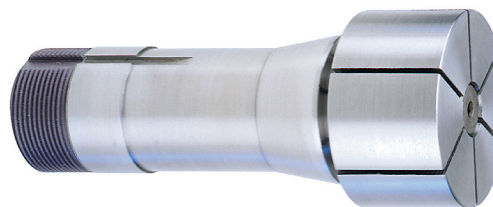




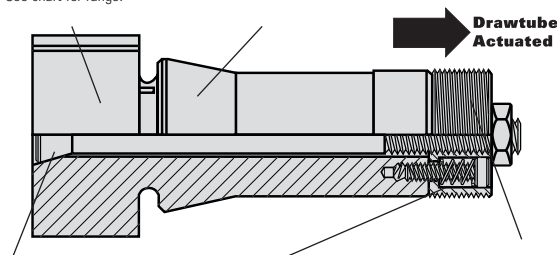
ROYAL 5C EXPANDING COLLETS

- 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 ± 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

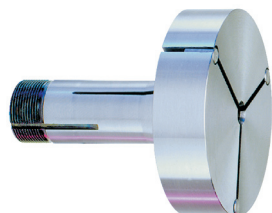
NOMINAL HEAD DIAMETER	HEAD LENGTH	MACHINABLE RANGE MIN-MAX	PART NUMBER	PRICE
3/4"	1"	1/4"–1 1/16"	20100	\$204
1"	1"	7/16"–1 5/16"	20101	204
1 1/2"	1"	3/4"–1 7/16"	20102	194
1 1/2"	1 1/2"	3/4"–1 7/16"	20103	213
1 1/2"	2"	3/4"–1 7/16"	20104	214
2"	1"	3/4"–1 15/16"	20107	224
2"	1 1/2"	3/4"–1 15/16"	20108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

Replacement Expanding Rods

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



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**.
- 1/4" 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	\$184
3"	5/16"	1/4"	20022	244
4"	5/16"	1/4"	20024	381
5"	5/16"	1/4"	20025	493

*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.