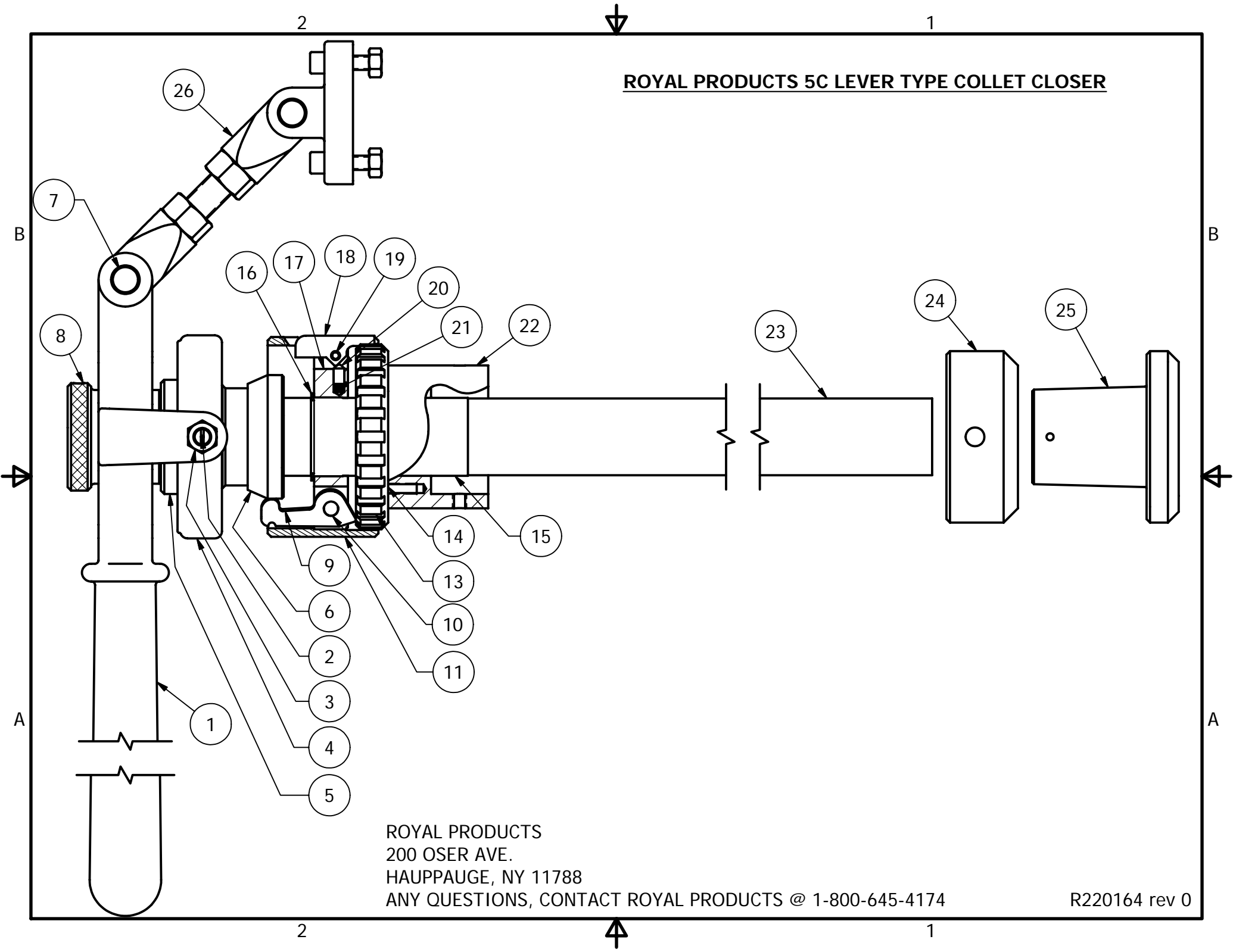


ROYAL PRODUCTS 5C LEVER TYPE COLLET CLOSER



ROYAL PRODUCTS
200 OSER AVE.
HAUPPAUGE, NY 11788
ANY QUESTIONS, CONTACT ROYAL PRODUCTS @ 1-800-645-4174

R220164 rev 0

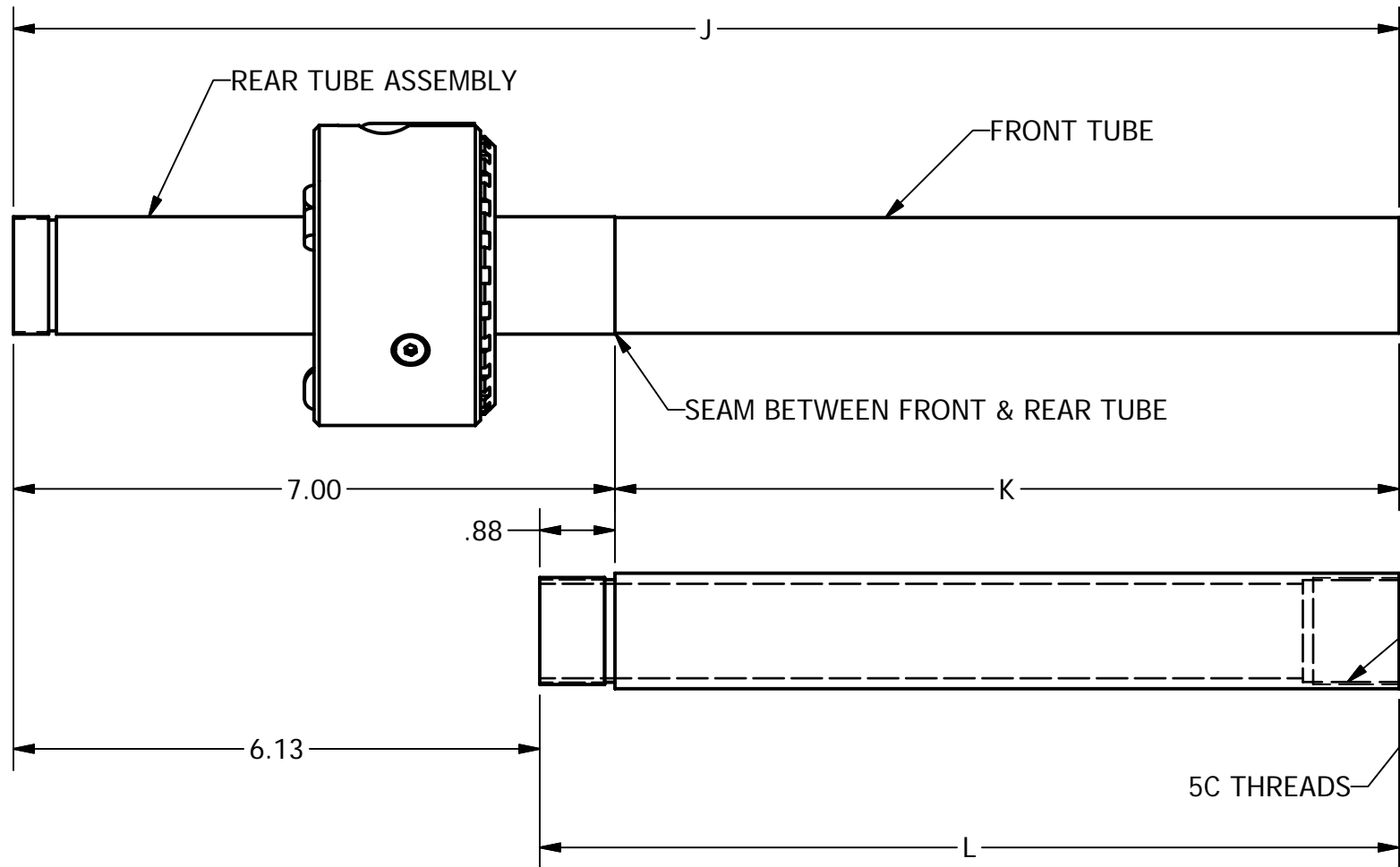
PARTS LIST 5C LEVER TYPE COLLET CLOSER

ITEM	QTY	PART NUMBER	DESCRIPTION	
1	1	R184723	HANDLE	
2	2	R185504FIN	PIVOT SCREW	
3	2	R.312-24-HN	5/16-24 HEX NUT	
4	1	R184716	BEARING & HOUSING	
5	1	R185303	LOCK NUT	
6	1	R185810	SPOOL	
7	2	R185511	LINKAGE PIN	
	1	R181704	HANDLE ASSEMBLY (INCLUDES ITEMS 1 THRU 7)	
B 8	1	R185306	STOP NUT (SET SCREW INCLUDED P/N R1/4-20X.25HSSB)	B
9	3	R184502	PRESSURE FINGER	
10	3	R.25X1.25DP	1/4 DIA X 1-1/4 LONG DOWEL PIN (FOR PRESSURE FINGER)	
11	1	R184719	CAGE HOUSING	
12	2	R10-32X.375FH	10-32 X 3/8 LONG FLAT HEAD SCREW- NOT SHOWN (FOR CAGE HOUSING)	
13	1	R185703	LOCATING RING	
14	3	R10-32X.625CS	10-32 X 5/8 LONG CAP SCREW (FOR LOCATING RING)	
15	1	R185975	REAR TUBE	
16	1	R5100-137	SNAP RING	
17	1	R185976	CAGE & REAR TUBE ASSEMBLY (INCLUDES CAGE & ITEMS 15 & 16)	
	1	R185985	COMPLETE REAR TUBE ASSEMBLY (INCLUDES ITEMS 9, 10, 11, 12, 17, 18, 19, 20 & 21)	
18	1	R184503	LOCATING FINGER	
19	1	R.125X.75DP	1/8 DIA X 3/4 LONG DOWEL PIN (FOR LOCATING FINGER)	
20	1	R185502	CAM PIN	
21	1	RLC-022B-1	SPRING (FOR CAM PIN)	
22	1	VARIES	REAR END SPINDLE ADAPTER (CUSTOM MADE FOR EACH MACHINE) NEED TO FILL OUT COLLET CLOSER ORDERING SHEET	
23	1	VARIES	FRONT TUBE (LENGTH VARIES WITH EACH MACHINE)	
24	1	VARIES	NOSE CAP (ONLY PROVIDED FOR MACHINES WITH THREADED OR L-TYPE SPINDLE NOSES) SEE ATTACHED LIST FOR PART NUMBERS	
25	1	VARIES	COLLET ADAPTER (VARIES WITH EACH MACHINE) SEE ATTACHED LIST FOR COMMON ADAPTERS	
A 26	1	R182146	STANDARD LINKAGE ASSEMBLY (IF YOUR LINKAGE DOESN'T LOOK AS SHOWN, YOU HAVE A CUSTOM LINKAGE- CALL WITH MACHINE MAKE & MODEL FOR CUSTOM LINKAGE PART NUMBER)	A

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ROYAL 5C LEVER TYPE COLLET CLOSER FRONT TUBE & REAR TUBE ASSEMBLY



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TO REPLACE YOUR EXISTING FRONT TUBE:

NEWER COLLET CLOSERS INCORPORATE A TWO PIECE TUBE DESIGN, OLDER COLLET CLOSERS USED A ONE PIECE TUBE

IF YOU HAVE A TWO PIECE DESIGN: YOU WILL HAVE A SEAM 7.00" FROM THE END OF THE REAR TUBE WHERE THE FRONT & REAR TUBES THREAD TOGETHER. CALCULATE YOUR FRONT TUBE LENGTH (FTL) AND ORDER A NEW FRONT TUBE USING P/N R185980 & SPECIFY YOUR FTL

IF YOU HAVE A ONE PIECE DESIGN: YOU WILL NEED A NEW FRONT & REAR TUBE. MEASURE THE OVER ALL LENGTH OF THE TUBE AND SUBTRACT 6.13" TO GET THE FRONT TUBE FTL. ORDER A NEW FRONT TUBE USING P/N R185980 & SPECIFY YOUR FTL. YOU WILL ALSO NEED A NEW REAR TUBE. YOU CAN BUY JUST THE REAR TUBE (P/N R185975) WHICH WE DON'T RECOMMEND BECAUSE YOU WILL HAVE TO PRESS OFF YOUR EXISTING CAGE ASSEMBLY AND PRESS IT ONTO YOUR NEW REAR TUBE. WE RECOMMEND BUYING THE CAGE & REAR TUBE ASSEMBLY (P/N R185976)

IF YOU DO NOT HAVE A FRONT TUBE TO MEASURE OR YOU ARE PUTTING THIS COLLET CLOSER ON A DIFFERENT MACHINE YOU WILL HAVE TO FILL OUT THE COLLET CLOSER ORDERING SHEET SO WE CAN CALCULATE THE CORRECT TUBE LENGTH

CALCULATING FRONT TUBE LENGTH (FTL):

THERE ARE A FEW DIFFERENT WAYS TO CALCULATE YOUR FRONT TUBE LENGTH (FTL)

1. THREAD FRONT TUBE OFF OF REAR TUBE (RIGHT HAND THREAD) AND MEASURE OVERALL LENGTH OF FRONT TUBE (DIMENSION L)

OR

2. MEASURE OVER ALL LENGTH OF FRONT & REAR TUBE ASSEMBLY (DIMENSION J) AND SUBTRACT 6.13"

OR

3. MEASURE FROM END OF FRONT TUBE TO SEAM BETWEEN FRONT & REAR TUBES (DIMENSION K) AND ADD .88"

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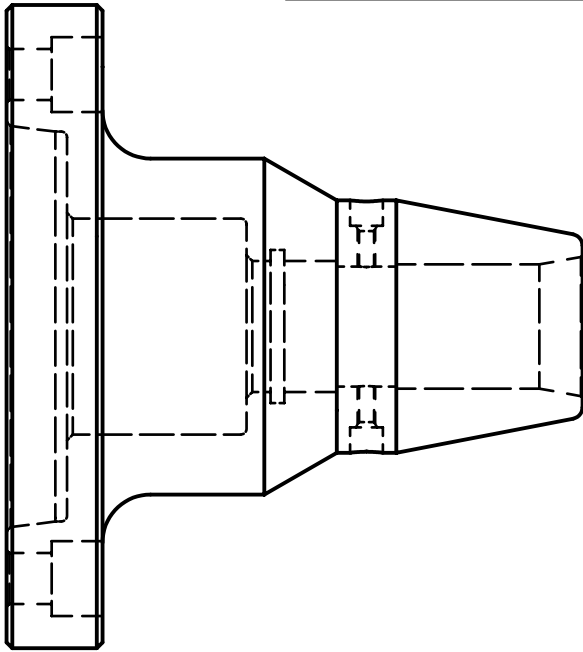
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PARTS LIST- COMMON 5C COLLET ADAPTERS

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@ 1-800-645-4174 R220164 rev 0

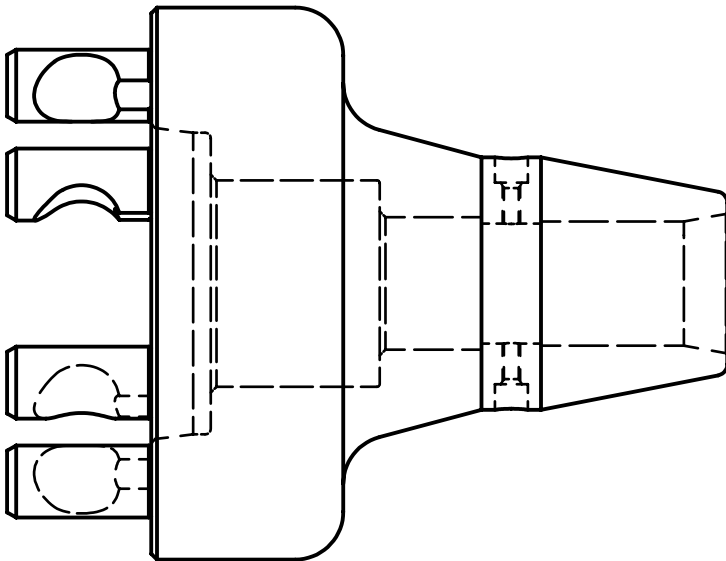
A-TYPE 5C COLLET ADAPTERS

A2-5 MOUNT P/N R188767
A2-6 MOUNT P/N R188751



D-TYPE CAM-LOCK 5C COLLET ADAPTERS

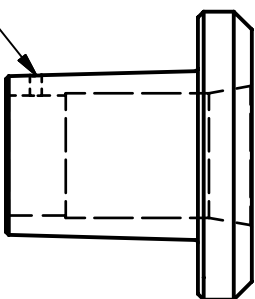
D1-3 MOUNT P/N R188762
D1-4 MOUNT P/N R188763
D1-5 MOUNT P/N R188764
D1-6 MOUNT P/N R188765
D1-8 MOUNT P/N R188766



REPLACING COLLET ADAPTER PIN-
DRILL OUT OLD PIN, INSERT 1/8" DIA COLD ROLLED
STEEL PIN. CUT PIN TO PROTRUDE .050" INTO BORE & .050"
ABOVE TAPER, PEEN END TO EXPAND, FILE SMOOTH W/ TAPER

TAPER MOUNT 5C COLLET ADAPTERS

-SPECIFY GAGE LINE DIAMETER OF SPINDLE'S INTERNAL TAPER
TO THE NEAREST THOUSANDTH OF AN INCH. (THIS IS THE
LARGE INTERNAL DIAMETER AT THE FACE OF THE SPINDLE)
THIS DIMENSION MAY BE OBTAINED BY INSERTING A CENTER
OR SLEEVE INTO SPINDLE AND MEASURING ITS OD SQUARE
AGAINST THE SPINDLE NOSE. IF NO SLEEVE OR CENTER IS
AVAILABLE, MEASURE ID BEHIND ANY CHAMFER OR RADIUS
AND INDICATE HOW DEEP MEASUREMENT WAS TAKEN.
-SPECIFY SPINDLE'S INTERNAL TAPER
(#5MT, #12 JARNO, ASA-250, ETC.)



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**NOSE CAP & SPANNER WRENCH PART LIST
(ONLY USED FOR MACHINES WITH THREADED OR L-TYPE SPINDLE NOSES)**

SPINDLE TYPE	NOSE CAP OAL	NOSE CAP P/N	SPANNER WRENCH P/N
L-00 (3.75-6 UN)	N/A	R184219	N/A
L-0 (4.50-6 UN)	N/A	R184218	N/A
L-1 (6.00-6 UN)	N/A	R184226	N/A
L-2 (7.75-5 UN)	N/A	R184246	N/A
2.25-8 UN	1.125	R184220	R34-225
2.25-8 UN	1.375	R184222	R34-225
2.25-8 UN	1.25	R184221	R34-225
2.375-6 UN	1.75	R184244	R34-228

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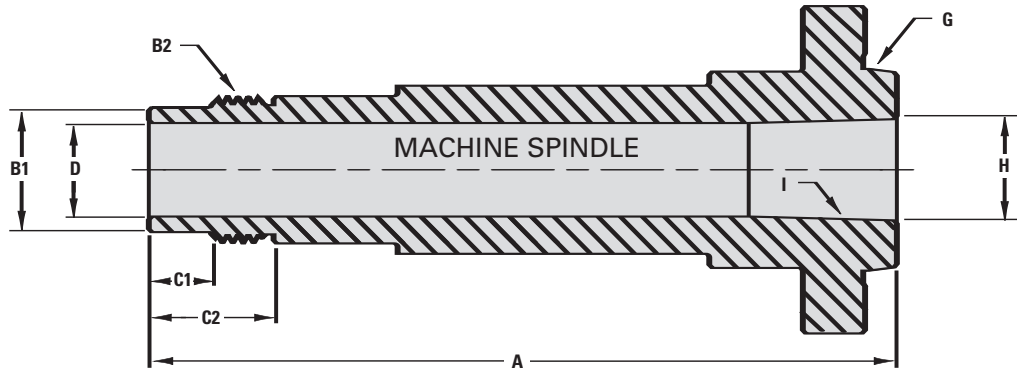
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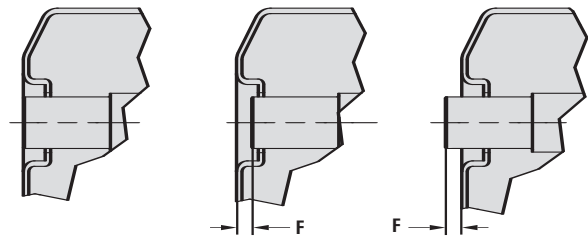
Because lathe spindle dimensions and guard configurations frequently vary, it may be necessary to complete this ordering sheet and submit it with your collet closer order. If you have any questions on how to obtain any of the required dimensions, please contact a Royal applications engineer at 1-800-645-4174.



Name of Machine: _____ Model: _____ Swing: _____

Customer Name: _____ Phone #: _____

- A Overall length of lathe spindle to the nearest 1/32".
- B1 O.D. of rear of spindle to the nearest thousandth of an inch.
- B2 O.D. thread (if applicable). Specify major diameter, pitch, and right or left hand.
- C1 Length of diameter B1.
- C2 Distance from rear of spindle to end of thread.
- D Spindle bore (1.375 min. to clear drawtube).
- F Distance from the rear of the spindle to guard. **Fill in measurement and check type below.**



FLUSH RECESSED PROTRUDING

G Select spindle type: D1-3 D1-4 D1-5 D1-6 D1-8 A2-4 A2-5 A2-6 A2-8

H Gage line diameter of internal taper.

I Internal spindle taper (5MT, 6MT, 12 Jarno, etc.).