

# INTERNAL WORKHOLDING FOR LATHES

## PRECISION EXPANDING MINI-COLLETS

Machinable to .062"  
For 5C, 16C, 2J & 3J Collet Chucks  
Tapered Stem



### Why Use Our Precision Expanding Mini-Collets?

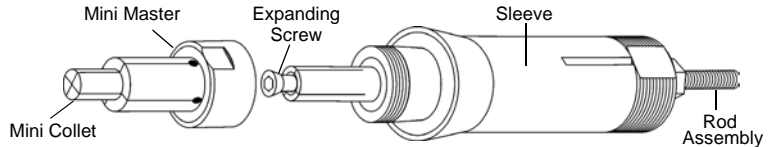
- **Low Cost-** Replacement collets keeps future costs to a minimum when you replace only the machinable collet.
- **Rigid Design-** Long taper fit increases rigidity, allowing for heavier cuts.
- **Interchangeable-** Adapter sleeves allow you to use the same expanding collet in different spindle sizes.
- **Precise-** Concentricity of .0002 T.I.R. and lengths of ± .0002 obtainable for parts with closely held bores. Reassembly concentricity is excellent.
- **Miniature Work Holding-** Mini Collets can grip bores down to 1/16" for light cuts.
- **Made in USA!**

### Features:

- Miniature workholding in 5C, 2J, 3J and 16C spindle sizes.
- Holds 3/8" to 1/16" diameter bores.
- Machinable to .062"

### Mini Collet Assembly Consists Of:

- 1-Mini Master
- 1-Expanding Screw
- 1-Mini Collet
- 1-Sleeve
- 1-Rod Assembly



### How to use the Mini Collet System:

1. **Mini Collet set up requires five parts:**  
(A) Mini Collet (B) Mini Master (C) Sleeve (D) Rod Assembly (E) RV-572 Expanding Screw
2. Clean taper of Mini Master and inside taper of Sleeve and install Mini Master securely into Sleeve.
3. Install Rod Assembly into the Sleeve and let it project into the Mini Master.
4. Insert Expanding Screw through front of Mini Master into the Rod Assembly. Hand tighten only.
5. Loosen Lock Nut and adjust Collet Nut so Rod Assembly will travel about 1/8" to 3/16".
6. Tighten Lock Nut and then lightly tighten Expanding Screw.
7. Slide Mini Collet over the Mini Master and rotate until the slots line up. Screw on the Locking Collar and tighten.
8. Insert the assembly into machine. Adjust the collet closer until Mini Collet expands slightly and machine to desired diameter.



MINI MASTER	
Part Number	Price
RV-500	\$62.77



EXPANDING SCREW	
Part Number	Price
RV-572	\$5.35



MINI COLLETS			
Dia	Lgth	Part Number	Price Each
7/16"	1/4"	RV-505	\$36.72
	9/16"	RV-506	\$53.43
	3/4"	RV-507	\$69.45

SLEEVE		
Spindle	Part Number	Price Each
5C	RV-590	\$62.11
16C	RV-591	\$110.19
2J	RV-592	\$95.50
3J	RV-593	\$110.19

ROD ASSEMBLY		
Spindle	Part Number	Price Each
5C	RV-583	\$36.72
16C	RV-584	\$54.10
2J	RV-585	\$46.74
3J	RV-585-3	\$54.10

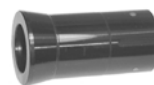
## EXPANDING COLLET ASSEMBLIES

-2 Collets, Machinable Down to .375"  
For 5C, 16C, 2J and 3J Collets



### -2 COLLET

Machinable Down to .375"				Replacement Screws		
Dia.	Length	Part Number	Price Each	Uses Rod Assembly Series:	Part Number	Price Each
1"	1"	RV-521	\$30.72	1-2	RV-572	\$5.35
	2"	RV-522	\$34.06	2-2	RV-576	\$6.67
	3"	RV-523	\$41.41	2-2		
1-1/4"	1"	RV-524	\$32.71	1-2	RV-572	\$5.35
1-1/2"	1"	RV-526	\$34.06	1-2	RV-576	\$6.67
	2"	RV-527	\$36.72	2-2		
2"	1"	RV-528	\$36.72	1-2	RV-572	\$5.35



-2 SLEEVE		
Spindle	Part No.	Price
5C	RV-590	\$62.11
16C	RV-591	\$110.19
2J	RV-592	\$95.50
3J	RV-593	\$110.19

### -2 ROD ASSEMBLY

Spindle	Series 1-2		Series 2-2	
	Part Number	Price Each	Part Number	Price Each
5C	RV-583	\$36.72	RV-583L	\$40.73
16C	RV-584	\$54.10	RV-584L	\$55.44
2J	RV-585	\$46.74	RV-585L	\$49.42
3J	RV-585-3	\$54.10	RV-585-3L	\$55.44

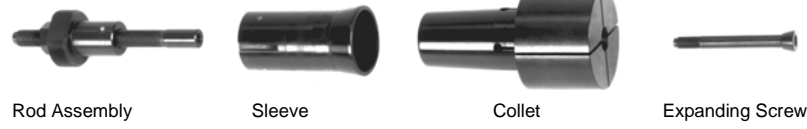
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## EXPANDING COLLET ASSEMBLIES

-4 Collets, Machinable Down to .500"



Dia.	Length	Part Number	Price Each	Uses Rod Assembly Series:	Replacement Screws	
					Part Number	Price Each
1-1/2"	1-1/2"	RV-541	\$33.39	-4 -1		
	2"	RV-542	\$38.73	-4 -1	RV-573	\$6.67
	3"	RV-543	\$47.42	-4 -2		
	4"	RV-543A	\$61.44	-4 -3	RV-578	\$8.67
2"	1-1/2"	RV-544	\$42.74	-4 -1		
	2"	RV-545	\$48.08	-4 -1	RV-573	\$6.67
	3"	RV-546	\$57.43	-4 -2		
	4"	RV-547	\$72.12	-4 -3		
	5"	RV-547A	\$114.86	-4 -4		
2-1/2"	1-1/2"	RV-548	\$51.43	-4 -1	RV-573	\$6.67
	2"	RV-549	\$60.76	-4 -1		
	3"	RV-550	\$73.46	-4 -2	RV-578	\$8.67
	4"	RV-551	\$88.15	-4 -3		
3"	1-1/2"	RV-552	\$62.11	-4 -1	RV-573	\$6.67
	2"	RV-553	\$72.12	-4 -1		
	3"	RV-554	\$95.50	-4 -2	RV-578	\$8.67
3-1/2"	1-1/2"	RV-555	\$76.79	-4 -1	RV-573	\$6.67
	3"	RV-556	\$106.19	-4 -2	RV-578	\$8.67
4"	1-1/2"	RV-557	\$94.17	-4 -1	RV-573	\$6.67
	3"	RV-557A	\$138.24	-4 -2	RV-578	\$8.67
4-1/2"	1-1/2"	RV-558	\$117.54	-4 -1		
5-1/4"	1-1/2"	RV-559	\$157.60	-4 -1	RV-573	\$6.67
6"	1-1/2"	RV-560	\$207.69	-4 -1		



**Expanding Collet Assembly Consists Of:**  
 1-Collet  
 1-Expanding Screw  
 1-Sleeve  
 1-Rod Assembly

### ROD ASSEMBLY (INCLUDES SCREW)

Spindle Type	Series -4 -1		Series -4 -2	
	Screw and 4-1/2" Rod	Price Each	Long Screw and 4-1/2" ROD	Price Each
5C	RV-586	\$40.73	RV-586L	\$43.42
16C	RV-587	\$56.10	RV-587L	\$57.43
2J	RV-588	\$46.74	RV-588L	\$58.10
3J	RV-589	\$56.10	RV-589L	\$58.10

### SLEEVE

Spindle Type	Part Number	Price Each
5C	RV-596	\$62.11
16C	RV-597	\$110.19
2J	RV-598	\$95.50
3J	RV-599	\$110.19

Spindle Type	Series -4 -3		Series -4 -4	
	Long Screw and 5-3/4" ROD	Price Each	Long Screw and 8-3/4" ROD	Price Each
5C	RV-586XL	\$43.42	RV-586XXL	\$48.74
16C	RV-587XL	\$62.11	RV-587XXL	\$64.11
2J	RV-588XL	\$62.77	RV-588XXL	\$64.11
3J	RV-589XL	\$62.77	-	-

## -8 COLLETS

Machinable Down to .500"

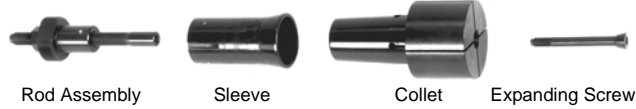


### -8 COLLETS

Dia.	Length	Part Number	Price Each	Uses Rod Assembly Series:	Replacement Screws	
					Part Number	Price Each
2"	2"	RV-822	\$64.77	-8-1		
	3"	RV-823	\$76.79	-8-1	RV-ES38L	\$24.04
	4"	RV-824	\$112.19	-8-1		
	5"	RV-825*	\$117.54	-8-2		
	6"	RV-826*	\$124.87	-8-2	RV-ES38XL	\$33.39
2-1/2"	2"	RV-82.52	\$76.79	-8-1		
	3"	RV-82.53	\$88.15	-8-1		
	4"	RV-82.54	\$95.50	-8-1		
3"	2"	RV-832	\$88.15	-8-1		
	3"	RV-833	\$104.84	-8-1		
3-1/2"	2"	RV-83.52	\$104.84	-8-1		
	3"	RV-83.53	\$116.20	-8-1	RV-ES38L	\$24.04
4"	2"	RV-842	\$116.20	-8-1		
	3"	RV-843	\$132.22	-8-1		
4-1/2"	2"	RV-84.52	\$131.57	-8-1		
	3"	RV-84.53	\$155.61	-8-1		
5-1/4"	2"	RV-85.252	\$183.65	-8-1		
6"	1-1/2"	RV-862	\$227.05	-8-1		

## -26 COLLETS

Machinable Down to .250"



### -26 COLLETS

Dia.	Length	Part No.	Price	Replacement Screws	
				Part No.	Price
1/2"	1"	RV-510	\$30.72	RV-571	\$5.35
1"	1"	RV-511	\$30.72		

Spindle	Sleeve		Rod Assembly	
	Part No.	Price	Part No.	Price
5C	RV-590	\$62.11	RV-580	\$36.72
16C	RV-591	\$110.19	RV-581	\$54.10
2J	RV-592	\$95.50	RV-582	\$45.41
3J	RV-593	\$110.19	RV-582-3	\$54.10

## ACCESSORIES



### NUTS

Part Number	Price Each
RV-16C	\$39.00
RV-2J	\$39.00
RV-3J	\$39.00
RV-5C	\$39.00

### COLLET SEPARATORS

Part Number	Price Each
RV-CS-16C	\$58.76
RV-CS-3J	\$58.76
RV-CS-5C	\$80.79

## THREADED RODS

All Rods have 3/8" threads



Collet Series	Rod Length	Part Number	Price Each
-26	4"	RV-R6	\$13.36
	5"	RV-R6L	\$13.36
-2	4 1/2"	RV-R10	\$14.69
	5 3/4"	RV-R10L	\$14.69
-4	4-1/2"	RV-R25	\$21.37
	5-3/4"	RV-R25L	\$21.37
	8-3/4"	RV-R25XL	\$21.37

-8 SLEEVES			-8 ROD ASSEMBLY			
Spindle Type	Part Number	Price Each	Series -8-1		Series -8-2	
			Part Number	Price Each	Part Number	Price Each
16C	RV-SL8-16C	\$110.19	RV-RA38L-16C	\$62.77	RV-RA38XL-16C	\$69.45
3J	RV-SL8-3J	\$110.19	RV-RA38L-3J	\$60.10	RV-RA38XL-3J	\$69.45

Call Us Or Visit Our Website For Our Complete Selection!

# INTERNAL WORKHOLDING FOR LATHES

## EXPANDING COLLET SYSTEM For 5C, 16C, 2J & 3J Collets

All Collets In This Section Are Compatible  
With Collets Sold By J.F.K.® Company



- Suited for ID Holding
- Complete system consists of:
  - Expanding Collet
  - Adapter
  - Expanding Screw
- Machinable collet
- Made in USA



② Select Adapter based on your spindle type



Ordering is as easy as 1-2-3!

① Select Collet based on workpiece diameter and machinable length



### ADAPTER

Type	Part No.	Price
5C	JK-698	\$62.20
16C	JK-699	\$115.11
2J	JK-695	\$96.50
3J	JK-696	\$115.11

③ Select Expanding Screw based on Collet Part Number in Step 1



### EXPANDING SCREWS

Using Collet Part Number	Part Number	Screw Price
JK-602 to JK-608	JK-1005	\$5.12
JK-612 to JK-618	JK-1006	\$5.12
JK-601*	JK-1009	\$6.49
Bolt for JK-1009	JK-1007	\$3.44
Stud for JK-1008	JK-1008	\$3.07

\*JK-1009 consists of Bolt (JK-1007) & Stud (JK-1008)

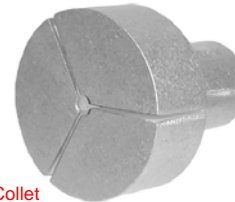
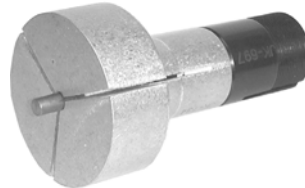
### COLLETS

Collet Range (diameter)	5/8" Length		1" Length		1-3/4" Length	
	Part No.	Price	Part No.	Price	Part No.	Price
5/16" to 9/16"	JK-601	\$29.20	-	-	-	-
1/2" to 1"	-	-	JK-602	\$29.63	JK-612	\$31.74
1/2" to 1-1/2"	-	-	JK-603	\$31.74	JK-614	\$36.83
1/2" to 2"	-	-	JK-604	\$35.56	JK-616	\$41.90
1/2" to 2-1/2"	-	-	JK-605	\$41.90	JK-618	\$48.26
1/2" to 3"	-	-	JK-606	\$49.52	-	-
1/2" to 4"	-	-	JK-607	\$57.14	-	-
1/2" to 5"	-	-	JK-608	\$64.75	-	-

Above Collets Come With Expanding Screw

## 5C OVERSIZE COLLETS Standard Stem

- Perfect for OD Holding
- Available in Steel and Aluminum
- Standard or extra thickness
- Assembly consists of collet and adapter



Collet

Adapter



### STANDARD THICKNESS

Head Dia	Head Lgth	Steel	Aluminum	Price Each
2"	3/4"	JK-633	JK-733	\$33.02
2-1/2"	1"	JK-634	JK-734	\$36.83
3"	1"	JK-635	JK-735	\$39.36
4"	1"	JK-636	JK-736	\$49.52

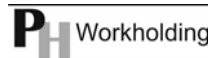
### EXTRA THICK

Head Dia	Head Lgth	Steel	Aluminum	Price Each
1-1/2"	7/8"	JK-641	JK-741	\$27.94
2"	1-1/4"	JK-642	JK-742	\$36.83
2-1/2"	1-1/2"	JK-643	JK-743	\$39.36
3"	1-5/8"	JK-644	JK-744	\$44.45

### 5C ADAPTER

Part Number	Price
JK-697	\$25.20

## 5C STEP COLLETS For O.D. Workholding



- For OD workholding
- Hardened bodies have no internal threads
- Allows for large diameter parts to be held in 5C collets
- Soft face for easy machining
- Diameters from 2" to 6"

Head Dia	PH WORKHOLDING		LYNDEX	
	Part Number	Price Each	Part Number	Price Each
2"	550-002-PH	\$45.16	LY-550-002	\$53.13
3"	550-003-PH	\$52.42	LY-550-003	\$61.67
4"	550-004-PH	\$76.40	LY-550-004	\$89.88
5"	550-005-PH	\$109.90	LY-550-005	\$129.29
6"	550-006-PH	\$128.34	LY-550-006	\$150.99

## OVERSIZE 5C COLLETS



### FEATURES:

- Perfect for OD holding
- Black oxide coating to ensure long life
- Machinable steel
- Made in USA



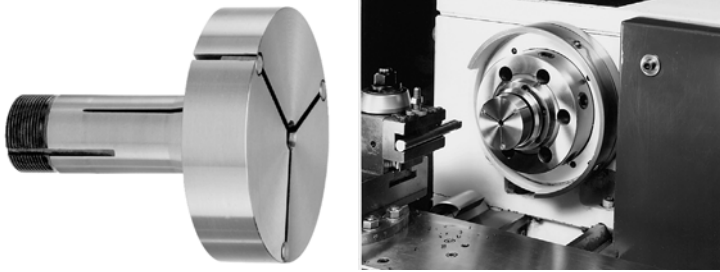
Head Dia	Head Lgth	Part Number	Price Each
1-1/2"	1-1/4"	JK-621	\$44.16
2"	1-1/4"	JK-622	\$49.69
2-1/2"	1-1/4"	JK-623	\$51.89

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# 5C WORKHOLDING FOR LATHES

TABLE OF CONTENTS

## 5C STEP COLLETS For O.D. Workholding



- 5C Step Collets allow large diameter parts to be held in a 5C collet.
- The head can be easily bored out to the desired size.
- 1-1/4" head thickness allows for a 1" bore depth.
- Made from 1144 steel-can be hardened

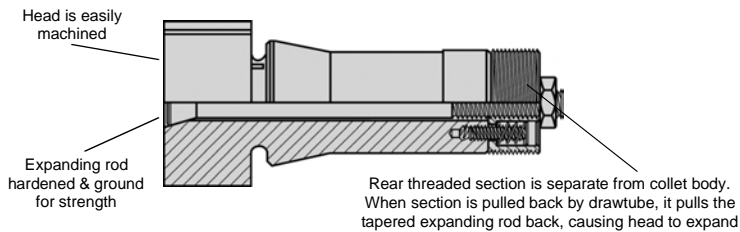
**ROYAL**  
PRODUCTS  
Optimize everything

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Head Dia	Pilot Dia	Pin Dia	Part Number	Price Each
2"	1/4"	1/8"	ROY-20020	\$163.00
3"	5/16"	1/4"	ROY-20022	\$210.70
4"	5/16"	1/4"	ROY-20024	\$329.28
5"	5/16"	1/4"	ROY-20025	\$426.30
6"	5/16"	1/4"	ROY-20026	\$523.32

## 5C INTERNAL EXPANDING COLLETS For ID Workholding

5C Internal Expanding Collets grip on the inside diameter of a workpiece, enabling the complete OD to be turned. The accu-length design ensures precise workpiece positioning - no z-axis movement. The collet head is easily turned to the required size, and can be re-machined as necessary. Concentricities of 0.0002" can typically be achieved using Royal 5C Expanding Collets. These collets are manufactured from 1144 steel that can be hardened after machining for wear resistance.



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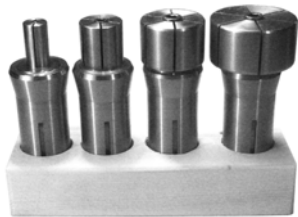
### Replacement Expanding Rods

Head Dia	Head Length	Part Number	Price Each
3/4"	1"	ROY-20135	\$41.80
1"	1"	ROY-20136	\$38.00
1-1/2"- 6"	1"	ROY-20130	\$29.45
1-1/2"- 6"	1-1/2"	ROY-20131	\$30.40
1-1/2"- 6"	2"	ROY-20132	\$31.35

Nom. Head Dia	Head Length	Mach Range Min-Max	Part Number	Price Each
3/4"	1"	1/4" - 11/16"	ROY-20100	\$176.40
1"	1"	7/16" - 15/16"	ROY-20101	\$176.40
1-1/2"	1"	3/4" - 1-7/16"	ROY-20102	\$167.58
1-1/2"	1-1/2"	3/4" - 1-7/16"	ROY-20103	\$184.24
1-1/2"	2"	3/4" - 1-7/16"	ROY-20104	\$185.22
2"	1"	3/4" - 1-15/16"	ROY-20107	\$193.06
2"	1-1/2"	3/4" - 1-15/16"	ROY-20108	\$204.82
2"	2"	3/4" - 1-15/16"	ROY-20109	\$234.22
2-1/2"	1"	3/4" - 2-7/16"	ROY-20112	\$237.16
3"	1"	3/4" - 2-15/16"	ROY-20117	\$259.70
5"	2"	3/4" - 4-15/16"	ROY-20127	\$499.80
6"	2"	3/4" - 5-15/16"	ROY-20128	\$556.64

## 5C EXPANDING COLLETS

**EAGLE ROCK**



MADE IN THE  
**USA**

For I.D. Workholding



Dia	Min. Length	Mach. Dia	Part Number	Price Each
SET- Includes 1 ea of below			AI-51-5C-001	\$176.70

### Replacement Collets

Dia	Min. Length	Mach. Dia	Part Number	Price Each
1/2"	1"	.250"	AI-51-5C-0500-1	\$51.20
1"	1"	.437"	AI-51-5C-1000-1	\$51.20
1-1/2"	1"	.750"	AI-51-5C-1500-1	\$51.20
2"	1"	.750"	AI-51-5C-2000-1	\$92.90

## EXPANDING ARBORS

### Machinable

An effective and economical means for internal chucking. Easy machinability and operation. The 8 piece set includes a wooden stand.

MADE IN THE  
**USA**

**EAGLE ROCK**

For I.D. Workholding



Dia	Mach. Dia	b	c	d	e	Part Number	Price Each
1/4	.0135	3	1/4	-	-	AI-52-0250	\$18.90
3/8	.200	3	1/2	-	-	AI-52-0375	\$18.90
1/2	.200	3	1/2	-	-	AI-52-0500	\$18.90
5/8	.250	3	7/8	-	-	AI-52-0625	\$22.50
3/4	.250	4	7/8			AI-52-0750	\$26.20
7/8	.360	4	1-1/4			AI-52-0875	\$26.20
1	.360	4	1-1/4			AI-52-1000	\$29.30
1-1/4	.360	4	1-1/4	1	1-1/2	AI-52-1250	\$36.60
1-1/2	.360	4	1-1/4	1	1-1/2	AI-52-1500	\$56.90
1-3/4	.360	4	1-1/4	1	1-1/2	AI-52-1750	\$71.20
2	.360	4	1-1/4	1	1-1/2	AI-52-2000	\$74.10
2-1/2	.360	4	1-1/4	1	1-1/2	AI-52-2500	\$119.42
<b>8 Pc Set</b>		1/8 thru 1 1/4				AI-52-0001	\$125.20
<b>3 Pc Set</b>		1 1/2, 1 3/4, 2				AI-52-0002	\$203.70

LATHE CHUCKS  
LIVE CENTERS

VICE JAWS  
VICE ACCESSORIES

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COLLET HOLDERS

TAP HOLDERS  
DRILL CHUCKS

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CUTTING TOOLS  
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TOOL STORAGE

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