

Why use machine adapted clamping units?

- Designed specifically for your machine
- Better performance
- Faster tool changes
- Use Coromant Capto tools for turning, milling and drilling
- Ready-equipped to channel high pressure coolant to the latest in CoroTurn HP cutting heads

Tooling packages and certificates

When you pay for a new machine, make sure it pays you back.

By reducing payback time, you reduce the time it takes for your new machine to start making your business more profitable. Sandvik Coromant offers custom tooling packages and Tooling Certificates to unleash the potential of your investment, right from the start.

Talk to your Sandvik Coromant Productivity Engineer or visit www.payback-calculator.com to learn more about paying off your new machines faster.

To order or for more information, contact your Sandvik Coromant sales representative or authorized distributor, or call **1-800-SANDVIK** (1-800-726-3845).

For clamping unit service, call the Coromant Capto Service Center at (704)714-7765.

www.sandvik.coromant.com

E-mail: us.coromant@sandvik.com



Coromant Capto® Machine Adapted Clamping Units

For Nakamura-Tome CNC lathes



Available for the following machines:

SC250M, SC200L, SC300M

WT-100, WT-150, WTS-150,
WT-250II, WT-300, WTW-150,
TW-10, TW-20 (12 and 16
stations)

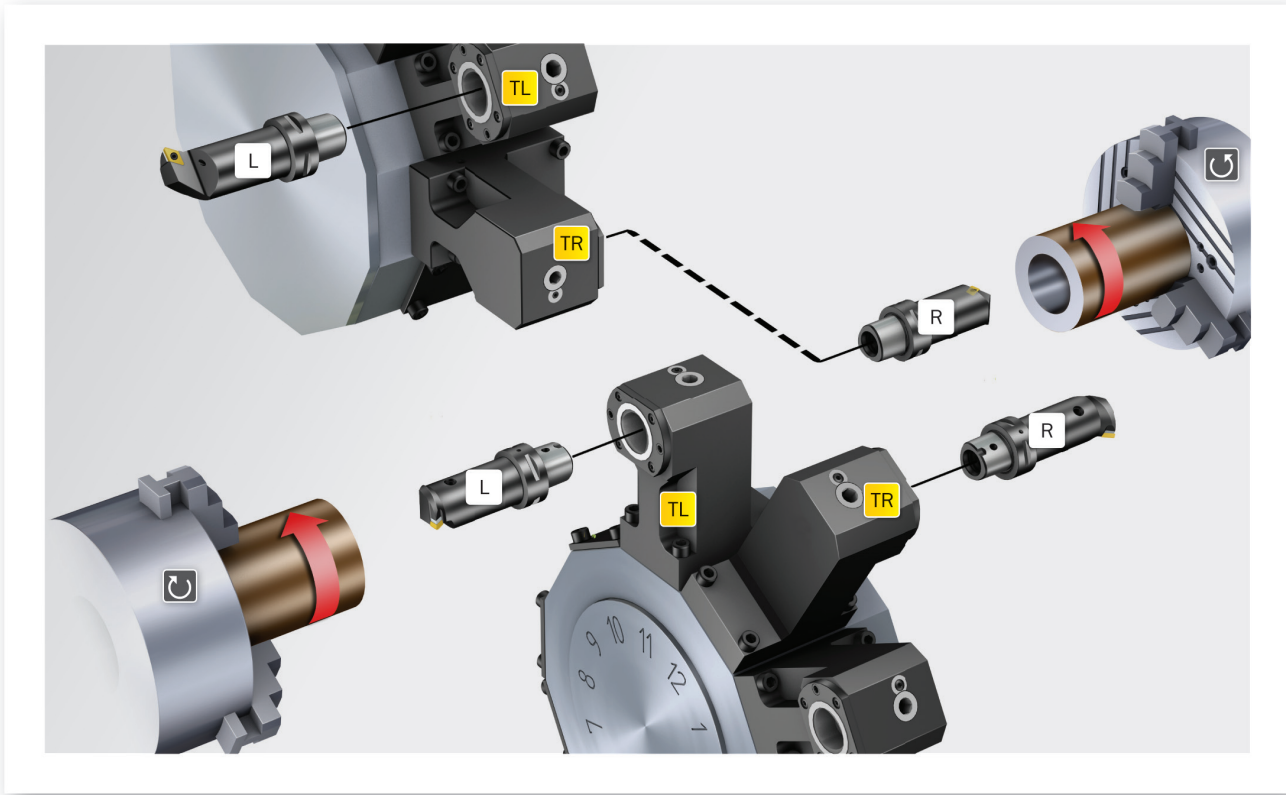
Super NTJX, Super NTM³,
Super NTJ, Super NTX,
Super NTY³



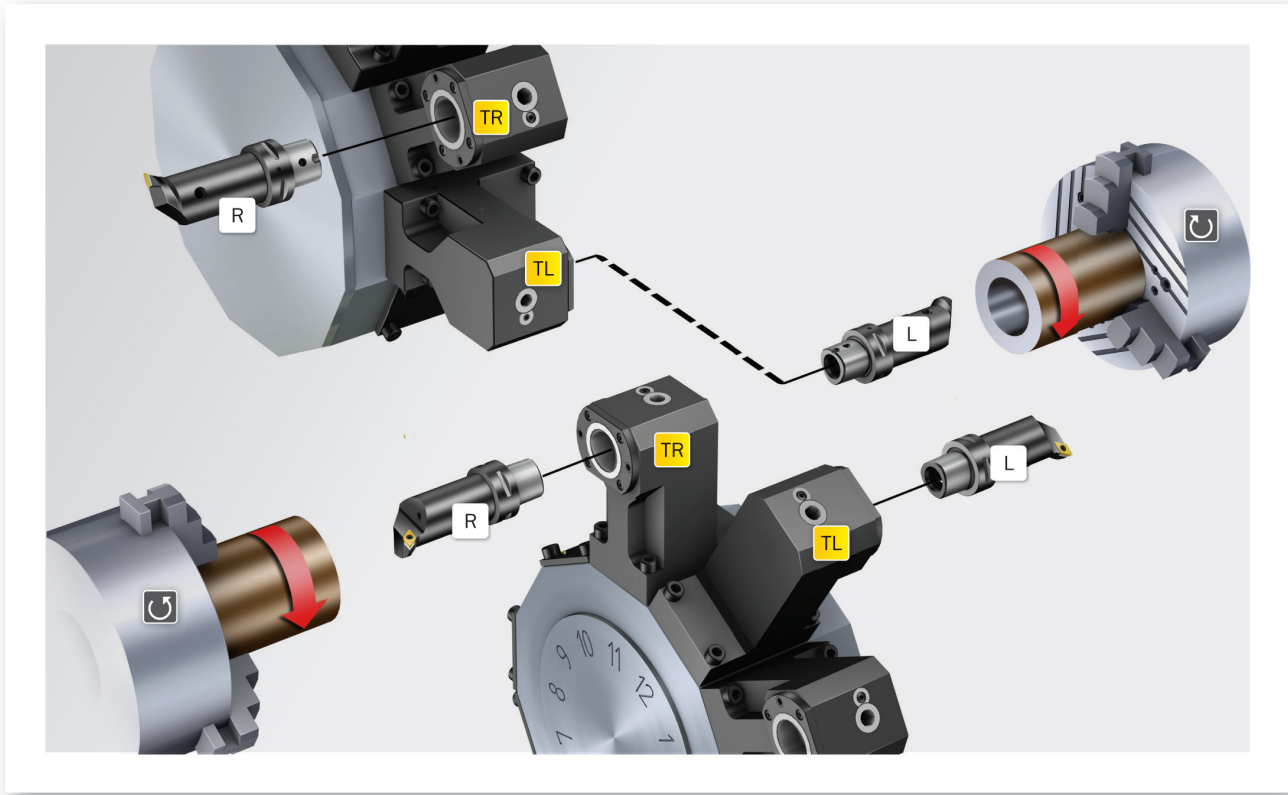
Your success in focus

Clamping unit configuration

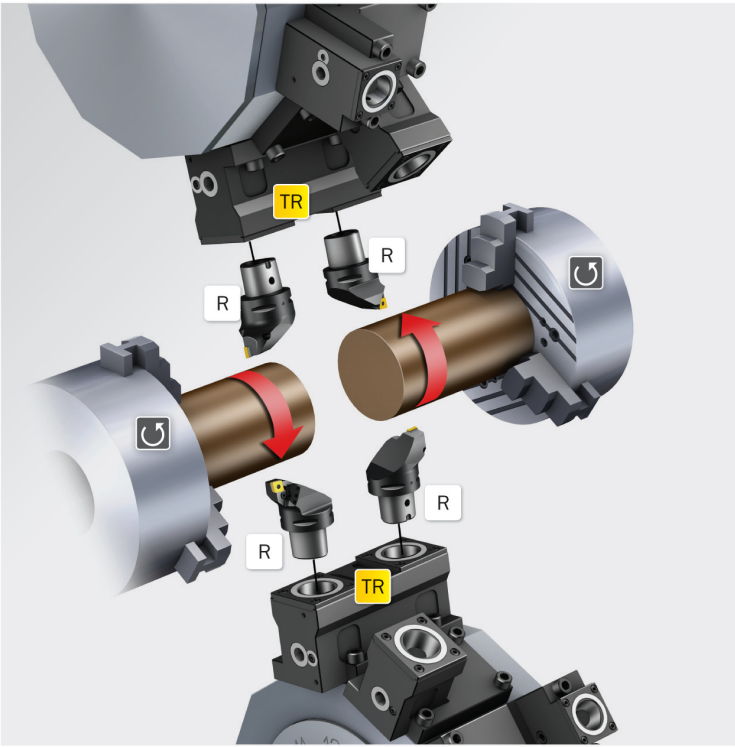
Internal setup



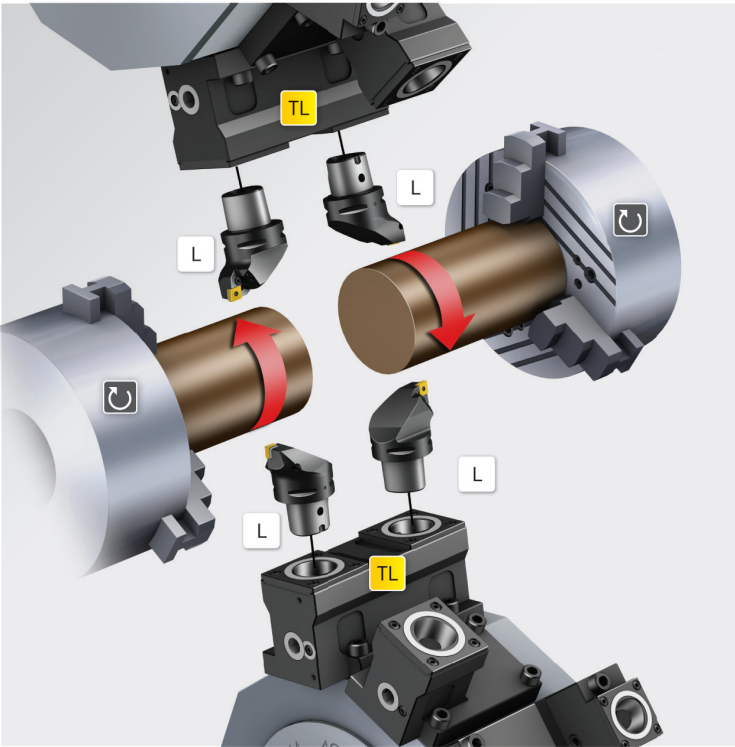
Internal setup



External setup



External setup



- R Right hand cutting unit
- L Left hand cutting unit
- TR Right hand clamping unit
- TL Left hand clamping unit
- Clockwise spindle rotation
- Counter clockwise spindle rotation

Single clamping unit is also right handed.

Single clamping unit is also left handed.

Code key for Coromant Capto® machine adapted clamping units

C5	-	D	N	I	-	NA	55	A	-	DT	I
1		2	3	4		5	6	7		8	9

1 Coromant Capto size

C4 – 40 mm
C5 – 50 mm

2 Application

T – Turning
D – Driven

3 Hand of clamping units

L – Left
R – Right
N – Neutral

4 Type of operation

E – External (OD)
I – Internal (face/ID)

5 Machine

NA – Nakamura Tome

6 Turret hole diameter (mm)

40, 60, 65, 68, 80

7 Turret interface version

A, B, C

8 Configuration

Blank – for normal single clamping unit

DT – for main spindle and subspindle (two clamping units in one holder)

ET – extended

DE – extended for main spindle and subspindle (two clamping units in one holder)

TT – for machine with half index turret (two clamping units in one holder)

YT – for machines with 'Y' axis (two clamping units in one holder)

DY – for machines with 'Y' axis (four clamping units in one holder)

SS – for subspindle

SP – short projection

XT – two clamping units in one holder (change tools with X axis)

9 Coolant supply (driven tools only)

I – internal and external (1160 PSI [80 bar])
E – external only

Code key for Coromant Capto® machine adapted clamping units

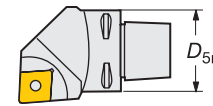
Static holders

C4	-	RC	E	-	NAK010	055	060			YT
1		2	3		4	5	6	7		9

Driven tool holders

C4	-	DT	I	-	NAK010	065	055			DT
1		2	3		4	5	6	8		9

1 Coupling size



D_{5m} = Coupling size

Size:	inch:	mm:
C3	$D_{5m} = 1.260$	32
C4	$D_{5m} = 1.575$	40
C5	$D_{5m} = 1.969$	50
C6	$D_{5m} = 2.480$	63
C8	$D_{5m} = 3.150$	80

2 Hand of clamping unit/type of unit

RC = Right
LC = Left
NC = Neutral
DT = Driven Tool

3 Type of operation

E = External
I = Internal

4 Machine model

Example:
NAK = Nakamura

5 Reference dimension

Gauge line in millimeters from reference point to center line of Coromant Capto coupling

6 Reference dimension

Gauge line in millimeters from reference point to face of Coromant Capto coupling

7 Version

A = New design
M = Modified from original

8 Coolant

I = Internal coolant (DTH clamping units only)

Note: All static Capto clamping units have internal coolant.

9 Configuration

SS = for subspindle
DT = for main spindle and subspindle (two clamping units in one holder)

TT = for machine with half index turret (two clamping units in one holder)

YT = for machines with 'Y' axis (two clamping units in one holder)

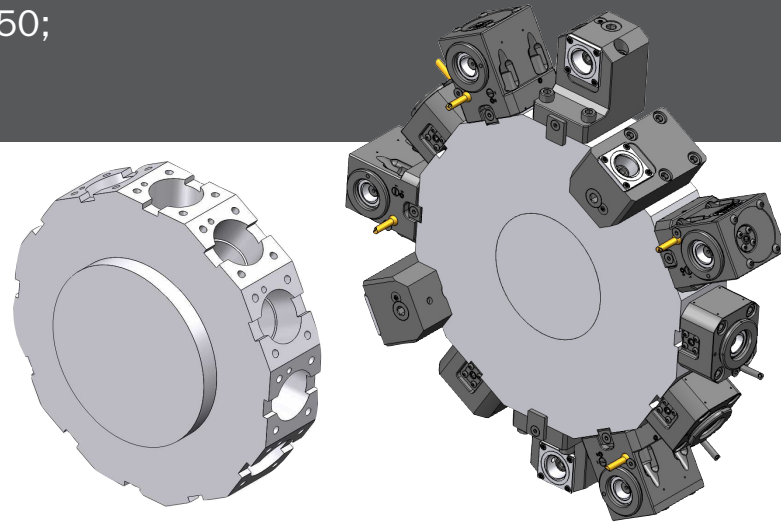
XT = two clamping units in one holder (change tools with 'X' axis)

Machines

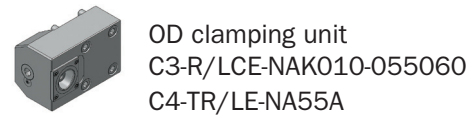
Nakamura SC-250M; WTS-150; WTW-150;
TW10 (TW20/16 stations)

Coromant Capto®

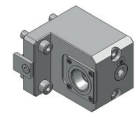
Machine adapted clamping units
Standard program



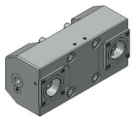
Static toolholders



OD clamping unit
C3-R/LCE-NAK010-055060
C4-TR/LE-NA55A

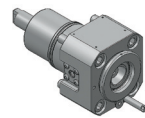


Face and ID clamping unit
C3-R/LCI-NAK010-075020
C4-TR/LI-NA55A

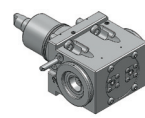


OD clamping unit, both sides
C3-R/LCE-NAK010-055060DT¹⁾
C4-TR/LE-NA55-DT¹⁾

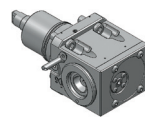
Driven toolholders



OD drill/milling unit
C3-DNE-NA55A-E
C3-DNE-NA55A-I *



Face drill/milling unit, both sides, $l_{1z}=65$
C3-DTI-NAK010-065055DT¹⁾



Face drill/milling unit, $l_{1z}=65$
C3-DNI-NA55A0E
C3-DNI-NA55A0I *

Suggested collet chuck adapter for Coromant Capto to maximize tool projection



Collet chuck adapter, short
C3-391.14-20 036 ER20

Additional short adapters available through Extended Product Offer.

Ordering example:

C3-RCE-NAK010-055060 (right hand unit)
C3-LCE-NAK010-055060 (left hand unit)

Products beginning with Cx-TR/L and Cx-DN, see code key page 4
Products beginning with Cx-R/LC, see code key page 5

¹⁾ Units for SC-250M only
Ratio 1:1

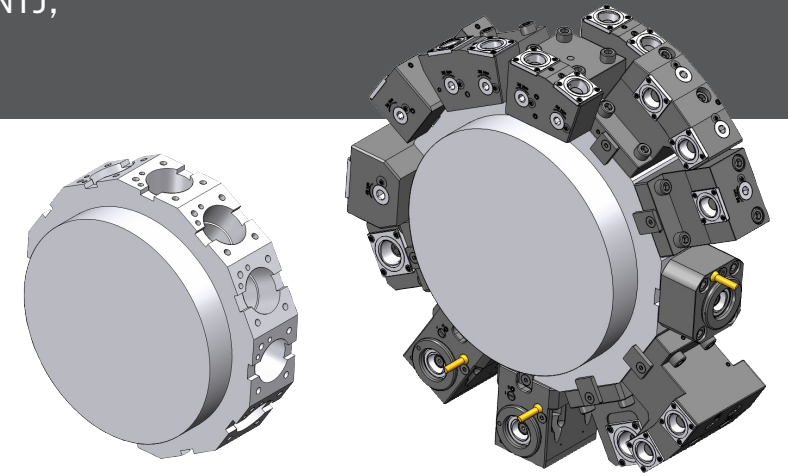
* Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Max. coolant pressure = 1160 PSI (80 bar)

Machines

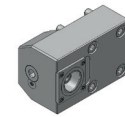
Nakamura WT150; Super NTM³; Super NTJ;
SC-200L; WT250II

Coromant Capto®

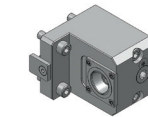
Machine adapted clamping units
Standard program



Static toolholders



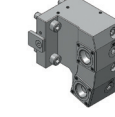
OD clamping unit
C3-R/LCE-NAK010-055060
C4-TR/LE-NA55A



Face and ID clamping unit
C3-R/LCI-NAK010-075020
C4-TR/LI-NA55A



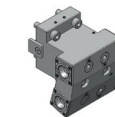
OD clamping unit, both sides
C3-R/LCE-NAK010-055060DT
C4-TR/LE-NA55A-DT



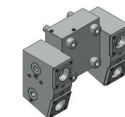
Face and ID clamping unit, double half index
C3-R/LCI-NAK010-082020TT



OD clamping unit, double half index
C3-R/LCE-NAK010-060060TT

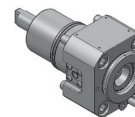


Face and ID clamping unit, double half index, both sides
C3-R/LCI-NAK010-082059DTT

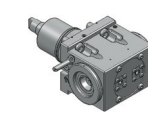


OD clamping unit, double half index, both sides
C3-R/LCE-NAK010-060060DTT

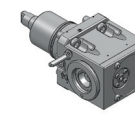
Driven toolholders



OD drill/milling unit
C3-DNE-NA55A-E
C3-DNE-NA55A-I *



Face drill/milling unit, both sides, $l_{1z}=65$
C3-DTI-NAK010-065055DT



Face drill/milling unit, $l_{1z}=65$
C3-DNI-NA55A-E
C3-DNI-NA55A-I *

Suggested collet chuck adapter for Coromant Capto to maximize tool projection



Collet chuck adapter, short
C3-391.14-20 036 ER20

Additional short adapters available through Extended Product Offer.

Ordering example:

C3-RCE-NAK010-055060 (right hand unit)
C3-LCE-NAK010-055060 (left hand unit)

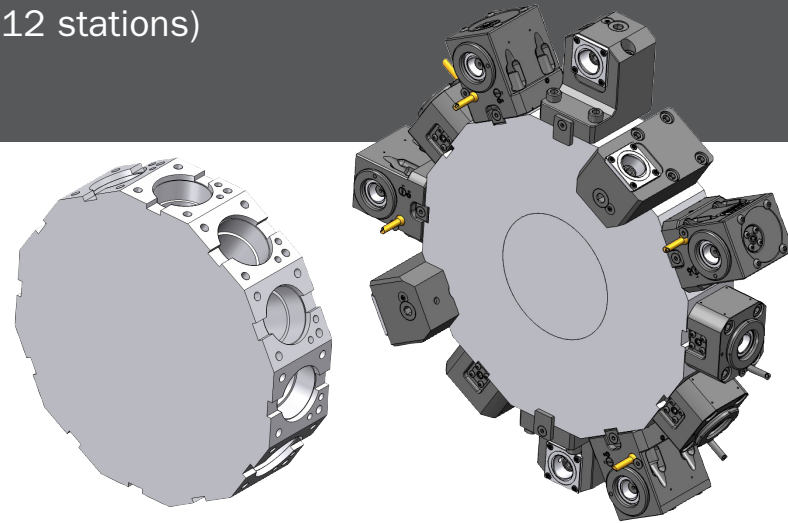
Products beginning with Cx-TR/L and Cx-DN, see code key page 4
Products beginning with Cx-R/LC, see code key page 5

Ratio 1:1

* Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Max. coolant pressure = 1160 PSI (80 bar)

Machines

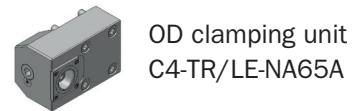
Nakamura WT300; Super NTX (TW-20, 12 stations)



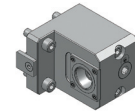
Coromant Capto®

Machine adapted clamping units
Standard program

Static toolholders



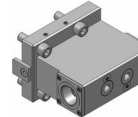
OD clamping unit
C4-TR/LE-NA65A



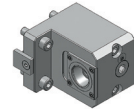
Face and ID clamping unit, back set
C4-TR/LI-NA65A-SS



OD clamping unit, both sides
C4-TR/LE-NA65A-DT

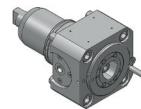


Face and ID clamping unit, both sides
C4-R/LCI-NAK020-090050MDT

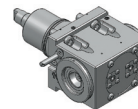


Face and ID clamping unit
C4-TR/LI-NA65A

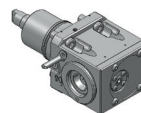
Driven toolholders



OD drill/milling unit
C4-DNE-NA65A-E
C4-DNE-NA65A-I *



Face drill/milling unit, both sides, $l_{1z}=65$
C4-DTI-NAK020-065070DT¹⁾



Face drill/milling unit
C4-DNI-NA65A-E
C4-DNI-NA65A-I *

Suggested collet chuck adapter for Coromant Capto to maximize tool projection



Collet chuck adapter, short
C4-391.14-20 035 ER20
C4-391.14-25 038 ER25

Additional short adapters available through Extended Product Offer.

Ordering example:

C4-TRE-NA65A (right hand unit)
C4-TLE-NA65A (left hand unit)

Products beginning with Cx-TR/L and Cx-DN, see code key page 4
Products beginning with Cx-R/LC, see code key page 5

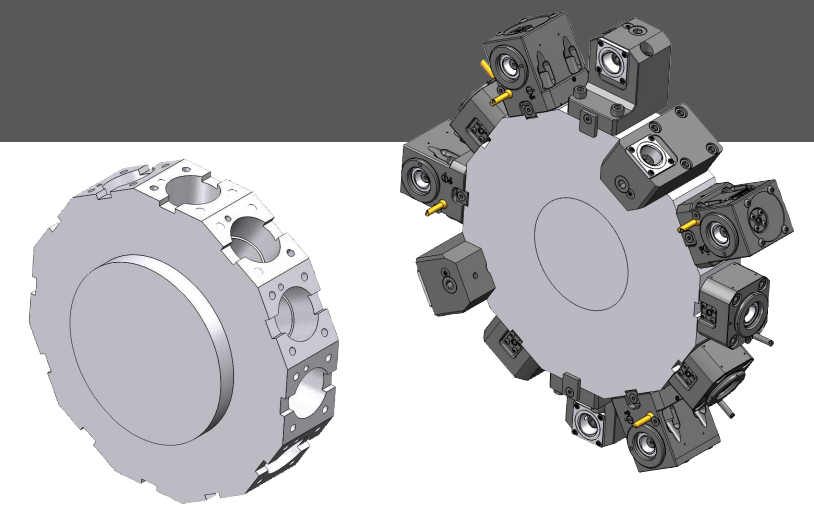
¹⁾ Reversible heads

Ratio = 1:1

* Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Max. coolant pressure = 1160 PSI (80 bar)

Machines

Nakamura Super NTJX



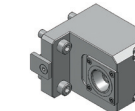
Coromant Capto®

Machine adapted clamping units
Standard program

Static toolholders



OD clamping unit
C3-R/LCE-NAK010-055060
C4-TR/LE-NA55A

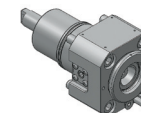


Face and ID clamping unit
C3-R/LCI-NAK010-085020
C4-R/LCI-NAK010-085015

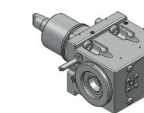


OD clamping unit, both sides
C3-R/LCE-NAK010-055060DT
C4-TR/LE-NA55A-DT

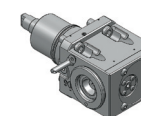
Driven toolholders



OD drill/milling unit
C3-DNE-NA55A-E
C3-DNE-NA55A-I *



Face drill/milling unit, both sides, $l_{1z}=65$
C3-DTI-NAK010-075055DT



Face drill/milling unit, $l_{1z}=75$
C3-DTI-NAK010-075050
C3-DTI-NAK010-075050I *

Suggested collet chuck adapter for Coromant Capto to maximize tool projection



Collet chuck adapter, short
C4-391.14-20 036 ER20

Additional short adapters available through Extended Product Offer.

Ordering example:

C3-RCE-NAK010-055060 (right hand unit)
C3-LCE-NAK010-055060 (left hand unit)

Products beginning with Cx-TR/L and Cx-DN, see code key page 4
Products beginning with Cx-R/LC, see code key page 5

Ratio 1:1

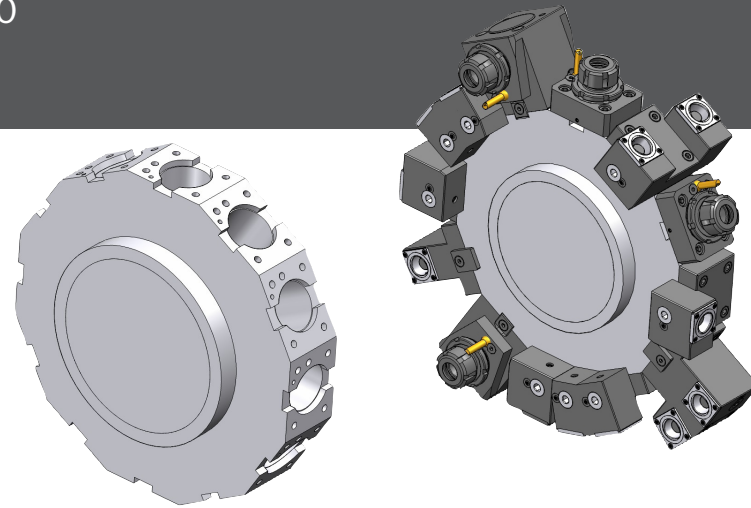
* Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Max. coolant pressure = 1160 PSI (80 bar)

Machines

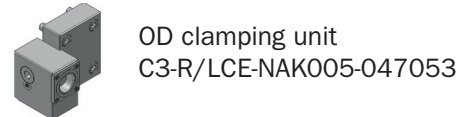
Nakamura WT100; Super NTY³, WY-100

Coromant Capto®

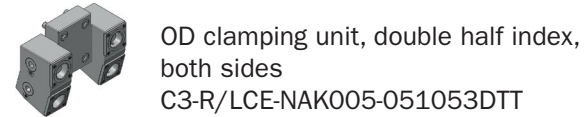
Machine adapted clamping units
Standard program



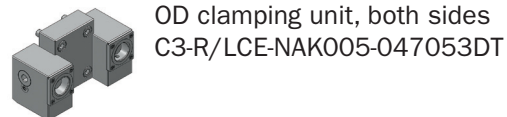
Static toolholders



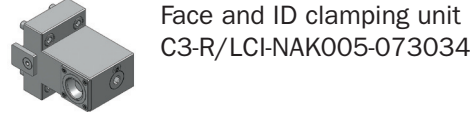
OD clamping unit
C3-R/LCE-NAK005-047053



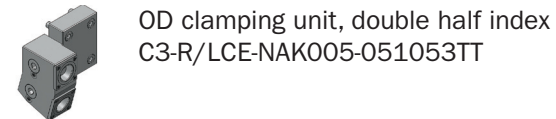
OD clamping unit, double half index,
both sides
C3-R/LCE-NAK005-051053DTT



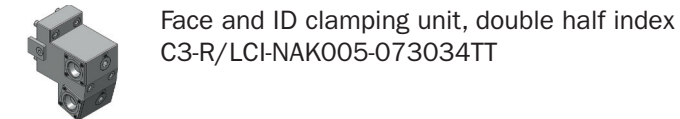
OD clamping unit, both sides
C3-R/LCE-NAK005-047053DT



Face and ID clamping unit
C3-R/LCI-NAK005-073034

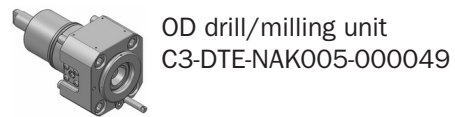


OD clamping unit, double half index
C3-R/LCE-NAK005-051053TT

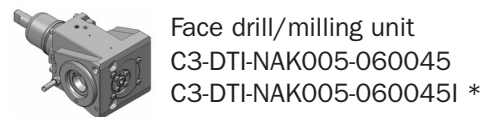


Face and ID clamping unit, double half index
C3-R/LCI-NAK005-073034TT

Driven toolholders

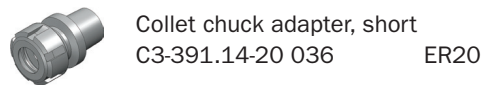


OD drill/milling unit
C3-DTE-NAK005-000049



Face drill/milling unit
C3-DTI-NAK005-060045
C3-DTI-NAK005-060045I *

Suggested collet chuck adapter for Coromant Capto to maximize tool projection



Collet chuck adapter, short
C3-391.14-20 036 ER20

Additional short adapters available through Extended Product Offer.

Ordering example:
C3-RCE-NAK005-047053 (right hand unit)
C3-LCE-NAK005-047053 (left hand unit)

Products beginning with Cx-TR/L and Cx-DN, see code key page 4
Products beginning with Cx-R/LC, see code key page 5

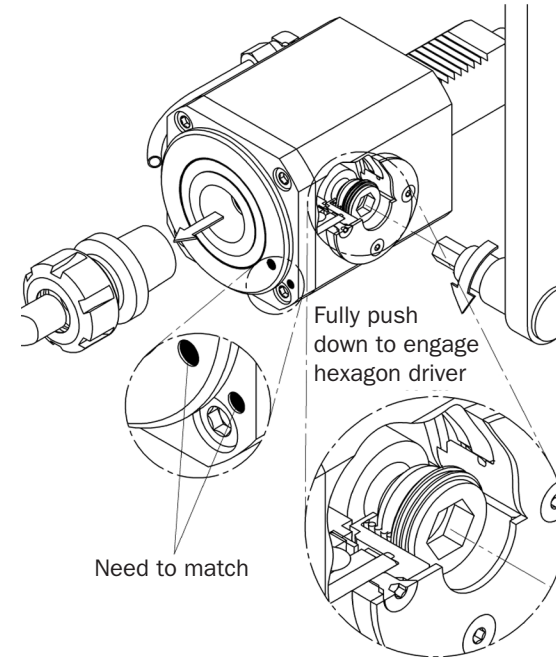
Ratio 1:1

* Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Max. coolant pressure = 1160 PSI (80 bar)

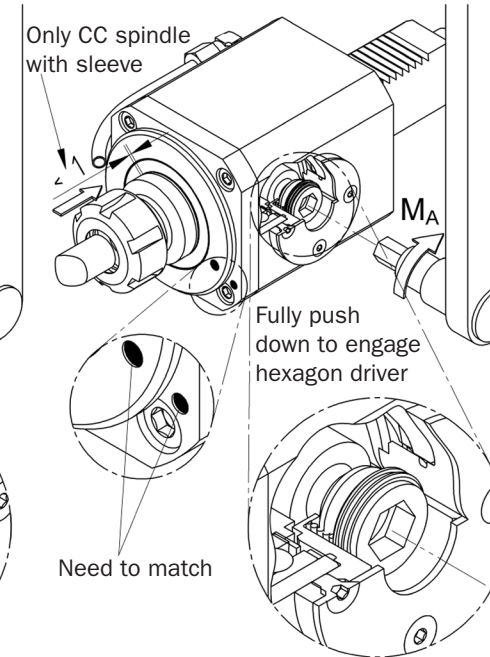
Operating instructions for Coromant Capto driven toolholders

Changing the cutting tool

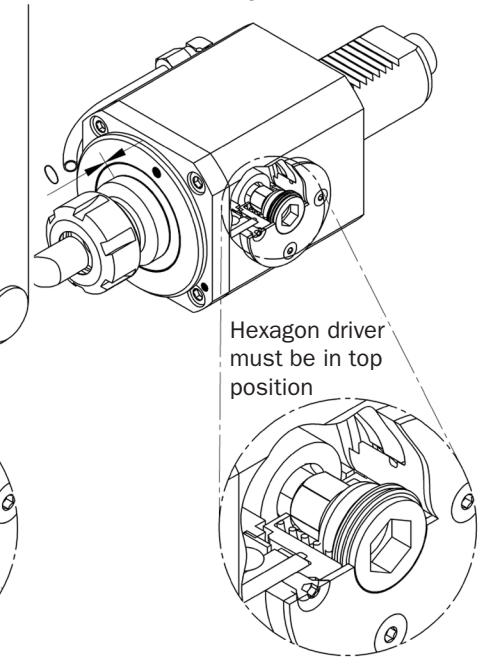
Unlock



Lock



Check before operation



Torque wrench for tool changing

Coupling size			Ordering code	Size mm	Spare parts
	ft-lbs	Nm	Torque wrench		Key adapter
C3	16	22	TW-30-01	5	5680 035-08
C3	26	35	BT-TK-02	8	5680 035-05
C4	37	50	C-TK-01	10	5680 035-06
C5	52	70	C-TK-01	12	5680 035-07
C6	66	90	C-TK-01	12	5680 035-07

To be calibrated according to ISO 6789, accuracy within 4%

For detailed information, see page G119 in the Sandvik Coromant main catalog.

Torque setting and wrench size

Capto size	Coromant Capto spindle with sleeve			Unlock + lock: Turn hexagon driver around approx. 140°	Solid Coromant Capto spindle		
	Wrench size	Torque M _A	Wrench size		Max Torque M _A	Unlock + lock: Turn hexagon driver around approx. 180°	
C3	8 mm	35 Nm	5 mm	22 Nm			
C4	8/10 mm	50 Nm	8 mm	38 Nm			
C5	12 mm	70 Nm	10 mm	64 Nm			
C6	12 mm	90 Nm	12 mm	90 Nm			