

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 Okuma CNC lathes



Available for the following machines:

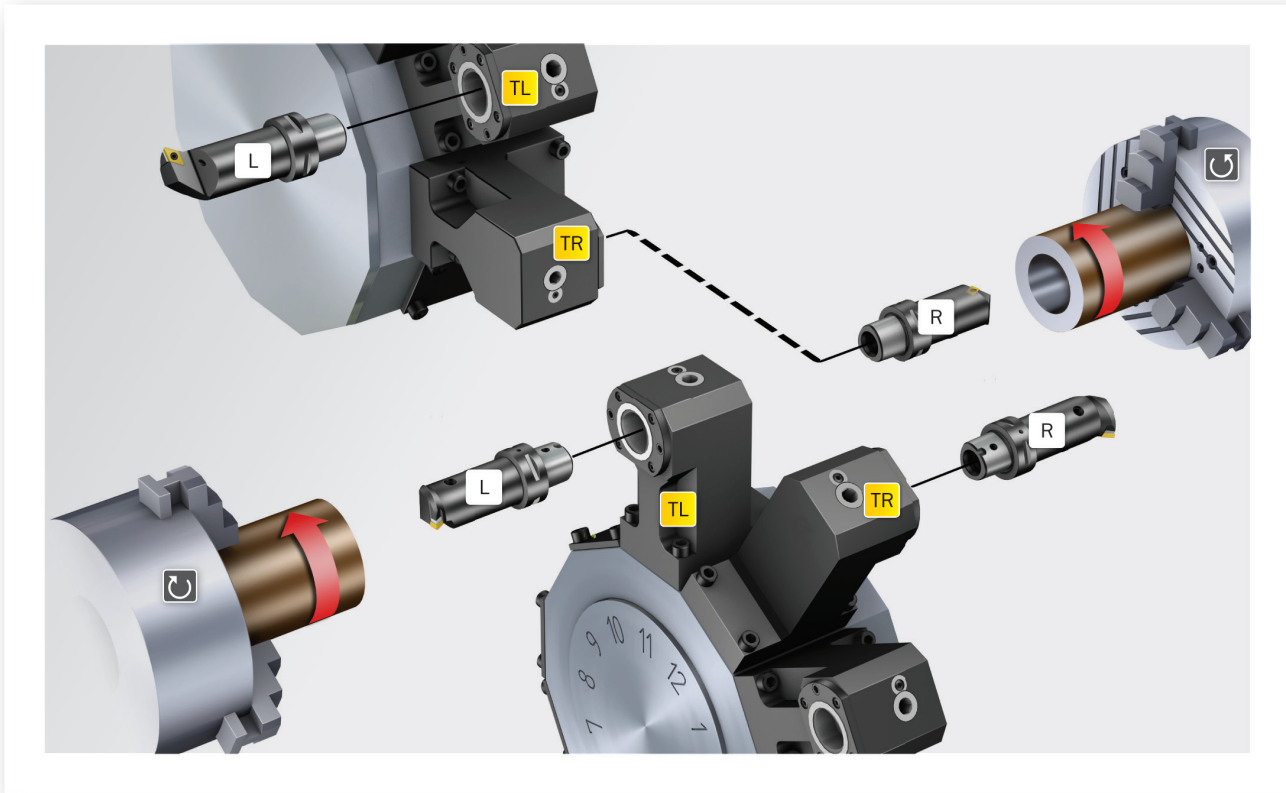
Genos L200 M, EM, MY	Space Turn LB4000 EX M, MY	LB300-M, LB300-MY	LU400-M
Genos L300 M, E-M, MY, MW, MYW	LB200-M, LB200-MY	LU300-M, LU300-MY	L470-M
Genos L400	ES-L8	ES-L10	LU35-M
Space Turn LB2000 EX M, MY	LT300-M, LT300-MY	L370-M	LB35II-M (1-step)
Space Turn LB3000 EX M, MY	Macturn 350	LB400-M	LU-45M



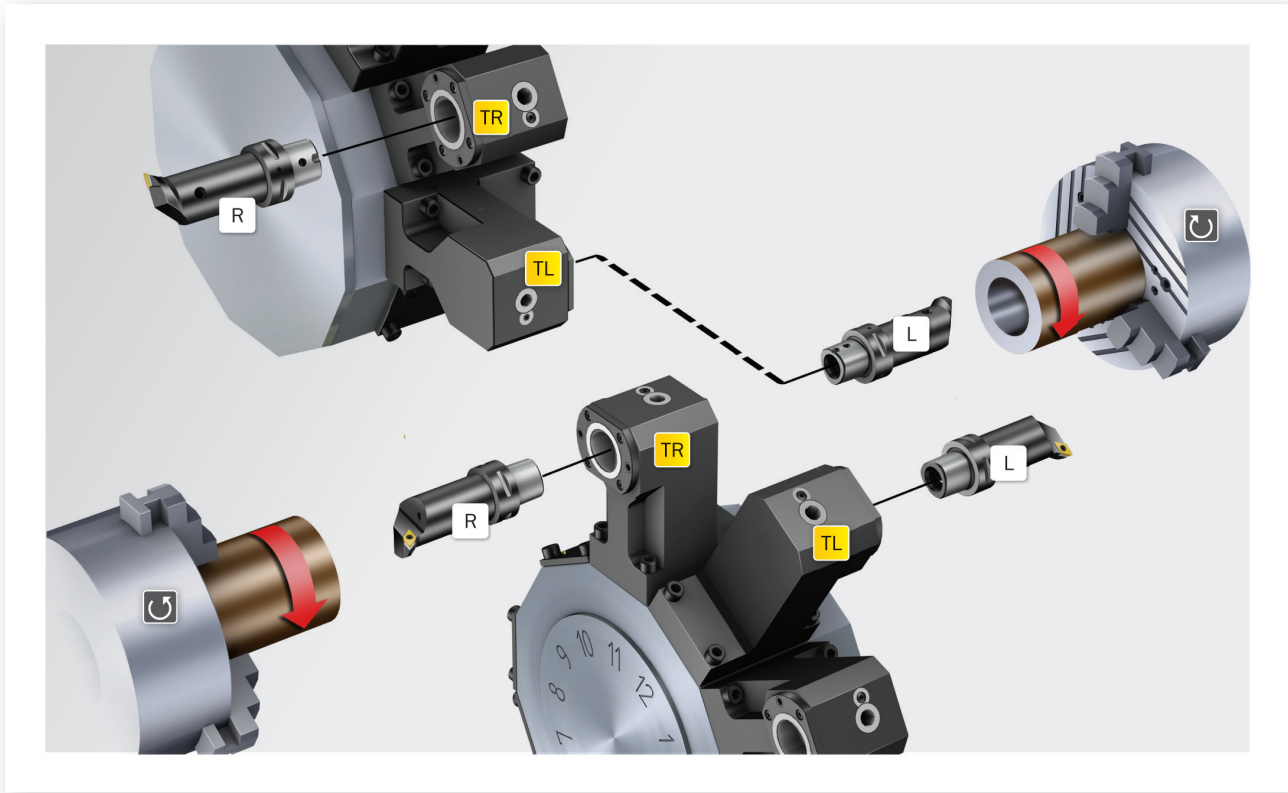
Your success in focus

Clamping unit configuration

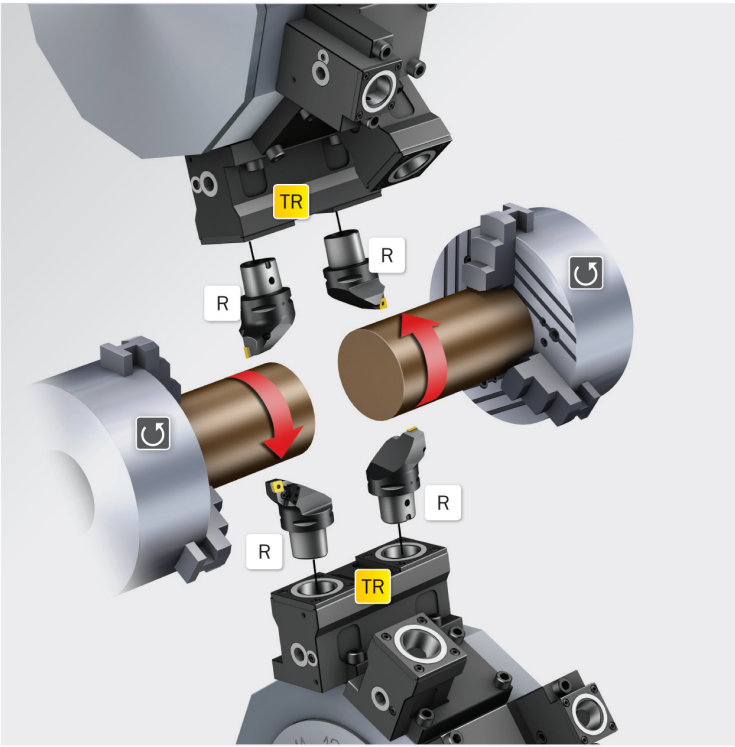
Internal setup



Internal setup

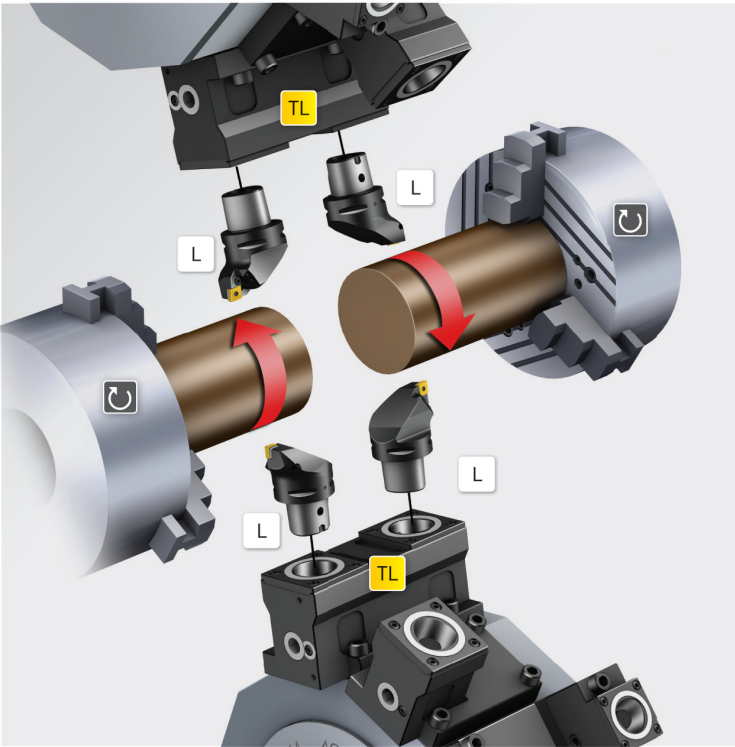


External setup



Single clamping unit is also right handed.

External setup



Single clamping unit is also left handed.

- 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

Code key for Coromant Capto® machine adapted clamping units

C5 - **D** **N** **I** - **OK** **60** **A** - **DT** **I**

1 2 3 4 5 6 7 8 9

<p>1 Coromant Capto size</p> <p>C4 – 40 mm C5 – 50 mm</p> <p>2 Application</p> <p>T – Turning D – Driven</p> <p>3 Hand of clamping units</p> <p>L – Left R – Right N – Neutral</p> <p>4 Type of operation</p> <p>E – External (OD) I – Internal (face/ID)</p> <p>5 Machine</p> <p>OK – Okuma</p> <p>6 Turret hole diameter (mm)</p> <p>40, 60, 65, 68, 80</p>	<p>7 Turret interface version</p> <p>A, B, C</p> <p>8 Configuration</p> <p>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)</p> <p>9 Coolant supply (driven tools only)</p> <p>I – internal and external (1160 PSI [80 bar]) E – external only</p>
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Code key for Coromant Capto® machine adapted clamping units

Static holders

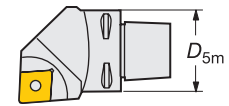
C4 - **RC** **E** - **LB2000** - **024065** **D** **YT**

1 2 3 4 5 6 7 9

Driven tool holders

C4 - **DT** **I** - **LB2000** - **070034** **DT**

1 2 3 4 5 6 8 9

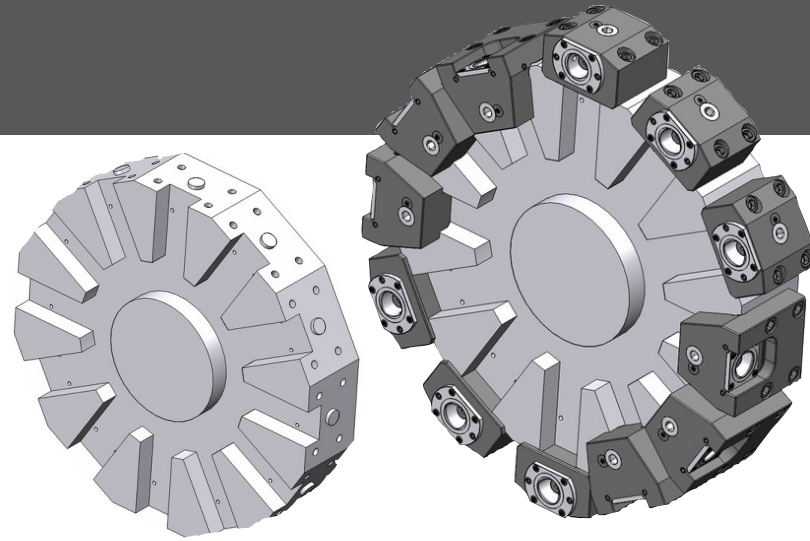
<p>1 Coupling size</p>  <p>D_{5m} = Coupling size</p> <table border="1"> <thead> <tr> <th>Size:</th> <th>inch:</th> <th>mm:</th> </tr> </thead> <tbody> <tr> <td>C3</td> <td>$D_{5m} = 1.260$</td> <td>32</td> </tr> <tr> <td>C4</td> <td>$D_{5m} = 1.575$</td> <td>40</td> </tr> <tr> <td>C5</td> <td>$D_{5m} = 1.969$</td> <td>50</td> </tr> <tr> <td>C6</td> <td>$D_{5m} = 2.480$</td> <td>63</td> </tr> <tr> <td>C8</td> <td>$D_{5m} = 3.150$</td> <td>80</td> </tr> </tbody> </table>	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	<p>2 Hand of clamping unit/type of unit</p> <p>RC = Right LC = Left NC = Neutral DT = Driven Tool</p>	<p>3 Type of operation</p> <p>E = External I = Internal</p>
Size:	inch:	mm:																		
C3	$D_{5m} = 1.260$	32																		
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C5	$D_{5m} = 1.969$	50																		
C6	$D_{5m} = 2.480$	63																		
C8	$D_{5m} = 3.150$	80																		
<p>4 Machine model</p> <p>Example: LB2000 = Okuma LB2000EX</p>	<p>5 Reference dimension</p> <p>Gauge line in millimeters from reference point to center line of Coromant Capto coupling</p>	<p>6 Reference dimension</p> <p>Gauge line in millimeters from reference point to face of Coromant Capto coupling</p>																		
<p>7 Version</p> <p>A = New design M = Modified from original</p>	<p>8 Coolant</p> <p>I = Internal coolant (DTH clamping units only)</p> <p>Note: All static Capto clamping units have internal coolant.</p>																			
<p>9 Configuration</p> <table border="0"> <tr> <td>SS = for subspindle DT = for main spindle and subspindle (two clamping units in one holder)</td> <td>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)</td> <td>XT = two clamping units in one holder (change tools with 'X' axis)</td> </tr> </table>			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)															
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Machines

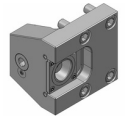
Okuma Genos L400

Coromant Capto®

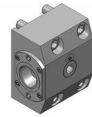
Machine adapted clamping units
Standard program



Static toolholders



OD clamping unit
C4-R/LCE-GS400-008015
C5-R/LCE-GS400-030015



Face and ID clamping unit
C4-R/LCI-GS400-030012
C5-R/LCI-GS400-040014

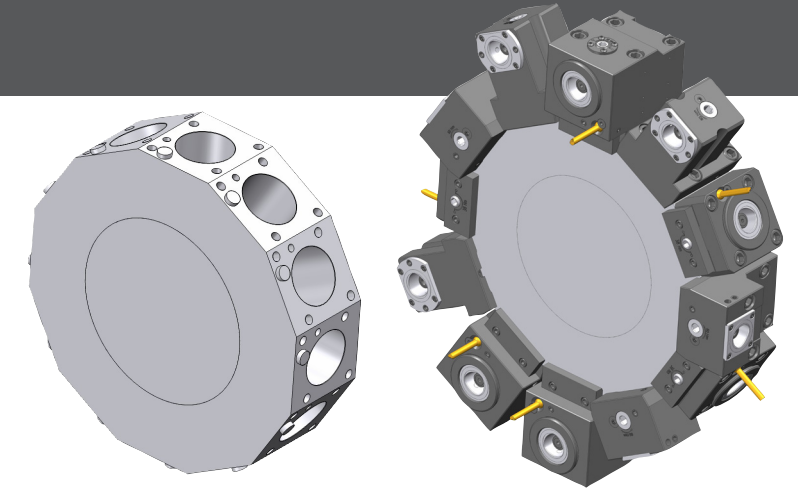
Ordering example:
C4-RCE-GS400-008015 (right hand unit)
C4-LCE-GS400-008015 (left hand unit)
Products beginning with Cx-TR/L and Cx-DN, see code key page 4
Products beginning with Cx-R/LC, see code key page 5

Machines

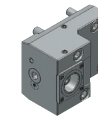
Okuma Space Turn LB2000 – 3000EX M, MY, MYW;
Genos L300-MW

Coromant Capto®

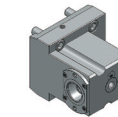
Machine adapted clamping units
Standard program



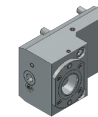
Static toolholders



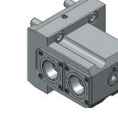
OD clamping unit
C4-TR/LE-OK60A



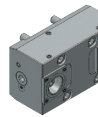
Face and ID clamping unit
C4-TR/LI-OK60A



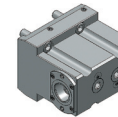
OD clamping unit, short
C4-R/LCE-LB2000-025050



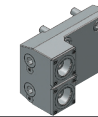
Face and ID clamping unit
C4-R/LCI-LB2000-095018X



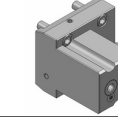
OD clamping unit, both sides
C4-TR/LE-OK60A-DT



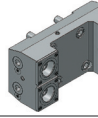
Face and ID clamping unit, both sides
C4-R/LCI-LB2000-090018DT



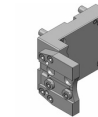
OD clamping unit, 26 mm "Y" axis
C4-TR/LE-OK60A-YT



Face and ID clamping unit, sub-spindle
C4-TR/LI-OK60A-SS

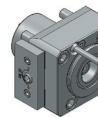


OD clamping unit, double, 26 mm "Y" axis
C4-R/LCE-LB2000-024065DYT

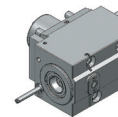


Parting blade holder
APB-TNE-OK60A-25

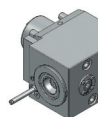
Driven toolholders



OD drill/milling unit
C4-DNE-OK60A-E
C4-DNE-OK60A-I *



Face drill/milling unit, both sides
C4-DTI-LB2000-070034DT



Face drill/milling unit
C4-DNI-OK60A-E
C4-DNI-OK60A-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.

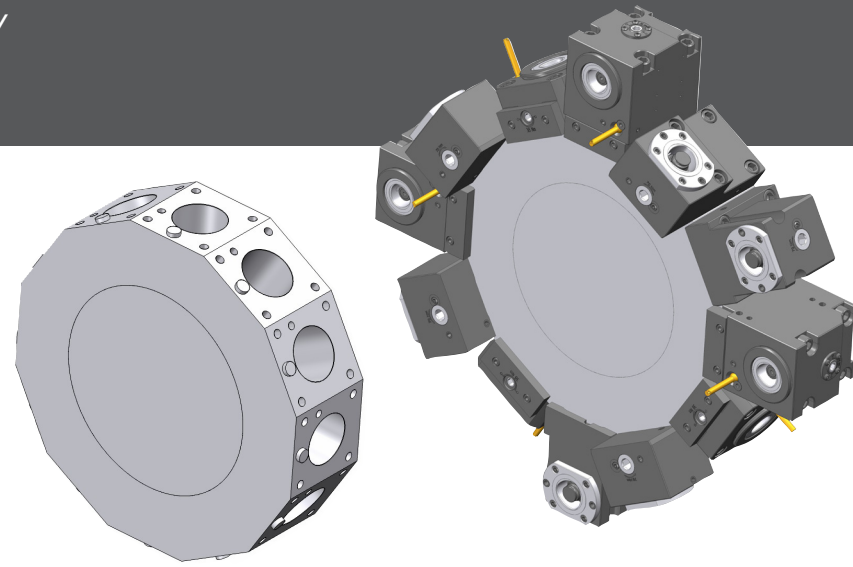
Ordering example:
C4-TRE-OK60A (right hand unit)
C4-TLE-OK60A (left hand unit)
Products beginning with Cx-TR/L and Cx-DN, see code key page 4
Products beginning with Cx-R/LC, see code key page 5
Ratio I =1:1
* Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Max. coolant pressure = 1160 PSI (80 bar)

Machines

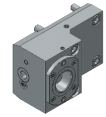
Okuma Space Turn LB4000EX M, MY

Coromant Capto®

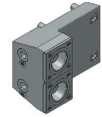
Machine adapted clamping units
Standard program



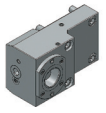
Static toolholders



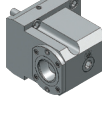
OD clamping unit
C5-TR/LE-OK60B



OD clamping unit, 32mm "Y" axis
C5-R/LCE-LB4000-028073YT

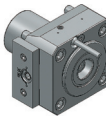


OD clamping unit, short
C5-R/LCE-LB4000-033065

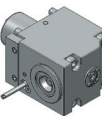


Face and ID clamping unit
C5-TR/LI-OK60B

Driven toolholders



OD drill/milling unit
C4-DNE-OK60B-E
C4-DNE-OK60B-I *



Face drill/milling unit
C4-DNI-OK60B-E
C4-DNI-OK60B-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:

C5-TRE-OK60B (right hand unit)
C5-TLE-OK60B (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 I = 1:1

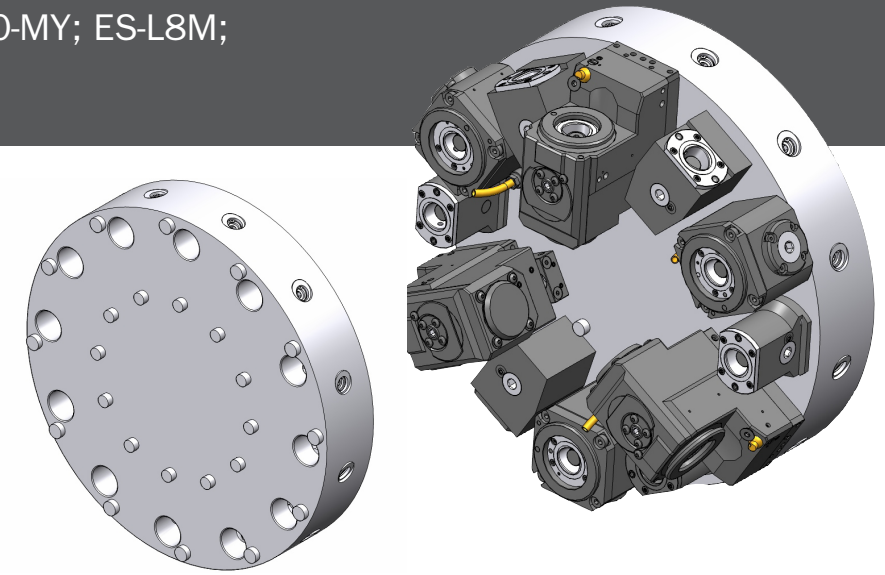
* Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Max. coolant pressure = 1160 PSI (80 bar)

Machines

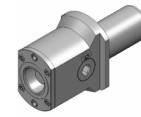
Okuma Space Turn LB200-M; LB200-MY; ES-L8M;
Genos L200M, E-M, MY

Coromant Capto®

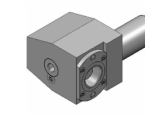
Machine adapted clamping units
Standard program



Static toolholders

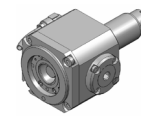


Face and ID clamping unit
C3-R/LC2030-00060M

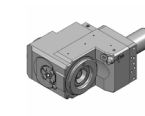


OD clamping unit
C3-R/LC2030-41020M
C3-R/LC2030-41030M

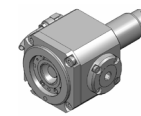
Driven toolholders



Straight drill/milling unit
C3-DTI-LB200M-000072



Right angle back set drill/milling unit
C3-DTE-LB200M-085008
C3-DTE-LB200M-085008I *



Straight drill/milling unit
C3-DTI-LB200M-000081I *

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-RCE2030-00060M (right hand unit)
C3-LCE2030-00060M (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
See main catalog for details on the static units.

Coromant Capto C3 ratio = 1:1

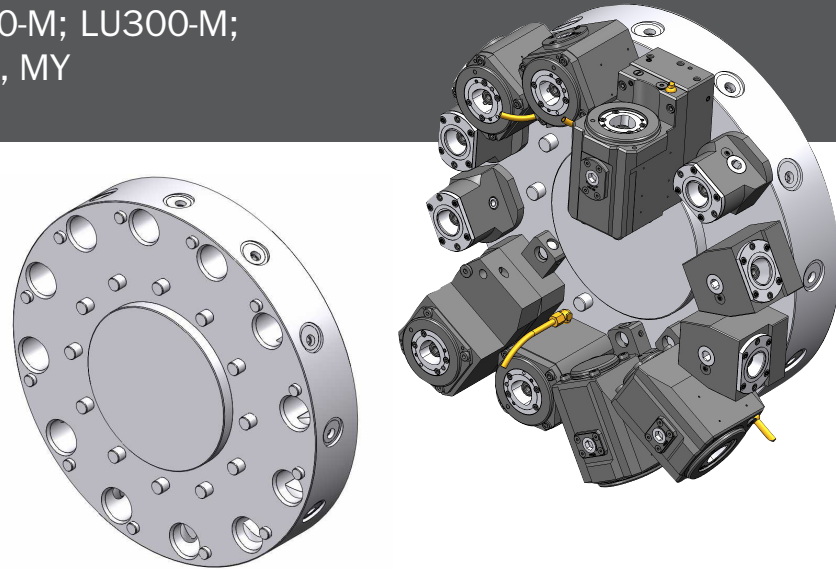
* Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Max. coolant pressure = 1160 PSI (80 bar)

Machines

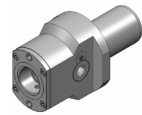
Okuma LB300-MY; LU300-MY; LB300-M; LU300-M;
ES-L10; L370-M; Genos L300M, E-M, MY

Coromant Capto®

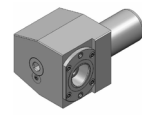
Machine adapted clamping units
Standard program



Static toolholders

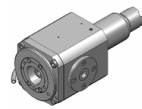


Face and ID clamping unit
C4-R/LC2040-00075M

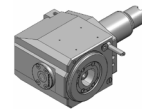


OD clamping unit
C4-R/LC2040-51030M
C4-R/LC2040-51040M

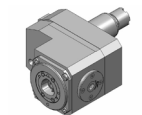
Driven toolholders



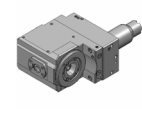
Straight drill/milling unit
C4-DTI-LB300M-000100
C4-DTI-LB300M-000100I *



Right angle drill/milling unit
C4-DTE-LB300M-070062
C4-DTE-LB300M-070062I *



Straight offset drill/milling unit
C4-DTI-LB300M-050120I *



Right angle back set drill/milling unit
C4-DTE-LB300M-100010
C4-DTE-LB300M-100010I *

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-RC2040-00075M (right hand unit)
C4-LC2040-00075M (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
See main catalog for details on static units.

Coromant Capto C4 ratio =1:1

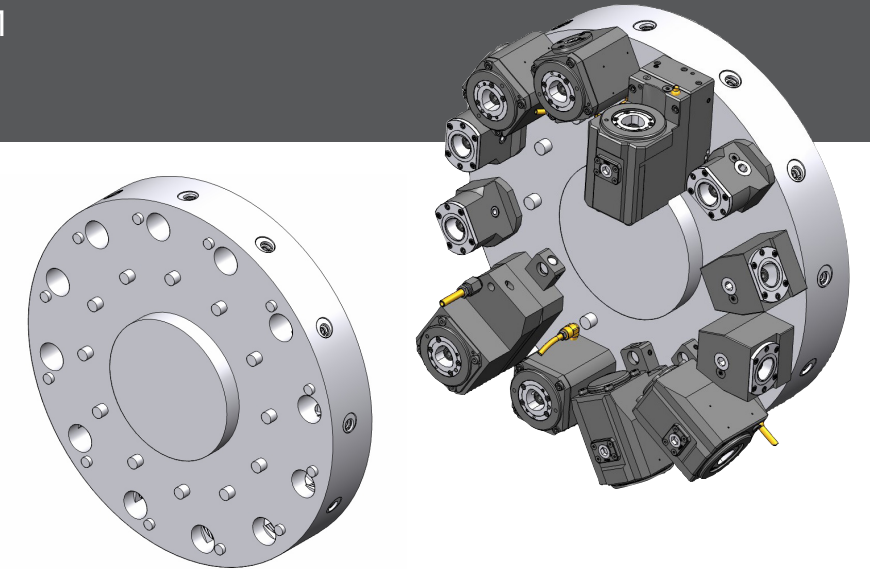
* Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Max. coolant pressure = 1160 PSI (80 bar)

Machines

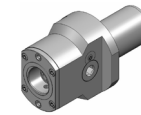
Okuma LB400-M; LU400-M; L470-M

Coromant Capto®

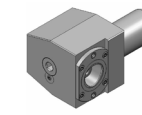
Machine adapted clamping units
Standard program



Static toolholders

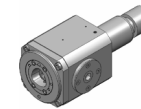


Face and ID clamping unit
C4-R/LC2040-00075M

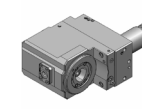


OD clamping unit
C4-R/LC2040-51030M
C4-R/LC2040-51040M

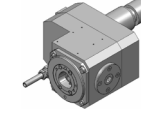
Driven toolholders



Face drill/milling unit
C4-DTI-LB400M-000100
C4-DTI-LB400M-000100I **



Right angle back set drill/milling unit
C4-DTE-LB400M-100012
C4-DTE-LB400M-100012I *



Straight offset drill/milling unit
C4-DTI-LB400M-050120I *

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-RC2040-00075M (right hand unit)
C4-LC2040-00075M (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
See main catalog for details on the static units.

Coromant Capto C4 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)

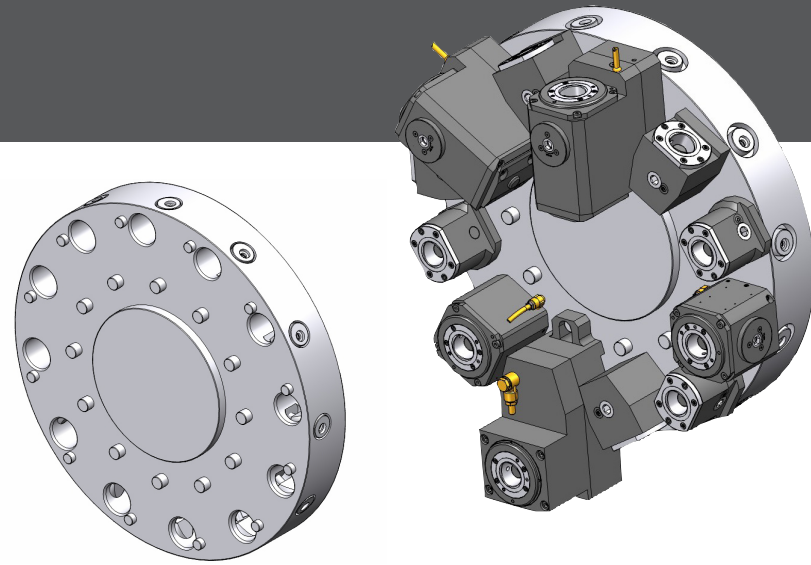
* Max. coolant pressure = 435 PSI (30 bar)
Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Do not use for machining abrasive materials such as cast iron, etc.

Machines

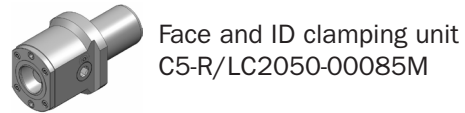
Okuma LU35-M; LB35II-M (1-step)

Coromant Capto®

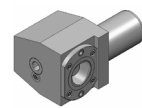
Machine adapted clamping units
Standard program



Static toolholders

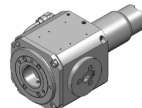


Face and ID clamping unit
C5-R/LC2050-00085M

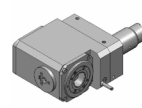


OD clamping unit
C5-R/LC2050-53030M
C5-R/LC2050-53040M

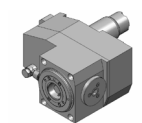
Driven toolholders



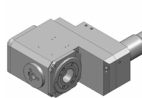
Straight drill/milling unit
C5-DTI-LU35M-000110
C5-DTI-LU35M-000110I **



Right angle back set drill/milling unit
C5-DTE-LU35M-124035
C5-DTE-LU35M-124035I *



Straight offset drill/milling unit
C5-DTI-LU35M-075160I *



Right angle extended back set drill/milling unit
C5-DTE-LU35M-129025
C5-DTE-LU35M-129025I *

Suggested collet chuck adapter for Coromant Capto to maximize tool projection



Collet chuck adapter, short
C5-391.14-32 045 ER32

Additional short adapters available through Extended Product Offer.

Ordering example:

C5-RC2050-00085M (right hand unit)
C5-LC2050-00085M (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
See main catalog for details on static units.

* 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)

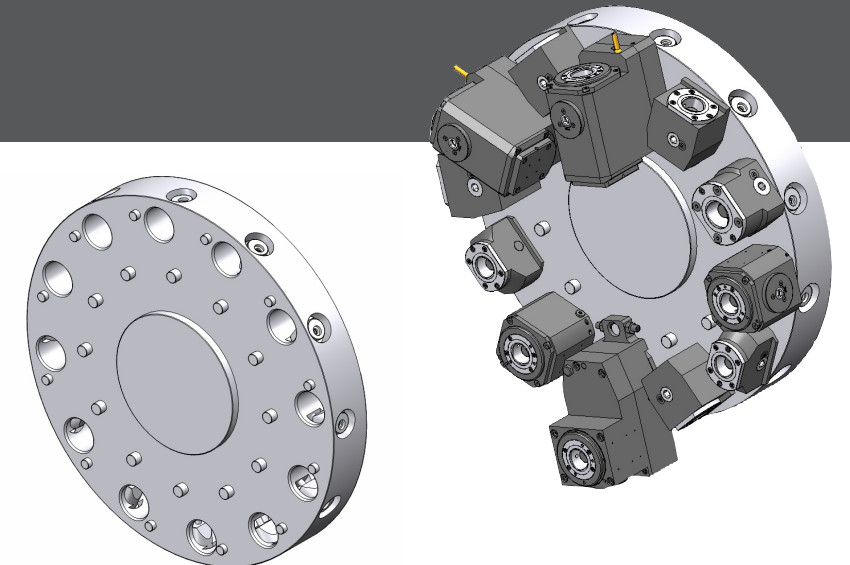
* Max. coolant pressure = 435 PSI (30 bar)
Internal and external coolant supply - Do not run without coolant.
Only use filtered coolant fluid (max. particle size = 100 µm)
Do not use for machining abrasive materials such as cast iron, etc.

Machines

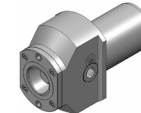
Okuma LU45-M

Coromant Capto®

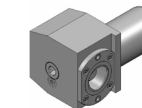
Machine adapted clamping units
Standard program



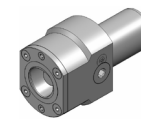
Static toolholders



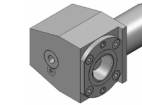
Face and ID clamping unit
C5-R/LC2060-00075M



OD clamping unit
C5-R/LC2060-43040M

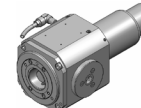


Face and ID clamping unit
C6-R/LC2060-00095

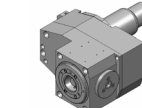


OD clamping unit
C6-R/LC2060-53040

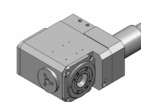
Driven toolholders



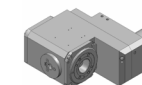
Straight drill/milling unit
C5-DTI-LU45M-000110
C5-DTI-LU45M-000110I **



Straight offset drill/milling unit
C5-DTI-LU45M-075160I *



Right angle back set drill/milling unit
C5-DTE-LU45M-124035
C5-DTE-LU45M-124035I *



Right angle extended back set drill/milling unit
C5-DTE-LU45M-124025
C5-DTE-LU45M-124025I **

Suggested collet chuck adapter for Coromant Capto to maximize tool projection



Collet chuck adapter, short
C5-391.14-32 045 ER32

Additional short adapters available through Extended Product Offer.

Ordering example:

C4-RC2060-00075M (right hand unit)
C4-LC2060-00075M (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
See main catalog for details on the static units.

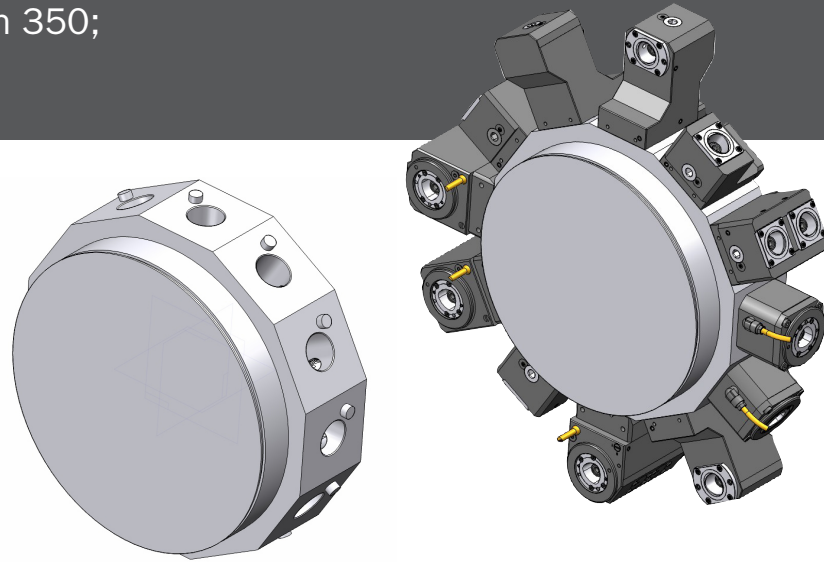
Ratio I =1:1

* 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)

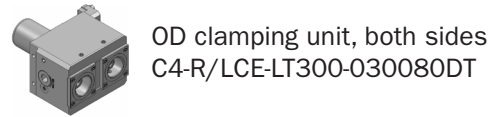
Machines

Okuma LT300-M; LT300-MY; Macturn 350;
Genos L300-MW, MYW (VDI 40)

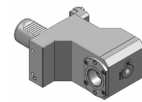
Coromant Capto® Machine adapted clamping units Standard program



Static toolholders

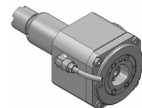


OD clamping unit, both sides
C4-R/LCE-LT300-030080DT

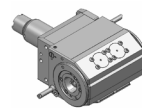


Face and ID clamping unit – 180°
reversible used for left or right
spindle
C4-R/LCI-LT300-105012

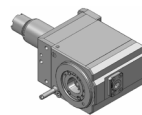
Driven toolholders



Straight drill/milling unit
C4-DTE-LT300-000074



Right angle drill/milling unit, both sides
C4-DTI-LT300-090064DT



Right angle drill/milling unit –
180° reversible
C4-DTI-LT300-090060
C4-DTI-LT300-090060I *

Suggested collet chuck adapter for Coromant Capto to
maximize tool projection



Collet chuck adapter, short
C4-391.14-30 035 ER20
C4-391.14-25 038 ER25

Additional short adapters available through Extended Product Offer.

Ordering example:
C4-RCE-LT300-030080DT (right hand unit)
C4-RCE-LT300-030080DT (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
See main catalog for details on static units.

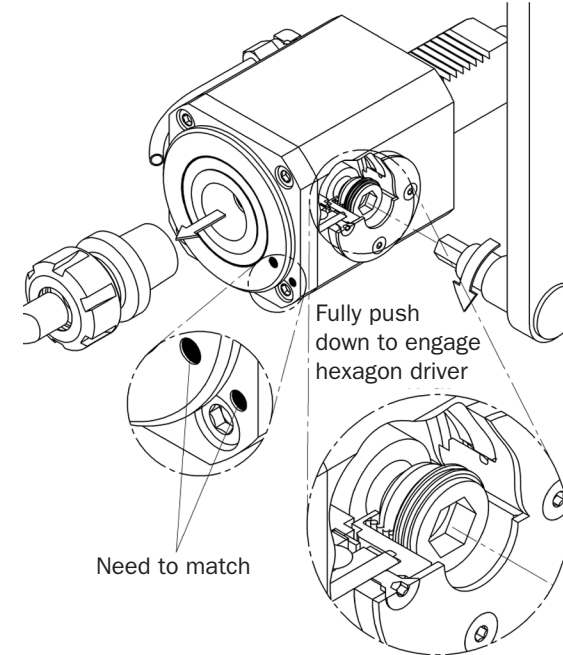
Coromant Capto C4
Ratio I =1:1

* 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)

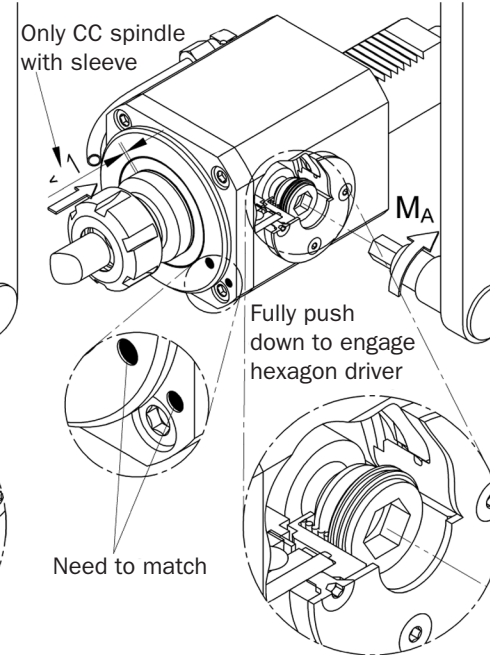
Operating instructions for Coromant Capto driven toolholders

Changing the cutting tool

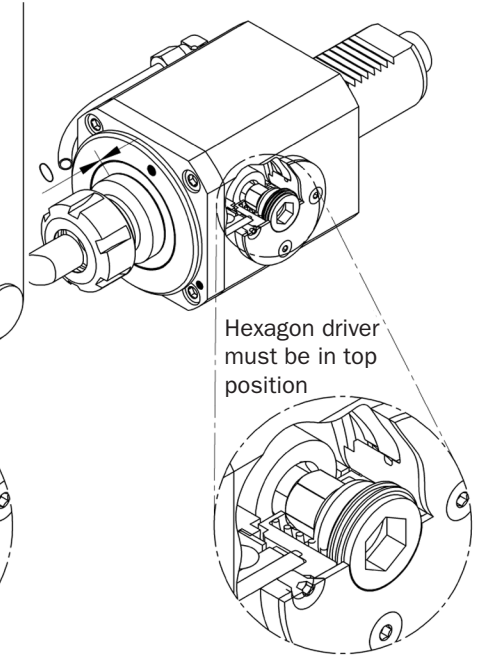
Unlock



Lock



Check before operation



Torque wrench for tool changing

Coupling size	Torque wrench		Ordering code	Size mm	Spare parts	
	ft-lbs	Nm			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				Solid Coromant Capto spindle			
	Wrench size	Torque M _A	Unlock + lock: Turn hexagon driver around approx. 140°	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				