

### 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](http://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](http://www.sandvik.coromant.com)

E-mail: [us.coromant@sandvik.com](mailto:us.coromant@sandvik.com)



Your success in focus

Mazak



# Coromant Capto® Machine Adapted Clamping Units

For Mazak CNC lathes



### Available for the following machines:

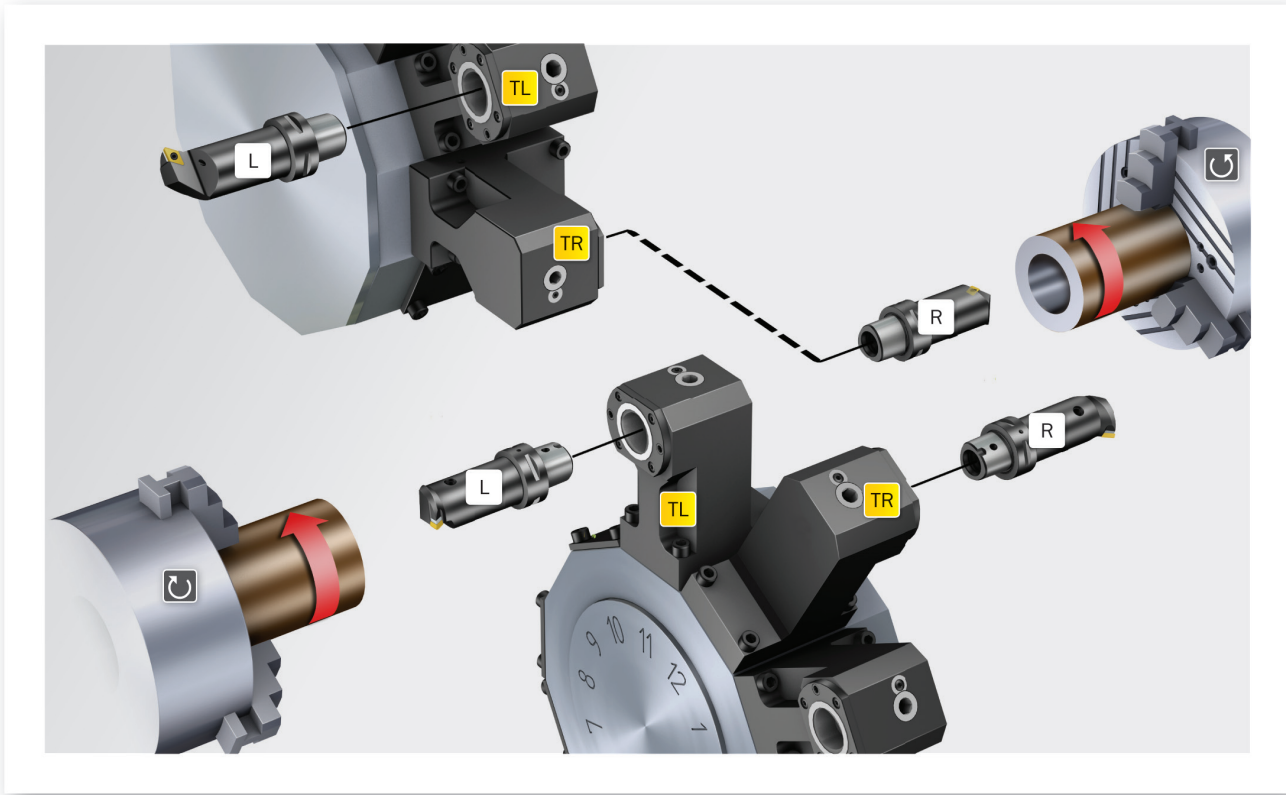
Quick Turn Smart 200, 200M  
Quick Turn Smart 300, 350  
Quick Turn Smart 300M, 350M  
Quick Turn Nexus 100M, MS, MSY (200/250M, MS, MSY 16 station turret)  
Quick Turn Nexus 200, 250, 300, 350

Quick Turn Nexus 200/250M, MS, MSY  
Quick Turn Nexus 300/350/400/450M  
Slant Turn Nexus 500, 550M  
Megaturn Nexus 900M  
Hyper Quadrex 450M (upper turret 1)  
Hyper Quadrex 100/150MSY

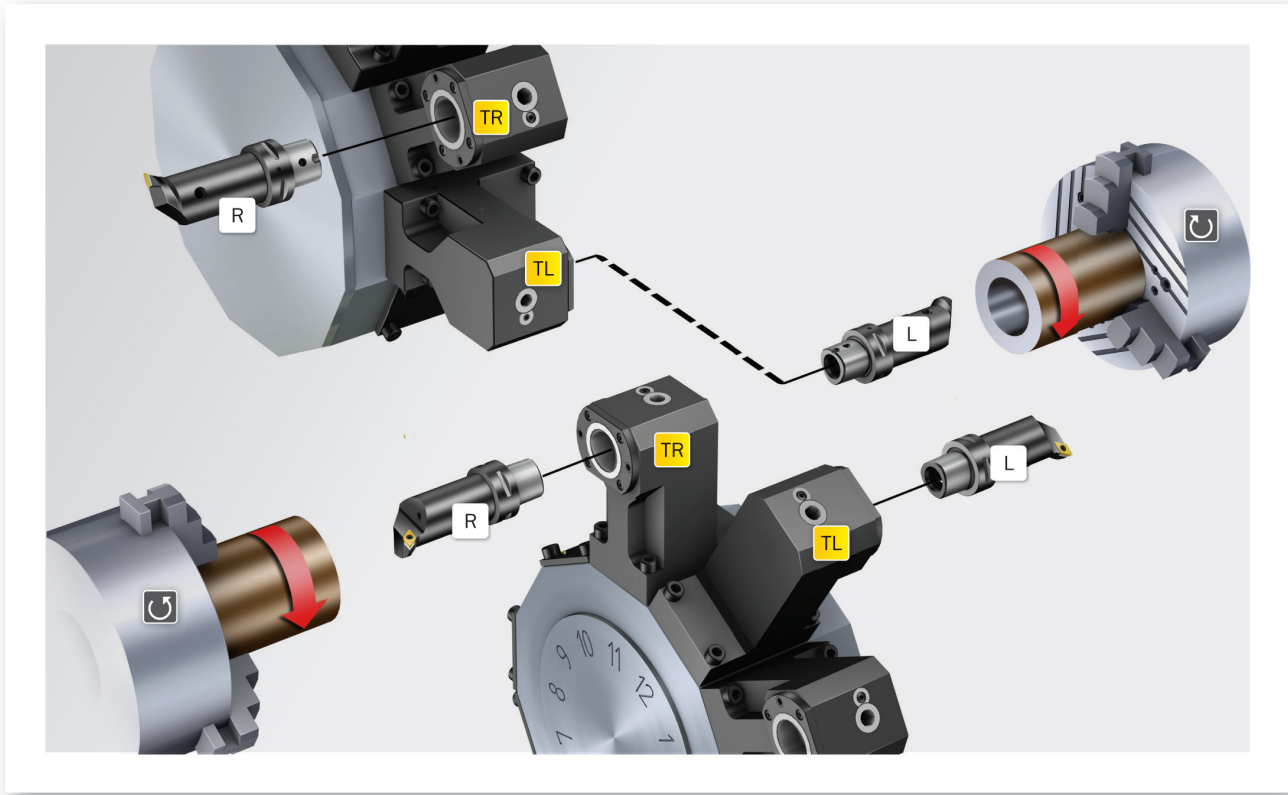
Hyper Quadrex 200 MSY  
Multiplex 6100/6200 (16 station turret)  
Multiplex 6200/6200Y/6250 (12 station turret)  
Cybertech Turn 4500M, MT

# Clamping unit configuration

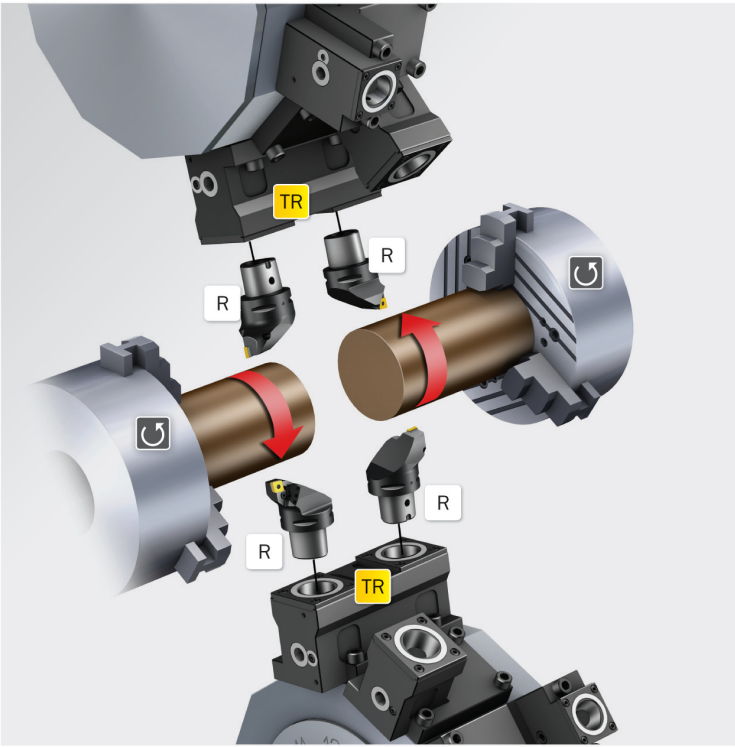
Internal setup



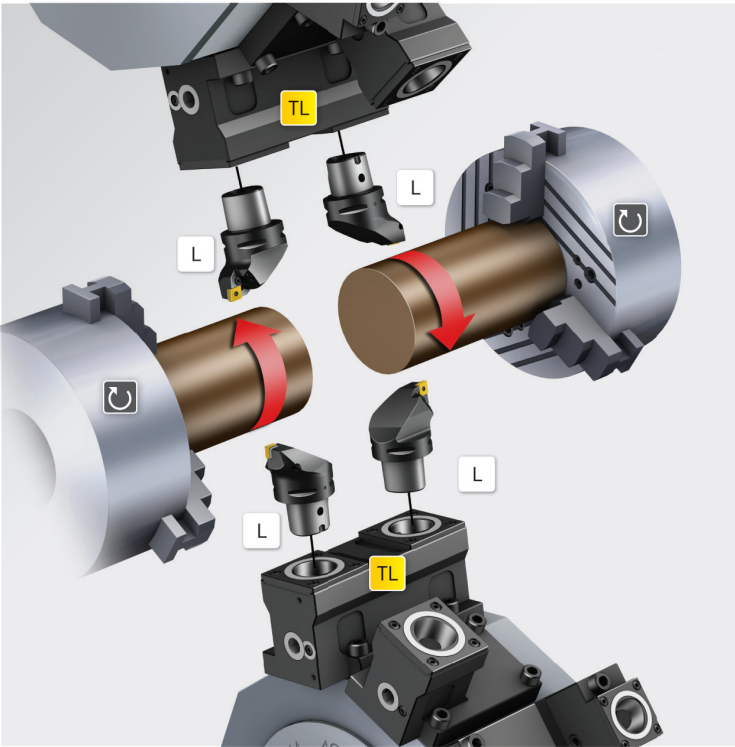
Internal setup



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.

**Global standard products**

**Code key for Coromant Capto® machine adapted clamping units**



**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  
  
MZ – Mazak

**6** Turret hole diameter (mm)  
  
40, 60, 65, 68, 80

**7** Turret interface version  
  
A, B, C

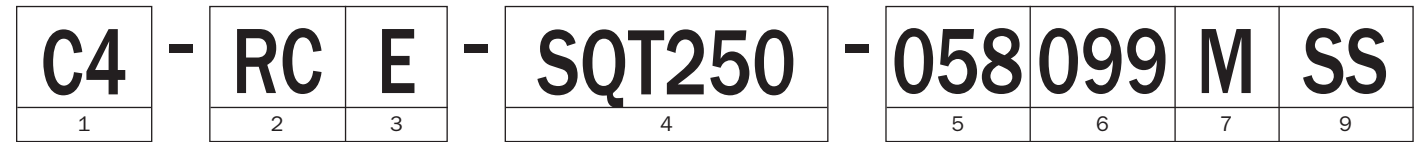
**8** Configuration  
  
Blank – for normal single clamping unit  
DT – for main spindle and subspindle (two clamping units in one holder)  
ET – extended  
DE – extended for main spindle and subspindle (two clamping units in one holder)  
TT – for machine with half index turret (two clamping units in 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

**U.S. local products**

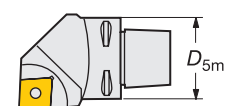
**Code key for Coromant Capto® machine adapted clamping units**

**Static holders**



**Driven tool holders**



**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:  
SQT250 = Super Quick Turn 250

**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)

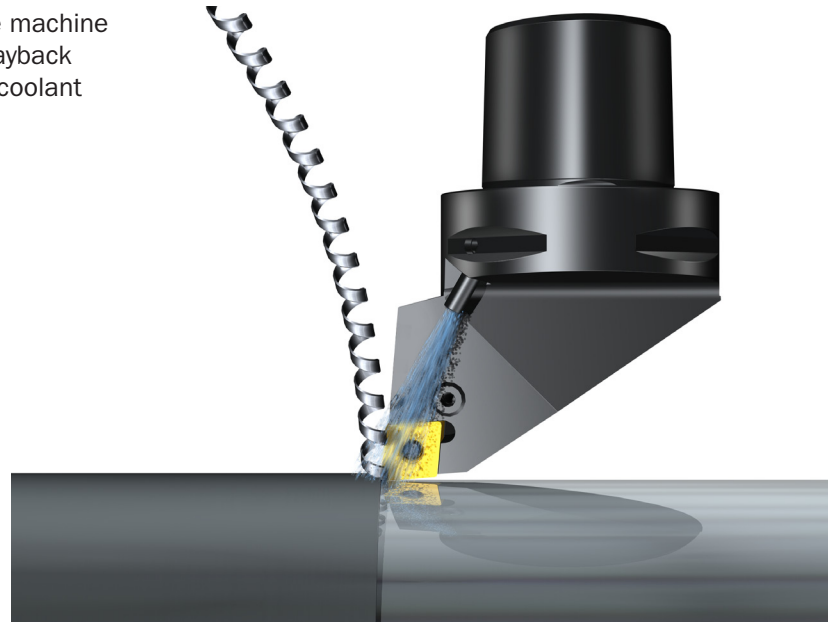
# High pressure coolant

High performance. Reduced production time.

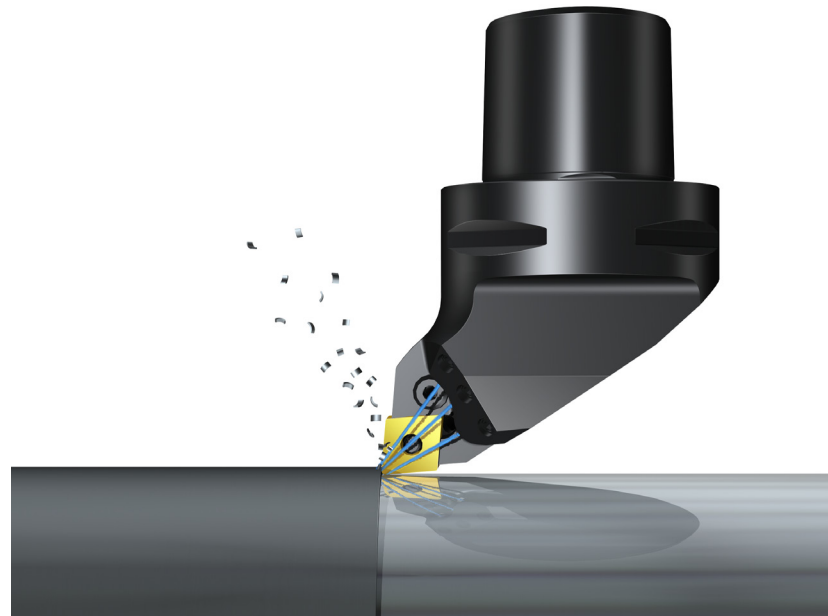
By channeling coolant delivery to the cutting edge through the spindle or turret, a high powered coolant jet of 80 bar (1160 PSI) can be positioned precisely at the cutting zone for maximum effect.

CoroTurn® HP high pressure coolant turning heads feature fixed nozzle positions, offering total chip control and preventing cycle interruption.

The production advantages are a higher utilization of the machine and available production time, thereby maximizing the payback on investment. An optimized system with high pressure coolant machining can pay for itself in a few months.



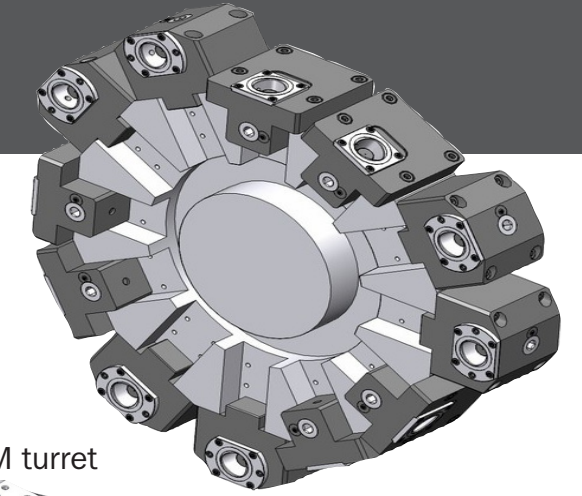
Flood coolant does cool the insert but it does not help with chip control. The coolant is not directed accurately or close enough to the cutting edge, allowing long strands of chips to form.



CoroTurn HP's fixed, pre-directed high precision nozzles create parallel laminar jets of coolant with high velocity, directed at the right place on the insert. The precision and character of these jets makes the difference. No setting with trials is needed; performance and security are built in.

## Machines

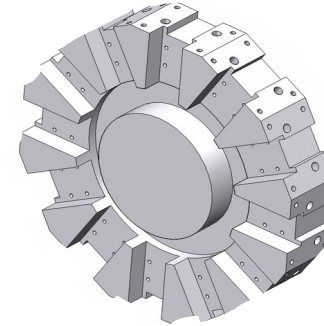
Mazak Quick Turn Smart 200, 250;  
Quick Turn Smart 200M, 250M



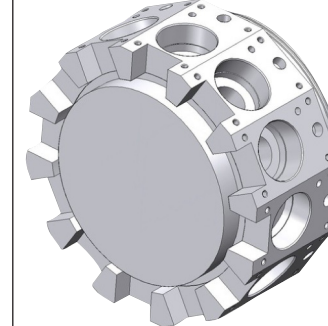
## Coromant Capto®

Machine adapted clamping units  
Standard program

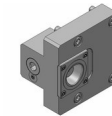
QTS 200 turret



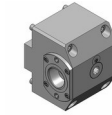
QTS 200M turret



### Static toolholders

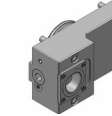


OD clamping unit  
C4-R/LCE-QTS20-025030<sup>1)</sup>

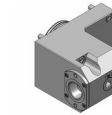


Face and ID clamping unit  
C4-R/LCI-QTS20-050031<sup>1)</sup>

### Static toolholders

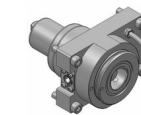


OD clamping unit  
C4-TR/LE-MZ68B<sup>2)</sup>

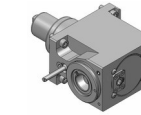


Face and ID clamping unit  
C4-TR/LI-MZ68B<sup>2)</sup>

### Driven toolholders



OD drill/milling unit  
C4-DNE-MZ68B-E<sup>2)</sup>  
C4-DNE-MZ68B-I<sup>2)</sup> \*



Face drill/milling unit  
C4-DNI-MZ68B-E<sup>2)</sup>  
C4-DNI-MZ68B-I<sup>2)</sup> \*

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-MZ68B (right hand unit)  
C4-TLE-MZ68B (left hand unit)

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

<sup>1)</sup>For QTS 200 machines only.

<sup>2)</sup>For QTS 200M machines only.

\* 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)

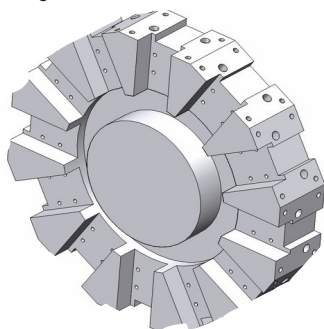
## Machines

Mazak Quick Turn Smart 300M, 350M;  
Quick Turn Smart 300, 350;  
Quick Turn Nexus 200, 250, 300, 350

### Coromant Capto®

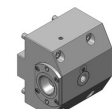
Machine adapted clamping units  
Standard program

QTS 300 turret

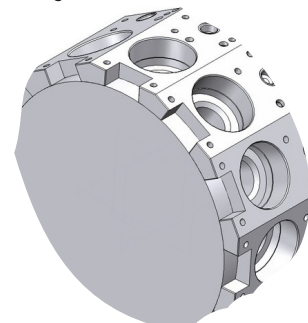


#### Static toolholders

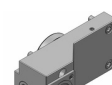
 OD clamping unit  
C4-R/LCE-QTS30-025025<sup>1)</sup>

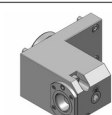
 Face and ID clamping unit  
C4-R/LCI-QTS30-050031<sup>1)</sup>  
C5-R/LCI-QTS30-047033<sup>1)</sup>

QTS 300M turret

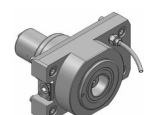


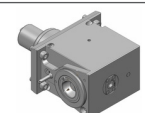
#### Static toolholders

 OD clamping unit  
C5-TR/LE-MZ80A<sup>2)</sup>

 Face and ID clamping unit  
C5-TR/LI-MZ80A<sup>2)</sup>

#### Driven toolholders

 OD drill/milling unit  
C5-DNE-MZ80A-E<sup>2)</sup>  
C5-DNE-MZ80A-I<sup>2)</sup> \*

 Face drill/milling unit  
C5-DNI-MZ80A-E<sup>2)</sup>  
C5-DNI-MZ80A-I<sup>2)</sup> \*

Ordering example:

C4-RCE-QTS30-025025 (right hand unit)  
C4-LCE-QTS30-025025 (left hand unit)


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

<sup>1)</sup>For QTS 300, 350, QTN 200, 250, 300, 350 machines only.

<sup>2)</sup>For QTS 300M, 350M machines only.

\* 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)

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

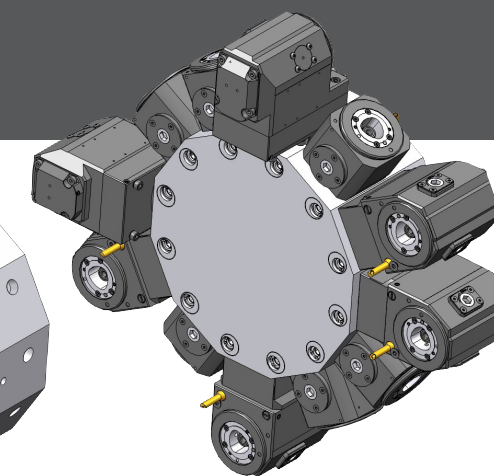
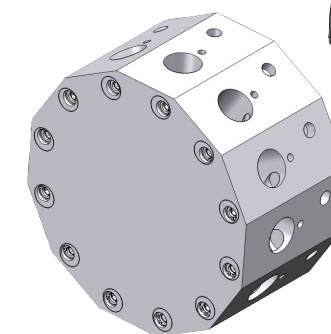
Additional short adapters available through Extended Product Offer.

## Machines

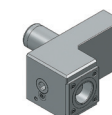
Mazak Quick Turn Nexus 100 M, MS -  
(200/250 M, MS, MSY 16 station turret)

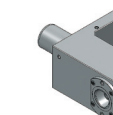
### Coromant Capto®

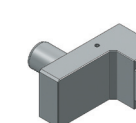
Machine adapted clamping units  
Standard program

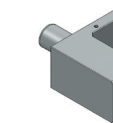


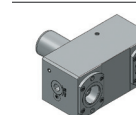
#### Static toolholders

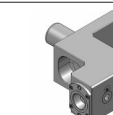
 OD offset clamping unit  
C4-R/LCE-QTN100-043069

 Face and ID clamping unit  
C4-R/LCI-QTN100-110056

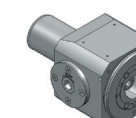
 OD offset clamping unit  
C4-R/LCE-QTN100-063079SS

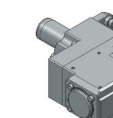
 Face and ID clamping unit  
C4-R/LCI-QTN100-110015SS

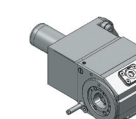
 OD clamping unit, both sides  
C4-R/LCE-QTN100-043079DT

 Face and ID clamping unit, both sides  
C4-R/LCI-QTN10-110126DT


#### Driven toolholders

 OD drill/milling unit  
C4-DTE-QTN100-000074

 Right angle back set drill/milling unit  
C4-DTI-QTN100-100012SS  
C4-DTI-QTN100-100012ISS \*

 Face drill/milling unit  
C4-DTI-QTN100-100060  
C4-DTI-QTN100-100060I \*

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-RCE-QTN100-043069 (right hand unit)  
C4-LCE-QTN100-043069 (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

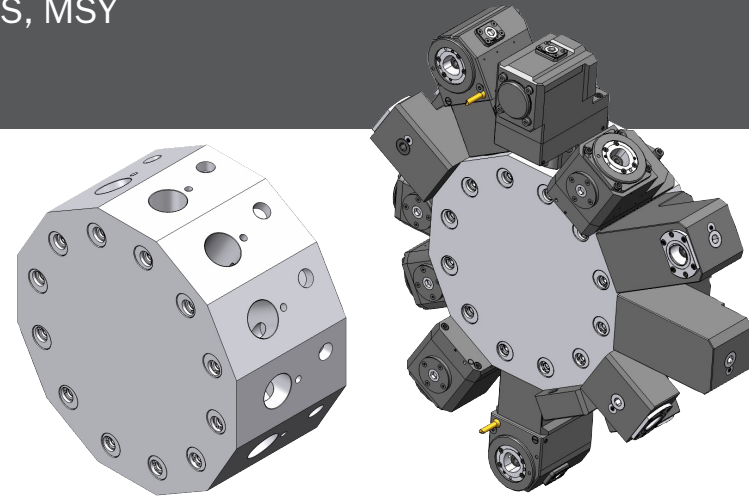
\* Internal and external coolant supply - Do not run without coolant.  
Only use filtered coolant fluid (max. particle size = 100 µm)  
Max. coolant pressure = 1160 PSI (80 bar)

# Machines

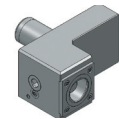
Mazak Quick Turn Nexus 200/250 M, MS, MSY

## Coromant Capto®

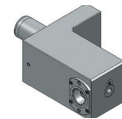
Machine adapted clamping units  
Standard program



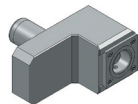
### Static toolholders



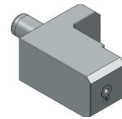
OD offset clamping unit  
C4-R/LCE-QTN200-058100  
C5-R/LCE-QTN200-050090



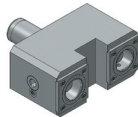
Face and ID clamping unit  
C4-R/LCI-QTN200-140076  
C5-R/LCI-QTN200-140075



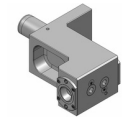
OD offset clamping unit - sub-spindle  
C4-R/LCE-QTN200-058100SS  
C5-R/LCE-QTN200-050090SS



Face and ID clamping unit - sub-spindle  
C4-R/LCI-QTN200-140015SS  
C5-R/LCI-QTN200-140015SS

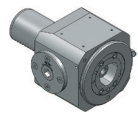


OD clamping unit, both sides  
C4-R/LCE-QTN200-058116DT  
C5-R/LCE-QTN200-050106DT

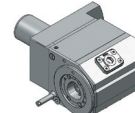


Face and ID clamping unit, both sides  
C4-R/LCI-QTN20-140121DT  
C5-R/LCI-QTN20-140143DT

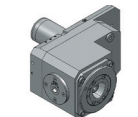
### Driven toolholders



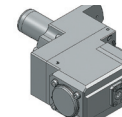
Straight drill/milling unit  
C4-DTE-QTN200-000083



Right angle drill/milling unit  
C4-DTI-QTN200-130060  
C4-DTI-QTN200-130060I \*



Straight offset drill/milling unit  
C4-DTE-QTN200-050107  
C4-DTE-QTN200-050107I \*



Right angle back set drill/milling unit  
C4-DTI-QTN200-125012SS  
C4-DTI-QTN200-125012ISS

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-RCE-QTN200-058100 (right hand unit)  
C4-LCE-QTN200-058100 (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

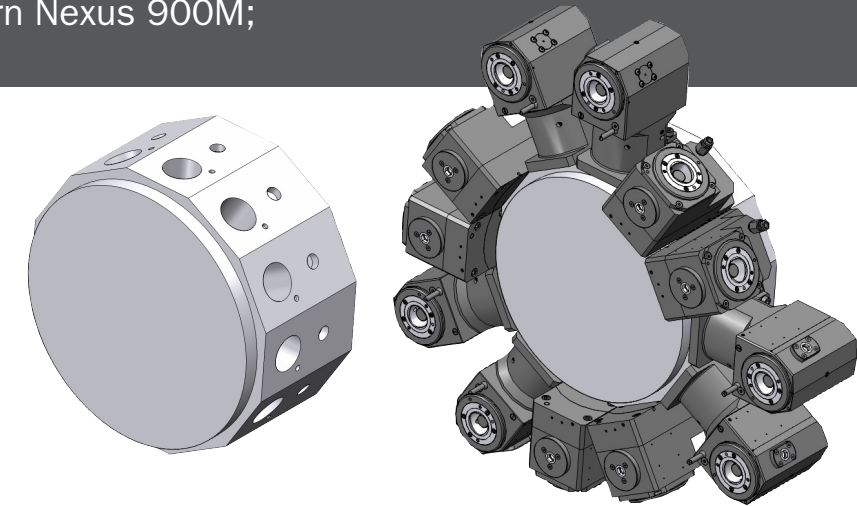
\* Internal and external coolant supply - Do not run without coolant.  
Only use filtered coolant fluid (max. particle size = 100 µm)  
Max. coolant pressure = 1160 PSI (80 bar)

# Machines

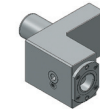
Mazak Quick Turn Nexus 300/350/400/450M, MY;  
Slant Turn Nexus 500/550M; Megaturn Nexus 900M;  
HyperQuadrex 450M (upper turret 1)

## Coromant Capto®

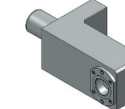
Machine adapted clamping units  
Standard program



### Static toolholders

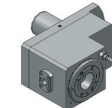


OD clamping unit, both sides  
C5-R/LCE-QTN300-052130  
C6-TR/LE-MZ50V

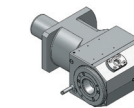


Face and ID clamping unit  
C5-R/LCI-QTN300-175065  
C6-TR/LI-MZ50V

### Driven toolholders



OD drill/milling unit  
C5-DNE-MZ50V-E  
C5-DNE-MZ50V-I \*



Face drill/milling unit  
C5-DNI-MZ50V-E  
C5-DNI-MZ50V-I \*

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:

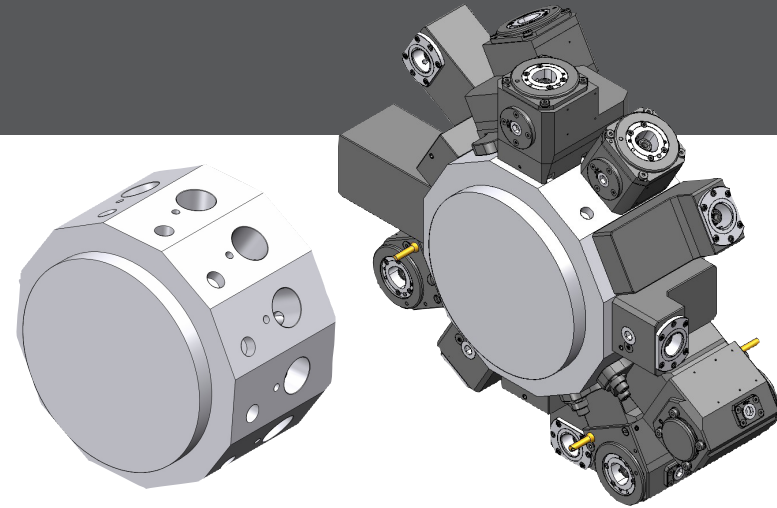
C5-RCE-QTN300-052130 (right hand unit)  
C5-LCE-QTN300-052130 (left hand unit)

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

\* 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

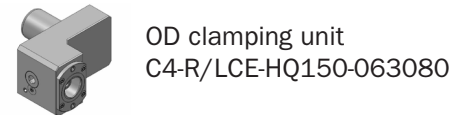
Mazak Hyper Quadrex 100/150MSY;  
Multiplex 6100 (6200 16 station turret)



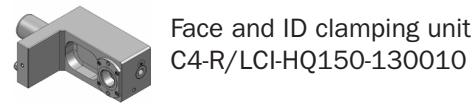
### Coromant Capto®

Machine adapted clamping units  
Standard program

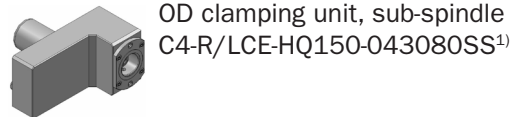
#### Static toolholders



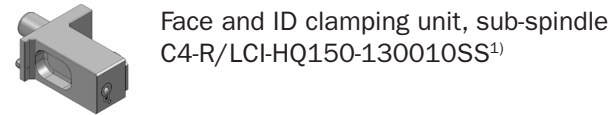
OD clamping unit  
C4-R/LCE-HQ150-063080



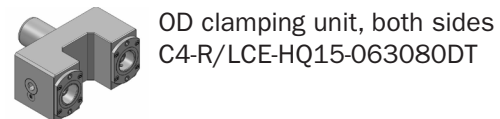
Face and ID clamping unit  
C4-R/LCI-HQ150-130010



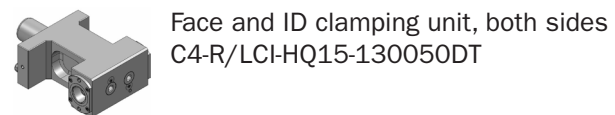
OD clamping unit, sub-spindle  
C4-R/LCE-HQ150-043080SS<sup>1)</sup>



Face and ID clamping unit, sub-spindle  
C4-R/LCI-HQ150-130010SS<sup>1)</sup>

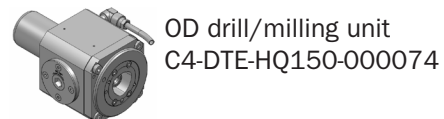


OD clamping unit, both sides  
C4-R/LCE-HQ15-063080DT

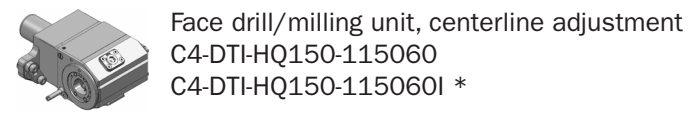


Face and ID clamping unit, both sides  
C4-R/LCI-HQ15-130050DT

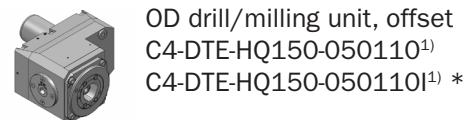
#### Driven toolholders



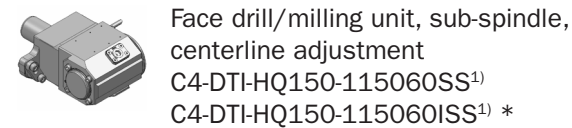
OD drill/milling unit  
C4-DTE-HQ150-000074



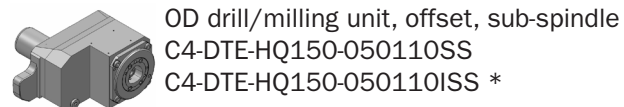
Face drill/milling unit, centerline adjustment  
C4-DTI-HQ150-115060  
C4-DTI-HQ150-115060I \*



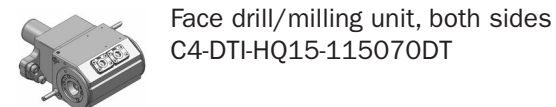
OD drill/milling unit, offset  
C4-DTE-HQ150-050110<sup>1)</sup>  
C4-DTE-HQ150-050110I<sup>1)</sup> \*



Face drill/milling unit, sub-spindle,  
centerline adjustment  
C4-DTI-HQ150-115060SS<sup>1)</sup>  
C4-DTI-HQ150-115060ISS<sup>1)</sup> \*

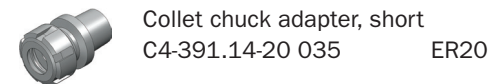


OD drill/milling unit, offset, sub-spindle  
C4-DTE-HQ150-050110SS  
C4-DTE-HQ150-050110ISS \*



Face drill/milling unit, both sides  
C4-DTI-HQ15-115070DT

Suggested collet chuck adapter for Coromant Capto to maximize tool projection



Collet chuck adapter, short  
C4-391.14-20 035 ER20

Additional short adapters available through Extended Product Offer.

Ordering example:

C4-RCE-HQ150-063080 (right hand unit)  
C4-LCE-HQ150-063080 (left hand unit)

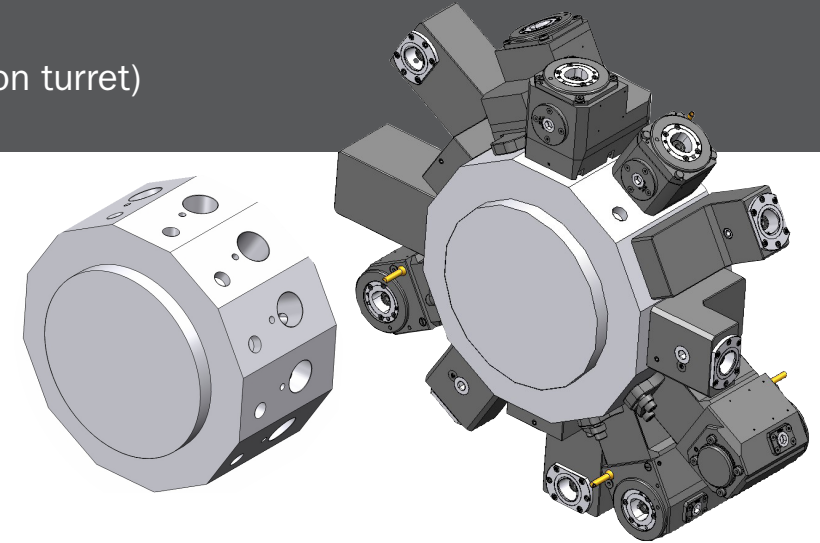
Products beginning with Cx-TR/L and Cx-DN, see code key page 4  
Products beginning with Cx-R/LC, see code key page 5

<sup>1)</sup> For sub-spindle Hyper Quadrex machines only.

\* 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

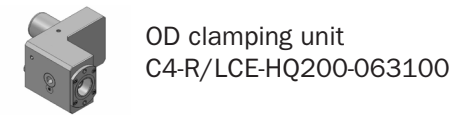
Mazak Hyper Quadrex 200MSY;  
Multiplex 6200/6200Y/6250 (12 station turret)



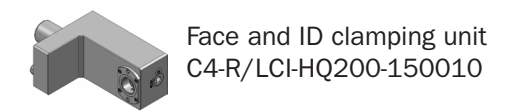
### Coromant Capto®

Machine adapted clamping units  
Standard program

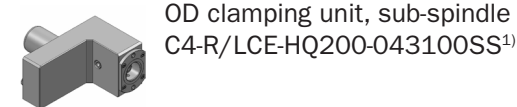
#### Static toolholders



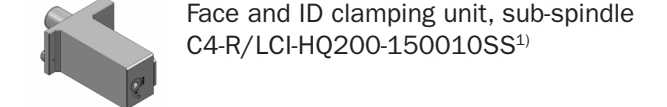
OD clamping unit  
C4-R/LCE-HQ200-063100



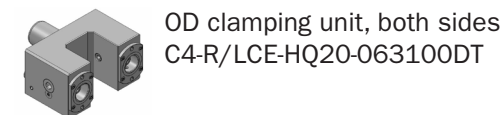
Face and ID clamping unit  
C4-R/LCI-HQ200-150010



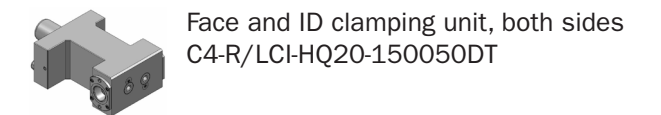
OD clamping unit, sub-spindle  
C4-R/LCE-HQ200-043100SS<sup>1)</sup>



Face and ID clamping unit, sub-spindle  
C4-R/LCI-HQ200-150010SS<sup>1)</sup>

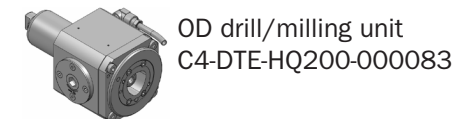


OD clamping unit, both sides  
C4-R/LCE-HQ20-063100DT

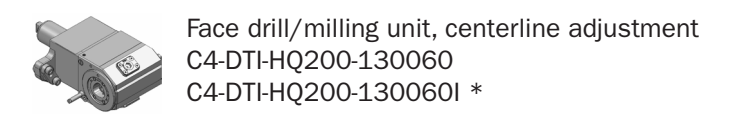


Face and ID clamping unit, both sides  
C4-R/LCI-HQ20-150050DT

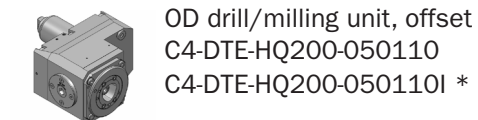
#### Driven toolholders



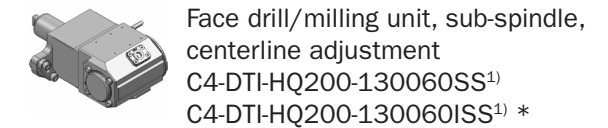
OD drill/milling unit  
C4-DTE-HQ200-000083



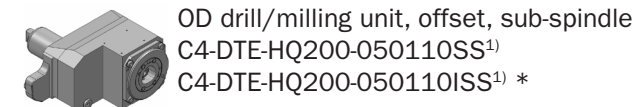
Face drill/milling unit, centerline adjustment  
C4-DTI-HQ200-130060  
C4-DTI-HQ200-130060I \*



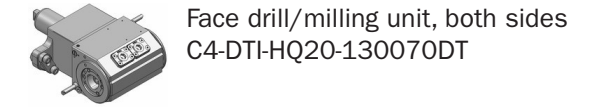
OD drill/milling unit, offset  
C4-DTE-HQ200-050110  
C4-DTE-HQ200-050110I \*



Face drill/milling unit, sub-spindle,  
centerline adjustment  
C4-DTI-HQ200-130060SS<sup>1)</sup>  
C4-DTI-HQ200-130060ISS<sup>1)</sup> \*

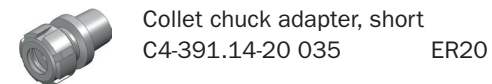


OD drill/milling unit, offset, sub-spindle  
C4-DTE-HQ200-050110SS<sup>1)</sup>  
C4-DTE-HQ200-050110ISS<sup>1)</sup> \*



Face drill/milling unit, both sides  
C4-DTI-HQ20-130070DT

Suggested collet chuck adapter for Coromant Capto to maximize tool projection



Collet chuck adapter, short  
C4-391.14-20 035 ER20

Additional short adapters available through Extended Product Offer.

Ordering example:

C4-RCE-HQ200-063100 (right hand unit)  
C4-LCE-HQ200-063100 (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

<sup>1)</sup> For sub-spindle Hyper Quadrex machines only.

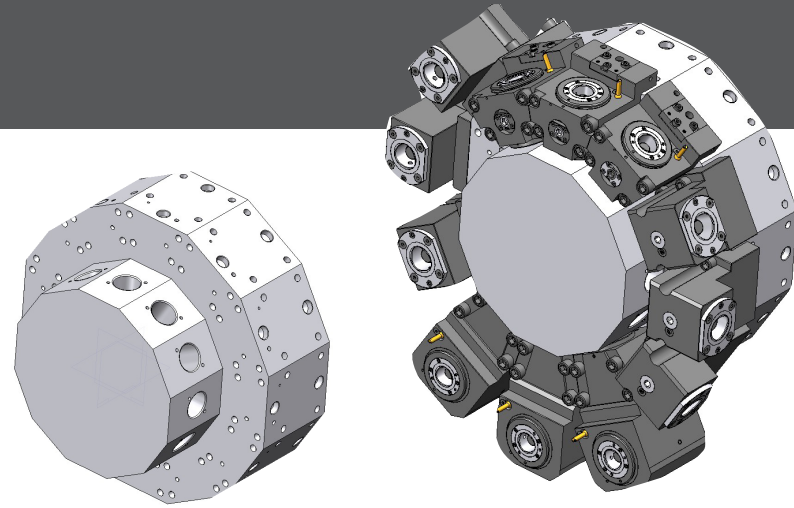
\* Internal and external coolant supply - Do not run without coolant.  
Only use filtered coolant fluid (max. particle size = 100 µm)  
Max. coolant pressure = 1160 PSI (80 bar)

# Machines

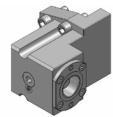
Mazak Cybertech Turn 4500M, MT

## Coromant Capto®

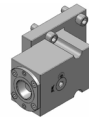
Machine adapted clamping units  
Standard program



### Static toolholders

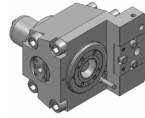


OD clamping unit  
C6-R/LCE-CT4500M-138074

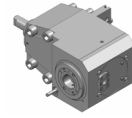


Face and ID clamping unit  
C6-R/LCI-CT4500M-079097

### Driven toolholders



OD drill/milling unit  
C5-DTE-CT4500M-000005  
C5-DTE-CT4500M-000005I \*\*



Face drill/milling unit  
C5-DTI-CT4500M-084086  
C5-DTI-CT4500M-084086I \*

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:  
C6-RCE-CT4500M-138074 (right hand unit)  
C6-LCE-CT4500M-138074 (left hand unit)

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

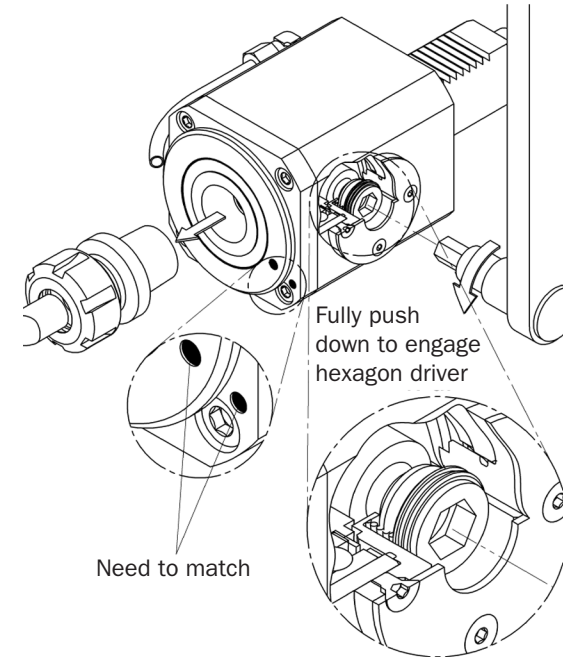
\* Face drill/milling unit with Coromant Capto C5  
Ratio i=1:1  
Internal and external coolant supply - Do not run without coolant.  
Only use filtered coolant fluid (max. particle size = 100 µm)  
Max. coolant pressure = 1160 PSI (80 bar)

\*\* OD drill/milling unit with Coromant Capto C5  
Internal and external coolant supply - Do not run without coolant.  
Only use filtered coolant fluid (max. particle size = 100 µm)  
Max. coolant pressure = 435 PSI (30 bar)

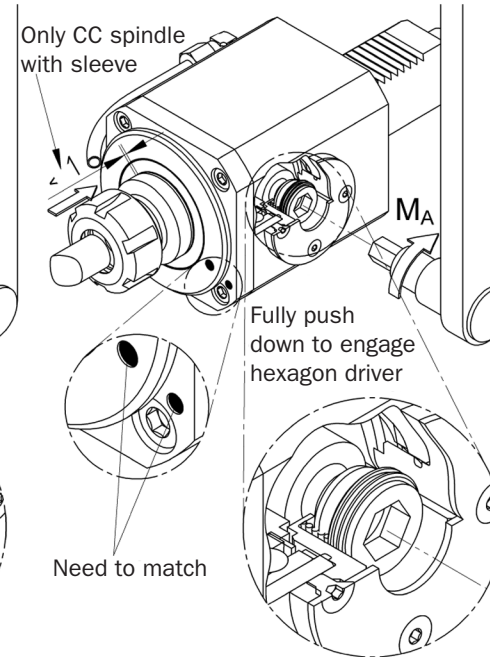
# Operating instructions for Coromant Capto driven toolholders

## Changing the cutting tool

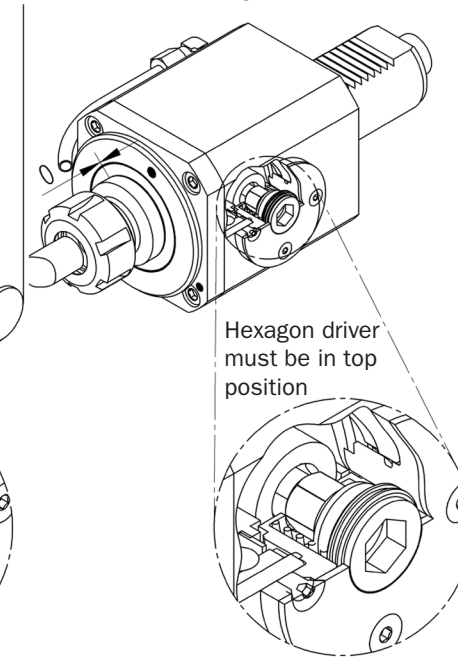
### Unlock



### 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				Solid Coromant Capto spindle			
	Wrench size	Torque MA	Unlock + lock: Turn hexagon driver around approx. 140°	Wrench size	Max Torque MA	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				