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

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 360, 350M
- 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

Coromant Capto®
Machine Adapted Clamping Units
For Mazak CNC lathes
Clamping unit configuration

Internal setup

External setup

Single clamping unit is also right handed.

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
CCW  Clockwise spindle rotation
CW  Counter clockwise spindle rotation
Global standard products

Code key for Coromant Capto® machine adapted clamping units

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>C4</td>
<td>Coupling size: C4 = 40 mm</td>
</tr>
<tr>
<td>C5</td>
<td>C5 = 50 mm</td>
</tr>
<tr>
<td>C3</td>
<td>C3 = 32 mm</td>
</tr>
<tr>
<td>C4</td>
<td>C4 = 40 mm</td>
</tr>
<tr>
<td>C5</td>
<td>C5 = 50 mm</td>
</tr>
<tr>
<td>C6</td>
<td>C6 = 63 mm</td>
</tr>
<tr>
<td>C8</td>
<td>C8 = 80 mm</td>
</tr>
</tbody>
</table>

1 Coromant Capto size

2 Application

1 T – Turning
2 D – Driven

3 Hand of clamping units

1 L – Left
2 R – Right
3 N – Neutral

4 Type of operation

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

5 Machine

1 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

![Diagram](https://via.placeholder.com/150)

Static holders

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>C4</td>
<td>Coupling size: C4 = 40 mm</td>
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<tr>
<td>C5</td>
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<td>C3</td>
<td>C3 = 32 mm</td>
</tr>
<tr>
<td>C4</td>
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</tr>
<tr>
<td>C5</td>
<td>C5 = 50 mm</td>
</tr>
<tr>
<td>C6</td>
<td>C6 = 63 mm</td>
</tr>
<tr>
<td>C8</td>
<td>C8 = 80 mm</td>
</tr>
</tbody>
</table>

1 Coupling size

2 Hand of clamping unit/type of unit

1 RC = Right
2 LC = Left
3 NC = Neutral
4 DT = Driven Tool

3 Type of operation

1 E = External
2 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)

Driven tool holders

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>C3</td>
<td>Coupling size: C3 = 32 mm</td>
</tr>
<tr>
<td>C4</td>
<td>C4 = 40 mm</td>
</tr>
<tr>
<td>C5</td>
<td>C5 = 50 mm</td>
</tr>
<tr>
<td>C6</td>
<td>C6 = 63 mm</td>
</tr>
<tr>
<td>C8</td>
<td>C8 = 80 mm</td>
</tr>
</tbody>
</table>

1 Coupling size

2 Hand of clamping unit/type of unit

1 RC = Right
2 LC = Left
3 NC = Neutral
4 DT = Driven Tool

3 Type of operation

1 E = External
2 I = Internal

4 Machine model

Example: QTN200 = Quick Turn 200

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)
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.

Coromant Capto®

Machine adapted clamping units

Standard program

Machines

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

CoroTurn® HP head features:

- Fixed nozzle positions
- Chip control
- Cycle interruption prevention

Production advantages:

- Higher machine utilization
- Maximized payback on investment

- Flood coolant limitations

Ordering example:

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

Suggested collet chuck adapter for Coromant Capto to maximize tool projection

Collet chuck adapter, short
C4-391L.14.20 035 ER20
C4-391L.14.25 038 ER25

* Internal and external coolant supply - Do not run without coolant.

Driven toolholders

OD drill/milling unit
C4-DNI-M268B E
C4-DNI-M268B I

Face drill/milling unit
C4-DNI-M268B EM
C4-DNI-M268BI

Static toolholders

OD clamping unit
C4-R/LCE-QTS20-025030

Face and ID clamping unit
C4-R/LCI-QTS20-050031

Face and ID clamping unit
C4-TR/LQTS20-050031*
Coromant Capto®
Machine adapted clamping units
Standard program

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

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

* 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)

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

Coromant Capto®
Machine adapted clamping units
Standard program

Ordering example:
C4-RCE-QTN100-043069 (right hand unit)
C4-LCE-QTN100-043069 (left hand unit)

* 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)

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

Static toolholders
- OD clamping unit
  C4-R/LCE-QTS30-025025
- Face and ID clamping unit
  C4-R/LCI-QTS30-050031
  C5-R/LCI-QTS30-047033

Driven toolholders
- OD drill/milling unit
  C5-DNE-MZ80A
- Face drill/milling unit
  C5-DNI-MZ80A

Static toolholders
- OD clamping unit
  C5-TR/LE-MZ80A
- Face and ID clamping unit
  C5-TR/LI-MZ80A

Driven toolholders
- OD offset clamping unit
  C4-R/LCE-QTN100-043069
- OD offset clamping unit
  C4-R/LCE-QTN100-063079SS
- OD clamping unit, both sides
  C4-R/LCE-QTN100-043079DT
- Face and ID clamping unit
  C4/R/LCI-QTN100-110126DT

Static toolholders
- OD offset clamping unit
  C4/R/LCI-QTN100-043069
- Face and ID clamping unit
  C4/R/LCI-QTN100-110015SS

Driven toolholders
- OD drill/milling unit
  C5-DNE-MZ80A-E
  C5-DNE-MZ80A-I
- Right angle back set drill/milling unit
  C4-DTI-QTN100-100012SS
  C4-DTI-QTN100-100012SS *

Static toolholders
- OD clamping unit
  C5-TR/LE-MZ80A
- Face and ID clamping unit
  C5-TR/LI-MZ80A

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

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.
### Coromant Capto®
Machine adapted clamping units

#### Standard program

#### Static toolholders

<table>
<thead>
<tr>
<th>OD offset clamping unit</th>
<th>C4-R/LCE-QTN200-058100</th>
<th>C5-R/LCE-QTN200-050090</th>
</tr>
</thead>
<tbody>
<tr>
<td>Face and ID clamping unit</td>
<td>C4-R/LCI-QTN200-140076</td>
<td>C5-R/LCI-QTN200-140075</td>
</tr>
</tbody>
</table>

| 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-QTN200-140121DT | C5-R/LCI-QTN200-140143DT |

#### Driven toolholders

| Straight drill/milling unit | C4-DTE-QTN200-000083 |
| Right angle drill/milling unit | C4-DTI-QTN200-130060 | C4-DTI-QTN200-130060I * |

| Face drill/milling unit | C5-DNI-MZ50V-E | C5-DNI-MZ50V-I * |
| OD drill/milling unit | C5-DNE-MZ50V-E | C5-DNE-MZ50V-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.

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

**Coromant Capto®**
Machine adapted clamping units

#### 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.

### 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

#### Static toolholders

| OD clamping unit, both sides | C5-R/LCE-QTN300-052130 | C5-R/LCE-QTN300-176065 |
| Face and ID clamping unit | C5-R/LCI-QTN300-176065 | C5-R/LCI-QTN300-176065 |

| OD drill/milling unit | C5-DNI-MZ50V-E | C5-DNI-MZ50V-I * |
| OD drill/milling unit | C5-DNE-MZ50V-E | C5-DNE-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.
## Machines

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

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

### Coromant Capto®

**Machine adapted clamping units**

#### Standard program

<table>
<thead>
<tr>
<th>Static toolholders</th>
<th>Driven toolholders</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>OD clamping unit</th>
<th>Face and ID clamping unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>C4-R/LCE-HQ150-063080</td>
<td>C4-R/LCI-HQ150-130010</td>
</tr>
<tr>
<td>C4-R/LCE-HQ150-043080SS</td>
<td>C4-R/LCI-HQ150-130010SS</td>
</tr>
<tr>
<td>C4-R/LCE-HQ15-063080DT</td>
<td>C4-R/LCI-HQ15-130050DT</td>
</tr>
</tbody>
</table>

**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-RC-E-HQ150-063080 (right hand unit)
- C4-LCE-HQ150-063080 (left hand unit)

Products beginning with Cx/R/L, see code key page 4

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)

**Coromant Capto®**

**Machine adapted clamping units**

#### Standard program

<table>
<thead>
<tr>
<th>Static toolholders</th>
<th>Driven toolholders</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>OD clamping unit</th>
<th>Face and ID clamping unit</th>
</tr>
</thead>
<tbody>
<tr>
<td>C4-R/LCE-HQ200-063100</td>
<td>C4-R/LCI-HQ200-150010</td>
</tr>
<tr>
<td>C4-R/LCE-HQ200-043100SS</td>
<td>C4-R/LCI-HQ200-150010SS</td>
</tr>
<tr>
<td>C4-R/LCE-HQ20-063100DT</td>
<td>C4-R/LCI-HQ20-150050DT</td>
</tr>
</tbody>
</table>

**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-RC-E-HQ200-063100 (right hand unit)
- C4-LCE-HQ200-063100 (left hand unit)

Products beginning with Cx/R/L, see code key page 4

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)
Operating instructions for Coromant Capto driven toolholders

**Changing the cutting tool**

**Unlock**
- Fully push down to engage hexagon driver
- Need to match

**Lock**
- Only CC spindle with sleeve
- Fully push down to engage hexagon driver
- Hexagon driver must be in top position

**Check before operation**
- Fully push down to engage hexagon driver
- Hexagon driver must be in top position

**Torque wrench for tool changing**

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

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**

<table>
<thead>
<tr>
<th>Capto size</th>
<th>Coromant Capto spindle with sleeve</th>
<th>Solid Coromant Capto spindle</th>
</tr>
</thead>
<tbody>
<tr>
<td>C3</td>
<td>8 mm</td>
<td>35 Nm</td>
</tr>
<tr>
<td>C4</td>
<td>8/10 mm</td>
<td>50 Nm</td>
</tr>
<tr>
<td>C5</td>
<td>12 mm</td>
<td>70 Nm</td>
</tr>
<tr>
<td>C6</td>
<td>12 mm</td>
<td>90 Nm</td>
</tr>
</tbody>
</table>

**Static toolholders**
- OD clamping unit
  - C6-R/LC-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-DFT-CT4500M-084086
  - C5-DFT-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.**

**Machines**
- Mazak Cybertech Turn 4500M, MT

**Coromant Capto®**
- Machine adapted clamping units
  - Standard program

**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**

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