Coromant Capto®
Machine Adapted Clamping Units
For Nakamura-Tome CNC lathes

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:
- SC250M, SC200L, SC300M
- WT-100, WT-150, WTS-150,
- WT-250II, WT-300, WTW-150,
- TW-10, TW-20 (12 and 16 stations)
- Super NTX, Super NTM,
- Super NT, Super NTX,
- Super NTY
Clamping unit configuration

Internal setup

External setup

Single clamping unit is also right handed.

Single clamping unit is also left handed.

Right hand cutting unit
Left hand cutting unit
Right hand clamping unit
Left hand clamping unit
Clockwise spindle rotation
Counter clockwise spindle rotation
Global standard products
Code key for Coromant Capto® machine adapted clamping units

- **Coromant Capto size**
  - C4 – 40 mm
  - C5 – 50 mm

- **Application**
  - T – Turning
  - D – Driven

- **Hand of clamping units**
  - L – Left
  - R – Right
  - N – Neutral

- **Type of operation**
  - E – External (OD)
  - I – Internal (face/ID)

- **Machine**
  - NA – Nakamura Tome

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

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

- **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)

- **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

- **Coupling size**
  - C3 – 1.260
  - C4 – 1.575
  - C5 – 1.969
  - C6 – 2.480
  - C8 – 3.150

- **Hand of clamping unit/type of unit**
  - RC = Right
  - LC = Left
  - NC = Neutral
  - DT = Driven Tool

- **Type of operation**
  - E = External
  - I = Internal

- **Machine model**
  - Example: NAK = Nakamura

- **Reference dimension**
  - Diameter in millimeters from reference point to center line of Coromant Capto coupling

- **Version**
  - A = New design
  - M = Modified from original

- **Coolant**
  - I = Internal coolant (DTH clamping units only)
  - Note: All static Capto clamping units have internal coolant.

- **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
  C3-DNI-NA55A0E
  C3-391.14-20 036 ER20

- OD clamping unit, both sides
  C3-R/LCE-NAK010-055060DT
  C3-DNI-NA55A0D

Driven toolholders
- OD drill/milling unit
  C3-DNE-NA55A-E
  C3-DNE-NA55A-I

- Face and ID clamping unit
  C3-R/LCI-NAK010-075020
  C3-391.14-20 036 ER20

- Face drill/milling unit, both sides, l_z=65
  C3-DNI-NA55A-E
  C3-DNI-NA55A-I

- OD clamping unit, both sides
  C3-R/LCE-NAK010-055060DT
  C3-DNI-NA55A0D

- Face and ID clamping unit, double half index, both sides
  C3-R/LCI-NAK010-082060TT

- OD drill/milling unit, l_z=65
  C3-DNE-NA55A-E
  C3-DNE-NA55A-I

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

- Face drill/milling unit, l_z=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-R/L, see code key page 4
Products beginning with Cx/L/IC, see code key page 5

Additional units 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 NTM®; 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

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

- Face drill/milling unit, both sides, l_z=65
  C3-DNI-NA55A0E
  C3-DNI-NA55A0I

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

- Face drill/milling unit, l_z=65
  C3-DNI-NA55A0E
  C3-DNI-NA55A0I

- OD clamping unit, double half index
  C3-R/LCE-NAK010-082060DDT

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-R/L, see code key page 4
Products beginning with Cx/L/IC, 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)
## Nakamura WT300: Super NTX (TW-20, 12 stations)

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

### Static toolholders

<table>
<thead>
<tr>
<th>Description</th>
<th>Code</th>
</tr>
</thead>
<tbody>
<tr>
<td>OD clamping unit</td>
<td>C4-TR/LE-NA65A</td>
</tr>
<tr>
<td>OD clamping unit, both sides</td>
<td>C4-TR/LE-NA65A-DT</td>
</tr>
<tr>
<td>Face and ID clamping unit</td>
<td>C4-TR/LI-NA65A</td>
</tr>
</tbody>
</table>

### Driven toolholders

<table>
<thead>
<tr>
<th>Description</th>
<th>Code</th>
</tr>
</thead>
<tbody>
<tr>
<td>OD drill/milling unit</td>
<td>C4-DNI-NA65A-E</td>
</tr>
<tr>
<td>OD drill/milling unit</td>
<td>C4-DNI-NA65A-I</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  
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  
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)

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## Nakamura Super NTJX

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

### Static toolholders

<table>
<thead>
<tr>
<th>Description</th>
<th>Code</th>
</tr>
</thead>
<tbody>
<tr>
<td>OD clamping unit</td>
<td>C3-R/LCE-NAK010-055060</td>
</tr>
<tr>
<td>OD clamping unit, both sides</td>
<td>C3-R/LCE-NAK010-055060DT</td>
</tr>
<tr>
<td>Face and ID clamping unit</td>
<td>C3-R/LCI-NAK010-085020</td>
</tr>
<tr>
<td>Face and ID clamping unit, back set</td>
<td>C3-R/LCI-NAK010-085015</td>
</tr>
</tbody>
</table>

### Driven toolholders

<table>
<thead>
<tr>
<th>Description</th>
<th>Code</th>
</tr>
</thead>
<tbody>
<tr>
<td>OD drill/milling unit</td>
<td>C3-DNI-NA55A-E</td>
</tr>
<tr>
<td>OD drill/milling unit</td>
<td>C3-DNI-NA55A-I</td>
</tr>
</tbody>
</table>

**Suggested collet chuck adapter for Coromant Capto to maximize tool projection**

Collet chuck adapter, short  
C3-391.14-20 036 ER20  
C3-391.14-25 038 ER25  
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  
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 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-NAK005-051053DT
- OD clamping unit, both sides
  C3 R/LCE-NAK005-047053DT
- Face and ID clamping unit
  C3 R/LCI-NAK005-073034

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 RCE-NAK005-14-20 036 ERZ0

Additional short adapters available through Extended Product Offer.

Operating instructions for Coromant Capto driven toolholders

Changing the cutting tool

Unlock
- Fully push down to engage hexagon driver

Lock
- Fully push down to engage hexagon driver
- Only CC spindle with sleeve

Check before operation
- Hexagon driver must be in top position

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></td>
<td>Wrench size</td>
<td>Torque Mₘ</td>
</tr>
<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>

Torque wrench for tool changing

<table>
<thead>
<tr>
<th>Coupling size</th>
<th>ft/lbs</th>
<th>Nm</th>
<th>Ordering code Torque wrench</th>
<th>Size mm</th>
<th>Spare parts</th>
<th>Key adapter</th>
</tr>
</thead>
<tbody>
<tr>
<td>C3</td>
<td>16</td>
<td>22</td>
<td>TW-3001</td>
<td>5</td>
<td>5680 035-08</td>
<td></td>
</tr>
<tr>
<td>C3</td>
<td>26</td>
<td>35</td>
<td>BT-TK-02</td>
<td>8</td>
<td>5680 035-05</td>
<td></td>
</tr>
<tr>
<td>C4</td>
<td>37</td>
<td>50</td>
<td>C-TK-01</td>
<td>10</td>
<td>5680 035-06</td>
<td></td>
</tr>
<tr>
<td>C5</td>
<td>52</td>
<td>70</td>
<td>C-TK-01</td>
<td>12</td>
<td>5680 035-07</td>
<td></td>
</tr>
<tr>
<td>C6</td>
<td>66</td>
<td>90</td>
<td>C-TK-01</td>
<td>12</td>
<td>5680 035-07</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.

Suggested collet chuck adapter for Coromant Capto to maximize tool projection
Collet chuck adapter, short
C3 RCE-NAK005-14-20 036 ERZ0

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/L, 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)

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