Coromant Capto®
Machine Adapted Clamping Units
For Okuma 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:
- Genos L200 M, EM, MY
- Genos L300 M, E-M, MY, MW, MVW
- Genos L400
- Space Turn LB2000 EX M, MY
- Space Turn LB3000 EX M, MY
- Space Turn LB4000 EX M, MY
- LB200-M, LB200-MY
- LB300-M, LB300-MY
- LT300-M, LT300-MY
- Maclturn 350
- LB300-M, LB300-MY
- LB400-M
- LB400-M
- LU35-M
- LU45-M
- LB35II-M (1-step)
- LU-45M
- ES-L8
- LT300-M, LT300-MY
- LB300-M, LB300-MY
- LU300-M, LU300-MY
- ES-L10
- L370-M
- LU400-M
- LU400-M
- L470-M
- LU35-M
- LB35II-M (1-step)
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
- **TR**: Clockwise spindle rotation
- **L**: Counter clockwise spindle rotation
### U.S. local products

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

#### Static holders

1. **Coupling size**
   - C4: 40 mm
   - C5: 50 mm

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: LB2000 = Okuma LB2000EX

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)
   - DY = for machines with 'Y' axis (four clamping units in one holder)
   - SP = short projection

#### Driven tool holders

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

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

3. **Machine model**
   - Example: LB2000 = Okuma LB2000EX

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

5. **Reference dimension**
   - Gauge line in millimeters from reference point to face of Coromant Capto coupling

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

7. **Coolant**
   - I = Internal coolant (DTH clamping units only)

8. **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)
   - SP = short projection

### Global standard products

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

<table>
<thead>
<tr>
<th>C5</th>
<th>D</th>
<th>N</th>
<th>I</th>
<th>OK</th>
<th>60</th>
<th>A</th>
<th>DT</th>
<th>I</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>2</td>
<td>3</td>
<td>4</td>
<td>5</td>
<td>6</td>
<td>7</td>
<td>8</td>
<td>9</td>
</tr>
</tbody>
</table>

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**
   - OK = Okuma

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

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

8. **Configuration**
   - Blank = for normal single clamping unit
   - DT = for main spindle and subspindle (two clamping units in one holder)
   - ET = extended
   - DE = extended for main spindle and subspindle (two clamping units in one holder)
   - TT = for machine with half index turret (two clamping units in one holder)
   - YT = for machines with ‘Y’ axis (two clamping units in one holder)
   - DY = for machines with ‘Y’ axis (four clamping units in one holder)
   - SS = for subspindle
   - SP = short projection
   - XT = two clamping units in one holder (change tools with X axis)

9. **Coolant supply (driven tools only)**
   - I = internal and external (1160 PSI [80 bar])
   - E = external only

### Code key

- **C4** = 40 mm
- **C5** = 50 mm
- **D** = Driven
- **N** = Neutral
- **I** = Internal
- **OK** = Okuma
- **60** = Turret hole diameter (60 mm)
- **A** = Application
- **DT** = Driven Tool
- **I** = Internal (face/ID)
- **RC** = Right
- **E** = External
- **LB2000** = Machine model
- **024** = Turret interface version
- **065** = Turret interface version
- **D** = Drive
Coromant Capto®
Machine adapted clamping units
Standard program

Static toolholders

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

Face and ID clamping unit
C4-R/LCI-GS400-008015
C5-R/LCI-GS400-008015

Ordering example:
C4-R/LCE-GS400-008015 (right hand unit)
C4-R/LCI-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

Driven toolholders

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

Face drill/milling unit
C4-DNI-OK60A-E
C4-DNI-OK60A-I *

Ordering example:
C4-DRE-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)

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
- OD clamping unit
  C5-TR/LE-OK60B
- OD clamping unit, 32mm "Y" axis
  C5R/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-DNI-OK60B E
  C4-DNI-OK60B1 *
- OD drill/milling unit
  C4-DNE-OK60B E
  C4-DNE-OK60B1 *

Suggested collet chuck adapter for Coromant Capto to maximize tool projection
- Collet chuck adapter, short
  C3-391.14-20 035 ER20
  C4-391.14-25 038 ER25

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)

Driven toolholders
- Face drill/milling unit
  C3-DNI-LB200M-000072
  C3-DNI-LB200M-000072I *
- Straight drill/milling unit
  C3-DTL-LB200M-085008I *

Suggested collet chuck adapter for Coromant Capto to maximize tool projection
- Collet chuck adapter, short
  C3-391.14-20 036 ER20

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
- Additional short adapters available through Extended Product Offer.
- 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)
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 *
- OD clamping unit
  - C4-R/LC2040-00075M
- 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:**
Collet chuck adapter, short
- C4-391.14-20 035 ER20
- C4-391.14-25 038 ER25

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)

Additional short adapters available through Extended Product Offer.

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

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.
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-075160I *
- Face and ID clamping unit
  C5-R/LC2050-000110
  C5-R/LC2050-000110I **
- OD clamping unit
  C5-R/LC2050-43040M

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-DTE-LU35M-124035I *
- C5-DTE-LU35M-129025I *

Additional short adapters available through Extended Product Offer.

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

Driven toolholders
- Straight drill/milling unit
  C5-DTI-LU45M-075160I *
- Straight offset drill/milling unit
  C5-DTI-LU45M-000110
  C5-DTI-LU45M-000110I **
- OD clamping unit
  C5-R/LC2060-53040

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-DTE-LU45M-124035
- C5-DTE-LU45M-124035I *

Additional short adapters available through Extended Product Offer.

* 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.
Operating instructions for Coromant Capto driven toolholders

Changing the cutting tool

Unlock

Lock

Check before operation

Unlock + lock:

Turn hexagon
driver around
approx. 140°

Fully push
down to engage
hexagon driver

Need to match

Fully push
down to engage
hexagon driver

Need to match

Hexagon driver
must be in top
position

Torque setting and wrench size

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.

Torque wrench for tool changing

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

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

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 – 180° reversible
C4-DTI-LT300-090060
C4-DTI-LT300-090060I *

Face and ID clamping unit – 180° reversible used for left or right spindle
C4-DTI-LT300-090064DT

Ordering example:
C4-RCE-LT300-030080DT (right hand unit)
C4-RCE-LT300-030080DF (left hand unit)
Products beginning with Cx/R/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)

Torque wrench and key adapter

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

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

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