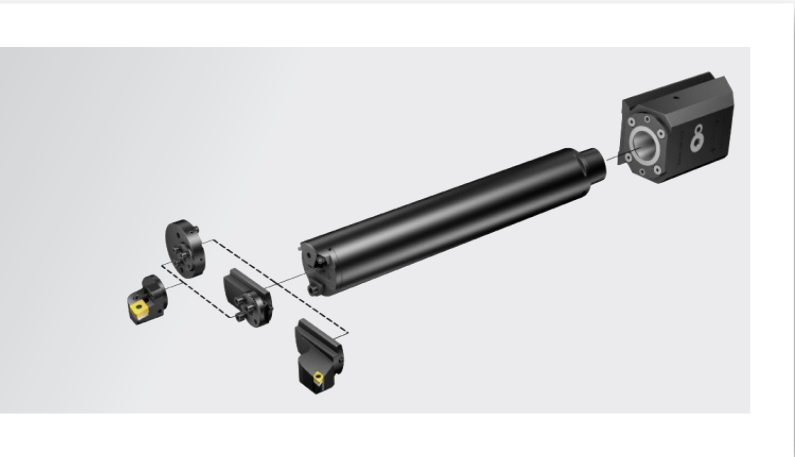


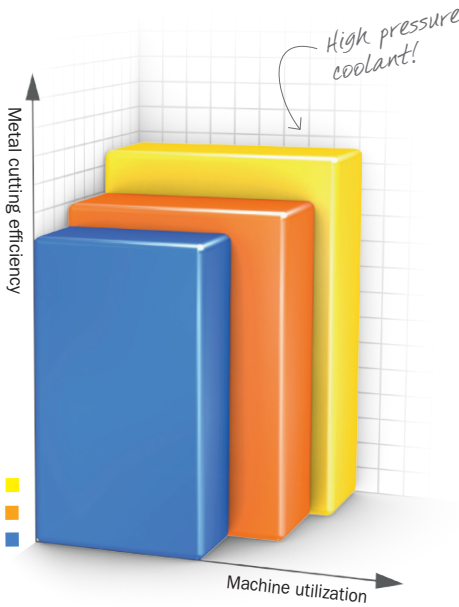
Machine utilization

Heavy duty & flat bed lathes offer extremely high stability but slow tool indexing and changing . Shank tool holders are very heavy and with the limited number of tool positions with dovetail turrets, quick change has a dramatic effect on machine efficiency.

Using quick change will reduce the measuring, set up and tool change time allowing considerably extra metal cutting time.

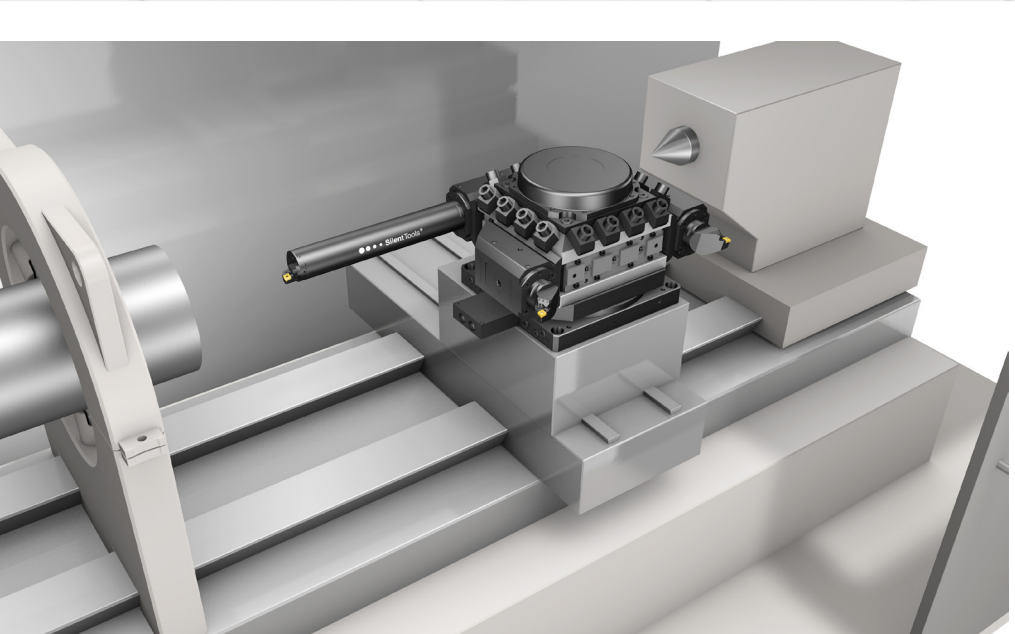
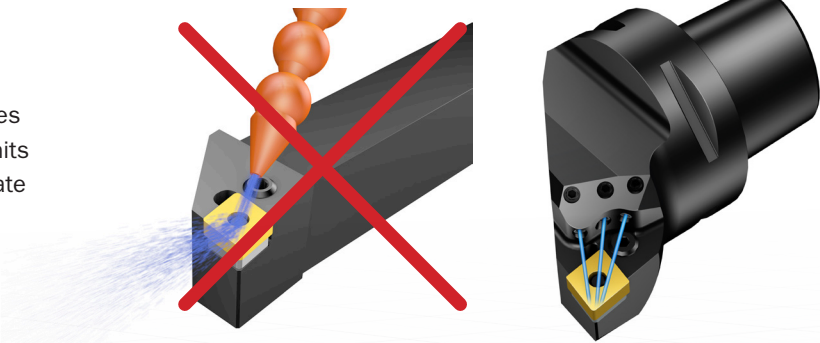


High Pressure coolant
Quick change
Normal production

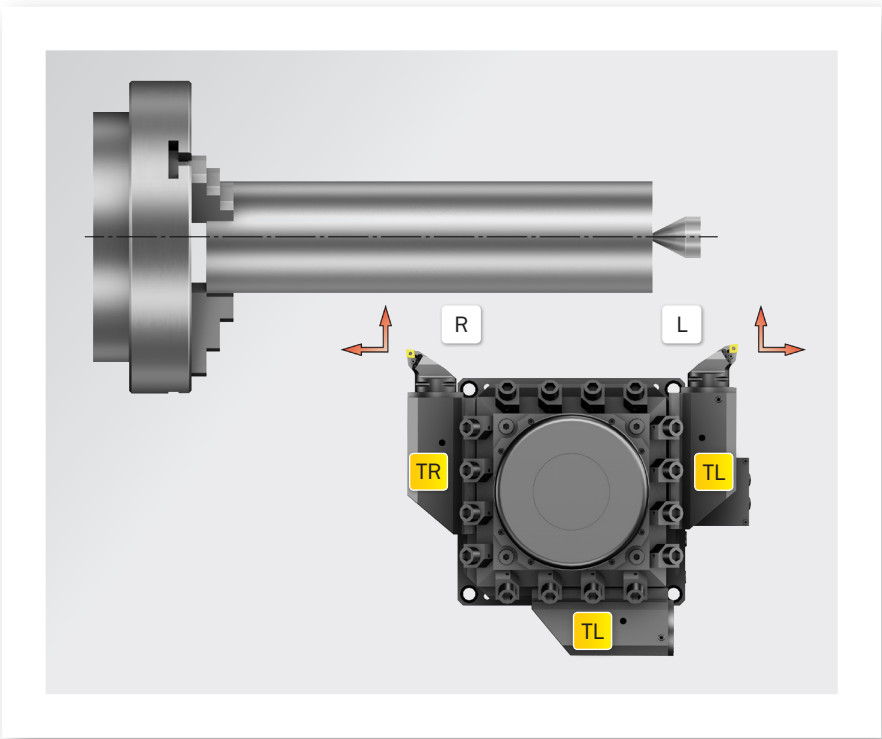


The advantages with long boring bars are doubled with dampened solutions up to 10xD and quick change allowing tool change with 2µm accuracy in less than 1 minute.

Through coolant delivery ensures that the full capabilities of the machine are harnessed with optimized cutting units to deliver the coolant with maximum impact and eliminate setting and chip removal.

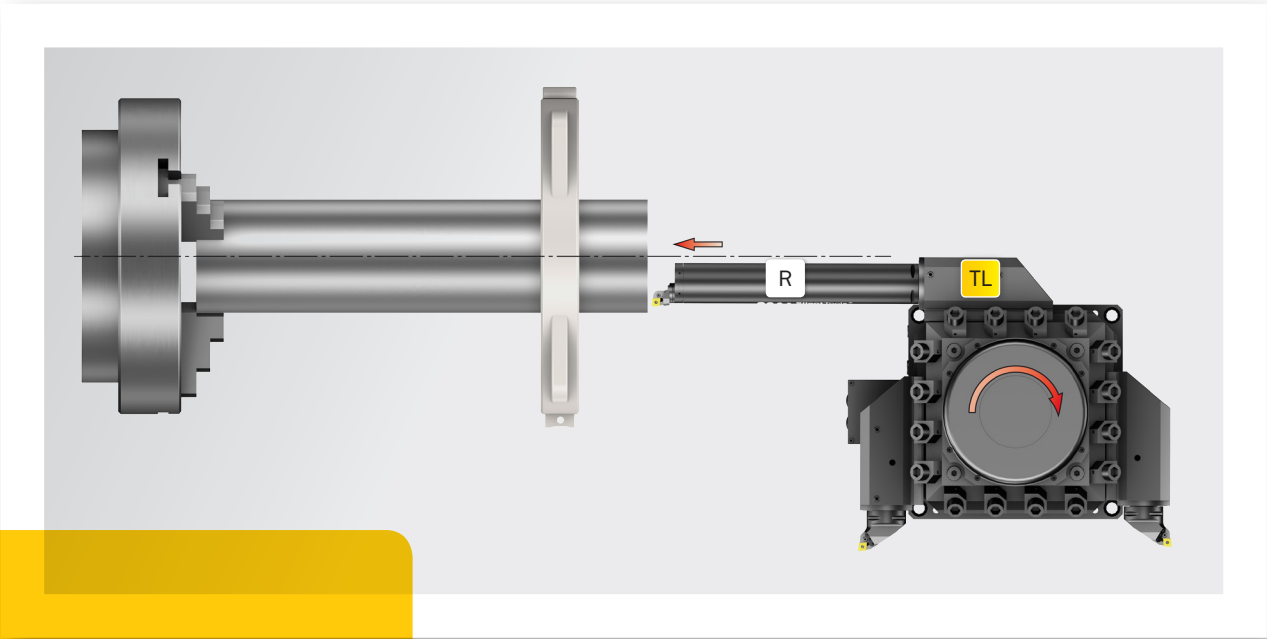


Clamping unit configuration



External setup

Internal setup



- R Right-hand cutting unit
- L Left-hand cutting unit
- TR Right hand clamping unit
- TL Left hand clamping unit

Program

For VDI turrets DIN 69881

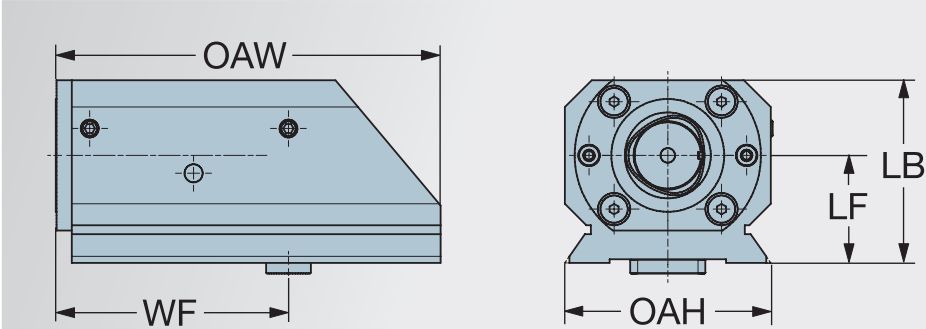
As tools are heavy, tool change is time-consuming and difficult, often 15-20 kg. A typical change of a shank tool takes 15 minutes plus a measuring cut. With Coromant Capto® quick change, you reduce tool change time to 1 minute and benefit from lighter tool holders below 5 kg.


The dovetail holders are available in sizes 115 mm and 140 mm

- VDI 140 – C6, C8, C10 – long and short design
- VDI 110 – C6



Right hand version shown



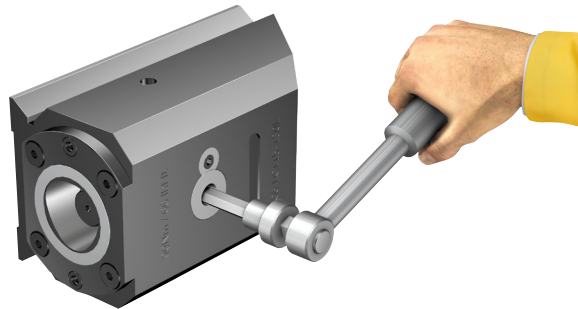
dm _m , size, mm	Coromant Capto size	Ordering code	LB, mm				
			OAW	OAH	WF	LB	
115	C6	C6-R/LC115-130L	215	115	130	102	13.9
140	C6	C6-R/LC140-165L	310	140	165	102	22.2
140	C8	C8-R/LC140-165L	310	140	165	120	27.2
140	C6	C6-R/LC140-205L	350	140	205	102	25.5
140	C8	C8-R/LC140-205L	350	140	205	120	31.7
140	C10	C10-R/LC140-205L	350	140	205	153	40

Contact your local Sandvik Coromant representative for other design requirements

R = Right hand, L = Left hand

Use of torque wrench is always advised for easiest handling and best precision

Coromant Capto® size	Clamping torque (Nm)	Adaptor key	Hex size (mm)	Torque wrench
C6	90	5680 035-07	12	C-TK-01
C8	130	5680 035-07	12	C-TK-02
C10	285	5680 035-10	17	C-TK-03



Coromant Capto® tooling

The right tooling can lead to even greater savings

Using the right tools can lead to better performance and utilization of the machine, and ultimately lead to even greater cost savings. Savings come from process improvements, such as increasing cutting speeds, or extending the time between tool changes through use of a longer-lasting insert grade.

The Coromant Capto coupling is available in an extensive range of tools proven to increase productivity in every application.

Even more importantly, new Sandvik Coromant tooling technology is developed with the Coromant Capto coupling, making the system a wise investment towards the long-term profitability of your shop.



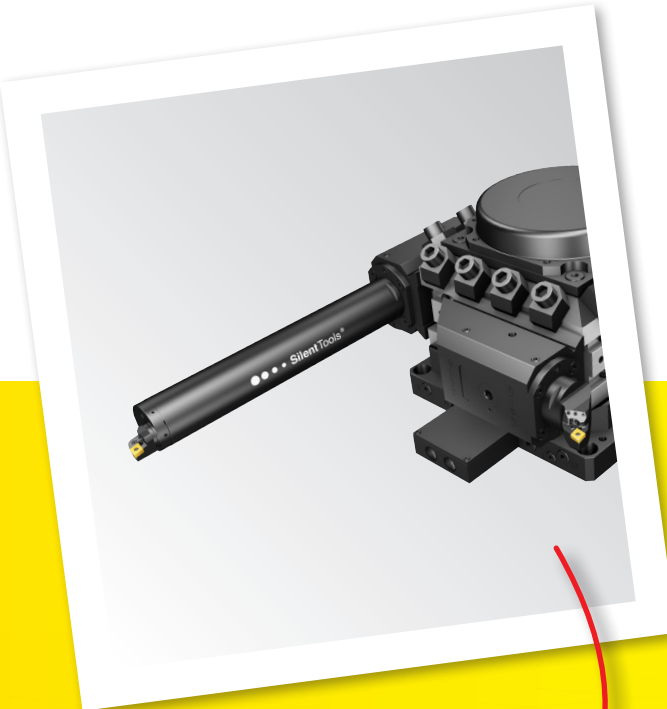
How much can you save?

Visit www.payback-calculator.com and click on productivity calculators today.



Quick change

Clamping units for flat bed lathes
VDI 'Dovetail' – DIN 69881



over 2000 standard turning products ensure you have the right tool for every component when you need it.

Head office:
AB Sandvik Coromant
SE-811 81 Sandviken, Sweden
www.sandvik.coromant.com
E-mail: info.coromant@sandvik.com

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Your success in focus

