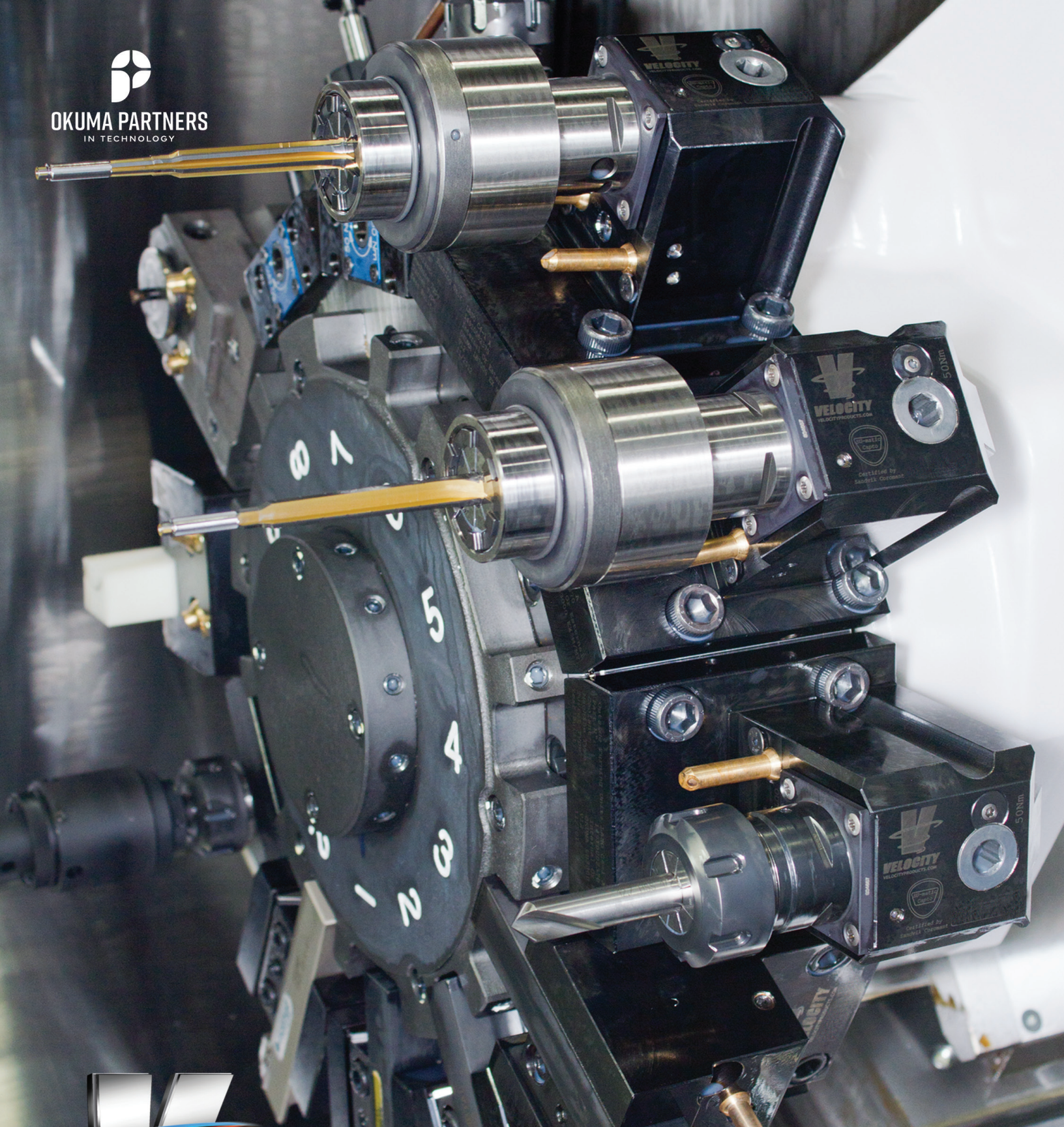




OKUMA PARTNERS
IN TECHNOLOGY



VELOCITY

VELOCITYPRODUCTS.COM



A Complete Lineup of In-Stock Lathe Tooling for Okuma • Three Year Warranty

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

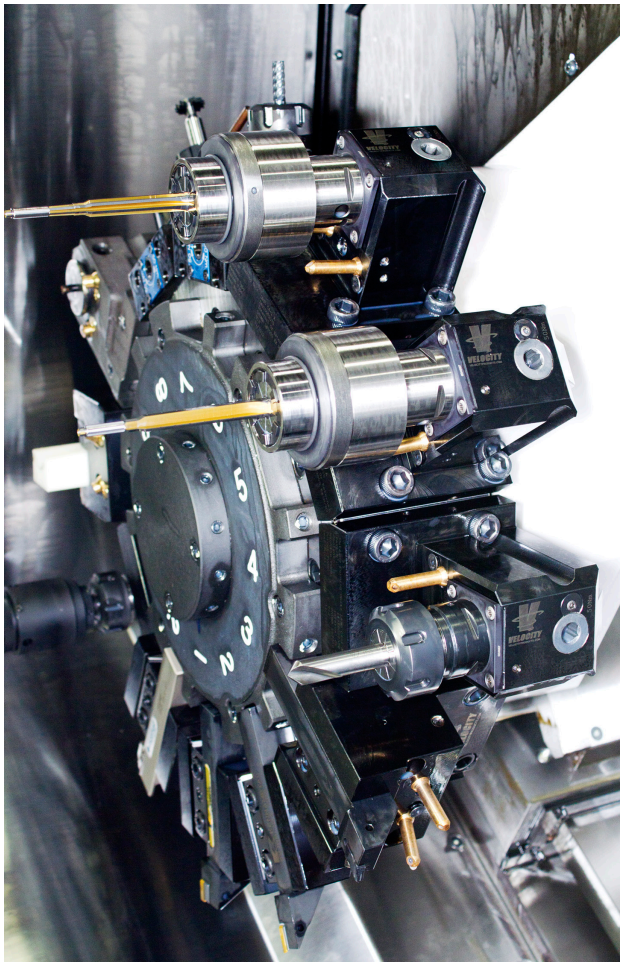
VELOCITY

Velocity Tooling: Exclusively for Okuma

Velocity Products, a leading supplier in the machine tool industry, is proud to offer the most comprehensive inventory of lathe tooling for Okuma in North America. As the official OEM supplier of startup tooling kits for Okuma lathes, Velocity Products has established a strong reputation for quality and reliability. Developed in Switzerland, Velocity tooling is created through close collaboration with engineers from Okuma America, Okuma Japan, and Okuma Europe. This ensures impeccable performance on Okuma lathes, multitasking machines, and machining centers. This premium tooling is available exclusively for Okuma machine tools.

Innovative Velocity Tooling Technology

Velocity tools are designed with convenience and efficiency in mind. Upon delivery, all live tools have already undergone a thorough run-in process at the factory, ensuring optimal performance. Internal coolant tools are pressure tested for quality assurance before shipping, providing confidence in their durability and reliability. Velocity tools are greased for life, which eliminates the need for customer maintenance and saves valuable time and resources. For further quality control, all tools are inspected using Coordinate Measuring Machines (CMM) and serialized records are maintained for future reference and traceability.



Three-Year Warranty

Velocity Tooling is meticulously designed for longevity and durability, even under the most demanding applications. The exceptional build quality of these tool holders is backed by a Three-Year Factory Warranty, demonstrating Velocity's commitment to customer satisfaction. Within three years from the date of purchase, Velocity pledges to repair any defective tool holder, ensuring that customers can invest in their products with confidence.

Continuous Improvement and Customer Support

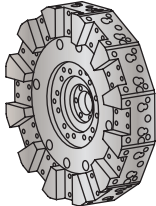
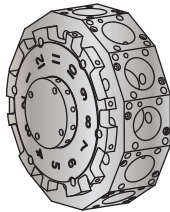









Velocity Products is dedicated to continuous improvement and innovation, staying up-to-date with the latest trends and technologies in the machine tool industry. By maintaining open lines of communication with Okuma engineers around the world, Velocity is able to promptly address any issues and adapt its products to better serve the needs of Okuma machine operators. Additionally, Velocity offers comprehensive customer support, providing technical assistance, training, and guidance to ensure the best possible user experience.

Velocity offers an exclusive and comprehensive solution for Okuma machine tools, with a focus on quality, innovation, and customer satisfaction. By combining cutting-edge technology, exceptional build quality, and unparalleled support, Velocity Products provides Okuma machine operators with the tools they need to succeed in a competitive market.

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

2SP-2500H/HM Tooling Kits



2SP-2500H (12) Position L-Turret		2SP-2500H (12) Position M-Turret			
					
Description		Static Kit • L Turret	Static Kit • M Turret	Live Tooling Kits	
Tool Type Tool Size Velocity #	Turret / Type	2SP-2500H L	2SP-2500H M	External Coolant	Internal Coolant
	Part # OAC	KUP-1173-00	KUP-1174-00	KUP-1175-00	KUP-1176-00
	Part # Velocity	14.430.0.0212.0	14.430.0.0213.0	14.430.0.0214.0	14.430.0.0215.0
ID 1.5" 14.910.0.0500.0		4	4		
Offset ID 1.5" 14.910.0.0502.0		2	2		
OD-I 1" 14.910.0.0496.0		6	6		
OD-II 1" 14.910.0.0498.0		2	2		
Turret Plugs V01-D0-0511			10		
Face Tool (EXT) ER-32 14.101.0.0370.0				2	
Cross Tool (EXT) ER-32 14.800.0.0472.0				2	
Face Tool (IC) ERC-32 14.101.0.0369.0					2
Cross Tool (IC) ERC-32 14.800.0.0471.0					2

2SP-2500 H/HM turrets are mounted at 90° to spindles, so OD and live tool designations are opposite from tools on other machines.

VELOCITY

VELOCITYPRODUCTS.COM

www.velocityproducts.com • 256-258-5549 • FAX: 256-461-8164 • sales@velocityproducts.com

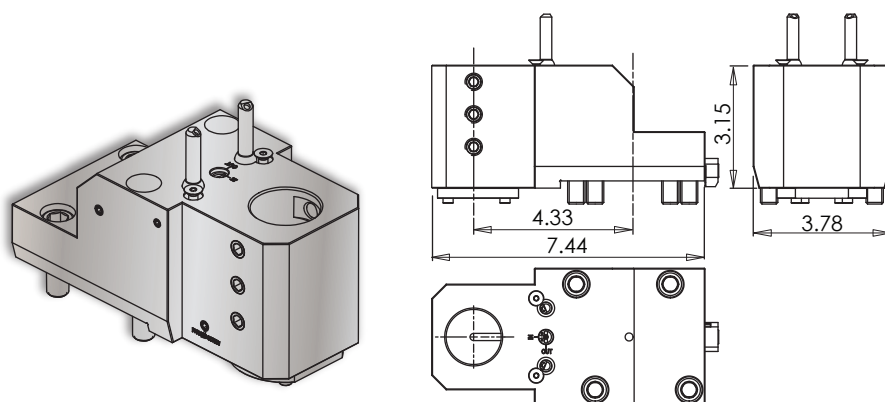
VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

2SP-2500H/HM Tools



2SP-2500H/HM ID Holder

Notes



VELOCITY ID holders can be used with both internal and external coolant. **Internal Coolant Plates** are included with all **VELOCITY** multitasking turret ID holders.

Turret Plugs

V01-D0-0511

VELOCITY tooling for **OKUMA** is manufactured on **OKUMA** machine tools.

Coolant filtration is recommended when using ID holders with internal coolant plates.

Tool

Reversible (Main/Sub)

Coolant

ID

14.910.0.0500.0

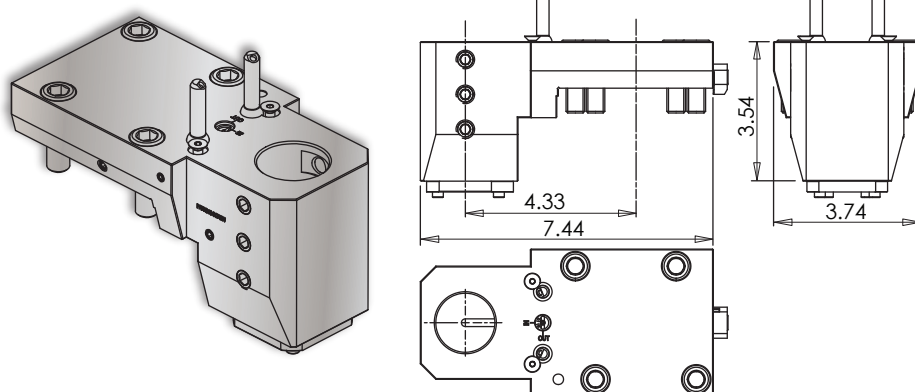
No

IC/EXT

1.5"

2SP-2500H/HM Offset ID Holder

Notes



VELOCITY ID holders can be used with both internal and external coolant. **Internal Coolant Plates** are included with all **VELOCITY** multitasking turret ID holders.

Turret Plugs

V01-D0-0511

VELOCITY tooling for **OKUMA** is manufactured on **OKUMA** machine tools.

Coolant filtration is recommended when using ID holders with internal coolant plates.

Tool

Reversible (Main/Sub)

Coolant

ID

14.910.0.0502.0

No

IC/EXT

1.5"

VELOCITY

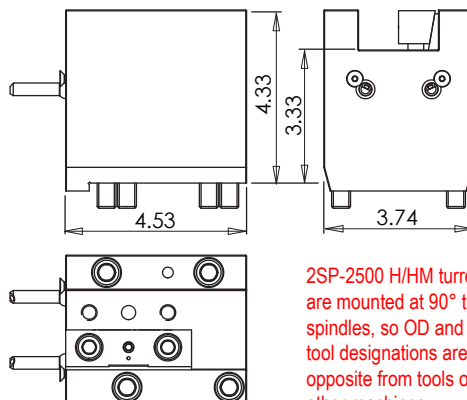
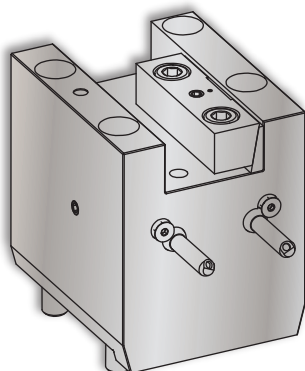
VELOCITYPRODUCTS.COM

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

2SP-2500H/HM Tools



2SP-2500H/HM OD-I Holder



2SP-2500 H/HM turrets are mounted at 90° to spindles, so OD and live tool designations are opposite from tools on other machines.

Notes

3D Models (.stp) and CAS (.stl) files are available for all **VELOCITY** tool holders. Please contact Velocity: sales@velocityproducts.com.

Turret Plugs

V01-D0-0511

VELOCITY tooling for **OKUMA** is manufactured on **OKUMA** machine tools.

VELOCITY has the most complete inventory of tooling for **OKUMA** machine tools in North America.

Tool

14.910.0.0496.0

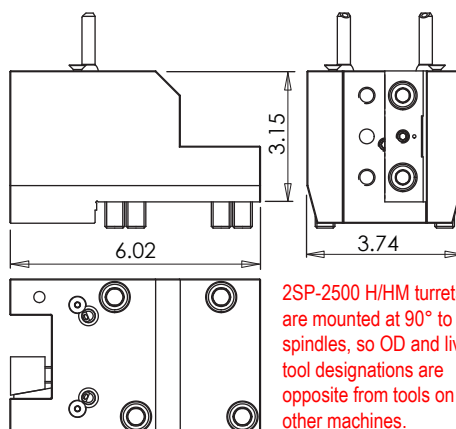
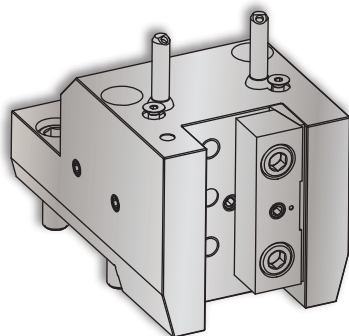
Reversible (Main/Sub)

No

Stick Size

1.0"

2SP-2500H/HM OD-II Holder



2SP-2500 H/HM turrets are mounted at 90° to spindles, so OD and live tool designations are opposite from tools on other machines.

Notes

3D Models (.stp) and CAS (.stl) files are available for all **VELOCITY** tool holders. Please contact Velocity: sales@velocityproducts.com.

Turret Plugs

V01-D0-0511

VELOCITY tooling for **OKUMA** is manufactured on **OKUMA** machine tools.

VELOCITY has the most complete inventory of tooling for **OKUMA** machine tools in North America.

Tool

14.910.0.0498.0

Reversible (Main/Sub)

No

Stick Size

1.0"

VELOCITY

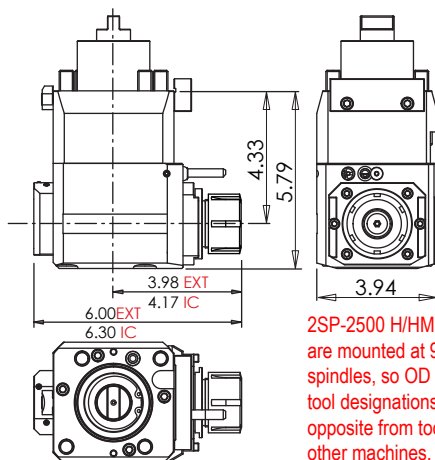
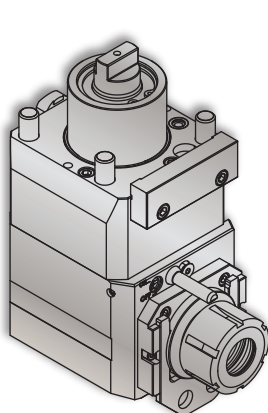
VELOCITYPRODUCTS.COM

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

2SP-2500HM Tools



2SP-2500HM Cross Tools • ER-32 Outputs



2SP-2500 H/HM turrets are mounted at 90° to spindles, so OD and live tool designations are opposite from tools on other machines.

Notes

Wrenches Included with Tools

Maximum Drill Ø		Maximum Mill Ø	
EXT	13/16"	EXT	23/32"
IC	3/4"	IC	23/32"

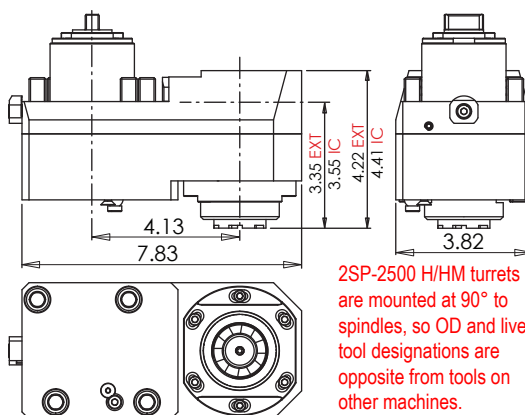
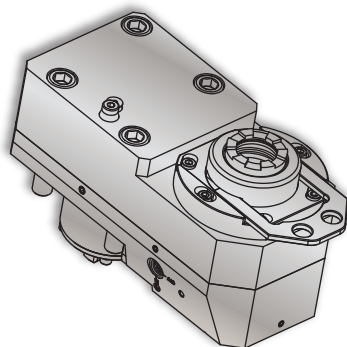
Turret Plugs V01-D0-0511

* 1,450 psi internal coolant (IC) cross tool **CAN** be run without coolant; the coolant sealing mechanism can be completely dis-engaged.

All coolant thru live tools require 30 micron coolant filtration nominal, 50 micron coolant filtration absolute.

Tool #	Coolant	Output	Rotation (In:Out)	Ratio (In:Out)	Max. RPM	Torque	Spindle Wrench	Collet Wrench
14.800.0.0472.0	EXT	ER-32	CW:CW	1:1	6,000	60 Nm	Special	7111.32000
14.800.0.0471.0	IC & EXT* 1,450 psi	ERC-32	CW:CW	1:1	6,000	60 Nm	Special	7111.32000

2SP-2500HM Face Tools • ERAX-32 Outputs



2SP-2500 H/HM turrets are mounted at 90° to spindles, so OD and live tool designations are opposite from tools on other machines.

Notes

Wrenches Included with Tools

Maximum Drill Ø		Maximum Mill Ø	
EXT	13/16"	EXT	23/32"
IC	3/4"	IC	23/32"

Turret Plugs V01-D0-0511

* 1,450 psi internal coolant (IC) face tool **CAN** be run without coolant; the coolant sealing mechanism can be completely dis-engaged.

All coolant thru live tools require 30 micron coolant filtration nominal, 50 micron coolant filtration absolute.

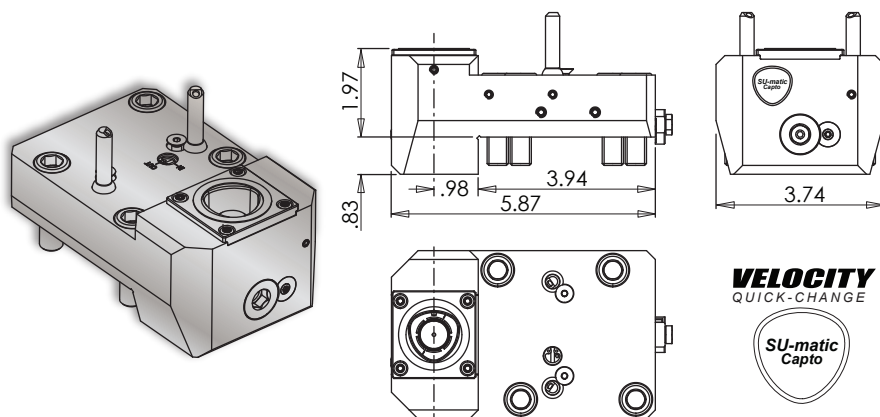
Tool #	Coolant	Output	Rotation (In:Out)	Ratio (In:Out)	Max. RPM	Torque	Spindle Wrench	Collet Wrench
14.101.0.0370.0	EXT	ERAX-32	CW:CW	1:1	6,000	60 Nm	Special	7117.32000
14.101.0.0369.0	IC & EXT* 1,450 psi	ERAXC-32	CW:CW	1:1	6,000	60 Nm	Special	7117.32000

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

2SP-2500H/HM Quick Change



2SP-2500H/HM C4 ID Holder



Notes

REGO-FIX® C4 Collet Chucks

ER Output	Rego-Fix Part #
ER-16	2804.11630
ER-20	2804.12010
ER-25	2804.12510
ER-32	2804.13210

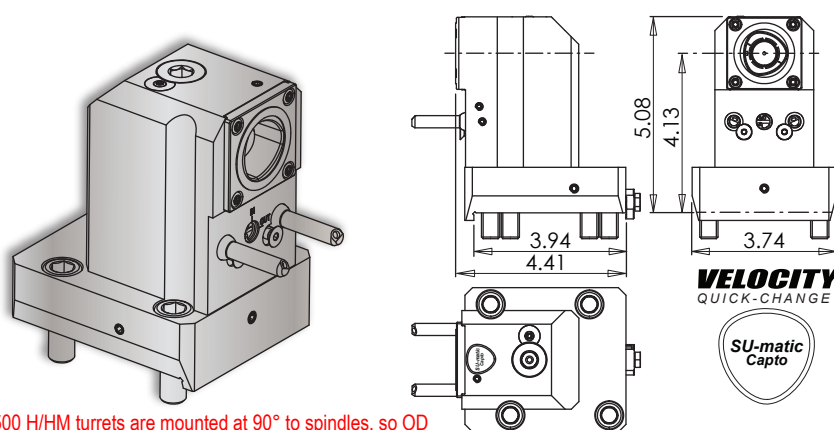
Turret Plugs V01-D0-0511

VELOCITY tooling for **OKUMA** is manufactured on **OKUMA** machine tools.

Quick Change static tools are coolant thru. Coolant filtration is recommended.

Tool #	Reversible (Main/Sub)	Coolant	Output	Hex Wrench	C4 Collet Chucks
14.910.0.0525.0	Yes	IC/EXT	C4	10 mm	See Above

2SP-2500H/HM C4 OD-I Holder



2SP-2500 H/HM turrets are mounted at 90° to spindles, so OD and live tool designations are opposite from tools on other machines.

Notes

REGO-FIX® C4 Collet Chucks

ER Output	Rego-Fix Part #
ER-16	2804.11630
ER-20	2804.12010
ER-25	2804.12510
ER-32	2804.13210

Turret Plugs V01-D0-0511

VELOCITY tooling for **OKUMA** is manufactured on **OKUMA** machine tools.

Quick Change static tools are coolant thru. Coolant filtration is recommended.

Tool #	Reversible (Main/Sub)	Coolant	Output	Hex Wrench	C4 Collet Chucks
14.910.0.0530.0	No	IC/EXT	C4	10 mm	See Above

VELOCITY

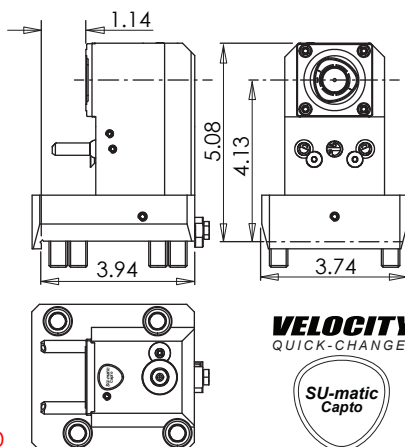
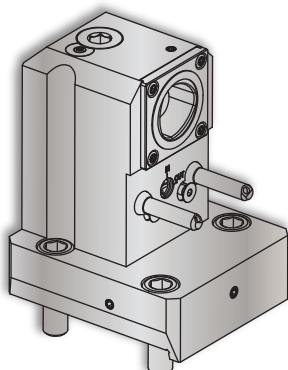
VELOCITYPRODUCTS.COM

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

2SP-2500H/HM Quick Change



2SP-2500H/HM C4 Offset OD-I Holder



2SP-2500 H/HM turrets are mounted at 90° to spindles, so OD and live tool designations are opposite from tools on other machines.

Notes

REGO-FIX® C4 Collet Chucks

ER Output	Rego-Fix Part #
ER-16	2804.11630
ER-20	2804.12010
ER-25	2804.12510
ER-32	2804.13210

Turret Plugs V01-D0-0511

VELOCITY tooling for **OKUMA** is manufactured on **OKUMA** machine tools.

Quick Change static tools are coolant thru. Coolant filtration is recommended.

Tool #	Reversible (Main/Sub)	Coolant	Output	Hex Wrench	C4 Collet Chucks
14.910.0.0531.0	Yes	IC/EXT	C4	10 mm	See Above

VELOCITY

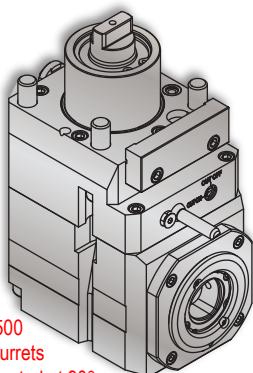
VELOCITYPRODUCTS.COM

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

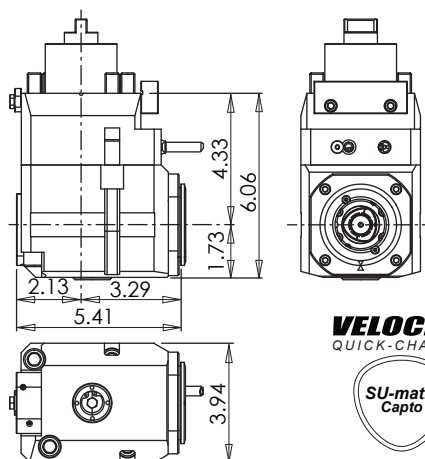
2SP-2500H/HM Quick Change



2SP-2500HM C4 Cross Tool



2SP-2500 H/HM turrets are mounted at 90° to spindles, so OD and live tool designations are opposite from tools on other machines.



VELOCITY
QUICK-CHANGE



Notes

REGO-FIX® C4 Collet Chucks

ER Output	Rego-Fix Part #
ER-16	2804.11630
ER-20	2804.12010
ER-25	2804.12510
ER-32	2804.13210

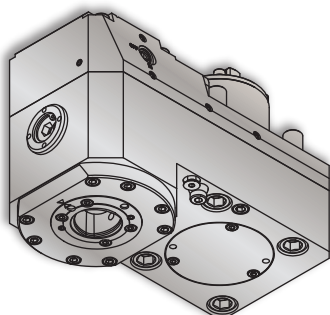
Turret Plugs V01-D0-0511

* 1,000 psi internal coolant (IC) cross tool **CANNOT** be run without coolant.

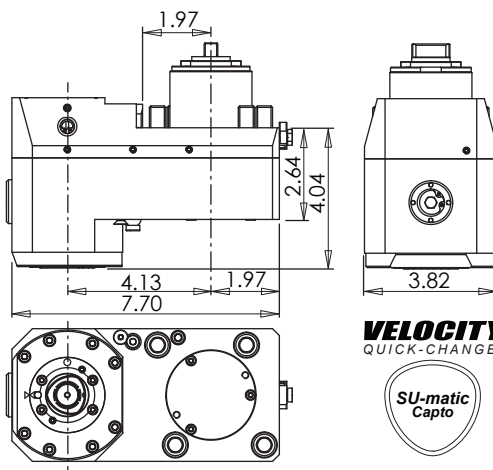
All coolant thru live tools require 30 micron coolant filtration nominal, 50 micron coolant filtration absolute.

Tool #	Coolant	Output	Rotation (In:Out)	Ratio (In:Out)	Max. RPM	Torque	Hex Wrench	C4 Collet Chucks
14.800.0.0517.0	IC & EXT* 1,450 psi	C4	CW:CW	1:1	6,000	60 Nm	10 mm	See Above

2SP-2500HM C4 Face Tool



2SP-2500 H/HM turrets are mounted at 90° to spindles, so OD and live tool designations are opposite from tools on other machines.



VELOCITY
QUICK-CHANGE



Notes

REGO-FIX® C4 Collet Chucks

ER Output	Rego-Fix Part #
ER-16	2804.11630
ER-20	2804.12010
ER-25	2804.12510
ER-32	2804.13210

Turret Plugs V01-D0-0511

* 1,450 psi internal coolant (IC) face tool **CAN** be run without coolant; the coolant sealing mechanism can be completely dis-engaged.

All coolant thru live tools require 30 micron coolant filtration nominal, 50 micron coolant filtration absolute.

Tool #	Coolant	Output	Rotation (In:Out)	Ratio (In:Out)	Max. RPM	Torque	Hex Wrench	C4 Collet Chucks
14.101.0.0395.0	IC & EXT* 1,450 psi	C4	CW:CW	1:2	12,000	20 Nm	10 mm	See Above

VELOCITY

VELOCITYPRODUCTS.COM

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

Rego-Fix® Accessories

OKUMA

VELOCITY / REGO-FIX® Inch Collets

Size (Inch)	ER-16		ER-20		ER-25		ER-32		ER-40	
	Standard ER Collets	Coolant Through ER Collets	Standard ER Collets	Coolant Through ER Collets	Standard ER Collets	Coolant Through ER Collets	Standard ER Collets	Coolant Through ER Collets	Standard ER Collets	Coolant Through ER Collets
1/16"	1116.01592									
3/32"	1116.02382									
1/8"	1116.03182	1216.03182	1120.03182	1220.03182	1125.03182		1132.03182		1140.03182	
5/32"	1116.03972									
3/16"	1116.04762	1216.04762	1120.04762	1220.04762	1125.04762		1132.04762		1140.04762	
7/32"	1116.05562									
1/4"	1116.06352	1216.06352	1120.06352	1220.06352	1125.06352	1225.06352	1132.06352	1232.06352	1140.06352	
9/32"	1116.07142									
5/16"	1116.07942	1216.07942	1120.07942	1220.07942	1125.07942	1225.07942	1132.07942	1232.07942	1140.07942	
11/32"	1116.08732									
3/8"	1116.09532	1216.09532	1120.09532	1220.09532	1125.09532	1225.09532	1132.09532	1232.09532	1140.09532	1240.09532
13/32"	1116.10322									
7/16"			1120.11112	1220.11112	1125.11112	1225.11112	1132.11112	1232.11112	1140.11112	1240.11112
1/2"			1120.12702	1220.12702	1125.12702	1225.12702	1132.12702	1232.12702	1140.12702	1240.12702
9/16"					1125.14292	1225.14292	1132.14292	1232.14292	1140.14292	1240.14292
5/8"					1125.15882	1225.15882	1132.15882	1232.15882	1140.15882	1240.15882
11/16"							1132.17462	1232.17462	1140.17462	1240.17462
3/4"							1132.19052	1232.19052	1140.19052	1240.19052
13/16"							1132.20642		1140.20642	1240.20642
7/8"									1140.22232	1240.22232
1"									1140.25402	1240.25402
Collet Set	(12) Collets 1116.00002	(5) Collets 1216.00002	(7) Collets 1120.00002	(7) Collets 1220.00002	(9) Collets 1125.00002	(7) Collets 1225.00002	(12) Collets 1132.00002	(9) Collets 1232.00002	(14) Collets 1140.00002	(10) Collets 1240.00002

VELOCITY

VELOCITYPRODUCTS.COM

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

Tooling and Accessories for Okuma Machines

OKUMA

VELOCITY/MP SYSTEMS VMP-8 DIFFERENTIAL COOLANT FILTER

All Internal Coolant Tools Require Coolant Filtration!

External coolant tools - and static tools - can also benefit from coolant filtration. **Swarf can find its way into all static and live tools** and clog coolant nozzles, degrade seals between the mounting plate and tool body of live tools, an eventually damage the bearings of live tools. Swarf can also clog coolant lines in the manifold of a lathe turret. **MP Systems**, a sister company of Velocity Products, is renowned for their high-pressure coolant systems and accessories. MP Systems has designed a standalone **VMP-8 Differential Coolant Filter** that is tied to a machine tool alarm circuit to protect Velocity Quick Change Tooling - and a machine tool - from damage caused by swarf in coolant or cutting oil.

The **Velocity/MP Systems VMP-8 Differential Coolant Filter** works by filtering swarf from coolant or cutting oil in a machine tool coolant tank before the coolant or cutting oil goes into the lock lines. The VMP-8 Filter specifications are 5µm nominal, 50µm absolute. the VMP-8 Differential Coolant Filter is equipped with a switch that will alarm out the machine tool when there is a pressure differential of 25 psi (indicating that the filter bag needs replacement.) Installation of the VMP-8 Differential Coolant Filter is simple on machine tools with a maximum standard coolant pump pressure of 125 psi. The VMP-8 Differential Coolant Filter can be used in conjunction with MP High Pressure Coolant Systems to achieve 100% Coolant filtration and maximum machining performance.



VELOCITY

VELOCITYPRODUCTS.COM

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

Velocity Repair Center



VELOCITY REPAIR CENTER AND 3 YEAR WARRANTY

Three-Year Warranty

Velocity Tooling is meticulously designed for longevity and durability, even under the most demanding applications. The exceptional build quality of these tool holders is backed by a Three-Year Factory Warranty, demonstrating Velocity's commitment to customer satisfaction. Within three years from the date of purchase, Velocity pledges to repair any defective tool holder, ensuring that customers can invest in their products with confidence.

Continuous Improvement and Customer Support

Velocity Products is dedicated to continuous improvement and innovation, staying up-to-date with the latest trends and technologies in the machine tool industry. By maintaining open lines of communication with Okuma engineers around the world, Velocity is able to promptly address any issues and adapt its products to better serve the needs of Okuma machine operators. Additionally, Velocity offers comprehensive customer support, providing technical assistance, training, and guidance to ensure the best possible user experience.

Velocity offers an exclusive and comprehensive solution for Okuma machine tools, with a focus on quality, innovation, and customer satisfaction. By combining cutting-edge technology, exceptional build quality, and unparalleled support, Velocity Products provides Okuma machine operators with the tools they need to succeed in a competitive market.

VELOCITY

VELOCITYPRODUCTS.COM

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

Tooling and Accessories for Okuma Machines

OKUMA

VELOCITY V-CLEAN VISION SYSTEM

The Velocity V-Clean Vision System clears coolant from machine tool enclosure windows. The V-Clean Vision System is powered solely by shop air and costs significantly less than competing window cleaning devices.

Features

- Three year guarantee
- Includes Velocity air knife, air switch, 16' air hose, air hose guides, fittings, and extensions

Installation

- V-Clean, air switch, and hose guides mounted with rare earth neodymium magnets
- Requires 100 psi/100 cfm air source for optimal performance
- V-Clean Vision Kits available: includes V-Clean and Velocity ROMA 18 LED machine tool light



ULTRA-BRIGHT LED LIGHTING FOR MACHINE TOOLS

Velocity ultra-bright LED lighting products are designed and manufactured specifically for use in a machine tool environment. Velocity lighting features extended life LED's, completely impervious assemblies sealed to IP68, and tempered glass lenses. Powerful neodymium rare earth magnets allow for fast installation wherever light is needed.

We offer the following standard lights:

- Three year guarantee
- ROMA 9 and ROMA 18 LED machine tool enclosure lights
- Stack lights with up to seven color combinations
- Flexible arm, magnetic base LED inspection lights



VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

Tooling and Accessories for Okuma Machines



VELOCITY OKUMA CERTIFIED PULL STUDS

Velocity Okuma Certified pull studs are specifically designed for Okuma spindles. The tolerances and surface finish to which Velocity pull studs are machined results in increased tool life and better part surface finishes. Velocity Okuma Certified pull studs are machined from SNMC 420 (JIS)/4320 (ASTM) alloy steel, hardened to HRC-52 - 58, and all surfaces are held to the surface finish requirements from Okuma, and all Velocity pull studs are coolant through.

MACHINES	DRAWING	PART NUMBER	CAT 40
OKUMA CAT 40 Machines with Internal Coolant Spindles.		CAT 40 611-2032-02 (Internal Coolant)	
MACHINES	DRAWING	PART NUMBER	CAT 50
OKUMA CAT 50 Machines with IC Spindles. also for 1000Nm High Torque Spindles. Confirm part# with Okuma.		CAT 50 613-2032-08-01 (Internal Coolant)	
MACHINES	DRAWING	PART NUMBER	CAT 50 HIGH TORQUE
OKUMA CAT 50 MA 12500 and MU10000 Geared Headstock Machines. (3000 RPM & 4500 RPM.)		CAT 50 HIGH TORQUE 613-2032-07 (Internal Coolant)	

VELOCITY TOOLING FOR OKUMA 2SP-2500 H/HM

Notes

OKUMA

VELOCITY

VELOCITYPRODUCTS.COM

2SP-2500 H/HM

www.velocityproducts.com



A Complete Lineup of In-Stock Lathe Tooling for Okuma • Three Year Warranty*

Velocity Products • 3611 Jack Kendall Way, Huntsville, AL 35806 • 256-258-5549

www.velocityproducts.com • sales@velocityproducts.com

*Warranty voided if internal coolant tools are used without coolant and coolant filtration. Exceeding specified maximum cutting tool sizes voids warranty.

© Velocity Products • Specifications subject to change without notice • 2SP-2500 H/HM 8.2023