

VELOCITY / SU-matic Tooling

• Velocity Tooling is designed, engineered, and manufactured in Switzerland and Italy by *SU-matic* - a worldwide leader in tooling technology.

• **SU-matic** is the only lathe tooling manufacturer that focuses almost exclusively on Okuma tooling.

• **VELOCITY / SU-matic** tooling is designed to give years of service under the most demanding applications. The build quality of our tool holders allows us to back them with an unconditional *Two Year Factory Warranty*. If you have any questions concerning **VELOCITY / SU-matic** tools, please call 256-258-5549.

• **VELOCITY / SU-matic** tools are delivered ready to use. All driven tools are run-in at the factory and internal coolant tools are pressure tested as a final quality check prior to shipment.

• **VELOCITY / SU-matic** driven tools are CMM inspected and serialized records are kept on file.

VELOCITY / SU-matic Capto Tools

• All **VELOCITY / SU-matic** Capto tools are internal coolant and require 30 micron coolant filtration nominal, 50 micron coolant filtration absolute*.

• **Cross/Radial** coolant through tools cannot be run dry! Operating cross/radial coolant through tools without coolant will quickly damage tool seals and bearings*.

• 1,450 psi Face/Axial coolant through tools are equipped with a switch on the back of the tool that allows the tool to be run dry. This switch completely disengages the internal coolant seals from the tool spindle allowing the tool to be run dry without damaging the tool.

* Failure to use coolant filtration and internal coolant as described above voids the tool warranty.



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VELOCITY / SU-matic Capto Tools

• **VELOCITY / SU-matic** Capto live tools use a SU-matic designed, sealed draw tube mechanism.

When installing a Capto cutting unit:

 Set a torque wrench to the number specified on the tool.
Push down hard on the torque wrench to make sure the hex drive is fully engaged in the hex socket. Do not use a ball tipped hex drive as this may damage the Capto mechanism.
If the seal does not snap back when the torque wrench is removed, wiggle the Capto cutting unit and the seal will snap back into a closed position. The spring loaded seal must snap back into a closed position before the tool is run.



VELOCITY / SU-matic Capto Tools

• **VELOCITY / SU-matic** Capto tools use a Sandvik Capto clamping unit installed in the "Right" orientation as standard. If the "Left" orientation is required, the tool holder can be ordered in advance with "Left" orientation, or the clamping unit can be easily rotated by using a Sandvik CC-ET-01extracting tool (C4) and a C4-WDT-02 withdrawal tool. Please contact Velocity for assistance if clamping unit rotation is required.



Right Orientation



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Left Orientation



VELOCITY / SU-matic Capto Tools

• The example below shows a main/sub spindle Capto OD holder. The orientation of the Capto clamping units can be adjusted so that the Capto cutting units are optimized for chip removal, insert maintenance, or uniformity of cutting units as shown on the next page. The "Right" orientation is standard.



Right Orientation





Left Orientation





VELOCITY / SU-matic Capto Tools

• The examples below show the options available on an Okuma LT2000 twin turret, main/sub spindle lathe for the orientation of the Capto clamping units on the tool holders, and also the choices available for the Capto cutting units.





LEFT

LEFT

• This example shows the Capto clamping units oriented on the tool holders for chip optimization. The Capto cutting units were chosen to ensure that the chips all drop in the same direction.

• This example shows the Capto clamping units oriented on the tool holders optimized for insert monitoring. The Capto cutting units were chosen so that the inserts are all facing the front of the machine.

• This example shows the Capto clamping units oriented on the tool holders so that only one type of Capto cutting unit is required.

LEFT

FFT

VELOCITY/SU-MATIC CAPTO® TOOLING

VELOCITY SU-matic

VELOCITY / SU-matic Capto Tools

• If the Capto clamping unit needs to be rotated, the proper extracting tool and withdrawal tool must be used.

Capto Size	Withdrawal Tool	Extracting Tool
C3	C3-WDT-01M	CC-ET-01
C4	C4-WDT-02	
C5	C5-WDT-02	CC-ET-02
C6	C6-WDT-02	
C8	C8-WDT-02	



Capto Clamping Unit Rotation Instructions

- Clean the CC sleeve and the cavity in the CC clamping unit.
- Slightly grease the external diameter of the CC sleeve.
- Carefully replace the sleeve (indexed 180° from the previous position) into the cavity. Gently tap down on the CC sleeve and positioning pins until the CC sleeve reaches the face of the CC clamping unit housing.
- Lock the CC sleeve with (4) Torx screws.





CAPTO TOOL INSTRUCTIONS



TOOLING FOR OKUMA



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

Velocity Products • 350 Electronics Blvd, Huntsville, AL 35824 • 256-258-5549 www.velocityproducts.com • sales@velocityproducts.com

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

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