

December 2019

ONLY FOR
OKUMA

VELOCITY

SU-matic®

2SP-H / 2SP-HM Series Tools

www.velocityproducts.com



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

VELOCITY **SU-matic**[®]

Velocity Tooling: Only for Okuma

Velocity Products has the largest inventory of lathe tooling for **Okuma** in North America. Velocity is the OEM supplier of tooling startup kits for **Okuma** lathes. Velocity tooling is designed and manufactured by SU-matic – a worldwide leader in tooling technology headquartered in Switzerland. SU-matic has several **Okuma** machine tools in their manufacturing facility. SU-matic works closely with engineers from **Okuma America**, **Okuma Japan**, and **Okuma Europe** when designing tools. This engineering collaboration ensures flawless tooling performance on **Okuma** lathes, multitasking machines, and machining centers. Velocity/SU-matic tooling is available **Only for Okuma** machine tools.

Velocity Tooling Technology

Velocity tools are delivered ready to use; all live tools are run-in at the factory and internal coolant tools are pressure tested as a final quality check prior to shipment. Velocity tools are greased for life; no customer maintenance is required. Velocity/SU-matic tools are CMM inspected and serialized records are kept on file.

Three Year Warranty

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 **UNMATCHED Three Year Factory Warranty**.



VELOCITY **SU-matic**[®]
VELOCITYPRODUCTS.COM



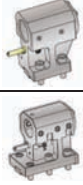


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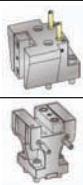




Tool Matrix

Boring Bar Holders







Holder	Machine Model	Type	Tool #	Quantity	Page	Bar Size (Inches)	Coolant
Boring Bar	 2SP-150 H/HM	Standard	14.910.0.0451.0		6	1.5	IC & EXT
		Offset	14.910.0.0487.0		6	1.5	IC & EXT
	 2SP-250 H/HM	Standard	14.910.0.0452.0		9	1.5	IC & EXT
		Offset	14.910.0.0454.0		9	1.5	IC & EXT
	 2SP-2500 H/HM	Standard	14.910.0.0500.0		12	1.5	IC & EXT
		Offset	14.910.0.0502.0		12	1.5	IC & EXT

OD-I Holders • OD-II Holders

Holder	Machine Model	Type	Tool #	Quantity	Page	Bar Size (Inches)	Coolant
OD Holders	 2SP-150 H/HM	OD-I	14.910.0.0450.0		7	1.0	EXT
		OD-II	14.910.0.0488.0		7	1.0	EXT
	 2SP-250 H/HM	OD-I	14.910.0.0453.0		10	1.0	EXT
		OD-II	14.910.0.0490.0		10	1.0	EXT
	 2SP-2500 H/HM	OD-I	14.910.0.0496.0		13	1.0	EXT
		OD-II	14.910.0.0498.0		13	1.0	EXT

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

Tool Matrix

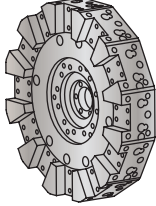
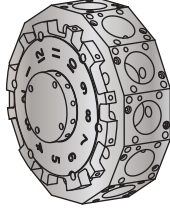









Live Tools										
Tool Type	Machine Model	Tool #	Quantity	Page	Coolant (PSI)	Output	Ratio (In:Out)	Torque (Nm)	Maximum RPM	
Cross	 2SP-150 HM	14.101.0.0336.0		8	External	ERAX-20	1:1	40	6,000	
		14.101.0.0311.0		8	IC (1,000)	ERAXC-20	1:1	40	6,000	
Face	 2SP-150HM	14.800.0.0291.0		8	External	ER-20	1:1	40	6,000	
		14.800.0.0436.0		8	IC (1,450)	ERC-20	1:1	40	6,000	
Cross	 2SP-250HM	14.101.0.0182.0		11	External	ERAX-32	1:1	85	5,000	
		14.101.0.0184.0		11	IC (1,000)	ERAXC-32	1:1	85	5,000	
Face	 2SP-250HM	14.800.0.0266.0		11	External	ER-32	1:1	85	5,000	
		14.800.0.0314.0		11	IC (1,450)	ERC-32	1:1	85	5,000	
Cross	 2SP-2500HM	14.800.0.0472.0		14	External	ER-32	1:1	60	6,000	
		14.800.0.0471.0		14	IC (1,450)	ERC-32	1:1	60	6,000	
Face	 2SP-2500HM	14.101.0.0370.0		14	External	ERAX-32	1:1	60	6,000	
		14.101.0.0369.0		14	IC (1,000)	ERAXC-32	1:1	60	6,000	

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 TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-2500H/HM Tooling Kits



2SP-2500H (12) Position L-Turret		2SP-2500H (12) Position M-Turret			
					
Description		Static Kit • L 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 14.430.0.0086.0			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

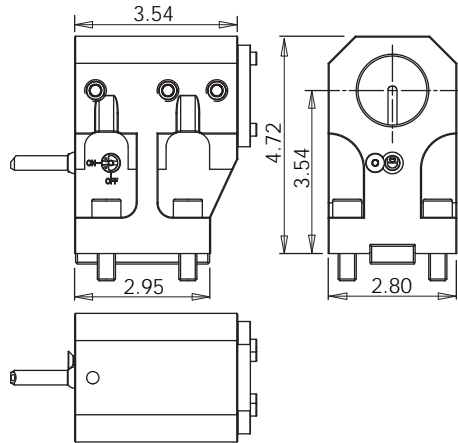
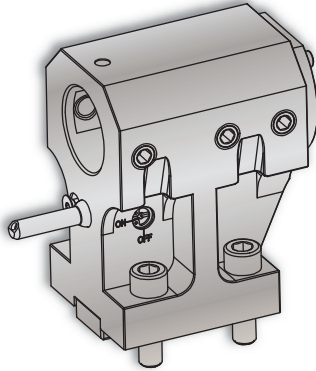
2SP-2500 H/HM turrets are mounted at 90° to spindles, so OD and live tool designations are opposite from tools on other machines.

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-150H/HM Tools



2SP-150H/HM ID Holder



Notes

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

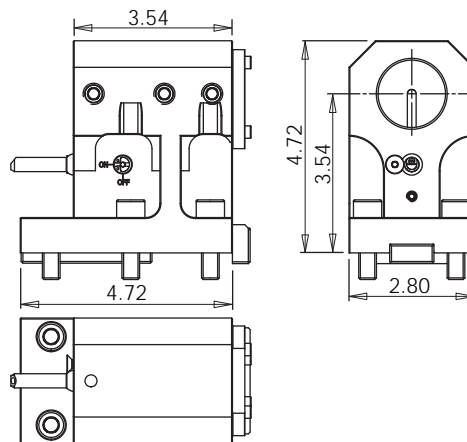
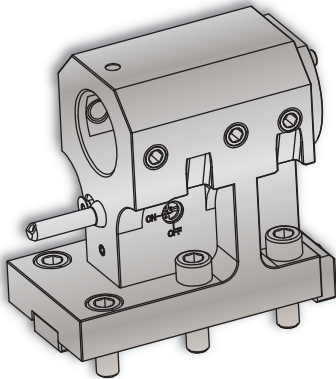
Turret Plugs | 14.430.0.0207.0

VELOCITY/SU-matic 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
14.910.0.0451.0	No	IC/EXT	1.5"

2SP-150H/HM Offset ID Holder



Notes

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

Turret Plugs | 14.430.0.0207.0

VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

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

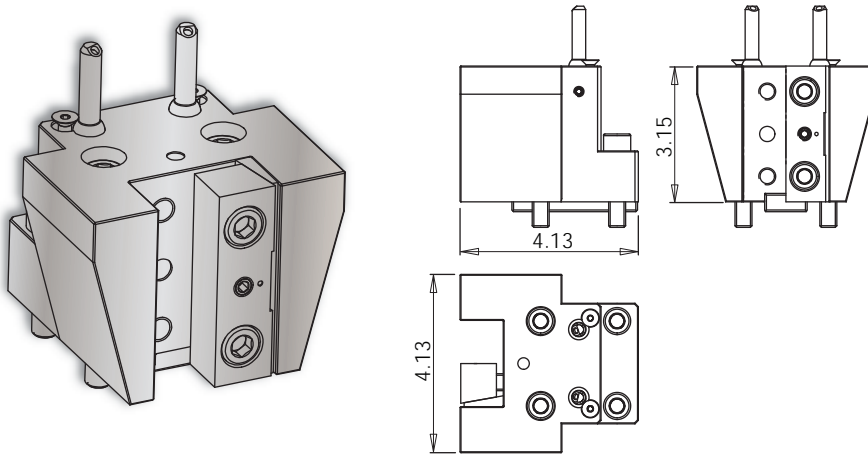
Tool #	Reversible (Main/Sub)	Coolant	ID
14.910.0.0487.0	No	IC/EXT	1.5"

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-150H/HM Tools



2SP-150H/HM OD-I Holder



Notes

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

Turret Plugs	14.430.0.0207.0
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VELOCITY/SU-matic 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 #

Reversible
(Main/Sub)

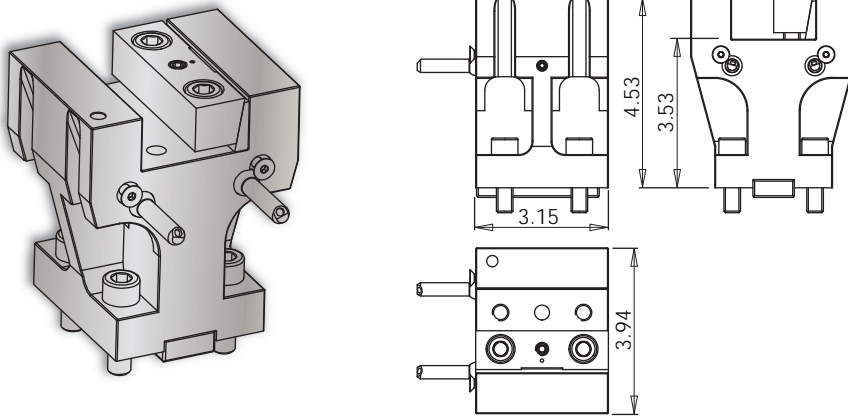
Stick Size

14.910.0.0450.0

No

1.0"

2SP-150H/HM OD-II Holder



Notes

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

Turret Plugs	14.430.0.0207.0
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VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

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Tool #

Reversible
(Main/Sub)

Stick Size

14.910.0.0488.0

No

1.0"

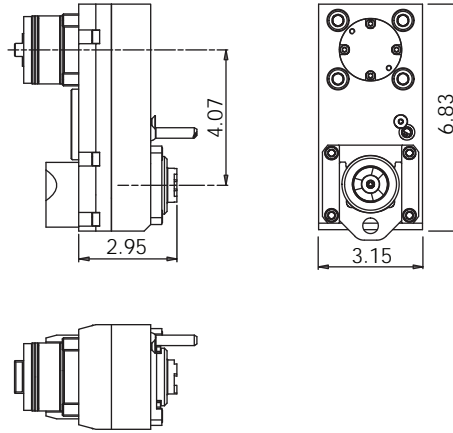
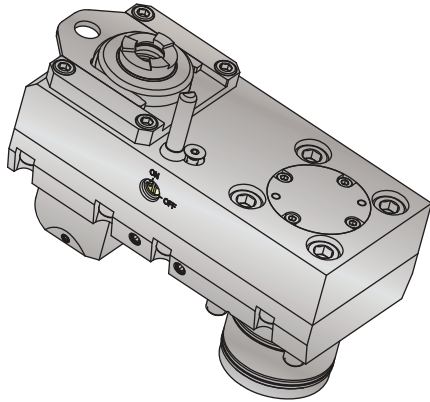
VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-150HM Tools



2SP-150HM Cross Tools • ERAX-20 Outputs

Notes



Wrenches Included with Tools

Maximum Drill Ø		Maximum Mill Ø	
EXT	1/2"	EXT	15/32"
IC	1/2"	IC	15/32"

Turret Plugs 14.430.0.0207.0

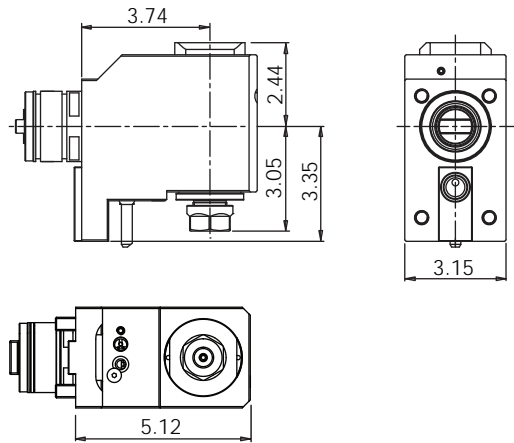
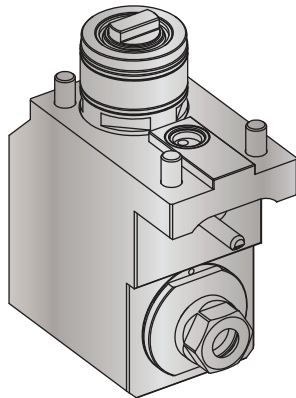
* 1,450 psi internal coolant (IC) cross tool **CAN** be run without coolant; the coolant sealing mechanism can be completely dis-engaged.

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
14.101.0.0336.0	EXT	ERAX-20	CW:CW	1:1	6,000	40 Nm	Special	7117.20000
14.101.0.0311.0	IC & EXT* 1,450 psi	ERAXC-20	CW:CW	1:1	6,000	40 Nm	Special	7117.20000

2SP-150HM Face Tools • ER-20 Outputs

Notes



Wrenches Included with Tools

Maximum Drill Ø		Maximum Mill Ø	
EXT	1/2"	EXT	15/32"
IC	1/2"	IC	15/32"

Turret Plugs 14.430.0.0207.0

* 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.

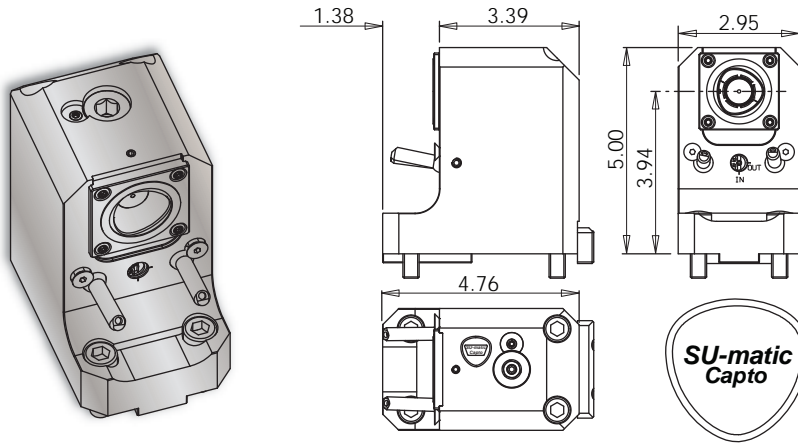
Tool #	Coolant	Output	Rotation (In:Out)	Ratio (In:Out)	Max. RPM	Torque	Spindle Wrench	Collet Wrench
14.800.0.0291.0	EXT	ER-20	CW:CW	1:1	6,000	40 Nm	Special	7111.20000
14.800.0.0436.0	IC & EXT* 1,450 psi	ERC-20	CW:CW	1:1	6,000	40 Nm	Special	7111.20000

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-150H/HM Capto®



2SP-150H/HM C4 Offset 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

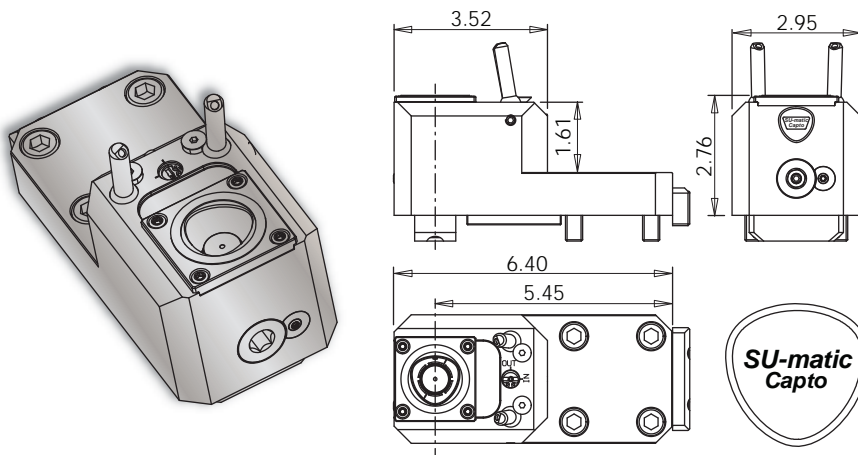
Turret Plugs	14.430.0.0207.0
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VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

SU-matic Capto® static tools are coolant thru. Coolant filtration is recommended.

Tool #	Reversible (Main/Sub)	Coolant	Output	Hex Wrench	C4 Collet Chucks
14.910.0.0193.0	No	IC/EXT	C4	10 mm	See Above

2SP-150H/HM C4 OD-I 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	14.430.0.0207.0
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VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

SU-matic Capto® static tools are coolant thru. Coolant filtration is recommended.

Tool #	Reversible (Main/Sub)	Coolant	Output	Hex Wrench	C4 Collet Chucks
14.910.0.0104.0	No	IC/EXT	C4	10 mm	See Above

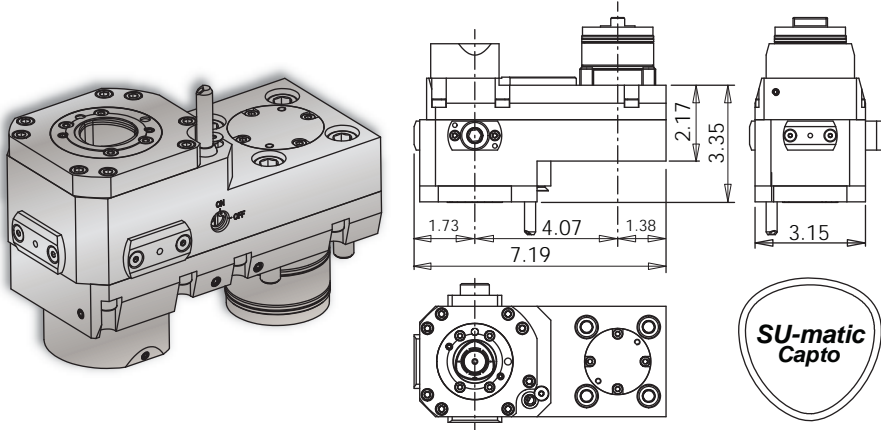
VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-150HM Capto®



2SP-150HM C4 Cross Tool

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 14.430.0.0207.0

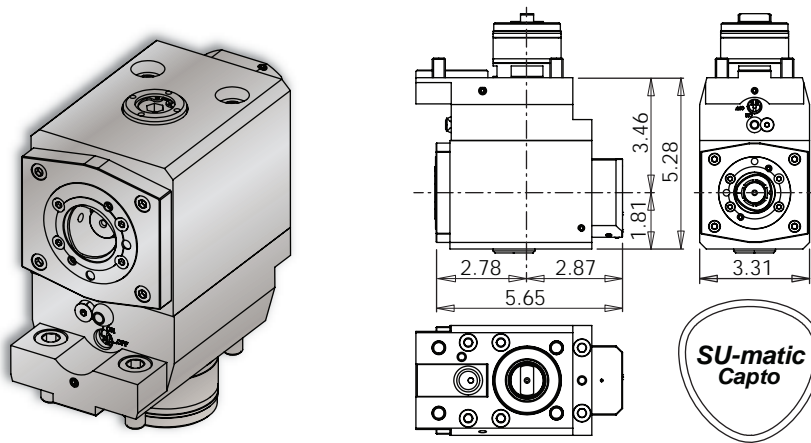
* 1,000 psi internal coolant (IC) cross tool CANNOT be run without coolant.

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
14.101.0.0322.0	IC & EXT* 1,000 psi	C4	CW:CW	1:1	6,000	40 Nm	10 mm	See Above

2SP-150HM C4 Face Tool

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 14.430.0.0207.0

* 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.

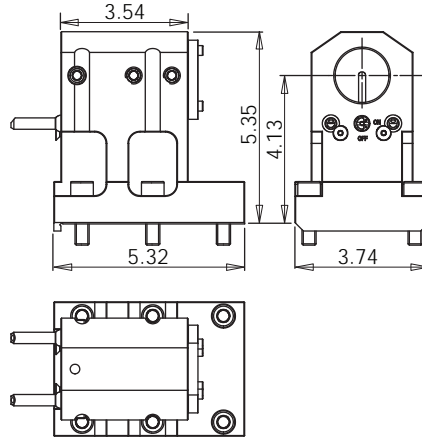
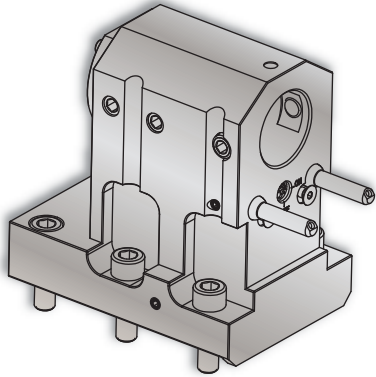
Tool #	Coolant	Output	Rotation (In:Out)	Ratio (In:Out)	Max. RPM	Torque	Hex Wrench	C4 Collet Chucks
14.800.0.0437.0	IC & EXT* 1,450 psi	C4	CW:CW	1:1	6,000	40 Nm	10 mm	See Above

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-250H/HM Tools



2SP-250H/HM ID Holder



Notes

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

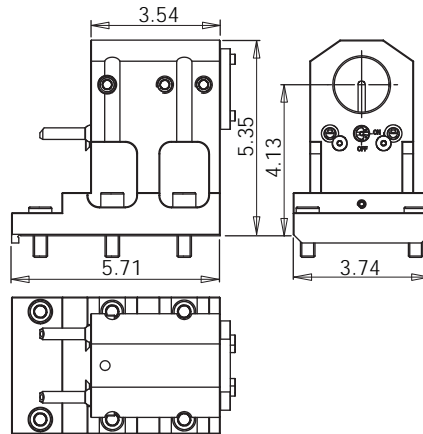
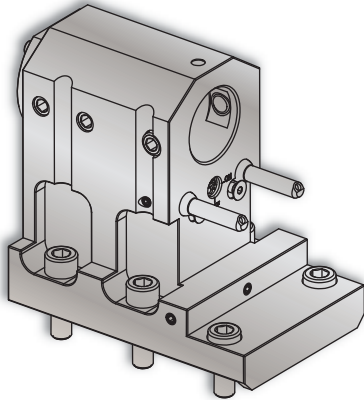
Turret Plugs | **14.430.0.0205.0**

VELOCITY/SU-matic 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
14.910.0.0452.0	No	IC/EXT	1.5"

2SP-250H/HM Offset ID Holder



Notes

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

Turret Plugs | **14.430.0.0205.0**

VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

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

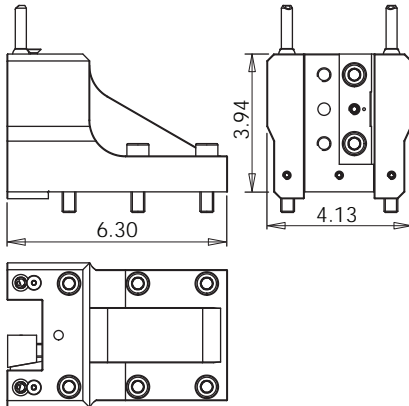
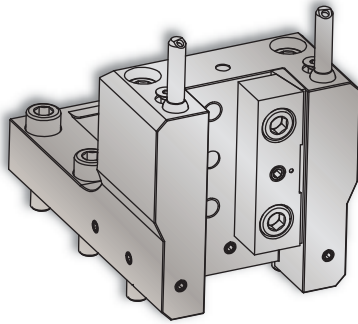
Tool #	Reversible (Main/Sub)	Coolant	ID
14.910.0.0454.0	No	IC/EXT	1.5"

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-250H/HM Tools



2SP-250H/HM OD-I Holder



Notes

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

Turret Plugs | 14.430.0.0205.0

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Tool #

Reversible (Main/Sub)

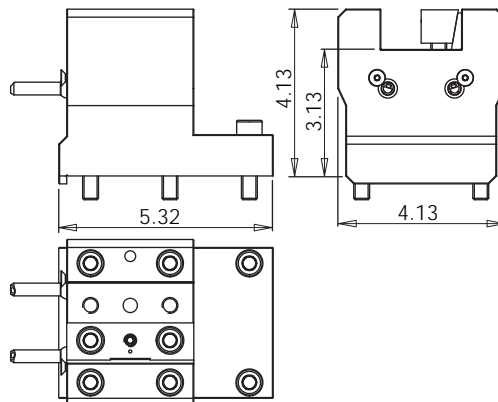
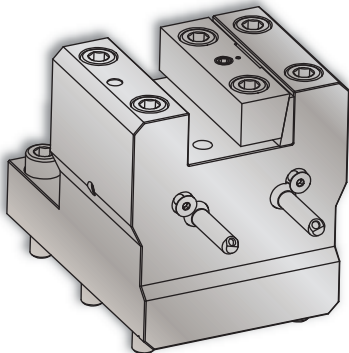
Stick Size

14.910.0.0453.0

No

1.0"

2SP-250H/HM OD-II Holder



Notes

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

Turret Plugs | 14.430.0.0205.0

VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

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Tool #

Reversible (Main/Sub)

Stick Size

14.910.0.0490.0

No

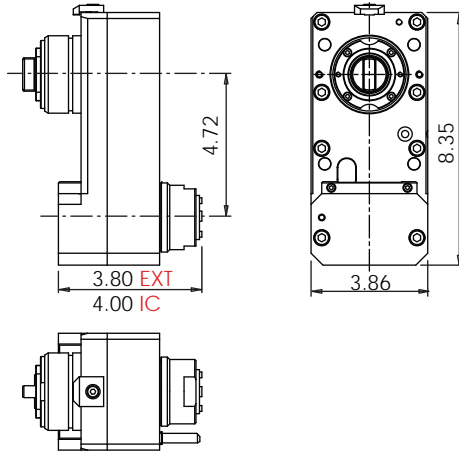
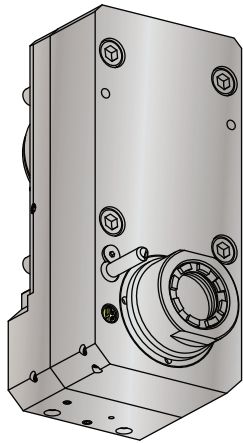
1.0"

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-250HM Tools



2SP-250HM Cross Tools • ERAX-32 Outputs



Notes

Wrenches Included with Tools

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

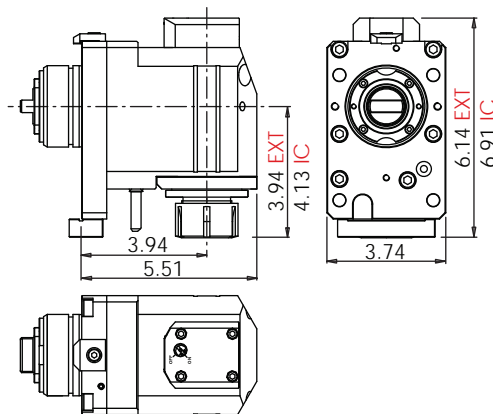
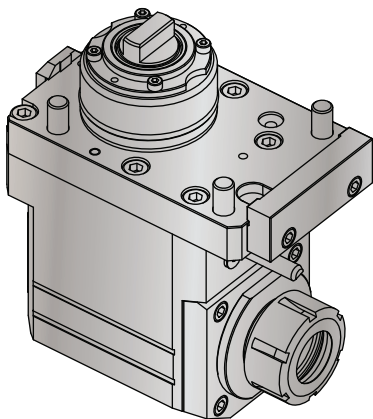
Turret Plugs **14.430.0.0205.0**

* 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
14.101.0.0182.0	EXT	ERAX-32	CW:CW	1:1	5,000	85 Nm	Special	7117.32000
14.101.0.0184.0	IC & EXT* 1,450 psi	ERAXC-32	CW:CW	1:1	5,000	85 Nm	Special	7117.32000

2SP-250HM Face Tools • ER-32 Outputs



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 **14.430.0.0205.0**

* 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
14.800.0.0266.0	EXT	ER-32	CW:CW	1:1	5,000	85 Nm	Special	7111.32000
14.800.0.0314.0	IC & EXT* 1,450 psi	ERC-32	CW:CW	1:1	5,000	85 Nm	Special	7111.32000

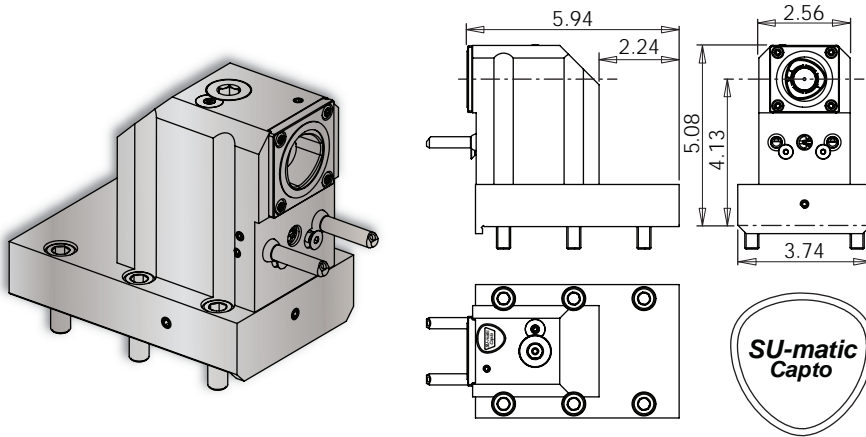
VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-250H/HM Capto®



2SP-250H/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 **14.430.0.0205.0**

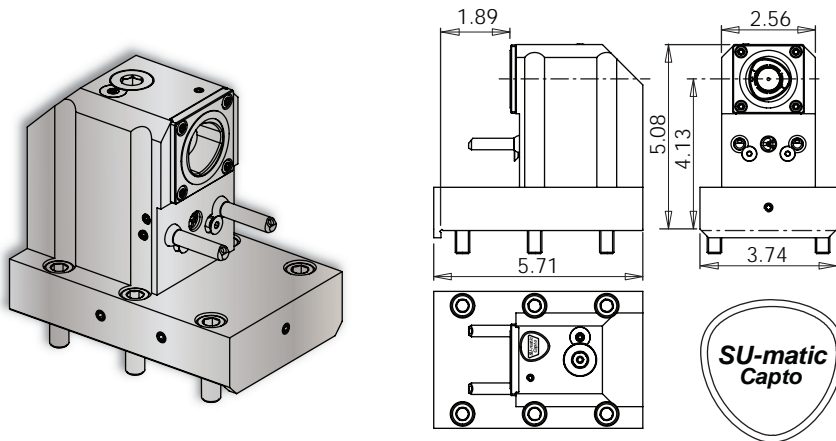
VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

SU-matic Capto® static tools are coolant thru. Coolant filtration is recommended.

Tool #	Reversible (Main/Sub)	Coolant	Output	Hex Wrench	C4 Collet Chucks
14.910.0.0461.0	Yes	IC/EXT	C4	10 mm	See Above

2SP-250H/HM C4 Offset 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 **14.430.0.0205.0**

VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

SU-matic Capto® static tools are coolant thru. Coolant filtration is recommended.

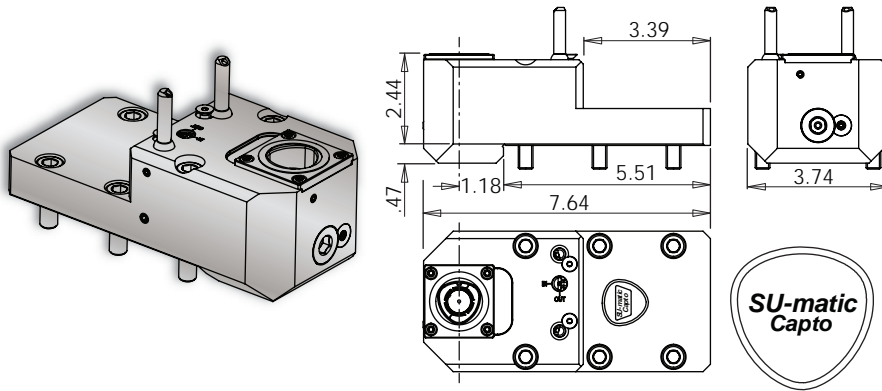
Tool #	Reversible (Main/Sub)	Coolant	Output	Hex Wrench	C4 Collet Chucks
14.910.0.0462.0	No	IC/EXT	C4	10 mm	See Above

2SP-250H/HM Capto®



2SP-250H/HM C4 OD-I 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 **14.430.0.0205.0**

VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

SU-matic Capto® static tools are coolant thru. Coolant filtration is recommended.

Tool #	Reversible (Main/Sub)	Coolant	Output	Hex Wrench	C4 Collet Chucks
14.910.0.0460.0	Yes	IC/EXT	C4	10 mm	See Above



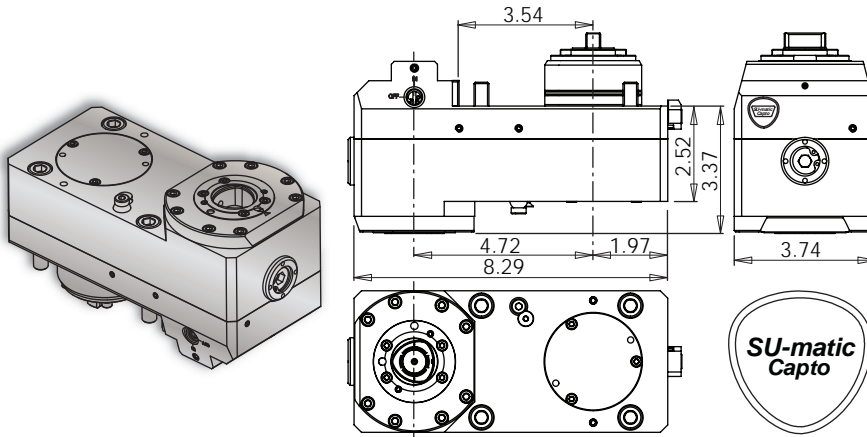
VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-250HM Capto®



2SP-250HM C4 Cross Tool

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 **14.430.0.0205.0**

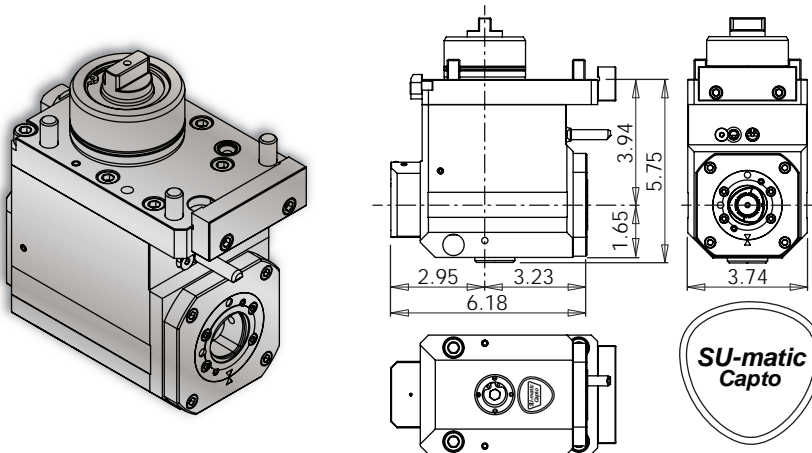
* 1,000 psi internal coolant (IC) cross tool CANNOT be run without coolant.

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
14.101.0.0340.0	IC & EXT* 1,000 psi	C4	CW:CW	1:1	6,000	60 Nm	10 mm	See Above

2SP-250HM C4 Face Tool

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 **14.430.0.0205.0**

* 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.

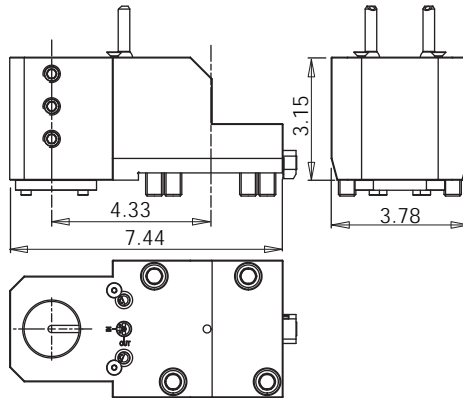
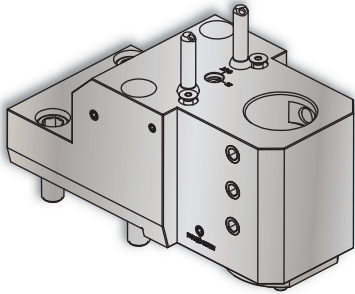
Tool #	Coolant	Output	Rotation (In:Out)	Ratio (In:Out)	Max. RPM	Torque	Hex Wrench	C4 Collet Chucks
14.800.0.0470.0	IC & EXT* 1,450 psi	C4	CW:CW	1:1	6,000	60 Nm	10 mm	See Above

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-2500H/HM Tools



2SP-2500H/HM ID Holder



Notes

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

Turret Plugs	14.430.0.0086.0
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VELOCITY/SU-matic 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

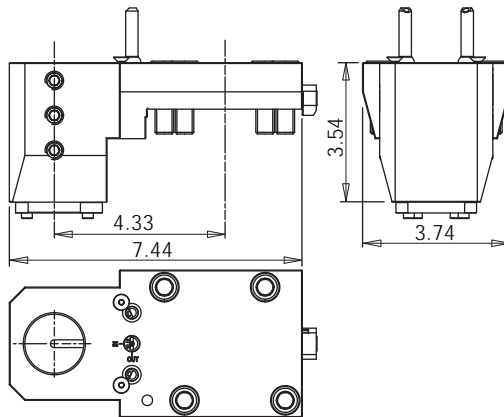
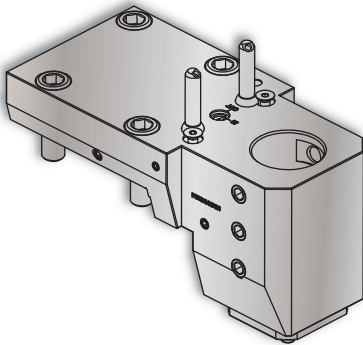
14.910.0.0500.0

No

IC/EXT

1.5"

2SP-2500H/HM Offset ID Holder



Notes

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

Turret Plugs	14.430.0.0086.0
--------------	-----------------

VELOCITY/SU-matic 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

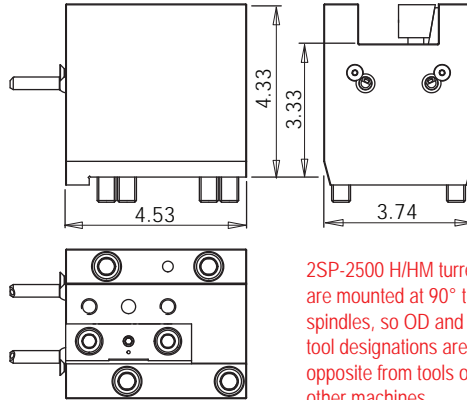
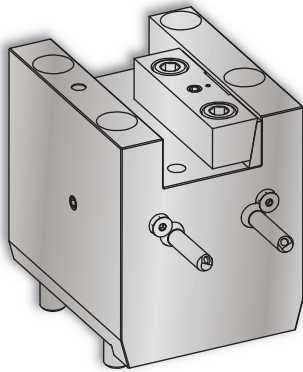
1.5"

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

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/SU-matic* tool holders. Please contact Velocity: sales@velocityproducts.com.

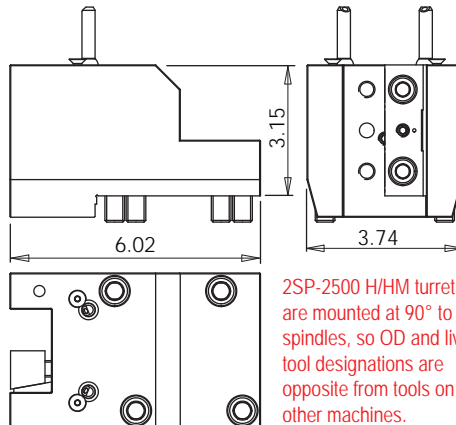
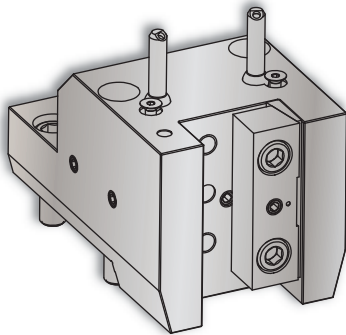
Turret Plugs	14.430.0.0086.0
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VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

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

Tool #	Reversible (Main/Sub)	Stick Size
14.910.0.0496.0	No	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/SU-matic* tool holders. Please contact Velocity: sales@velocityproducts.com.

Turret Plugs	14.430.0.0086.0
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VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

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

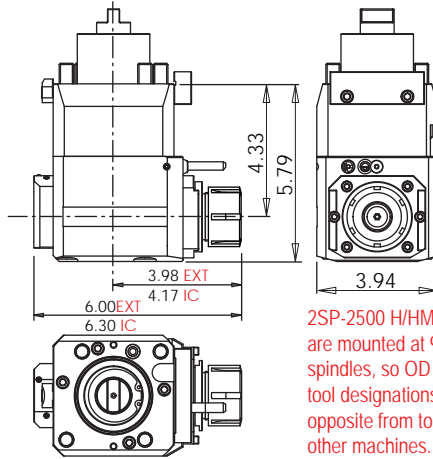
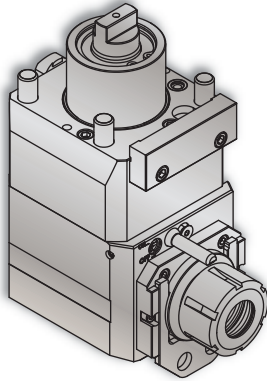
Tool #	Reversible (Main/Sub)	Stick Size
14.910.0.0498.0	No	1.0"

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

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"

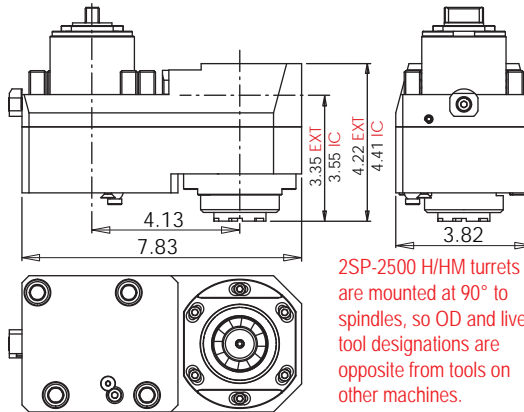
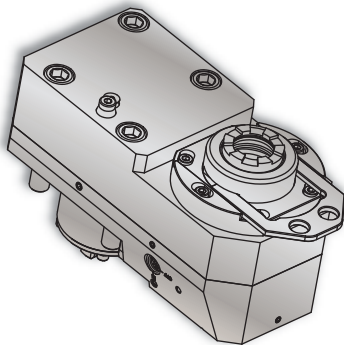
Turret Plugs 14.430.0.0086.0

* 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 14.430.0.0086.0

* 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.

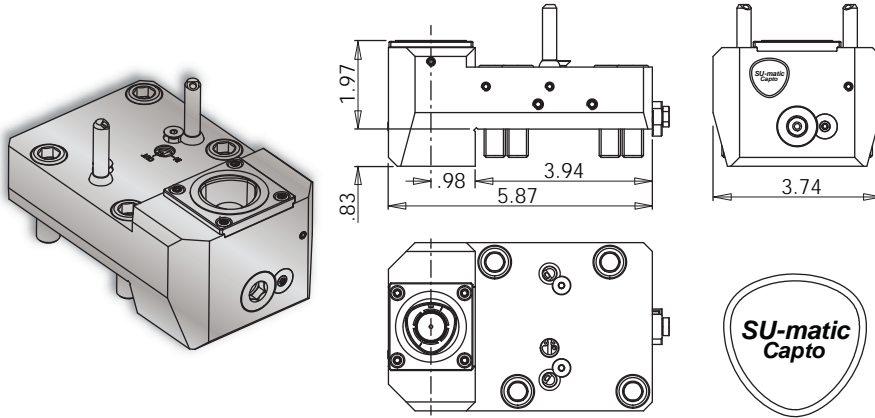
Tool #	Coolant	Output	Rotation (In:Out)	Ratio (In:Out)	Max. RPM	Torque	Spindle Wrench	Collet Wrench
14.101.0.0370.0	EXT	ERAX-32	CW:CW	1:1	6,000	60 Nm	Special	7117.32000
14.101.0.0369.0	IC & EXT* 1,450 psi	ERAXC-32	CW:CW	1:1	6,000	60 Nm	Special	7117.32000

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-2500H/HM Capto®



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

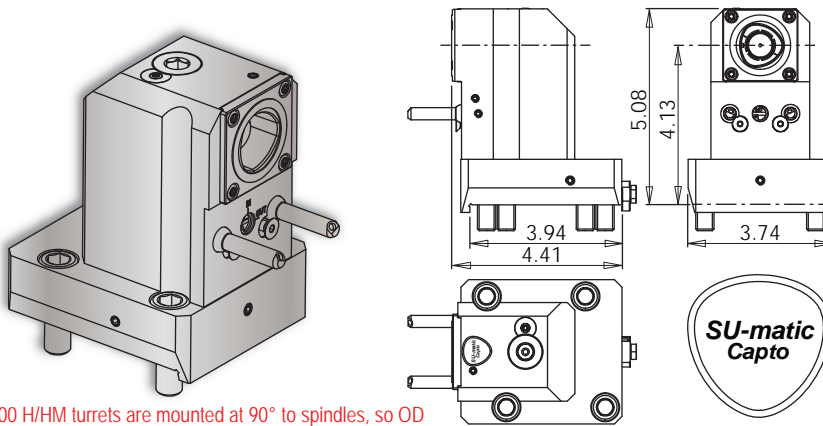
Turret Plugs 14.430.0.0086.0

VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

SU-matic Capto® 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 14.430.0.0086.0

VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

SU-matic Capto® static tools are coolant thru. Coolant filtration is recommended.

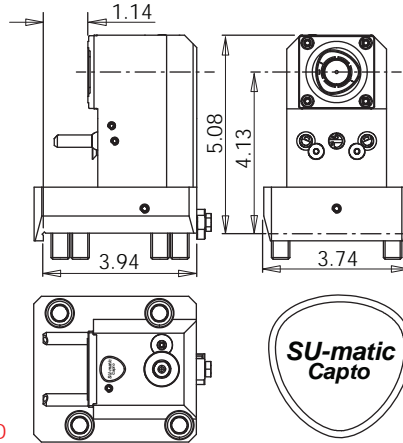
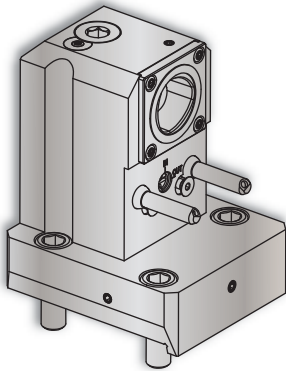
Tool #	Reversible (Main/Sub)	Coolant	Output	Hex Wrench	C4 Collet Chucks
14.910.0.0530.0	No	IC/EXT	C4	10 mm	See Above

VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

2SP-2500H/HM Capto®



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 14.430.0.0086.0

VELOCITY/SU-matic tooling for OKUMA is manufactured on OKUMA machine tools.

SU-matic Capto® 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

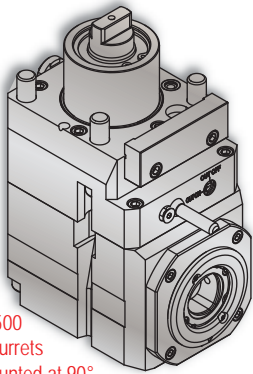


VELOCITY TOOLING FOR OKUMA 2SP-H/2SP-HM Series

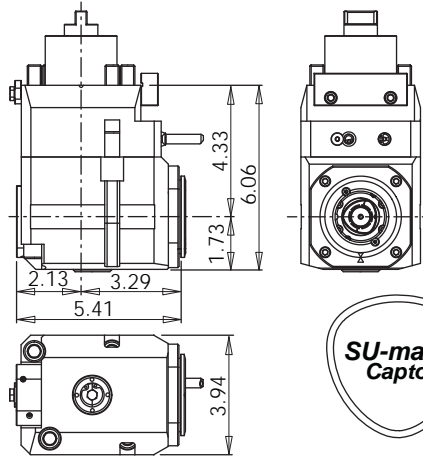
2SP-2500HM Capto®



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.



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

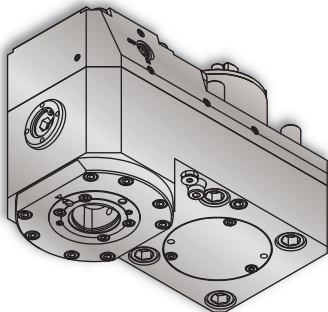
Turret Plugs 14.430.0.0086.0

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

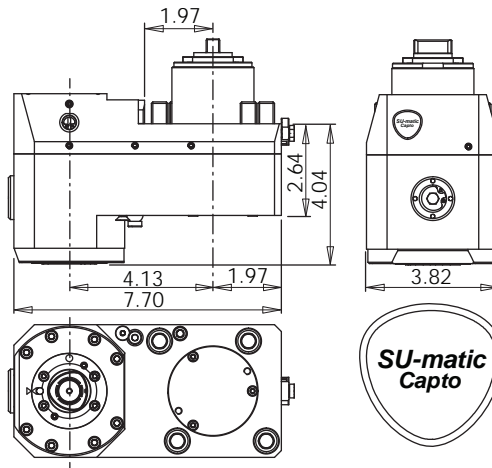
All coolant thru live tools require 30 micron coolant filtration nominal, 50 micron coolant filtration absolute.

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.



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 14.430.0.0086.0

* 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

ONLY FOR
OKUMA

VELOCITY
SU-matic®

2SP-H / 2SP-HM Series Tools

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