

SECO-CAPTO™



TOOLHOLDING FOR DOOSAN MACHINES

OUR EXTENSIVE RANGE

Seco Tools are very pleased to launch its first **Seco-Capto™** tool holding catalogue.

We have worked in close partnership with Craftsman Tools to develop the Seco-Capto™ quick change toolholders featured in this catalogue.

Together we have developed a wide variety of model specific clamping units for most Doosan machine tools. Alongside the standard Seco-Capto™ range, Craftsman Tools and Seco Tools can also jointly design and manufacture a number of innovative products and special applications for Doosan machines.

In addition to the Seco-Capto™ toolholders we can also offer the following complementary products:



Driven Units

Driven Seco-Capto™ Units

Reduce your set-up times and improve your surface finishing with our range of power driven holders. Seco-Capto's™ fully sealed units operate at speeds up to 6000 rpm. Induction hardened gears and high quality bearings ensure smooth and accurate operation with through coolant as an option.

Integrated Seco-Capto™ Turrets

Integrated Turrets offer increased rigidity, rapid tool change, larger work envelope, quicker set-up times, off-line tool setting and through-tool coolant to every station.

Options include turrets with two clamping stations at each position, and we have developed a range of accessories to increase the versatility of the turrets.

Integrated Turrets



Preseters



Seco-Capto™ Presetters

Reduce downtime with precision off-line tool setting.

Special Applications

Craftsman Tools design and manufacture one-off Seco-Capto™ toolholders to meet specific customer requirements.

Split Boring Bar Holders & Sleeves

Benefits of our Split and Hinged Boring Bar Holders include:

- Compatibility with both anti-vibration and standard boring bars
- Clamping length 4 x bar diameter
- Deeper boring capability (up to 10 times diameter)

Seco-Capto™ Toolholders for all leading machines.



- Increased cutting performance
- Through coolant capability

We also offer Split Reduction Sleeves for use with smaller diameter boring bars.

Our product range is always expanding. If you can't see the toolholder you need in this catalogue, contact your local Seco Representative to discuss your requirements.

Split Boring Bar Holders & Sleeves



**CRAFTSMAN
TOOLS**

Collaborating with the World's Finest

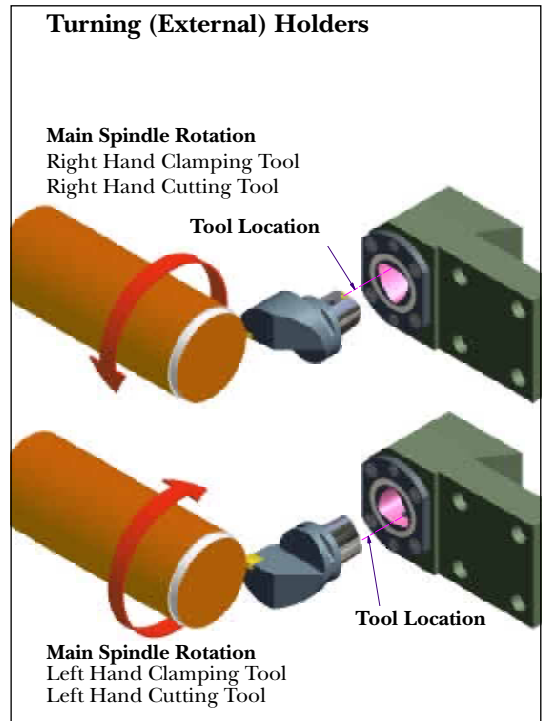
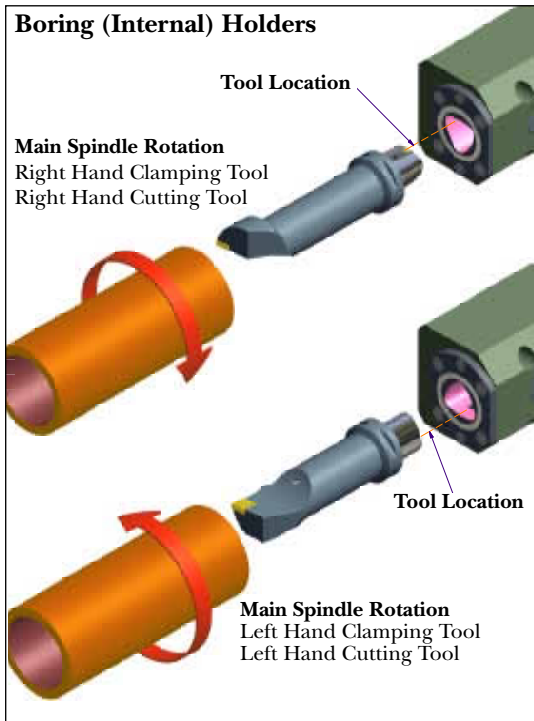
HOW TO USE THIS CATALOGUE

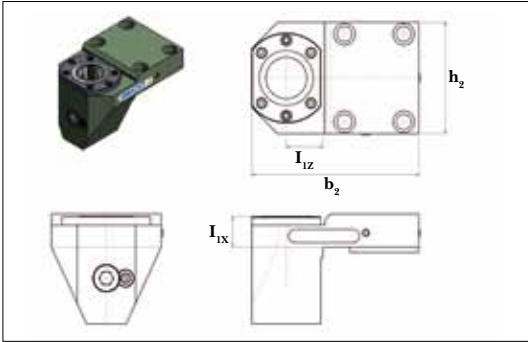
- Find your Doosan machine in the **tables** on pages 6-9, select the toolholder style and option you require (*e.g. Boring Holder, C4*) and note the *Product Code*.
- Check your requirements against the **type** diagrams shown on pages 5-6.
- Select the **Direction of Rotation** required using the illustrations below and replace * in the *Product Code* with **R** or **L**.

Please note that type diagrams and tables for **Presetters** can be found on page 9 and for split boring bar holders with reduction sleeve assemblies on page 10 - 11.

The information in this catalogue is correct at the time of going to press and is subject to change.

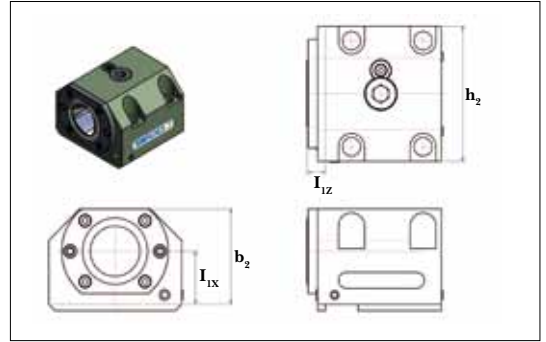
Direction of Rotation: Please specify Right (R) or Left (L) direction of rotation





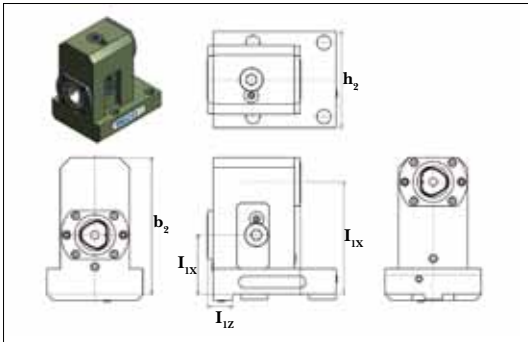
Type 1: Turning Holder

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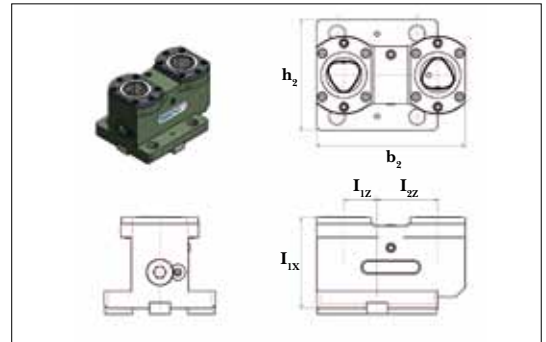
Type 2: Boring Holder

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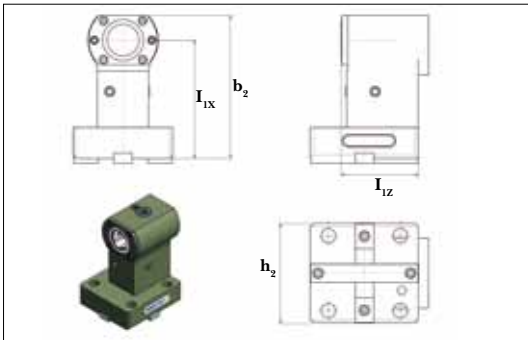
Type 3: Boring Holder - Main & Sub Spindles

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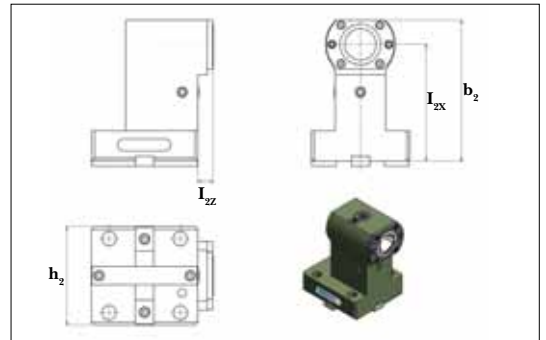
Type 4: Double Turning Holder

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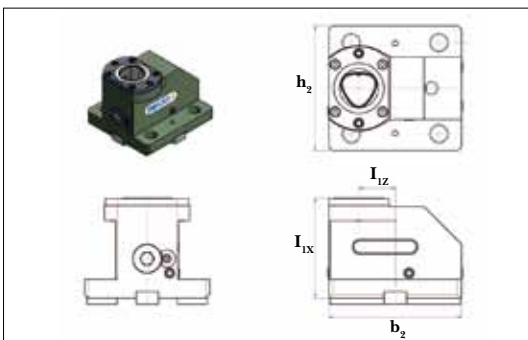
Type 5: Boring Holder

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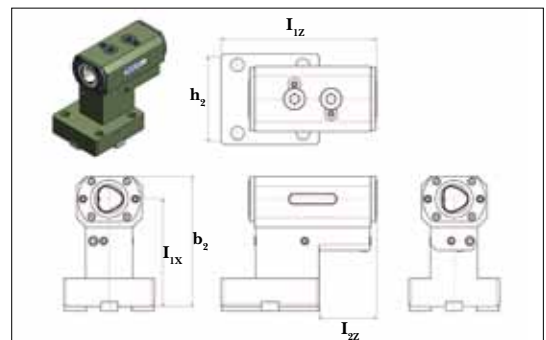
Type 6: Boring Holder - Sub Spindle

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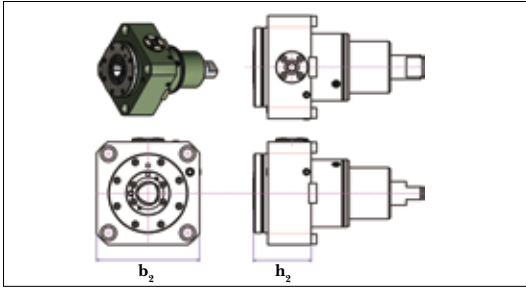
Type 7: Turning Holder - Main & Sub Spindles

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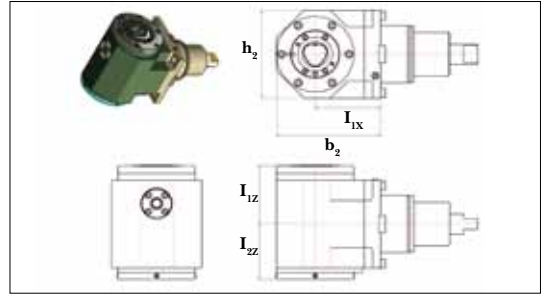


Type 8: Double Boring Holder

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V-Type Driven Holder



H-Type Driven Holder

Driven Holders

Product Code	Size	Dimensions (mm)					Type
		b_2	h_2	I_{1X}	I_{1Z}	I_2	
600M, 700M, 800M							
DAE8727	C4	130	73				V
DAE8796	C5	130	100				V
DAE8797	C5	130	151	95	87	82	H

Part	Product Code	Size	Dimensions (mm)				Type
			b_2	h_2	I_{1X}	I_{1Z}	
L220							
Turning Holder	C4-*CE-L220-025028	C4	129	93	28	25	1
Boring Holder	C4-*CI-L220-035011	C4	59	93	35	11	2
L220LM/M (BMT 45 Turret)							
Turning Holder	C4-*CE-L220M-072050	C4	136	75	50	72	7
Boring Holder	C4-*CI-L220M-065062	C4	89	75	65	62	5
240 A B & C							
Boring Holder	C4-*CI-PU240-035016	C4	59	94	35	16	2
Boring Holder	C5-*CI-PU240-035018	C5	67	94	35	18	2
Turning Holder	C5-*CE-PU240-050005	C5	162	94	5	50	1
230M, 240M, 280M, 1500, 2000, 2500 SY & LSY, TT 1500, 1800 (BMT55 Turret)							
Turning Holder	C4-*CE-PU230M-036040	C4	155	85	40	36	1
Boring Holder	C4-*CI-PU230M-070014	C4	94	85	70	14	2
Turning Holder	C5-*CE-PU230M-048030	C5	175	85	30	48	1
Boring Holder	C5-*CI-PU230M-060018	C5	92	85	60	18	2
Boring Holder	C6-*CI-PU230M-060040	C6	102	105	60	40	2
Boring Holder- subspindle	C4-*CI-PU230M-070035 SS	C4	94	85	70	35	3

Part	Product Code	Size	Dimensions (mm)				Type
			b ₂	h ₂	l _{1x}	l _{1z}	
300C							
Turning Holder	C5-*CE-PU300C-034028	C5	155	102	28	34	1
Boring Holder	C4-*CI-PU3000C-040014	C4	64	102	40	14	2
Boring Holder	C5-*CI-PU300C-040014	C5	72	102	40	14	2
Boring Holder	C6-*CI-PU300C-042035	C6	84	102	42	35	2
300M/LM/MS (BMT65 Turret), 3000M							
Turning Holder	C4-*CE-PU300M-020060	C4	149	97	60	20	1
Boring Holder	C4-*CI-PU300M-072012	C4	96	95	72	12	2
Boring Holder - Main & Sub Spindles	C4-*CI-PU300M-058111 DB	C4	134,8	95	<u>58,42</u> 110,82	25	3
Turning Holder	C5-*CE-PU300M-043050	C5	180	95	50	43	1
Boring Holder	C5-*CI-PU300M-072014	C5	104	95	72	14	2
400A/B/C/LA/LB - Suits Old (25 x 25) & New (32 x 32) style Turrets							
Boring Holder	C5-*CI-PU400-040016	C5	72	120	16	40	2
Turning Holder	C5-*CE-PU400-045043	C5	169	120	43	45	1
Turning Holder for grooving tool	C5-*CE-PU400-032035	C5	164	120	35	32	1
Boring Holder	C6-*CI-PU400-042027	C6	84	120	42	27	2
Turning Holder	C6-*CE-PU400-044044	C6	178	120	44	44	1
Boring Holder	C8-*CI-PU400-050047	C8	100	135	50	47	2
400MA/MB/LMA/LMB (BMT 75 Turret)							
Turning Holder	C4-*CE-PU400MB-035040	C4	174	112	40	35	1
Boring Bar Holder	C4-*CI-PU400MB-060050	C4	84	112	60	50	2
Turning Holder	C5-*CE-PU400MB-045040	C5	192	112	40	45	1
Boring Bar Holder	C5-*CI-PU400MB-060050	C5	92	112	60	50	2
Turning Holder	C6-*CE-PU400MB-057030	C6	214	112	30	57	1
Boring Bar Holder	C6-*CI-PU400MB-060050	C6	102	112	60	50	2

Part	Product Code	Size	Dimensions (mm)				Type
			b ₂	h ₂	l _{1x}	l _{1z}	
480/L, 600/L, 600MB, 700/L, 800/L							
Turning Holder	C5-*CE-PU600-043050	C5	225	150	50	43	1
Boring Bar Holder	C5-*CI-PU600-060014	C5	92	140	60	14	2
Boring Holder- dual high & low pressure	C5-*CI-PU600-060088	C5	92	140	60	88	5
Turning Holder	C6-*CE-PU600-058045	C6	250	140	45	58	1
Boring Bar Holder	C6-*CI-PU600-060015	C6	102	140	60	15	2
Boring Bar Holder	C8-*CI-PU600-060027	C8	110	140	60	27	2
Turning Holder	C8-*CE-PU600-054030	C8	254	140	30	54	1
500							
Turning Holder	C5-*CE-PU500-032050	C5	214	140	50	32	1
Boring Bar Holder	C6-*CE-PU500-060024	C6	102	140	60	24	2
600M/LM, 700M/LM, 800M/LM (BMT 85 Turret)							
Turning Holder	C5-*CE-PU600M-043035	C5	215	130	35	43	1
Boring Bar Holder	C5-*CI-PU600M-085055	C5	117	130	85	55	2
Turning Holder	C6-*CE-PU600M-043036	C6	225	130	36	43	1
Boring Bar Holder	C6-*CI-PU600M-085056	C6	127	130	85	56	2
Turning Holder	C8-*CE-PU600M-055050	C8	245	135	50	55	1
Boring Bar Holder	C8-*CI-PU600M-085056	C8	135	135	85	56	2

Part	Product Code	Size	Dimensions (mm)						Type
			b ₂	h ₂	l _{1x}	l _{1z}	l _{2x}	l _{2z}	
MX2000ST, MX2500ST, V400M (BMT65 Turret), TT2000SY, 2500M/MS/SY - Up & Low BMT65 turrets									
Double Turning Holder	C4-*CE-MX2000-000080 DT	C4	130	97	80	29		53	4
Boring Holder	C4-*CI-MX2000-115075	C4	139	97	115	75			5
Boring Holder - Sub Spindle	C4-*CI-MX2000-115015 SS	C4	139	97			115	15	6
Turning Holder - Main & Sub Spindle	C4-*CE-MX2000-029080	C4	106	100	80	29			7
Double Boring Holder	C4-*CI-MX2000-115000 DB	C4	139	91	115	166		61	8
V550 8 Station, 10 Station									
Boring Holder	C5-*CI-PUV550-050040	C5	82	140	50	40			2
Boring Holder	C6-*CI-PUV550-050051	C6	92	140	50	51			2
Turning Holder	C5-*CE-PUV550-045040	C5	206	140	40	45			2

Part	Product Code	Size	Dimensions (mm)						Type
			b_2	h_2	l_{1X}	l_{1Z}	l_{2X}	l_{2Z}	
Turning Holder	C6-*CE-PUV550-025025	C6	193	120	25	25			1
Boring Holder	C5-*CI-PUV550-040025	C5	72	120	40	25			2
Boring Holder	C6-*CI-PUV550-040029	C6	82	120	40	29			2
VT450 (BMT 65 Turret)									
Turning Holder	C5-*CE-PU300M-043050 VT450M	C5	180	95	50	43			1
Boring Holder	C5-*CI-PU300M-072014 VT450M	C5	104	95	72	14			2
VT900/T									
Boring Holder	C6-*CI-VT900-130016	C6	172	126	130	16			5
Turning Holder	C6-*CE-VT900-043055	C6	210	126	55	43			1
VT1100M									
Boring Holder	C5-*CI-VT1100M-150080	C5	182	184	150	80			5
Turning Holder	C6-*CE-VT1100M-035085	C6	227	184	85	35			1
Boring Holder	C6-*CI-VT1100M-150081	C6	192	184	150	81			5

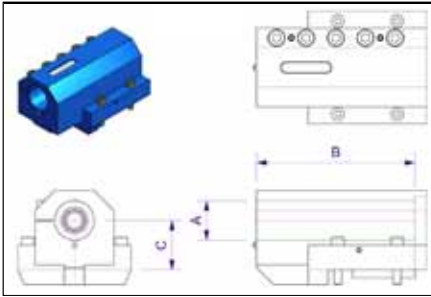
If you can't find the toolholder you are looking for, please contact your local Seco representative as it is possible that we have the solution you require.

Presettters

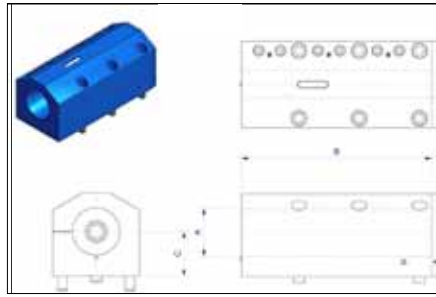
Product Code	Size	Dimensions (mm)
		l_1
C3-NCI-ISO50-000089	C3	89
C4-NCI-ISO40-000090	C4	90
C4-NCI-ISO50-000090	C4	90
C5-NCI-ISO50-000100	C5	100
C6-NCI-ISO50-000130	C6	130
C8-NCI-ISO50-000150	C8	147



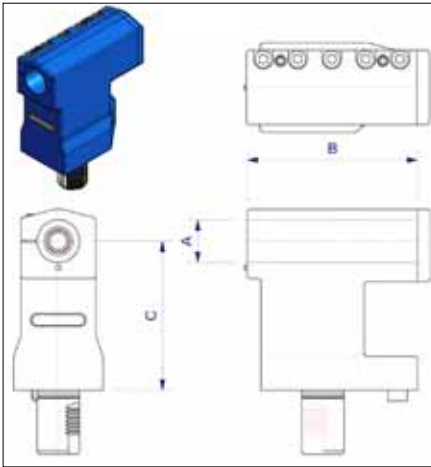
SPLIT BORING BAR HOLDERS



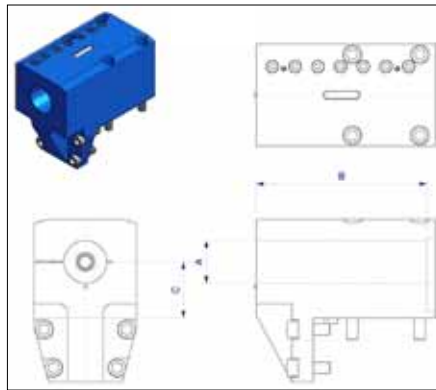
Type 1



Type 3



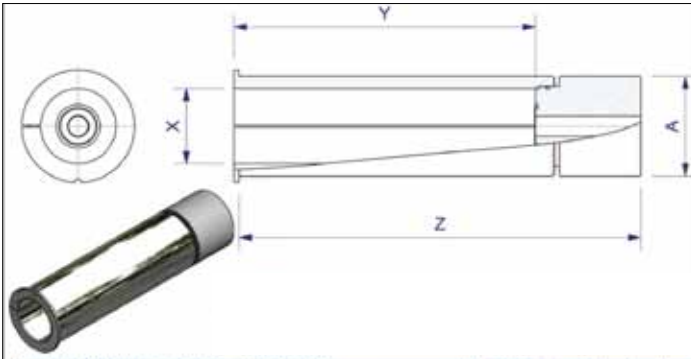
Type 2



Type 4

Doosan - Metric Range		A	B	C	Type
230M, 240M, 280M	SB50-PU230M-060	50	200	60	1
	SB40-PU230M-060	40	160	60	1
300M, MA, LMA, LM, LMB, MB, MC, LMC, MS (BMT65 Turret) 3000M	SB40-PU300M-072	40	160	72	1
300C	SB40-PU300C-040	40	160	40	1
400MA, MB, LMA, LMB (BMT75 Turret)	SB60-PU400MB-060	60	240	60	4
400A, B, C, LA, LB 6-bolt turrets	SB50-PU400-6H-040	50	200	40	1
400A, B, C, LA, LB 4-bolt turrets	SB40-PU400-040	40	160	40	1
500	SB80-PU500-060	80	320	60	1
	SB60-PU500-060	60	240	60	1
600M, LM, 700M, LM, 800M, LM (BMT85 Turret)	SB100-PU600M-085	100	400	85	4
	SB80-PU600M-085	80	320	85	4
	SB60-PU600M-085	60	240	85	4
480, 480L, 480XL, 600, 600L, 700, 700L, 800, 800L	SB80-PU600-060	80	320	60	1
	SB60-PU600-060	60	240	60	1

REDUCING SLEEVE ASSEMBLIES



Benefits of the Reducing Sleeve Assembly

The same holder can clamp a range of boring bars by using reduction sleeves.

Features include:

- Combined captive spacer which maintains a 4 x diameter clamp length.
- Easy withdrawl of both sleeve and spacer.
- Assembly alignment notch.

Reducing Sleeve Assemblies - Metric Range		W	X	Y	Z
100mm - 80mm	SL100080	100	80	320	400
80mm - 60mm	SL080060	80	60	240	320
60mm - 50mm	SL060050	60	50	200	240
60mm - 40mm	SL060040	60	40	160	240
60mm - 32mm	SL060032	60	32	128	240
50mm - 40mm	SL050040	50	40	160	200
50mm - 32mm	SL050032	50	32	128	200
40mm - 32mm	SL040032	40	32	128	160

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CRAFTSMAN TOOLS

Collaborating with the World's Finest

Craftsman Tools Ltd is a UK registered precision engineering company that specialises in toolholding and workholding solutions. The company is not associated in any way with Sears Roebuck or their range of Craftsman hand tools or lawn and garden products.



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