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TRAUB

Product note

INDEX TRAUB CAPTO with 2-flat actuator

Live tools

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*better.parts.**faster.***

Note on applicability

Illustrations in this publication may deviate from the product supplied. Errors and ommissions due to technical progress expected.

A word on copyright

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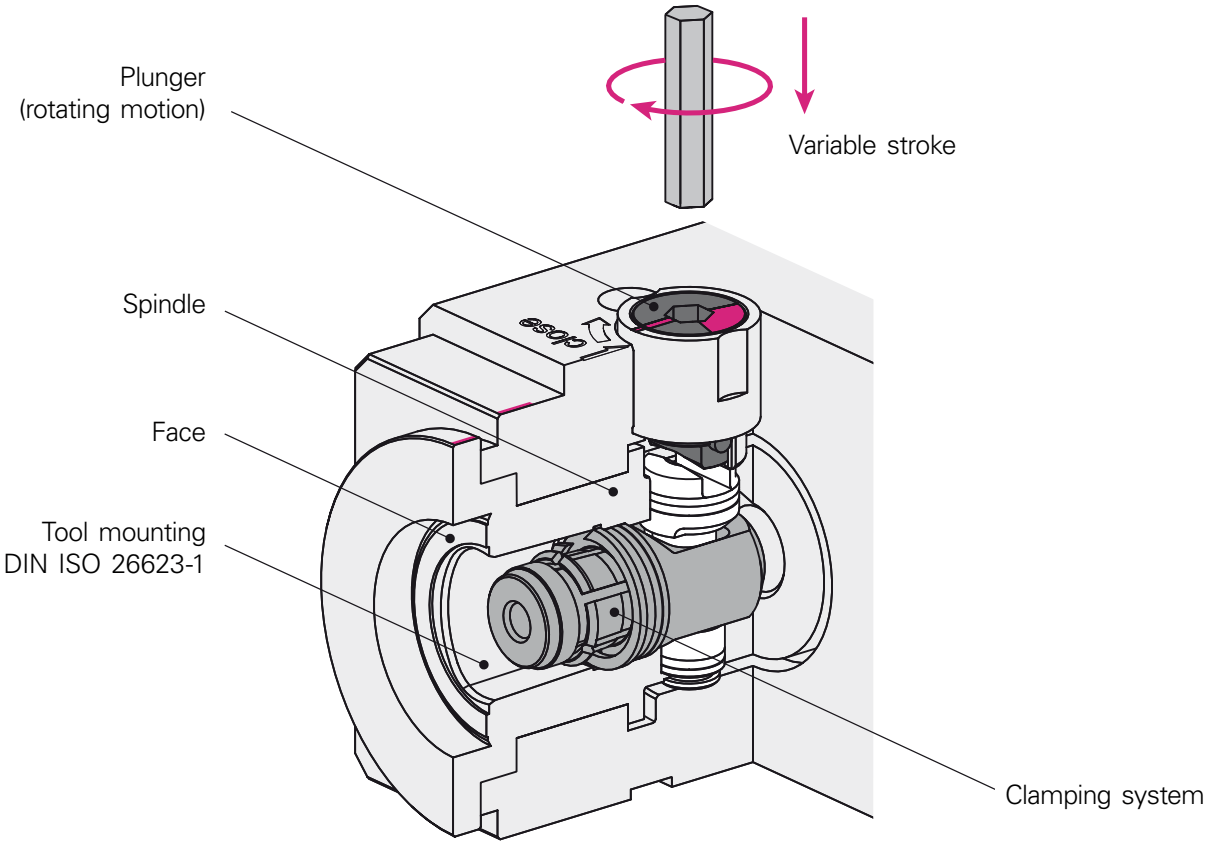
CAPTO system

A feature of the tool interface and contact surface according to DIN ISO 26623-1 is the polygonal hollow shaft taper that allows safe and backlash-free fixing in position and transmission of high torques without additional elements such as drive slots.



Technical highlights

- Very compact installation space
- High power gain and compact power flow by transmission in the clamping system
- Automatic tool ejection upon release by the clamping system
- Sealed system for central coolant supply
- Separate blow-out possible of the clamping system

The prescribed actuating stroke of the plunger must be achieved during release and clamping.

The plunger must be in raised position before the tool drive can be used.

With internal coolant supply, filtering the coolant to at least 50 microns must be ensured.

The tool holder must not be operated without clamping the tool adapter.

The tool adapter must only be used in the base position.

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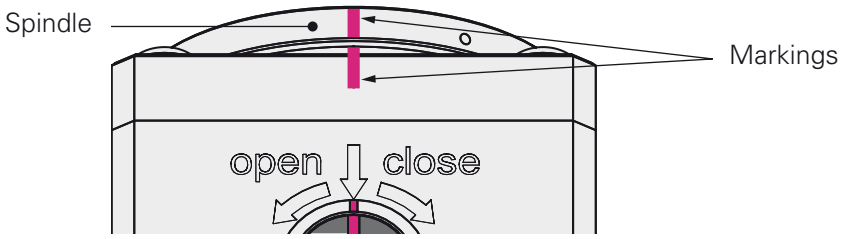
Cleaning the face contact surface

- Ensure absolute cleanliness when changing the tool.
- All functional surfaces must be cleaned before the clamping process.

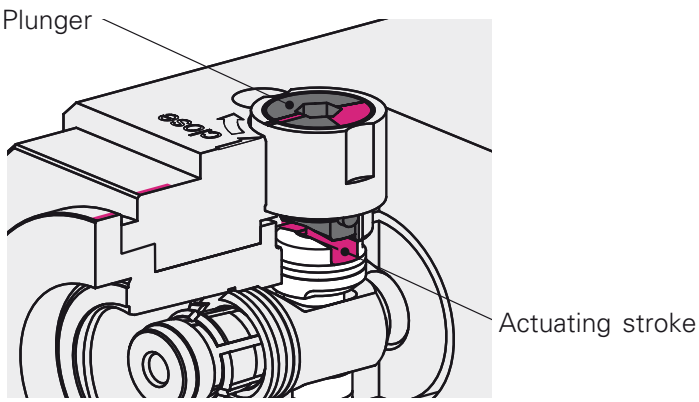
Adjustment

- Before the clamping system can be actuated, the markings on the housing and the spindle must be aligned to each other.
- To do so, rotate the spindle until it reaches the desired position.



Base position

- Delivery condition
- If the actuating stroke cannot be executed completely, the plunger must be rotated until this is possible.



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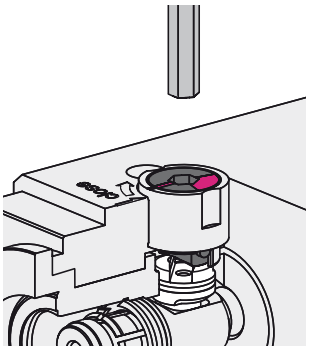
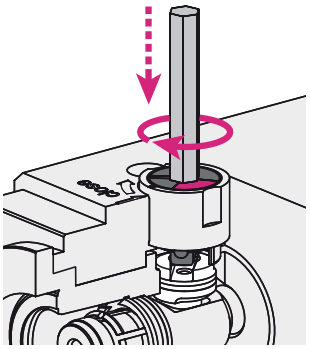
Bringing into base position

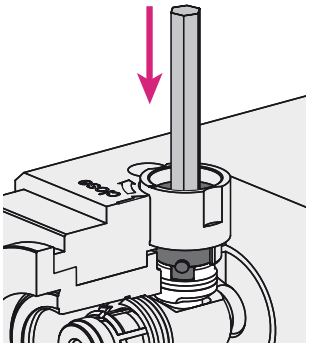
- For this, the spring of the plunger must be brought in the position of the clamp groove.



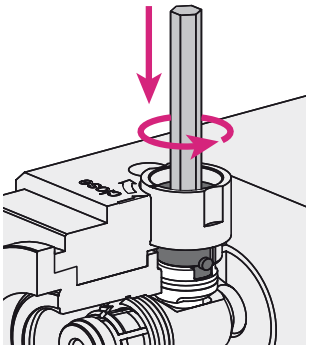
- Slightly depress the tool key.
- The actuating stroke cannot fully be executed.



- Rotate until the spring of the plunger can engage into the groove of the clamp.



- In the depressed position, the spring can engage into the groove of the clamp.
- The actuating stroke can fully be executed.



- With the tool key depressed, rotate it counterclockwise until the base position is reached.

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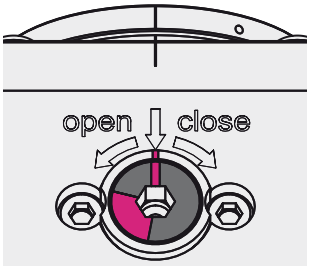
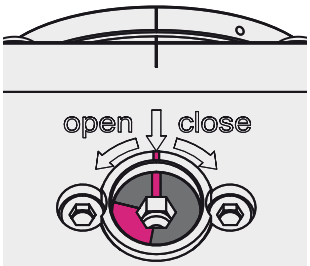
Inserting the tool adapter in base position

- When delivered, the tool clamp is open.
- The clamping actuator is in the base position.
- The tool adapter can be inserted in this position.
- An integrated latching function locks the tool adapter in the spindle.



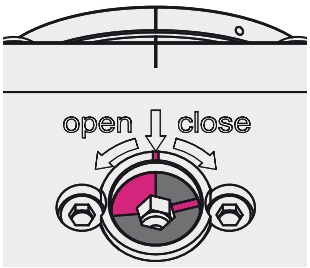
Clamping the tool adapter

- By pushing the plunger, it engages in the clamping mechanism, and by a subsequent rotation in the clockwise direction, the clamping mechanism is actuated.
- Make sure that the prescribed actuating stroke is achieved. For this, the spindle must be aligned as described in Section "Adjustment".
- For the torque and actuating stroke, see the Technical Data table (page 8).



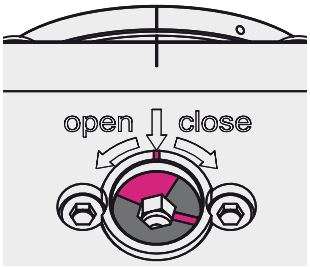
Self-locking range

- From a rotation of 75°, the clamp enters the self-locking range and the tool adapter is clamped.
- With increasing angle of rotation, the clamping force of the tool adapter is increased.



Maximum torque

- The specified maximum torques for maximum clamping force are achieved from a rotation angle of approximately 105°.
- For the forces and torques, see the Technical Data table (page 8).



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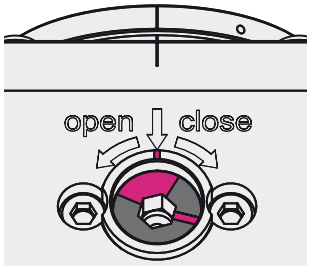
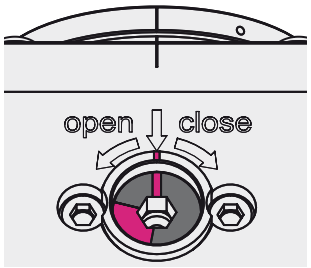
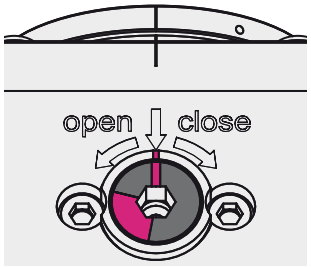
Releasing the tool adapter



- For this, the spindle must be aligned as described in Section "Adjustment".
- To release the tool adapter, depress the plunger again and rotate it counterclockwise to the base position.
- Make sure that the prescribed actuating stroke is achieved.



- If the actuating stroke cannot be fully executed, proceed as described in Section "Bringing into base position".



- Ejecting the tool adapter briefly requires an increased release torque shortly before reaching the end position.
- To release the adapter, see the specification in the Technical Data table (page 8).

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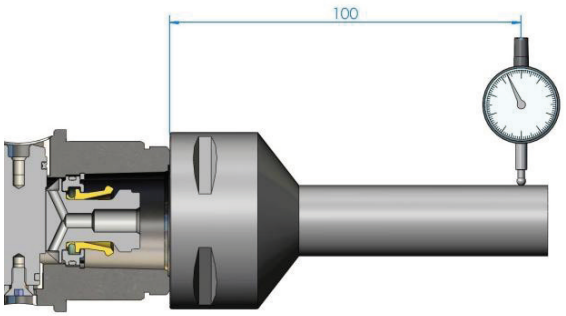
Technical data

	C3	C4	C5
Latching function	20 N	30 N	40 N
Force max.	16 kN	22 kN	27 kN
Torque max.	35 Nm	50 Nm	70 Nm
Release force	8 kN	10 kN	13 kN
Release torque	17 Nm	25 Nm	35 Nm
Actuating stroke	4 mm	4 mm	4.5 mm

Tightening torque when using mandrel gauges

Size	Actuation	Concentricity	Torque
C3	SW 6	0.025 mm	25 Nm
C4	SW 8	0.025 mm	40 Nm
C5	SW 10	0.025 mm	70 Nm



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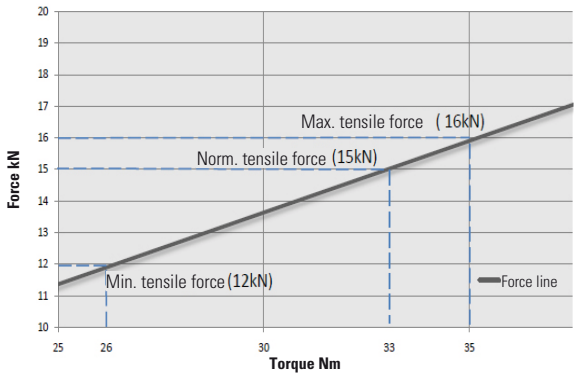
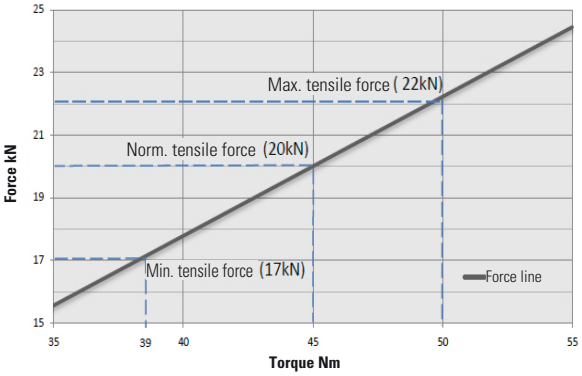
Charts

The German Industrial Standard (DIN) defines for this system a minimum tensile force, which is achieved by the torques shown in the chart.
In the rotating range, a torque according to ISO 26623-2 is required.
If high cutting forces occur in the static range, the maximum tensile forces at the maximum torque can be achieved as indicated in the charts.

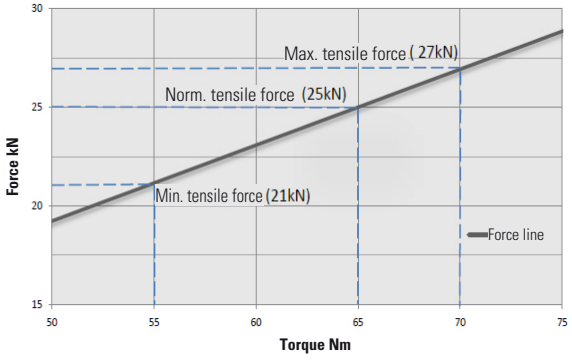
Force vs. torque chart C3



Force vs. torque chart C4



Force vs. torque chart C5



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