

SYNCHRONIZED TAPPING HOLDER (for 100% Synchronized Feed)



■ Synchronized (Rigid or Direct) Tapping Feed Function is one of recent machining function to feed 1 pitch of tap per 1 revolution of machine spindle.

Please use High Run-Out Accuracy & Powerful Gripping of SLIM CHUCK or MULTI LOCK Milling Chuck for this application.

■ Tapping holder & Collet for 100% Synchronized Tapping

■ For JIS TAP Shank

Metric Tap	Tap Shank Dia.	SLIM CHUCK	SLIM COLLET	MILLING CHUCK	KM COLLET
M 2	3.0	SK10	SK10- 3	C20	KM20- 5.5 KM20- 6 KM20- 6.2 KM20- 7 KM20- 8.5 KM20-10.5 KM20-12.5 KM20-14 KM20-15
M 3	4.0		SK10- 4		
M 4	5.0		SK10- 5		
M 5	5.5		SK10- 5.5		
M 6	6.0		SK10- 6		
M 8	6.2		SK10- 6.5		
M10	7		SK13- 7		
M12	8.5		SK13- 8.5		
M14	10.5	SK13-10.5	C32	KM32-17 KM32-19 KM32-20 KM32-23	
M16	12.5	SK16-12.5			
M18	14	SK16-14			
M20	15	SK16-15			
M22	17				
M24	19				
M27	20				
M30	23				

■ For ISO TAP Shank

Metric Tap	Tap Shank Dia.	SLIM CHUCK	SLIM COLLET	MILLING CHUCK	KM COLLET
M 2	3.0	SK10	SK10- 3	C20	KM20- 6 KM20- 8 KM20-10 KM20-12
M 3	4.0		SK10- 4		
M 4	6.0		SK10- 6		
M 5	6.0				
M 6	6.0				
M 8	8.0		SK13- 8		
M10	8.0				
M12	10.0		SK13-10		
M14	12.0	SK13-12	C32	KM32-20 KM32-25	
M16	16.0				
M18	16.0	SK16-16			
M20	16.0				
M22	20.0				
M24	20.0				
M27	20.0				
M30	25.0				

★ Tap Collet for Tap with Oil Hole is also available.

★ At use of MILLING CHUCK, please use tap with shank tolerance h7.

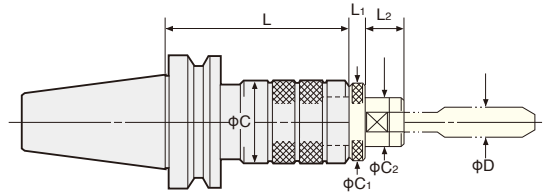
SYNCHRONIZED TAPPING HOLDER (with fine floating)



■ This fine floating tapping holder improves tap life remarkably by absorbing fine pitch error completely with the small floating mechanism.



Center Through Tool Coolant



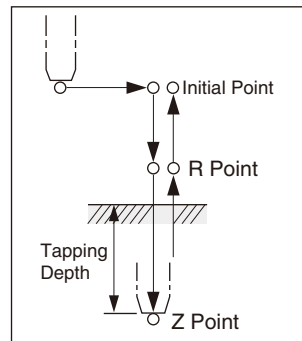
ZH-C

TAPER	Code No.	L	C	Weight (kg)	Tap Collet
No.40	BT40-ZH12CH- 80	80	36	1.2	ZMK12
	-105	105		1.5	OZMK12-OM
	-135	135		1.8	
	-ZH16CH- 95	95		1.5	ZMK16
	-120	120	45	1.9	OZMK16-OM
	-150	150	2.3		
	-ZH24CH-105	105	56	1.8	ZMK24
	-120	120	2.0		
-150	150	2.4			
No.50	BT50-ZH12CH- 90	90	36	3.9	ZMK12
	-135	135		4.3	OZMK12-OM
	-165	165		4.6	
	-200	200		5.0	
	-ZH16CH-105	105	45	4.2	ZMK16
	-135	135	4.6		
	-165	165	5.0		
	-200	200	5.5		
	-ZH24CH-105	105	56	4.4	ZMK24
	-135	135	5.0		
	-165	165	5.6		
	-200	200	6.2		

OZMK-OM Tap Collet

	OZMK12-OM		OZMK16-OM			OZMK24-OM		
D	M8	M8-M12	M6	M8-M12	M14-M16	M12	M14-M16	M18-M24
D ₂	19		25			30		
D ₃	28		36			42		
D ₄	13	19	13	19	26	19	26	32
H	16	20	21			29		
H ₁	6		6			8		
G	M4-0.5	M6-0.75	M4-0.5	M6-0.75		M6-0.75	M8-1.0	

■ Example of RIGID TAP cycle



No.1 MO3 S ... ; Spindle Rotation
No.2 G84.2 X ... Y ... Z ... R ... F ... ;
Rigid Tap Cycle Z point R point ★ Feed

★ F is calculated by Pitch of Tap and Spindle Rotation Speed.

For example, in case of M10×P1.5 and S400min⁻¹ (Cutting Speed 12.6m/min.) then F = 1.5mm×400min⁻¹ = 600 mm/min.

★ Please use OZMK-OM tap collet for center through tool coolant.

★ Please use ZMK P.66 tap collet for external coolant. In this case, the spacer attached as standard accessory is put on a tapper chuck.

ZH-C Tapping Holder has fine floating mechanism, but it's not standard floating system (Tension/Compression) like Z or ZL Tap Holder.



Therefore, please use this ZH Tap Holder only with synchronized tapping cycle, not with ordinary tapping cycle.



★ When use ZMK Collett, please attach a spacer (white) to ZH-C Tapping Holder with an attached bolt.