

SYNCHRO TAPPING HOLDER

(OPERATING INSTRUCTIONS)



1. DESCRIPTION:

Synchro Tapping Holder compensates synchronization errors during rigid tapping process.

An innovative adjustable viscoelastic system, especially designed to deliver controlled degree of freedom during tapping process performed on CNC machining centers or CNC milling/drilling machines.

Holder is endowed with a cylindrical coupling shaft DIN 1835 B+E, and taps shafts are clamped in ER collets DIN 6499 or Weldon.

Technical characteristics

- high concentricity
- adjustable stiffness
- with internal coolant-lubricant supply
- maximum working pressure 50 bar.
- short reaction time

Advantages

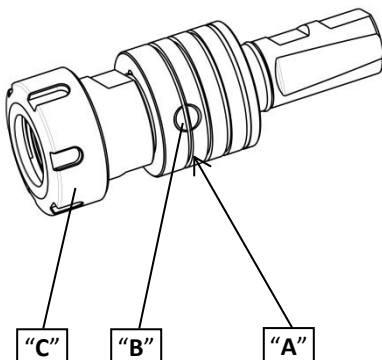
- increase taps life up to 60%
- improve thread quality
- minimized CNC machine downtimes

2. SETTING OF AXIAL FORCE

Tool Holder has an initial preset value for axial force value.

Depending of the tap which will be used and of material characteristics it will be set axial force, as follows:

- It is dismantling the toroidal spring **"A"**
- Axial force can be increased (by turning clockwise the screws **"B"**) or decreased (by turning anticlockwise the screws **"B"**) with a normal plate screwdriver.
- When you make fitting of screws **"B"**, please turn them with equal turns.
- Is to be avoided to tightened the screws till the locking of them.
- Finally, set the two **"B"** screws in place, by putting back the toroidal spring **"A"** into his initial position.



3. TAP CLAMPING

- Put ER collet correctly inside the ER nut **"C"**.
- Clean the inner cone of the holder, from swarf and other grains (it may appear an axial error alignment of the tap if you do not fulfil this supplementary cleaning).
- Put the collet inside the holder cone.
- Put the shaft of the desired tap inside the collet hole and tight ER nut **"C"** with proper nut spanner.
- Collet will be choose in conformity with the tap shaft diameter.

For threading operation with internal cooling it will be used specific ER sealed collets.

