



Tap Holder

SYNCHROMASTER SYNCHROFIT

Volume 3



KEY FEATURES: SYNCHROMASTER

1 Enables accurate depth control
Achieves stable performance even with difficult small chamfer

3 Prevents sudden breakage

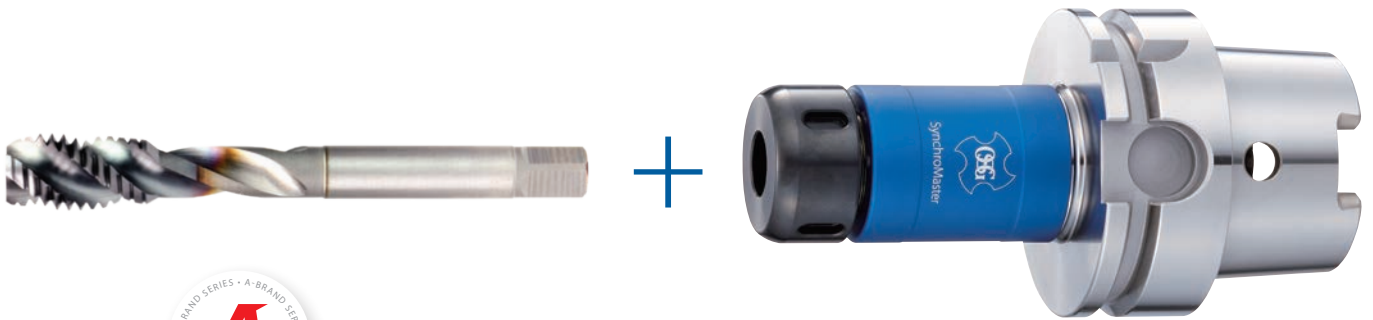
2 Improves thread quality

4 Prolongs tool life

5 The combination of SynchroMaster and synchronous feed machines brings out the best of your A-TAP tools

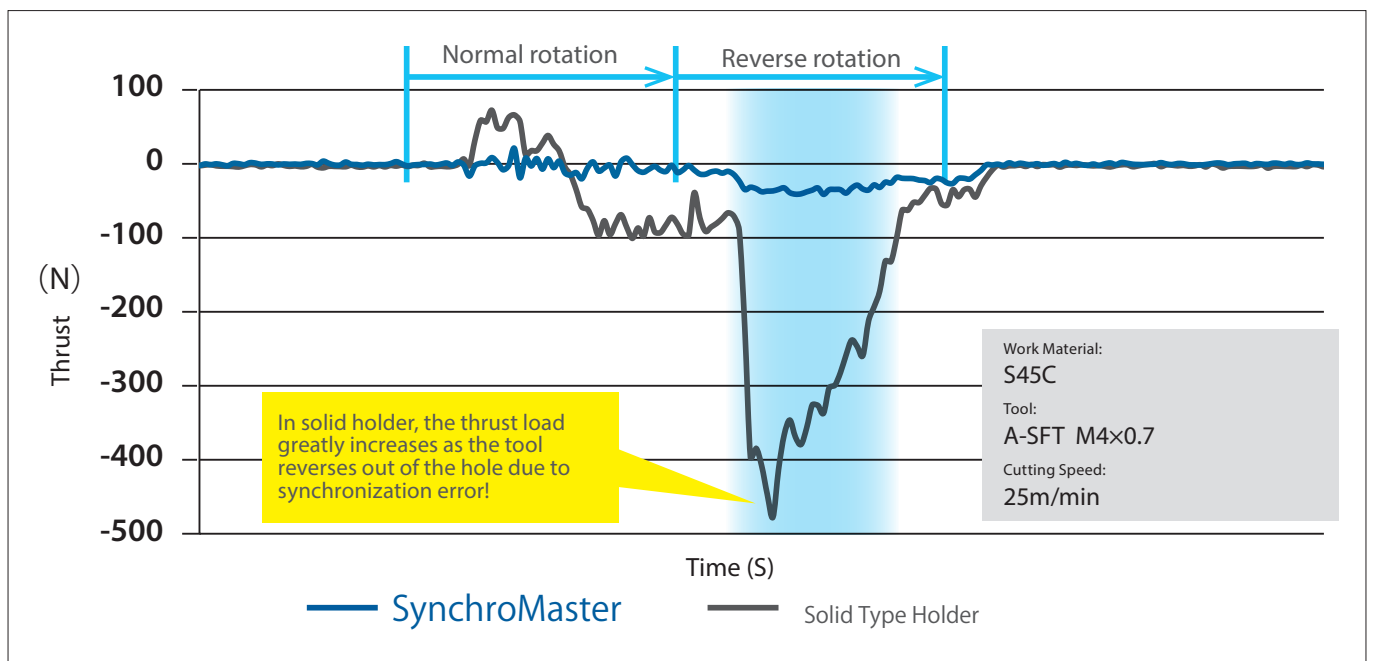


SYNCHROMASTER TAP HOLDER



A-TAP & SYNCHROMASTER THE BEST SOLUTION

SynchroMaster reduces axial and radial forces to enable the A-Tap series to reach its maximum potential !



| Machine | Holder | Tap (example) | Recommendation |
|---|---------------|---------------------------------------|----------------|
| Machine with synchronous feed mechanism | SynchroMaster | A-TAP (A-SFT, A-POT, S-XPf) | ● |
| | | General purpose tap (EX-SFT, TIN-POT) | ○ |

Synchro Tap is recommended to be used in combination with a solid holder and machine with synchronous feed mechanism

●: Best ○: Good



SYNCHROMASTER TAP HOLDER

The secret lies in its integrated single unit construction!

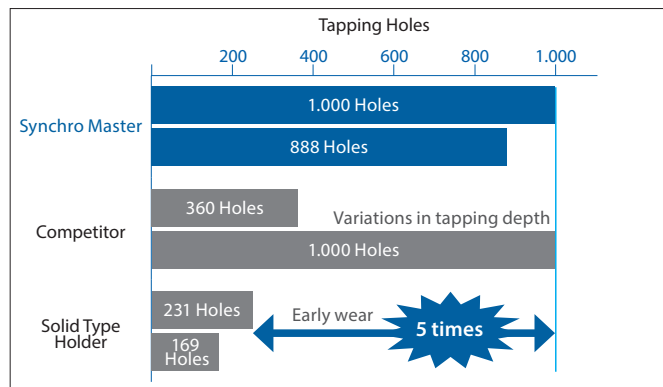
- Original metal flexure mechanism enables long tool life
- Ultra-small float mechanism ensures consistent tapping depth



- Disadvantages of General micro float holder
- Float mechanism that allows the 2-piece body construction with resin or rubber type damper to move in the thrust direction
 - Early degradation of the damper mechanism
 - Requires maintenance

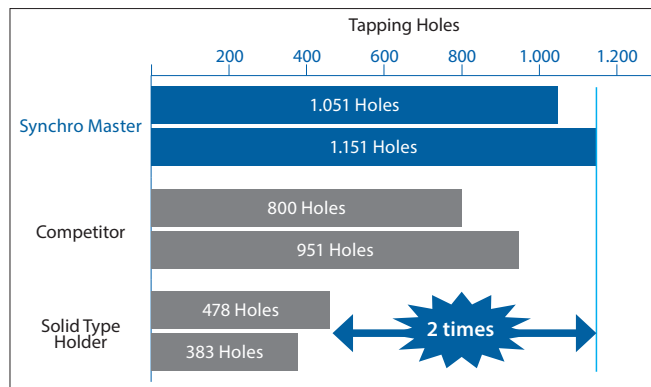
Long tool life

Stable performance even with difficult short chamfer



Work Material: S45C Tool: A-SFT M4x0.7 1P Cutting Speed: 10m/min

Durability of forming taps can also be improved



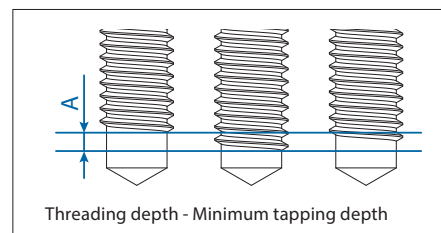
Work Material: SCM440 (30HRC) Tool: S-XPF M10x1.5 2P Cutting Speed: 15m/min

Suppresses variations in tapping depth

Achieves high precision tapping depth comparable to solid type holder

| Holder | Tap (example) |
|-------------------|---------------|
| SynchroMaster | 0.10 mm |
| Competitor | 0.20 mm |
| Solid Type Holder | 0.07 mm |

Work Material: S45C Tool: S-XPF M10x1,5 2P Cutting Speed: 22m/min



SynchroMaster (Holder+Nut)



Collet (Sold separately)



Spanner (Sold separately)

SFH SYNCHROFIT TAP HOLDER

Modern CNC machine tapping centers are designed to synchronize spindle rotation with the feed axis. In rigid tapping high axial forces have to be absorbed by the tap's thread flanks. This increased abrasive flank wear reduces the tool life of the tap as well as the surface quality and accuracy to gauge of the thread resulting in a significant decrease of process reliability, this may result in breakage of the tap. SynchroFit Tap Holder with it's new wear free radial cutting force compensation reduces the tap flank wear significantly.



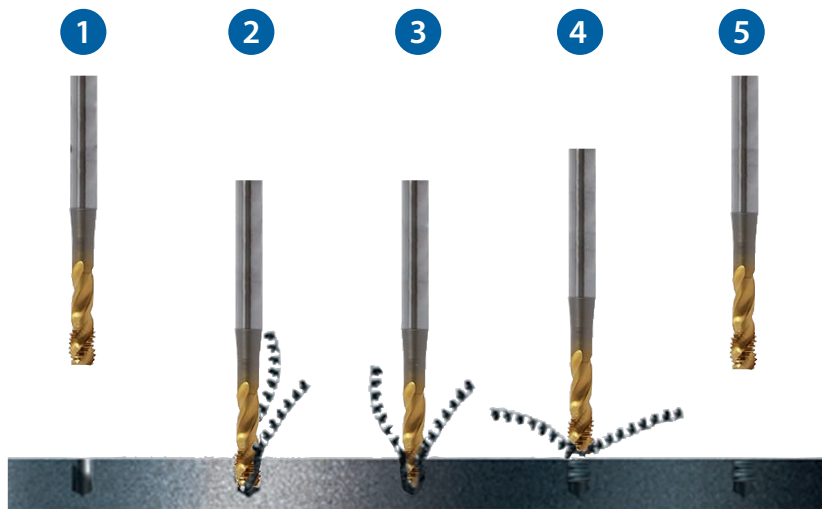
- Increased tool life
- Higher thread quality
- Increased process reliability

Most Synchro Tapping Chucks having a simple minimal length compensation using plastic elements. Deforming and harden appears after some time until compensation of synchronisation error is not possible anymore. Lifetime is reduced drastically compared to SynchroFit.

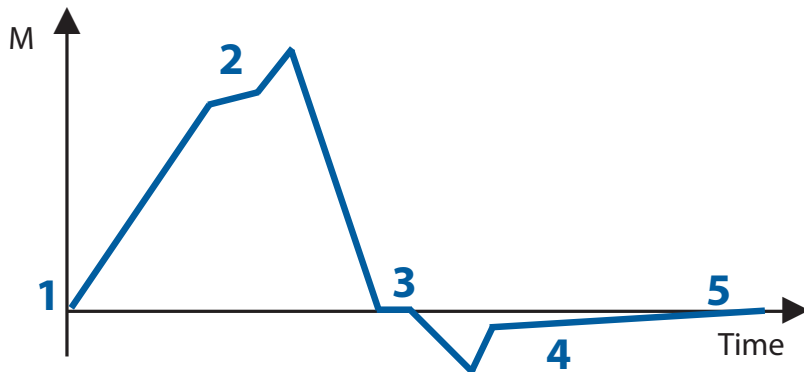


SFH SYNCHROFIT TAPPING HOLDER

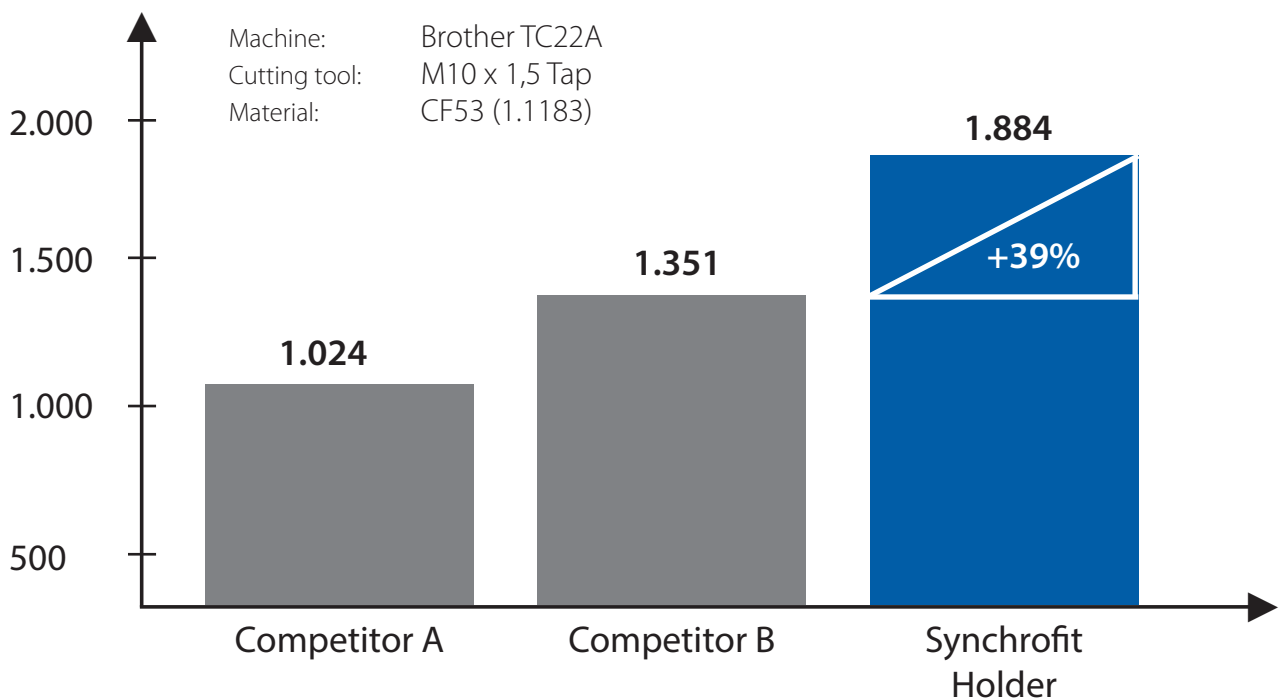
Tapping process



- **Step 1 & 2**
When cutting process starts, torque is increasing strongly.
- **Step 3**
When the spindle stops the torque is zero.
- **Step 4**
Again torque is increasing due to cutting of the residual chip at the end of the thread.
- **Step 5**
Torque is decreasing steadily down to zero. (depending on direction of rotation)



Tool life comparison



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