SYNCHRONIZED TAPPING HOLDER (for 100% Synchronized Feed) NIKKEN

■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		
M 3	4.0		SK10- 4		
M 4	5.0		SK10- 5		
M 5	5.5		SK10- 5.5	C20	KM20- 5.5
M 6	6.0		SK10- 6		KM20- 6
M 8	6.2		SK10- 6.5		KM20- 6.2
M10	7	SK13	SK13- 7		KM20- 7
M12	8.5		SK13- 8.5		KM20- 8.5
M14	10.5		SK13-10.5		KM20-10.5
M16	12.5	SK16	SK16-12.5		KM20-12.5
M18	14		SK16-14		KM20-14
M20	15		SK16-15		KM20-15
M22	17			C32	KM32-17
M24	19				KM32-19
M27	20				KM32-20
M30	23				KM32-23

★Tap Collet for Tap with Oil Hole is also available.
★At use of MILLING CHUCK, please use tap with shank tolerance h7.

■For ISO TAP Shank

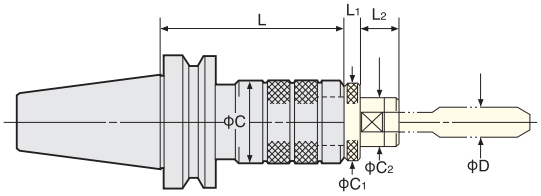
Metric Tap	Tap Shank Dia.	SLIM CHUCK	SLIM COLLET	MILLING CHUCK	KM COLLET
M 2	3.0	SK10	SK10- 3		
M 3	4.0		SK10- 4		
M 4	6.0		SK10- 6	C20	KM20- 6
M 5	6.0				
M 6	6.0				
M 8	8.0	SK13	SK13- 8		KM20- 8
M10	8.0				
M12	10.0		SK13-10		KM20-10
M14	12.0		SK13-12		KM20-12
M16	16.0	SK16	SK16-16		KM20-16
M18	16.0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

SYNCHRONIZED TAPPING HOLDER (with fine floating) NIKKEN

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

NEW

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 OZMK12-OM
	-105	105		1.5	
	-135	135		1.8	
	-ZH16CH- 95	95	45	1.5	ZMK16 OZMK16-OM
	-120	120		1.9	
	-150	150		2.3	
	-ZH24CH-105	105	56	1.8	ZMK24 OZMK24-OM
	-120	120		2.0	
	-150	150		2.4	
No.50	BT50-ZH12CH- 90	90	36	3.9	ZMK12 OZMK12-OM
	-135	135		4.3	
	-165	165		4.6	
	-200	200		5.0	
	-ZH16CH-105	105	45	4.2	ZMK16 OZMK16-OM
	-135	135		4.6	
	-165	165		5.0	
	-200	200		5.5	
	-ZH24CH-105	105	56	4.4	ZMK24 OZMK24-OM
	-135	135		5.0	
	-165	165		5.6	
	-200	200		6.2	

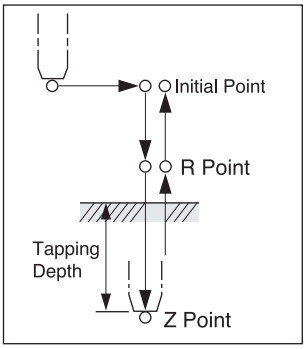
★Please use **OZMK-OM** tap collet for center through tool coolant.
★Please use **ZMK** ☞**P.58** tap collet for external coolant. In this case, the spacer attached as standard accessary is put on a tapper chuck.

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.**

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
Initial point
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.