



Maximum performance in thread machining

# SYNCHROFIT

Volume 3

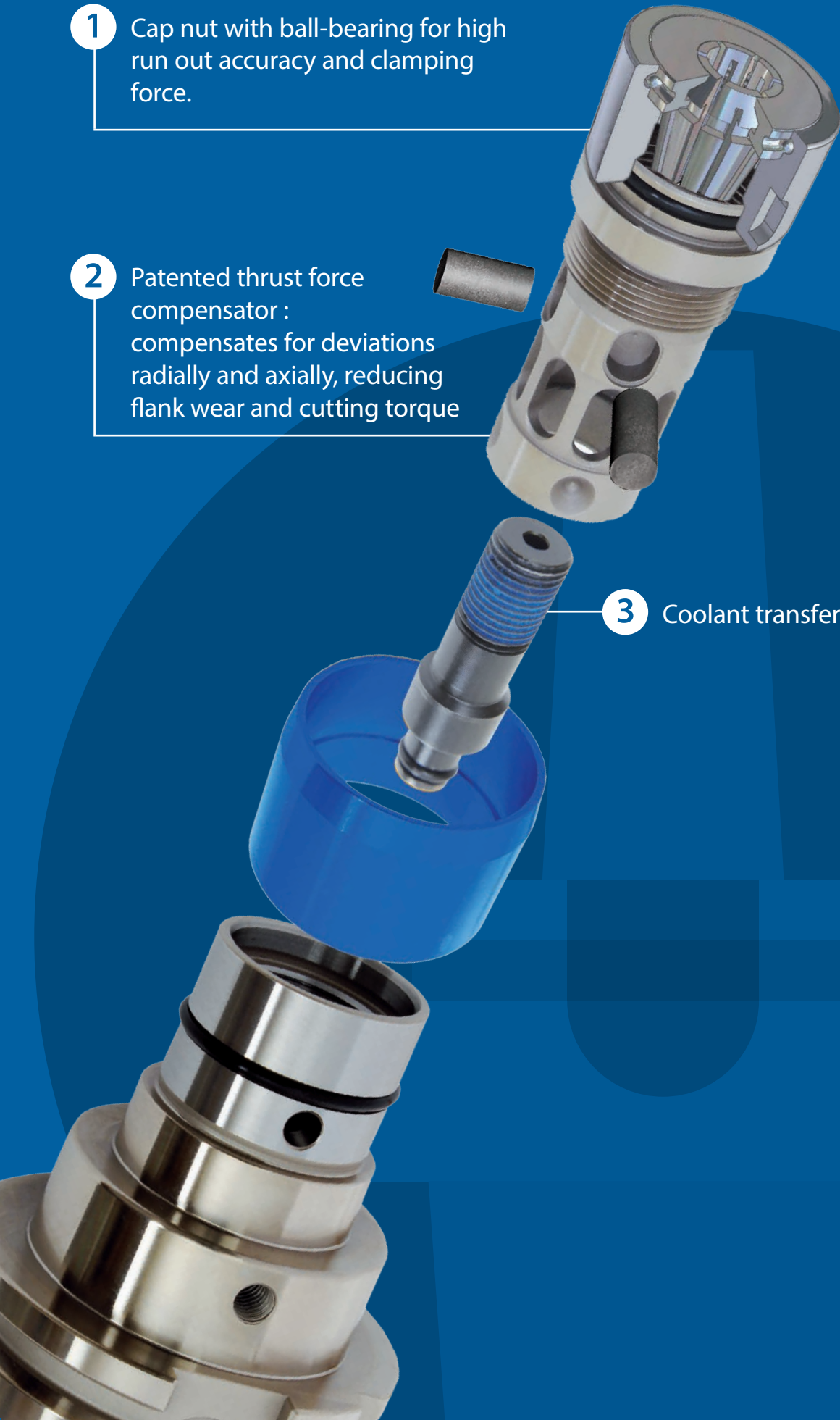


# Key Features : SFH SYNCHROFIT

**1** Cap nut with ball-bearing for high run out accuracy and clamping force.

**2** Patented thrust force compensator : compensates for deviations radially and axially, reducing flank wear and cutting torque

**3** Coolant transfer unit



# SFH Synchrofit tapping holder

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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 wearfree radial cutting force compensation reduces the tap flank wear significantly.

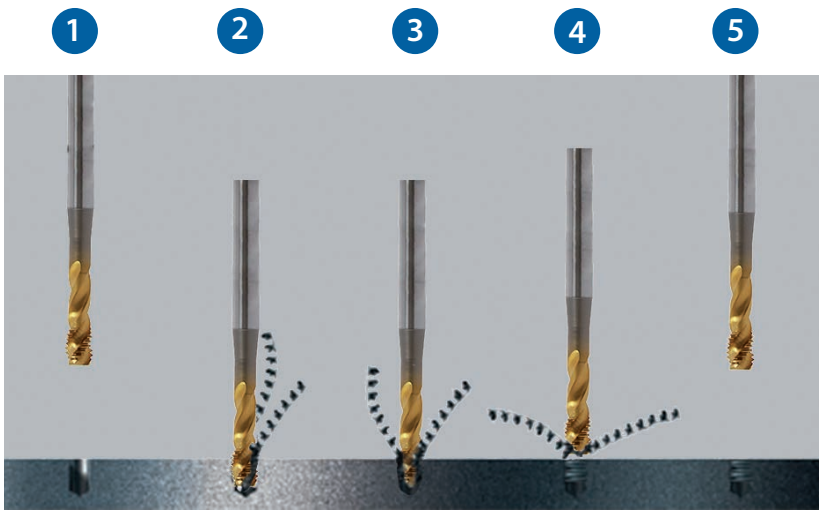
- More tool life
- More thread quality
- More process reliability

Most Synchro Tapping Chucks having a simple minimal length compensation using plastic elements, deforming and harden after some time until no compensation of synchronisation error is possible anymore. Lifetime is reduced drastically compared to SynchroFit.

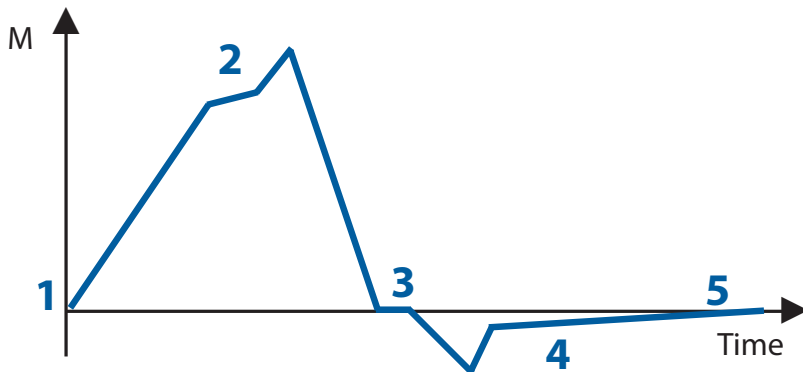


# SFH Synchrofit tapping holder

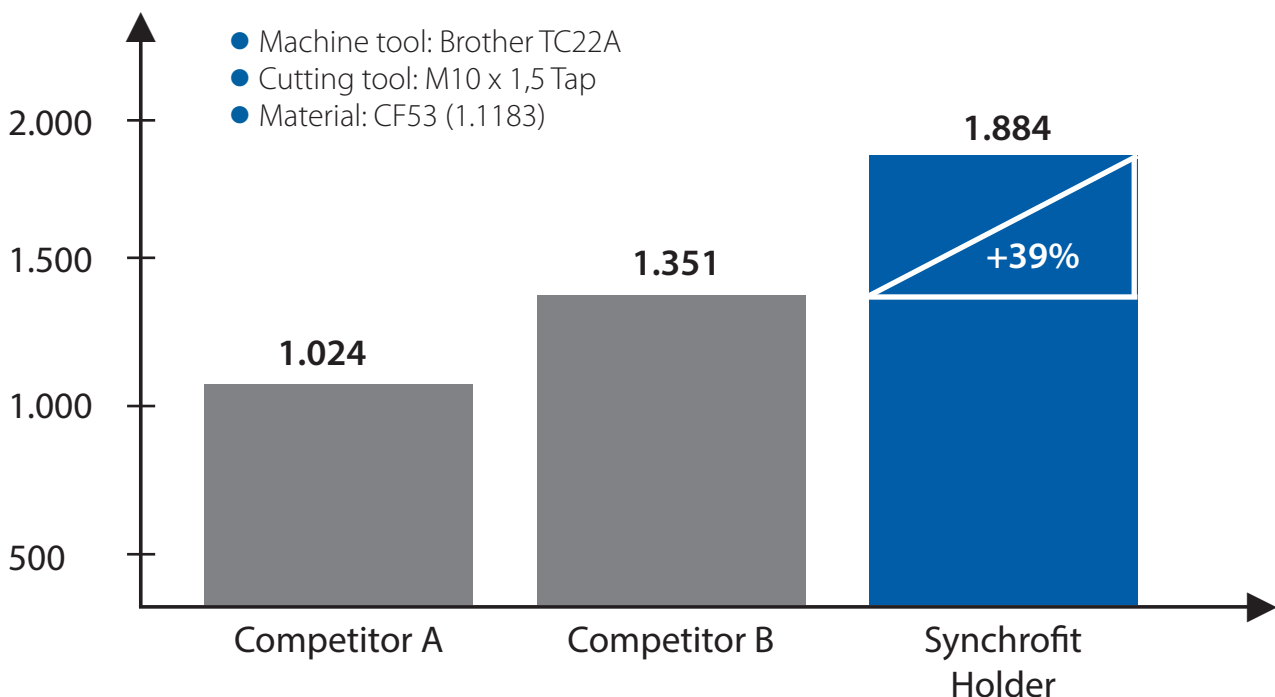
## Tapping process



- **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)

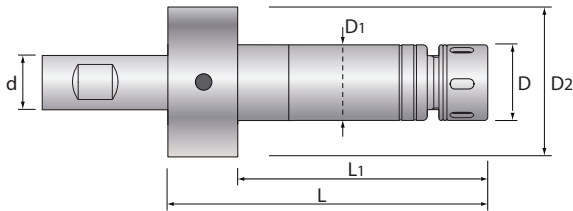




## Tool life comparison

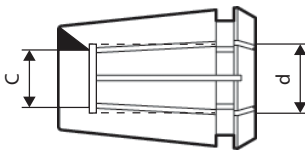


# PLUSLINE SYNCHROFIT


The PlusLine SynchroFit threading holder is equipped with a new, wear-free cutting force compensation. It works like a damper which absorbs the enormous axial thrust and pulling forces. This takes stress from the thread flanks and provides maximum tool life.



| EDP        | Type              | D  | D1 | D2 | L   | L1 | d  |  |  | Price |
|------------|-------------------|----|----|----|-----|----|----|--|---|-------|
| EP01922000 | ST20-SFH-ER16-80  | 32 | 34 | 45 | 80  | 60 | 20 | ER16-GB  | FK-0034   |       |
| EP01922500 | ST25-SFH-ER16-80  | 32 | 34 | 45 | 80  | 60 | 25 | ER16-GB  | FK-0034   |       |
| EP01922001 | ST20-SFH-ER25-105 | 42 | 40 | 45 | 105 | 85 | 20 | ER25-GB  | HS-1-16   |       |
| EP01922501 | ST25-SFH-ER25-105 | 42 | 40 | 45 | 105 | 85 | 25 | ER25-GB  | HS-1-16   |       |



| REFERENCE            | EDP          | C      | d        | DIN 371 | DIN 374-376 | Price |
|----------------------|--------------|--------|----------|---------|-------------|-------|
| ER 16-GB<br>(M4-M11) | 248000304516 | 3,4 mm | Ø 4,5 mm | M4      | M6          |       |
|                      | 248000306016 | 4,9 mm | Ø 6 mm   | M5 - M6 | M8          |       |
|                      | 248000308016 | 6,2 mm | Ø 8 mm   | M8      | M11         |       |
| ER 25-GB<br>(M6-M16) | 248000316025 | 4,9 mm | Ø 6 mm   | M5 - M6 | M8          |       |
|                      | 248000318025 | 6,2 mm | Ø 8 mm   | M8      | M11         |       |
|                      | 248000319025 | 7 mm   | Ø 9 mm   | M9      | M12         |       |
|                      | 248000310025 | 8 mm   | Ø 10 mm  | M10     | -           |       |
|                      | 248000311025 | 9 mm   | Ø 11 mm  | -       | M14         |       |
|                      | 248000312025 | 9 mm   | Ø 12 mm  | -       | M16         |       |
|                      | 248000314025 | 11 mm  | Ø 14 mm  | -       | M18         |       |
|                      | 163000311060 | 12 mm  | Ø 16 mm  | -       | M20         |       |

| EDP          |  | Price |
|--------------|---|-------|
| 244500000034 | FK-0034   |       |
| 071100001016 | HS-1-16   |       |

## SWEDEN

Branch office of OSG SCANDINAVIA  
Abrahams Gränd 8  
295 35 Bromölla  
Sweden  
Tel: +46 40 41 22 55  
Fax: +46 40 41 32 55  
osg@osg-scandinavia.com

## OSG SCANDINAVIA

(For Scandinavian countries)  
Langebjergvaenget 16  
4000 Roskilde  
Denmark  
Tel.: +45 46 75 65 55  
Fax: +45 46 75 67 00  
osg@osg-scandinavia.com

## OSG NETHERLANDS

Bedrijfsweg 5 - 3481 MG Harmelen  
Postbus 50 - 3480 DB Harmelen  
The Netherlands  
Tel.: +31 348 44 2764  
Fax: +31 348 44 2144  
info@osg-nl.com

## OSG UK

Shelton house, 5 Bentalls  
Pipps Hill Ind Est, Basildon Essex SS14 3BY  
United Kingdom  
Tel.: +44 845 305 1066  
Fax: +44 845 305 1067  
sales@osg-uk.com

## OSG EUROPE LOGISTICS

Avenue Lavoisier 1  
B-1300 Z.I. Wavre - Nord  
Belgium  
Tel.: +32 10 23 05 07  
Fax: +32 10 23 05 51  
info@osgeurope.com

## OSG BELUX

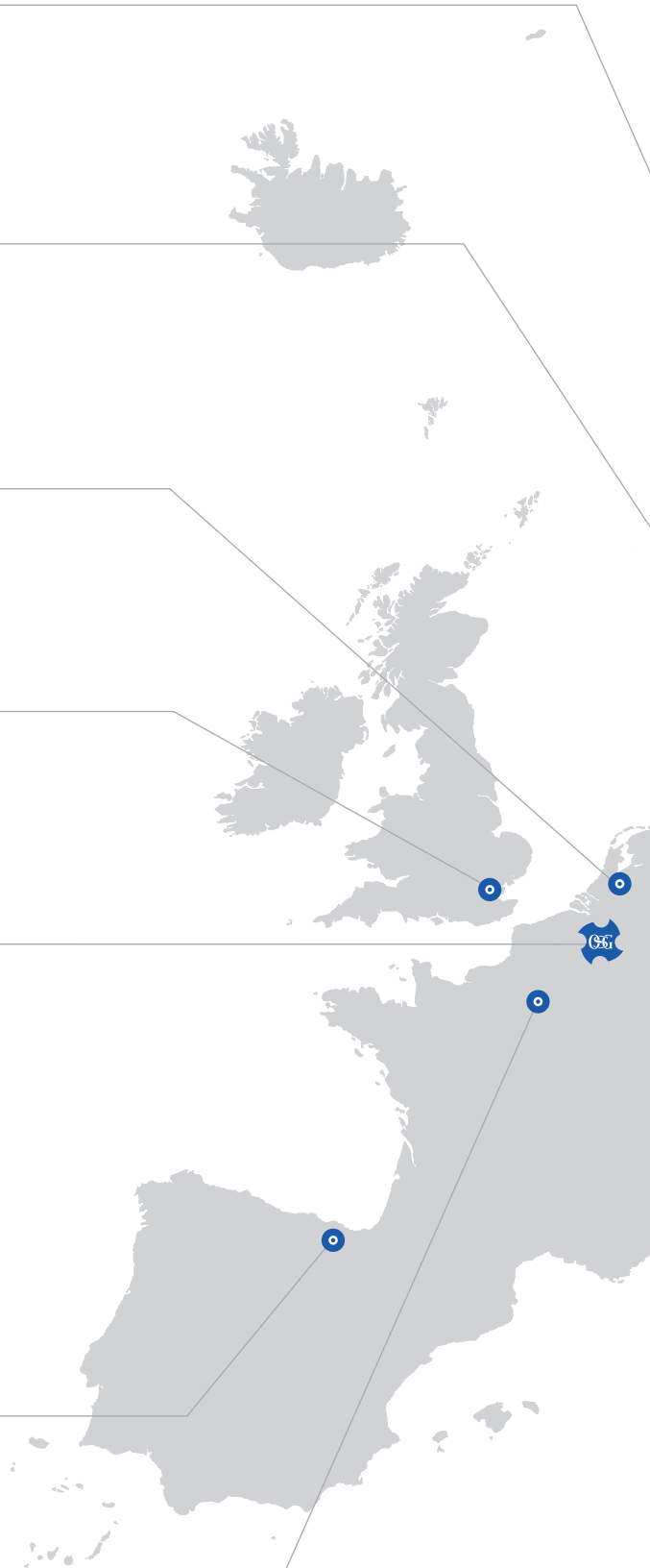
Avenue Lavoisier 1  
B-1300 Z.I. Wavre - Nord  
Belgium  
Tel.: +32 10 23 05 11  
Fax: +32 10 23 05 31  
info@osg-belgium.com

## OSG COMAHER

Bekolarra 4  
E - 01010 Vitoria-Gasteiz  
Spain  
Tel.: +34 945 242 400  
Fax: +34 945 228 883  
osg-comaher@osg-comaher.com

## OSG FRANCE

Paris Nord 2 385 rue de la Belle Etoile,  
4 allée du Ponant  
BP 66191 Roissy en France  
F-95974 Roissy Ch. De Gaule Cedex  
France  
Tel.: +33 1 49 90 10 10  
Fax: +33 1 49 90 10 15  
sales@osg-france.com





**SLOVAKIA**

Branch office of OSG Europe Logistics s.a.  
Tel: +32 10 23 05 04  
Fax: +32 10 23 05 31  
info@osg-belgium.com

**OSG POLAND**

59 Zlota St  
00-120 Warsaw  
Poland

**ROMSAN INTERNATIONAL CO. SRL**

Reprezentant Exclusiv OSG  
23-25, Nerva Traian Street  
031044 Bucuresti  
România  
Tel.: +40 021 322 07 47  
Fax: +40 021 321 56 00  
romsan.int@romsan.ro

**OSG TURKEY**

Rami Kışla Cad.No:56 Eyüp  
Istanbul 34056  
Turkey  
Tel.+90 212 565 24 00  
Fax: +90 212 565 44 00  
info@osg-turkey.com

**OSG ITALIA**

Via Cirenca n. 52 int. 61/63  
I - 10142 Torino  
Italy  
Tel.: +39 0117705211  
Fax: +39 0117071402  
info@osg-italia.it

**OSG GERMANY**

Karl-Ehmann-Str. 25  
D - 73037 Göppingen  
Germany  
Tel.: +49 7161 6064 - 0  
Fax: +49 7161 6064 - 444  
info@osg-germany.de



shaping your dreams

#### **OSG EUROPE LOGISTICS**

Avenue Lavoisier 1  
B-1300 Z.I. Wavre - Nord  
Belgium  
Tel.: +32 10 23 05 07  
Fax: +32 10 23 05 51  
info@osgeurope.com

#### **OSG BELUX**

Avenue Lavoisier 1  
B-1300 Z.I. Wavre - Nord  
Belgium  
Tel.: +32 10 23 05 11  
Fax: +32 10 23 05 31  
info@osg-belgium.com

#### **OSG FRANCE**

Parc Icade, Paris Nord 2  
Immeuble "Le Rimbaud"  
22 Avenue des Nations  
CS66191 - 93420 Villepinte  
France  
Tel.: +33 1 49 90 10 10  
Fax: +33 1 49 90 10 15  
sales@osg-france.com

#### **OSG NETHERLANDS**

Bedrijfsweg 5 - 3481 MG Harmelen  
Postbus 50 - 3480 DB Harmelen  
The Netherlands  
Tel.: +31 348 44 2764  
Fax: +31 348 44 2144  
info@osg-nl.com

#### **OSG UK**

Shelton house, 5 Bentalls  
Pipps Hill Ind Est, Basildon Essex SS14 3BY  
United Kingdom  
Tel.: +44 845 305 1066  
Fax: +44 845 305 1067  
sales@osg-uk.com

#### **SLOVAKIA**

Branch office of OSG Europe Logistics s.a.  
Tel (SK) +421 2 4329 1295  
Tel (BE) +32 10 23 05 07  
Fax (BE) +32 10 23 05 51  
sales-osgsvk@osgeurope.com

#### **OSG POLAND Sp. z.o.o.**

ul. Spółdzielcza 57  
05-074 Halinów  
Poland  
Tel: +22 760 82 71  
Fax: +22 760 82 71  
osg@osg-poland.com

#### **OSG GERMANY**

Karl-Ehmann-Str. 25  
D - 73037 Göppingen  
Germany  
Tel.: +49 7161 6064 - 0  
Fax: +49 7161 6064 - 444  
info@osg-germany.de

#### **OSG SCANDINAVIA**

(For Scandinavian countries)  
Langebjergvaenget 16  
4000 Roskilde  
Denmark  
Tel.: +45 46 75 65 55  
Fax: +45 46 75 67 00  
osg@osg-scandinavia.com

#### **SWEDEN**

Branch office of OSG SCANDINAVIA  
Abrahams Gränd 8  
295 35 Bromölla  
Sweden  
Tel: +46 40 41 22 55  
Fax: +46 40 41 32 55  
osg@osg-scandinavia.com

#### **OSG COMAHER**

Bekolarra 4  
E - 01010 Vitoria-Gasteiz  
Spain  
Tel.: +34 945 242 400  
Fax: +34 945 228 883  
osg-comaher@osg-comaher.com

#### **OSG ITALIA**

Via Cirenaiica n. 52 int. 61/63  
I - 10142 Torino  
Italy  
Tel.: +39 0117705211  
Fax: +39 0117071402  
info@osg-italia.it

#### **OSG TURKEY**

Rami Kışla Cad.No:56 Eyüp  
Istanbul 34056  
Turkey  
Tel.+90 212 565 24 00  
Fax: +90 212 565 44 00  
info@osg-turkey.com

#### **ROMSAN INTERNATIONAL CO. SRL**

Reprezentant Exclusiv OSG  
23-25, Nerva Traian Street  
031044 Bucuresti  
România  
Tel.: +40 021 322 07 47  
Fax: +40 021 321 56 00  
romsan.int@romsan.ro

#### **AUSTRIA**

Branch office of OSG GERMANY  
Messestraße 11  
A-6850 Dornbirn  
Tel.: +49 7161 6064-0  
Fax: +49 7161 6064-444  
info@osg-germany.de

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