

Broaching Unit

The new state of the art broaching unit for economic manufacturing of oriented keyways and splines.

This investment pays.

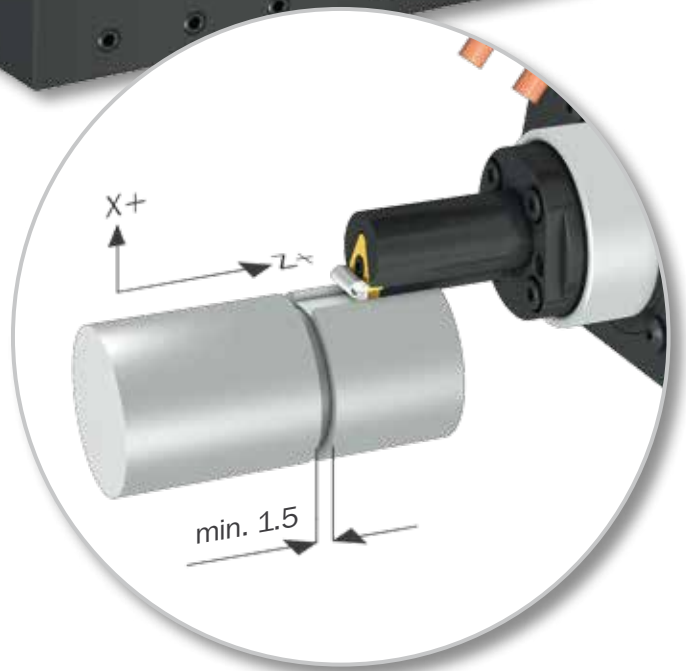
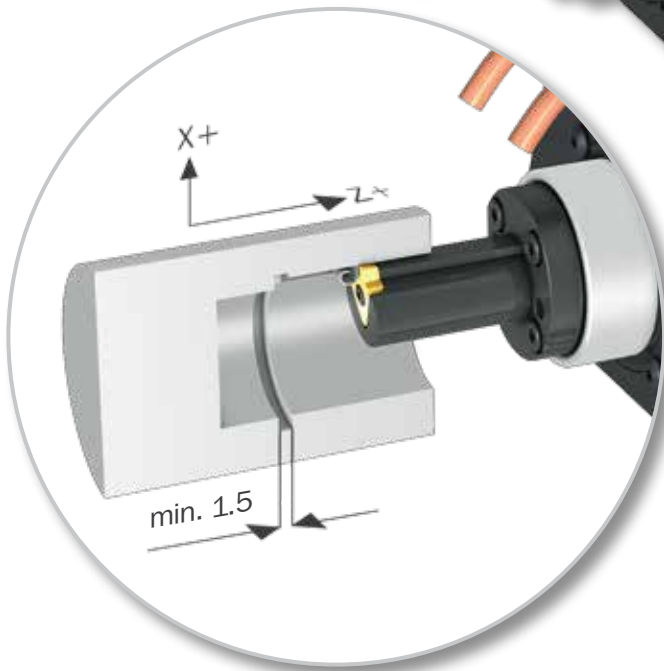


In operation:



Broaching Unit for ID and OD

Working stroke	32 mm
Total stroke	35 mm
Max. groove width	10 mm
Workpiece material	up to 1,000 N/mm ²
Max. stroke	1,000 1/min
Ratio	1:1
Max. feed per stroke	0.15 mm
Direction of cut	X+ or X-



Same insert holder for ID and OD broaching – Simply by rotating insert holder 180 degrees.

Function



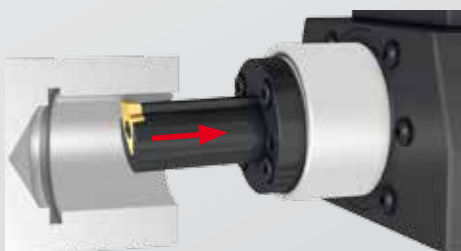
Position insert on Z



Cutter drives into workpiece

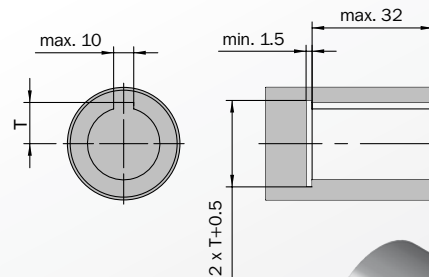


Cutter lifts from workpiece

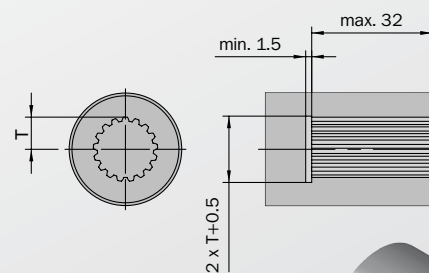
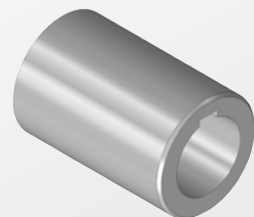


Lift-off function prevents wear/breakage when cutter retracts

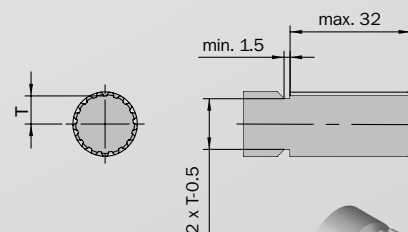
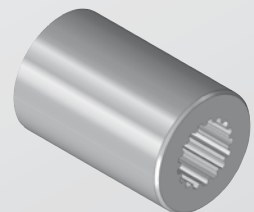
Sample workpieces



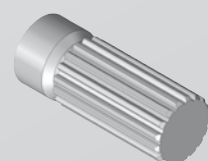
Keyway



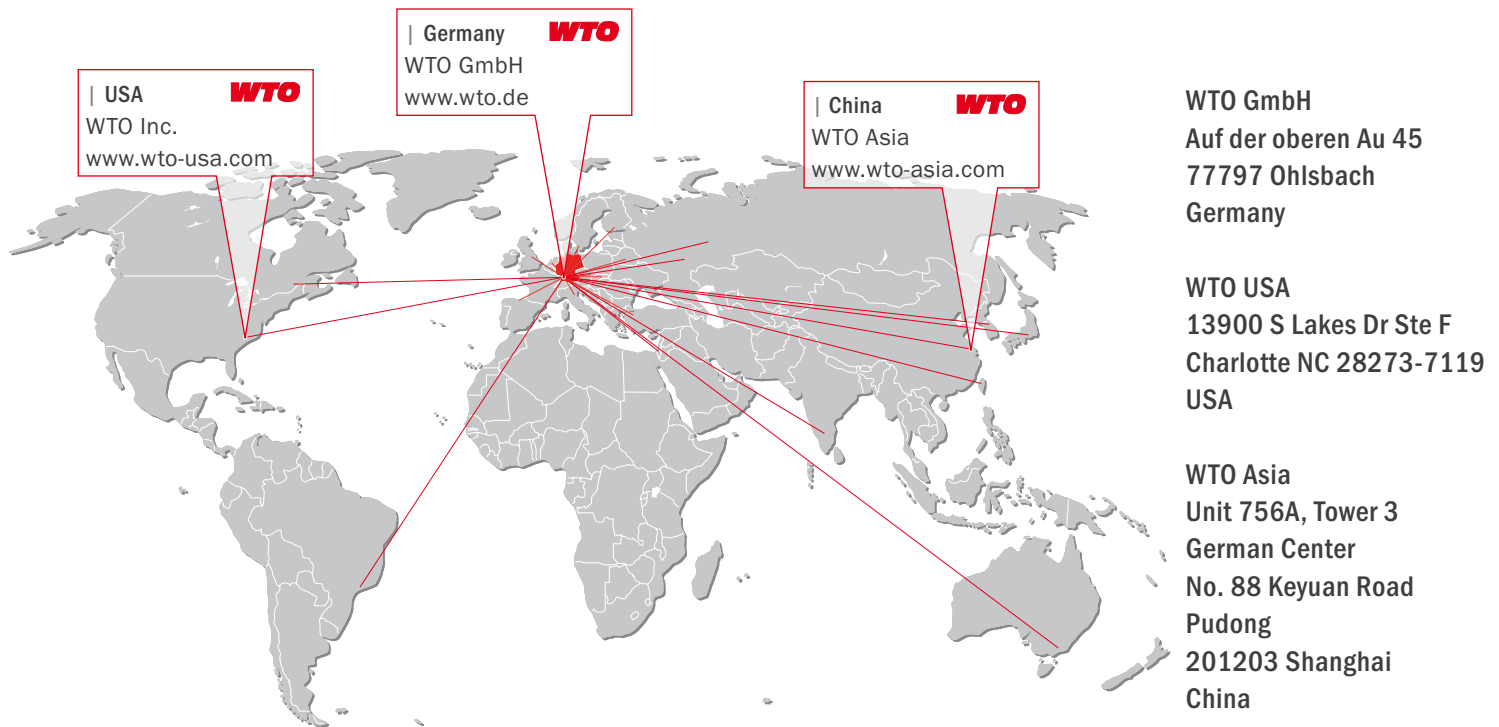
Internal involute spline according to DIN 5482



External involute spline according to DIN 5480



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