

Broaching Unit

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

Faster return on investment.



In operation:

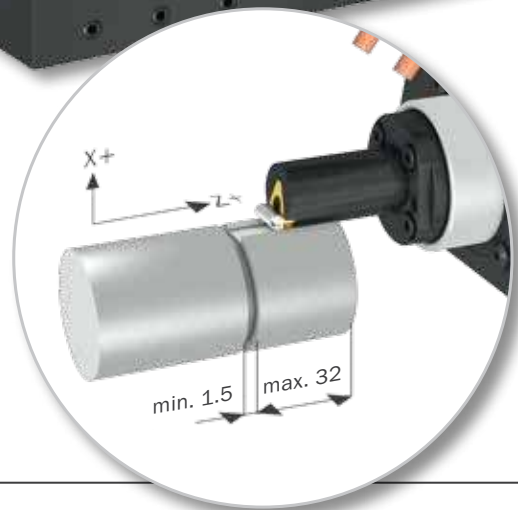
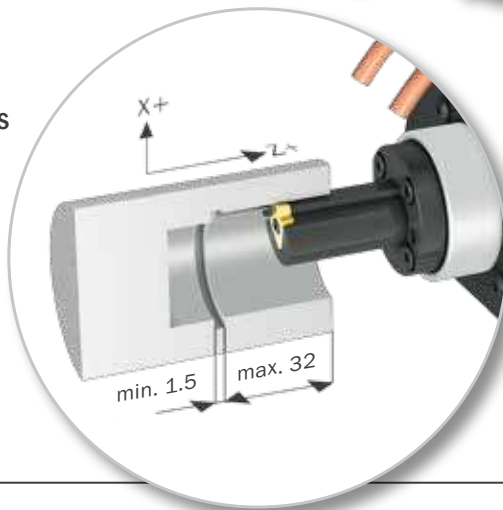


Broaching Unit for ID and OD

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 by rotating 180 degrees



Function

1
Position insert on Z



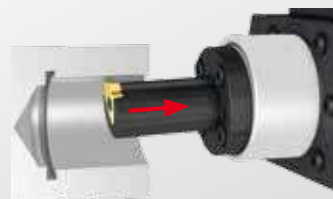
2
Cutter drives into workpiece



3
Cutter lifts from workpiece



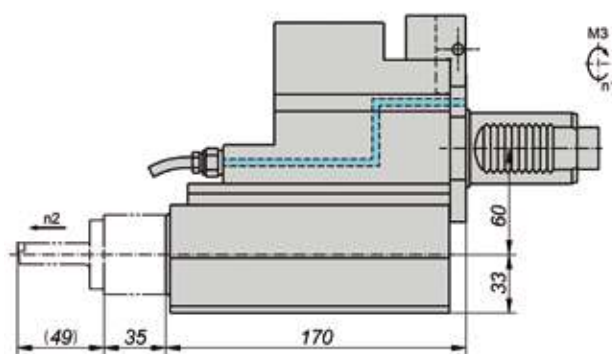
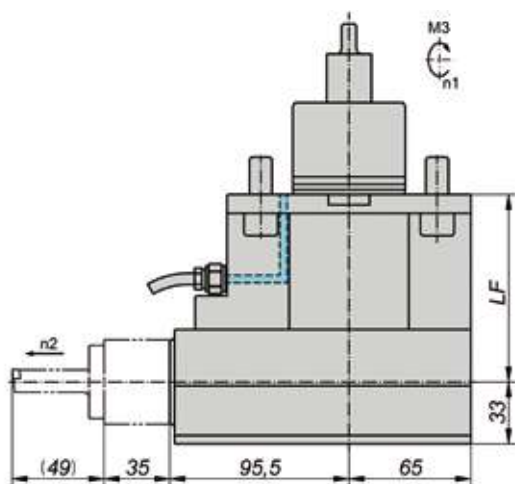
4
Lift-off function prevents wear/breakage when cutter retracts



Broaching Unit — OD mounted

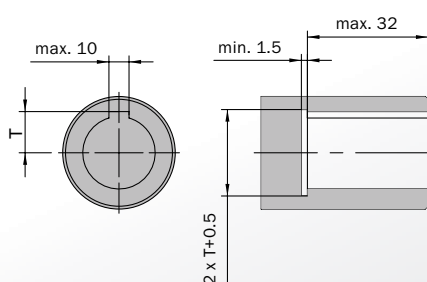


Broaching Unit — Face mounted

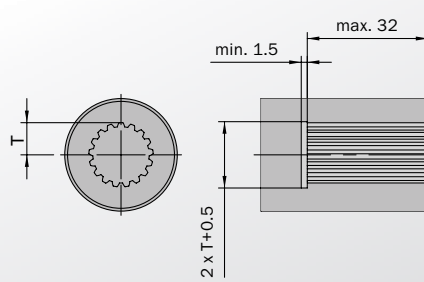
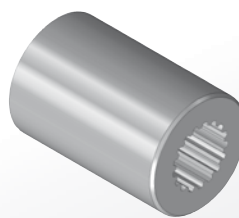


Sample workpieces

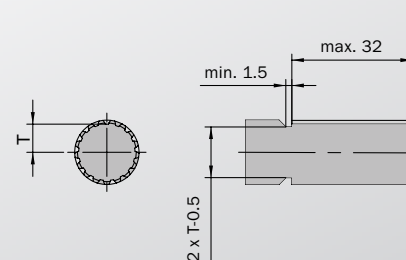
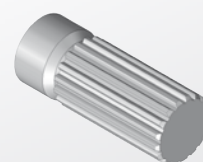
Keyway

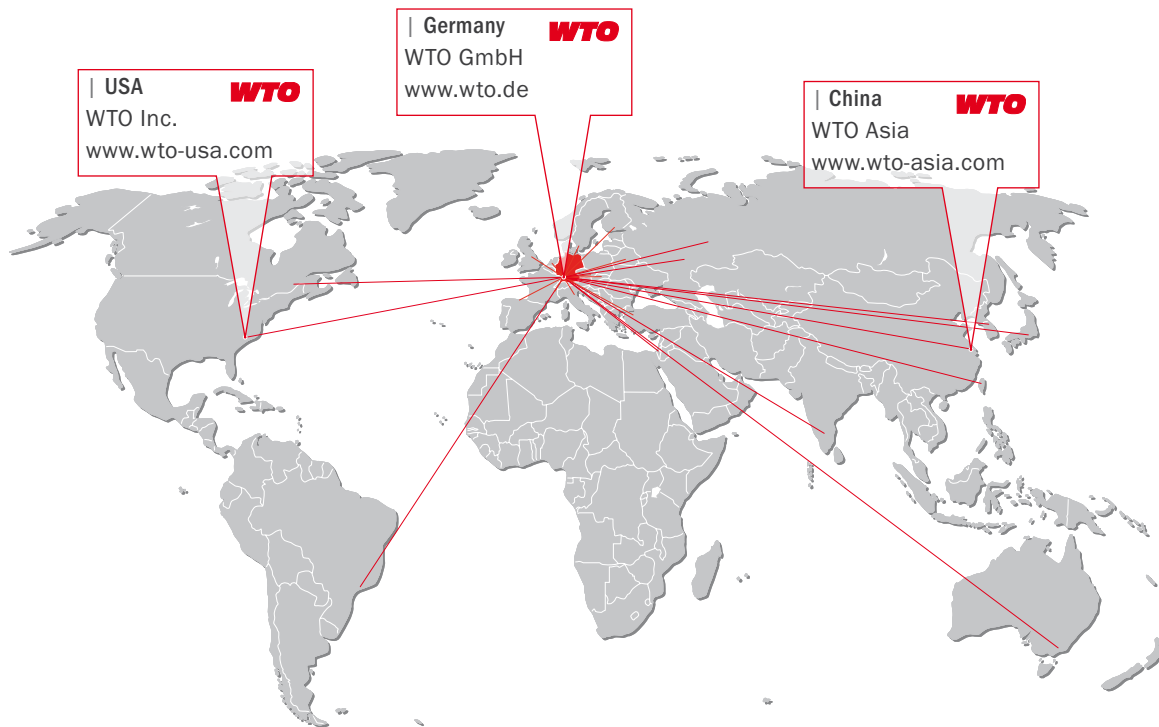


Internal involute spline according to DIN 5482



External involute spline according to DIN 5480





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