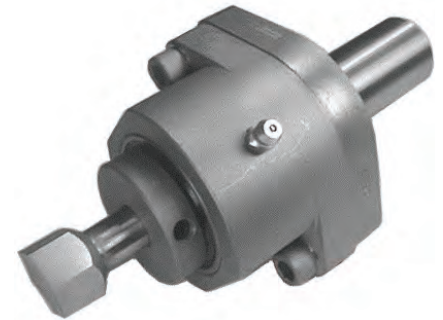


Adjustable Rotary Broach Holders



For Broaches With 0.315 Diameter Shanks

Overall Length	Shank Dia.	Shank Length	Broach Shank Depth	Hassay EDP No.	Code No.	Price \$
3-27/64	5/8	1-1/2	9/16	P-67040	182173	2,831.10
3-59/64	3/4	2	9/16	P-67048S	182175	2,924.47

For Broaches With 0.500 Diameter Shanks

Overall Length	Shank Dia.	Shank Length	Broach Shank Depth	Hassay EDP No.	Code No.	Price \$
4-17/32	3/4	2	0.742	P-67048	182177	3,172.35
4-17/32	1	2	0.742	P-67064	182179	3,260.53
5-17/32	1-1/4	3	0.742	P-67068	182181	3,359.18
5-17/32	1-1/2	3	0.742	P-67072	182183	2,961.72

For Broaches With 0.750 Diameter Shanks - Heavy Duty

Overall Length	Shank Dia.	Shank Length	Broach Shank Depth	Hassay EDP No.	Code No.	Price \$
7-9/16	1-1/2	3	1.25	P-67072HDS	182185	6,306.39
7-9/16	1-3/4	3	1.25	P-67076HD	182187	5,688.60

Applications

ROTARY/PUNCH BROACHES: Used in a variety of machines to cut polygons in blind holes: Any type of CNC or manual turning, milling, drilling or screw machine. The practical forming length of rotary/punch broaching is usually up to 1-1/2 times the size of the broach (measured across flats).

ROTARY BROACH HOLDERS: For optimal tool life in large production settings these broaches are used in Rotary Broach Holders. Holders and broaches are sold separately and available from stock for immediate delivery. These holders are for use on any type CNC or manual turning, milling, drilling or screw machine. The holder has an internal live spindle, which holds the end cutting broach tool. The centreline of the cutting tool is offset at 1° from the centreline of the workpiece. This causes the broach to wobble creating a shearing effect as the broach is advanced into the workpiece or vice versa as described below.

BROACHING A ROTATING WORKPIECE: In a turning or screw machine, the holder is mounted stationary while its internal live spindle and the broach rotates after contact with the rotating workpiece. At the appropriate feed, the workpiece is “sheared” by the pressure of the broach through a wobbling type action producing the polygon shape desired.

BROACHING A STATIONARY WORKPIECE: In a milling or drilling machine, the holder is mounted into and rotates with the machine spindle while its internal live spindle along with the broach remains stationary upon contact with the stationary workpiece. While the machine spindle is rotating, the broach’s pressure shears the polygon shape into the workpiece (wobbling type action).

PUNCHING VERSUS ROTARY BROACHING: Many applications can be achieved without the rotary broach holder. For the purpose of merely punching a polygon into an existing pilot hole, these broaches have successfully been used with universal machining methods.