

## Broaching Unit

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

Faster return on investment.

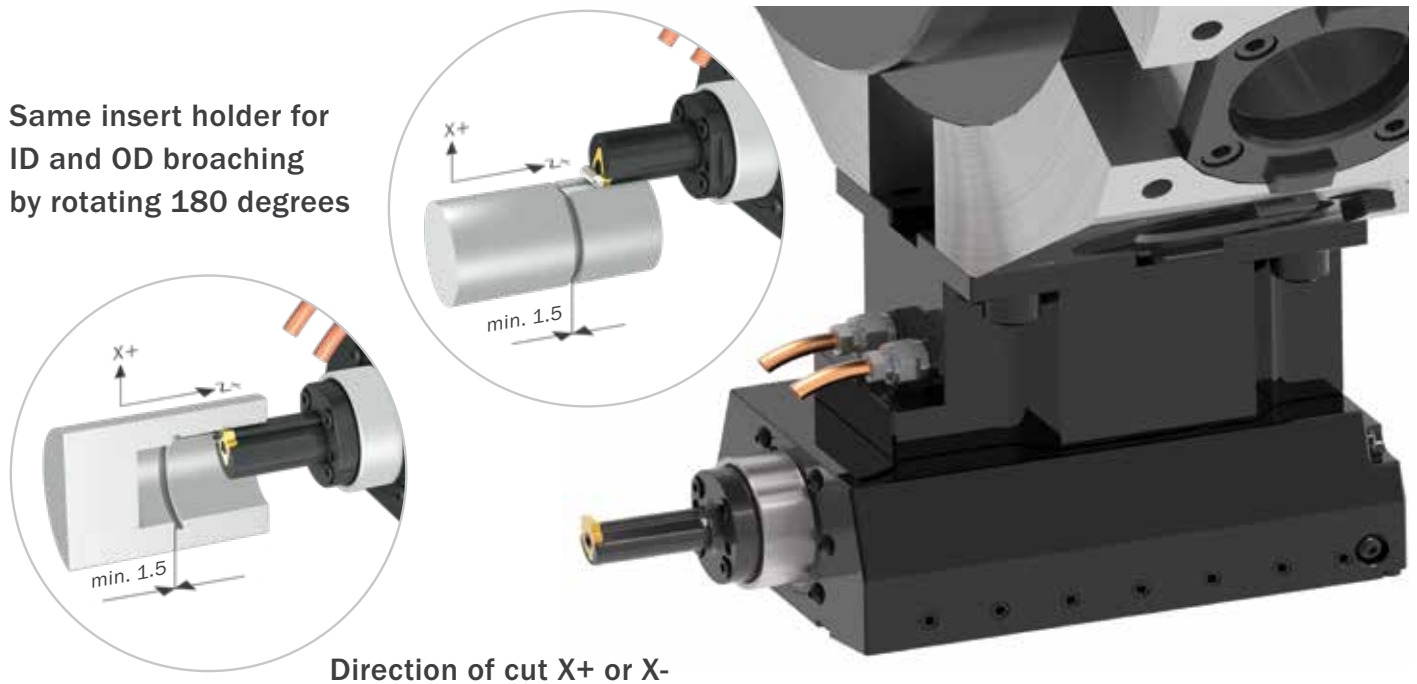


In operation:



# Broaching Unit – for ID and OD

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



## Function

1  
Position insert on Z



3  
Cutter lifts from workpiece



2  
Cutter drives into workpiece



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



## Sample workpieces

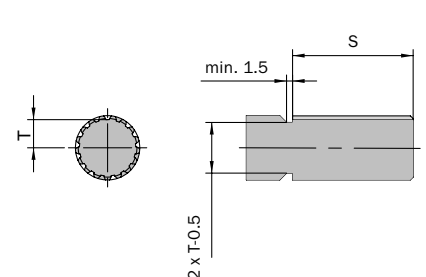
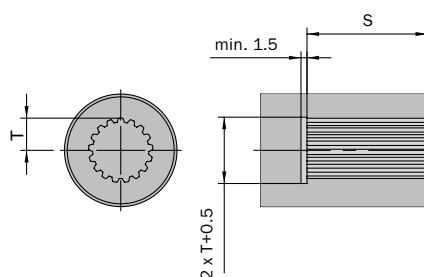
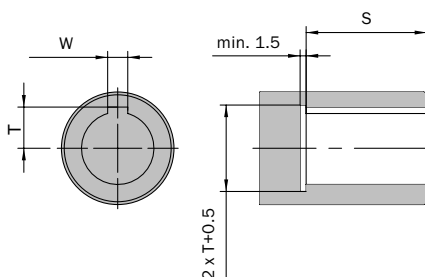
Keyway



Internal involute spline according to DIN 5482



External involute spline according to DIN 5480



## Broaching Unit — OD mounted

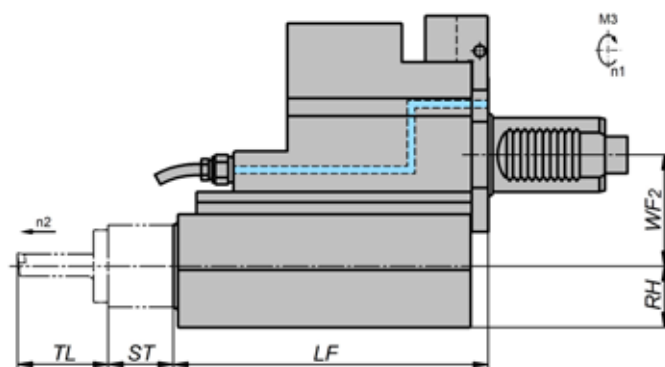
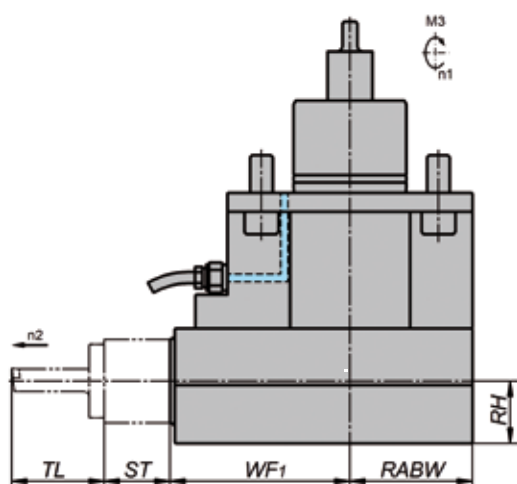


Type 26 / 32 / 52

## Broaching Unit — Face mounted



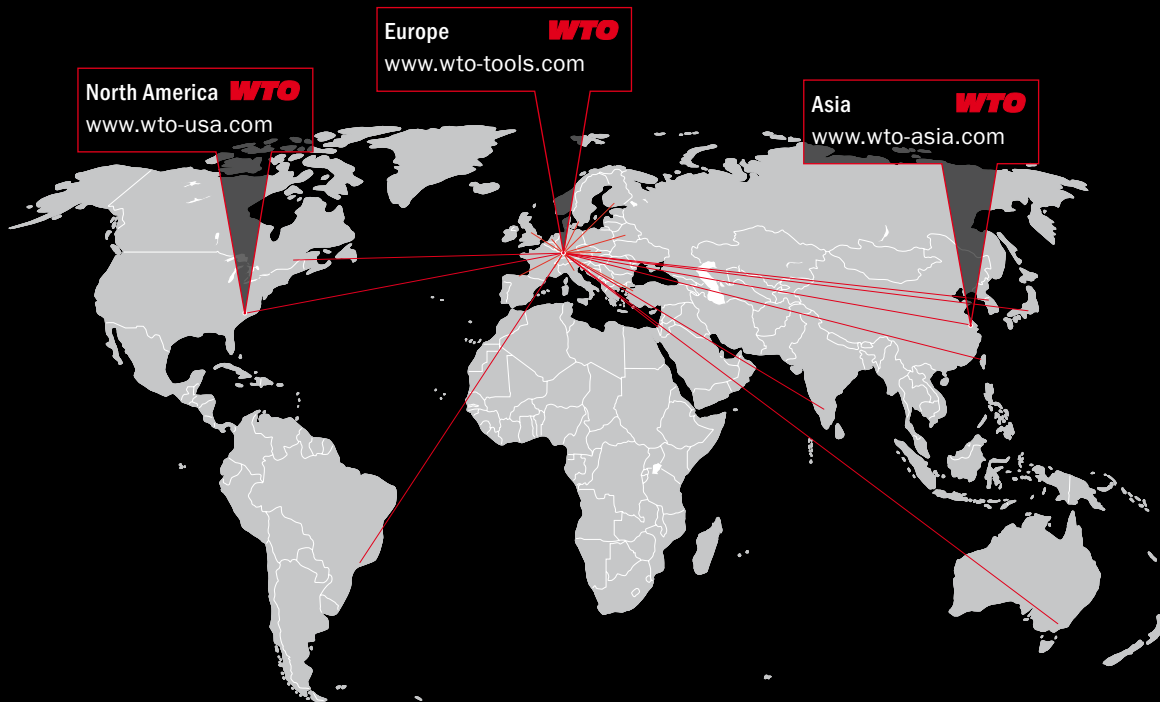
Type 32 / 52



Type	Working stroke (S)	Total stroke	Max. groove width (W)	Workpiece material [N/mm <sup>2</sup> ]	Max. strokes [1/min] (n2)	Ratio	Max. feed per stroke
26	26	28	6	1200	1500	2:1	0.15
32	32	35	12	1200	1000	1:1	0.15
52	52	55	12	1200	800	1:1	0.15

Type	TL	ST	LF	WF1	WF2	RABW	RH
26	38	28	-	59	-	61	30.5
32	49	35	170	95.5	60	65	33
52	67	55	180	105.5	65	74	33

Dimensions in mm



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