

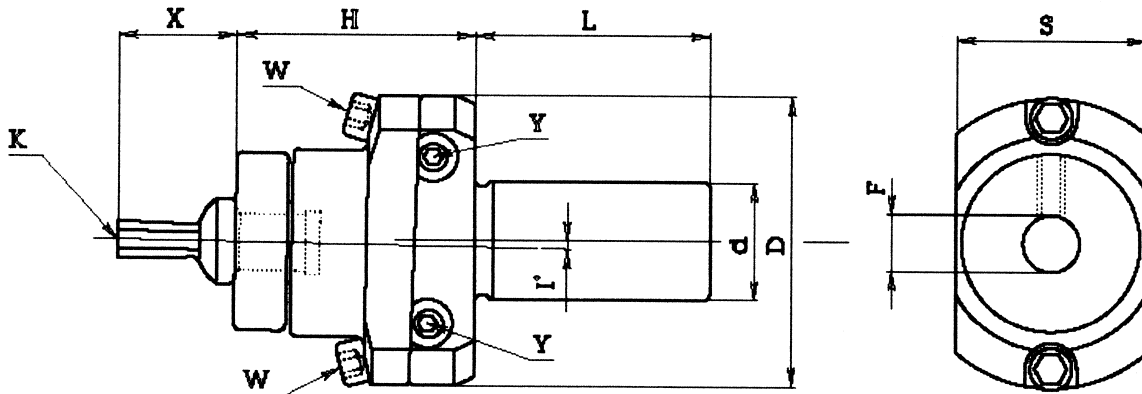
ADJUSTABLE BROACHING HEADS & BITS



In-process broaching

The Broaching Head is designed to generate Hexagons, Squares and Torx* forms during the machining cycle.

BROACHING HEADS



Reference	d	H	L	D	F	S
57.175.102	MT2	34	68	50	8	30
57.175.110	10		35			
57.175.112	12					
57.175.115	5/8"					
57.175.116	16					
57.175.119	3/4"					
57.175.120	20		46			
57.175.125	25					
57.175.126	1"					

Reference	d	H	L	D	F	S			
57.175.202	MT2	52	68	62	12	40.5			
57.175.219	3/4"		50						
57.175.220	20								
57.175.225	25								
57.175.226	1"								
57.175.231	1.1/4"								
57.175.232	32								

Setting example:

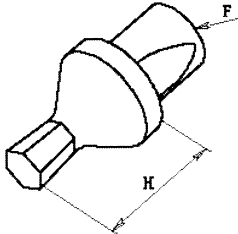
- Assemble Broaching Bit & measure length 'X'.
- Replace Broaching Bit with test bar & mark position 'X'.
- Locate the tool in the machine or V Block and lightly clamp.
- Tape the rotating spindle to the head (so they can revolve as one).
- Set a Dial Gauge at position 'X' and rotate the tool.
- Using screws 'Y' & 'W' adjust to 0.03mm TIR
- The centre-point K is now positioned on the centreline of the shank (d).

Operating example: Broaching a hexagon

- Centre Drill (60° or 45°) 0.25mm larger than the across corner size
- Drill The across flat size + 1 to 3% with a depth to diameter ratio if approx 1.5:1
- Cutting Data: Dependent on material (1000-2000rpm & 0.01-0.08mm/rev)

Standard Hexagon Broaching Bits will broach to a depth of the AF size + 20%

BROACHING BITS



Hexagon

Reference	F	H	AF
57.8010010	8	18	1.0
57.8010015			1.5
57.8010020			2.0
57.8010025			2.5
57.8010030			3.0
57.8010035			3.5
57.8010040			4.0
57.8010050			5.0
57.8010055			5.5
57.8010060			6.0
57.8010070			7.0
57.8010080			8.0

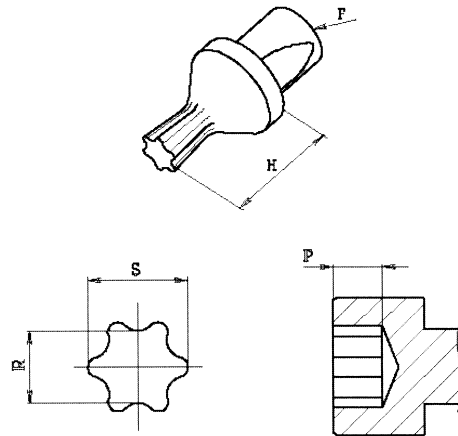
Reference	F	H	AF
57.8000010	12	25	1.0
57.8000015			1.5
57.8000020			2.0
57.8000025			2.5
57.8000030			3.0
57.8000035			3.5
57.8000040			4.0
57.8000050			5.0
57.8000055			5.5
57.8000060			6.0
57.8000070			7.0
57.8000080			8.0
57.8000090			9.0
57.8000100			10.0
57.8000110	11.0		
57.8000120	12.0		
57.8000130	13.0		
57.8000140	14.0		

Square

Reference	F	H	AF
57.8011020	8	18	2.0
57.8011025			2.5
57.8011030			3.0
57.8011035			3.5
57.8011040			4.0
57.8011050			5.0
57.8011055			5.5
57.8011060			6.0
57.8011070			7.0

Reference	F	H	AF
57.8001020	12	25	2.0
57.8001025			2.5
57.8001030			3.0
57.8001035			3.5
57.8001040			4.0
57.8001050			5.0
57.8001055			5.5
57.8001060			6.0
57.8001070			7.0
57.8001080			8.0
57.8001090			9.0
57.8001100			10.0
57.8001110			11.0
57.8001120	12.0		
57.8001130	13.0		

BROACHING BITS



Torx*

Reference	F	H	P	S	R	Torx*
57.801206	8	18	0.50-0.70	1.80	1.29	6
57.801208			0.70-0.90	2.45	1.80	8
57.801210			1.00-1.30	2.85	2.07	10
57.801215			1.30-1.50	3.38	2.44	15
57.801220			1.50-1.60	3.96	2.86	20
57.801225			1.60-2.00	4.55	3.28	25
57.801227			2.00-2.40	5.10	3.65	27
57.801230			2.60-3.00	5.65	4.07	30

Reference	F	H	P	S	R	Torx*
57.800206	12	25	0.50-0.70	1.80	1.29	6
57.800208			0.70-0.90	2.45	1.80	8
57.800210			1.00-1.30	2.85	2.07	10
57.800215			1.30-1.50	3.38	2.44	15
57.800220			1.50-1.60	3.96	2.86	20
57.800225			1.60-2.00	4.55	3.28	25
57.800227			2.00-2.40	5.10	3.65	27
57.800230			2.60-3.00	5.65	4.07	30
57.800240			3.00-3.30	6.80	4.88	40
57.800245			3.50-4.00	7.97	5.68	45
57.800250	4.00-4.50	8.99	6.50	50		

* Torx: Registered by Textron Inc. USA

Broaching Bits are available TiN coated if required

External Broaching – on application

