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Signature Series Rotary Broaching

Designed & Manufactured To The Highest Industry Standard

Rotary / Wobble Broaching on Swiss Type CNC Machines is a cost effective way to produce hex, square and hexlobular drive features and internal polygon forms in one operation. The Broaching process takes only seconds to produce the profile and parts can be finished complete out of the machine without the need for the broaching to be performed as a secondary operation.

The **PREMIERE** Holder For
Swiss-Type Rotary Broaching
The First Of Its Kind



Medical • Automotive • Aerospace

NEW! Signature Series Broach Tools



Precision Ground
To $\pm .0002$ in Tolerance

Hexagonal
Sizes Available

Pressure Vents Prevent
Hydraulic Locking

Three Broach Tool Types
For The Right Holders

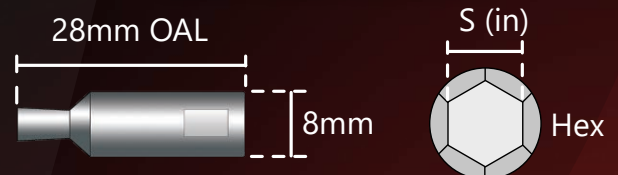
0832 TOOL HEX SIZES



Designed For Competitors' Holders



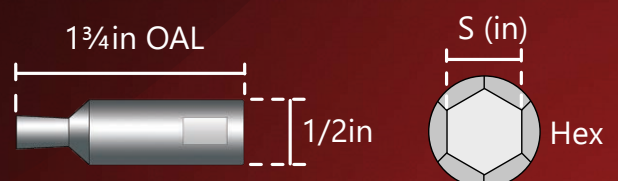
0828 TOOL HEX SIZES



Designed For GenSwiss 2160 Holders



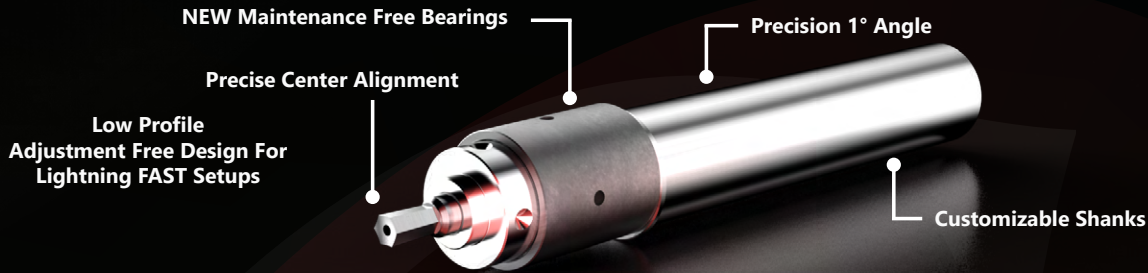
NOW AVAILABLE!
1/2in TOOL SHANK SIZES



Designed For Competitors' Holders

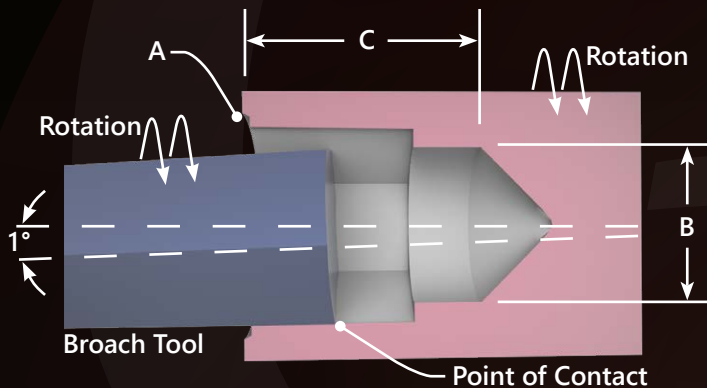
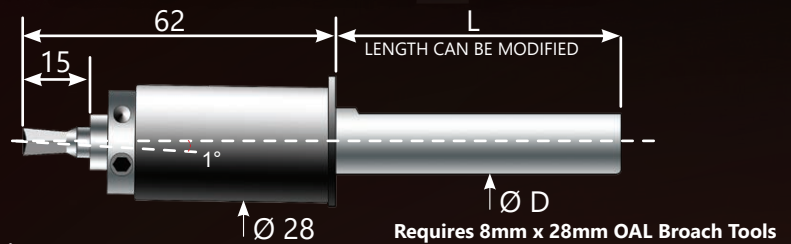
Swiss-Type Rotary Broach Holders

2160 Series - Best Choice For Swiss Machines



Part No.	Inch	D	L
RBH-2160-158-038		.625"	1.50"
RBH-2160-190-100		.750"	4.00"
RBH-2160-254-120		1.00"	4.75"
Part No.	Metric	D	L
RBH-2160-120-038		12	38
RBH-2160-140-038		14	38
RBH-2160-160-038		16	38
RBH-2160-200-100		20	100
RBH-2160-220-100		22	100
RBH-2160-250-100		25	100

- No Center Indicating Required
- Holds 8mm Shank Broaches - .050in - .375in Hex Size
- Capable Of Withstanding 2250lbs Of Thrust
- Easy To Set Up & Use
- Shank Length Can Be Modified To Your Application



Internal Broaching Tips

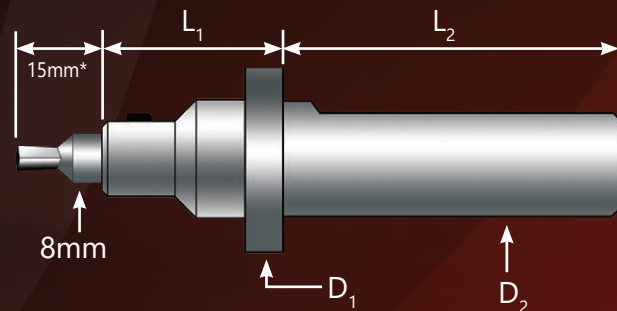
- Prepare the broach hole with a 60-90° chamfer slightly larger than the largest dimension of the broach tool.
- The hole diameter should be drilled approximately 1% larger than the length across the flats of the hex shape.
- Drill the hole to a length 1.4 times the length across the flats of the hex shape. If chips need to be removed, re-drill the hole with a slightly smaller drill size.

Static Punch Broach Holders & Tools

For Making Special ID Forms



- Partial Form Broaches Reduce Cutting Pressure
- No Push Back or Moving During Broaching
- Precise Positioning & Timing Of Broach Forms
- Available For Citizen, Star, Tugami, Tornos, & Other Swiss Turning Centers

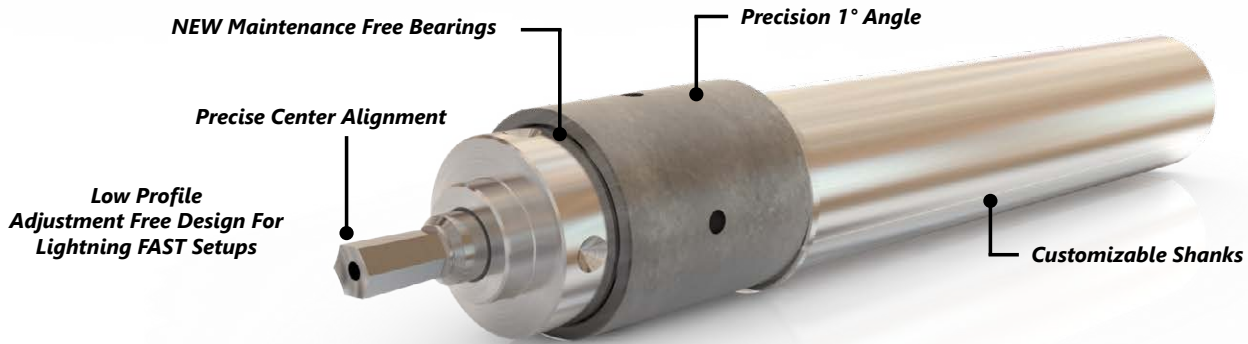


Part No.	D1	D2	L1	L2
SBH-158250-125-8M	1.00"	.625"	1.25"	2.5"
SBH-190250-125-8M	1.00"	.750"	1.25"	2.5"
SBH-200250-125-8M	1.00"	20mm	1.25"	2.5"
SBH-220250-125-8M	1.00"	22mm	1.25"	2.5"
SBH-254250-125-8M	1.10"	1.00"	1.25"	2.5"

*Only applies when standard 2110 series broaches are used

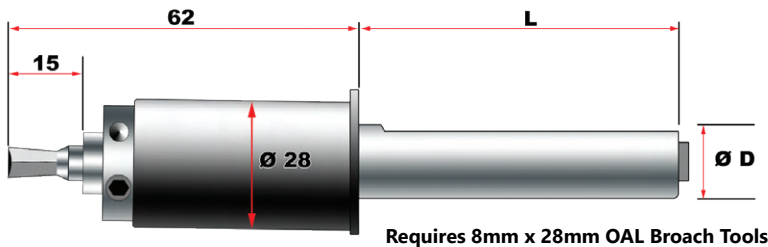
Swiss-Type Rotary Broaching Solutions

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2160 Series - Best Choice for Swiss Machines

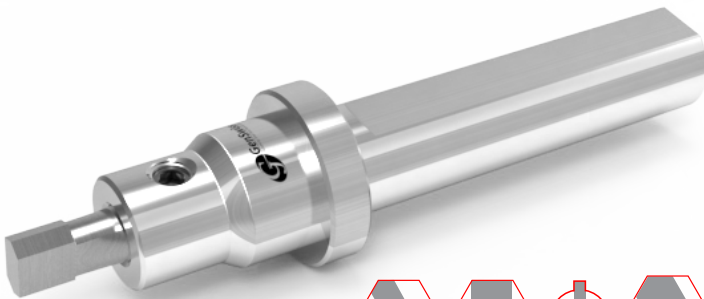
- NO CENTER INDICATING REQUIRED
- Holds 8mm Shank Broaches - .050" - .375" Hex Size
- Capable of Withstanding 2250 lbs of Thrust
- Easy To Set Up & Use
- Shank Length Can be Modified to your Application



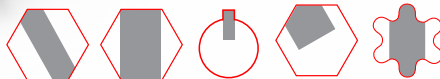
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