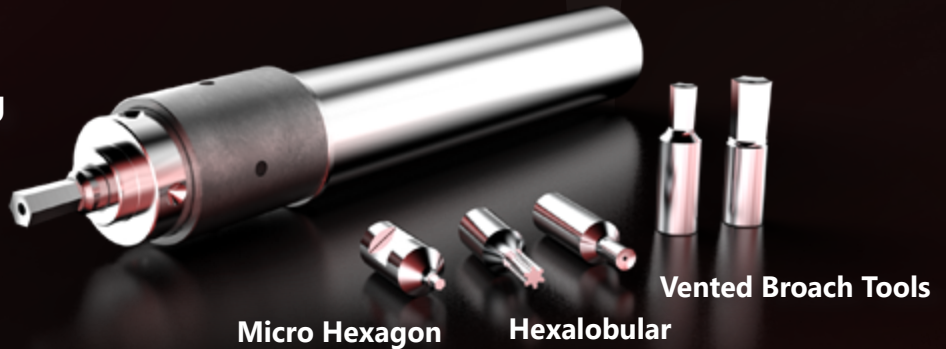


Signature Series Rotary Broaching

Designed & Manufactured To The Highest Industry Standard

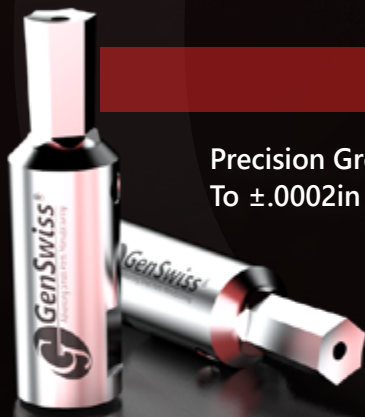
Rotary / Wobble Broaching on Swiss Type CNC Machines is a cost effective way to produce hex, square and hexlobular drive features and internal polygon forms in one operation. The Broaching process takes only seconds to produce the profile and parts can be finished complete out of the machine without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

Signature Series Broach Tools



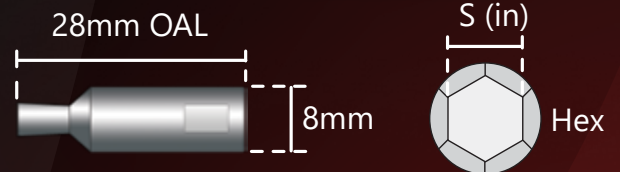
Precision Ground
To $\pm .0002$ in Tolerance

Hexagonal
Sizes Available

Pressure Vents Prevent
Hydraulic Locking

Three Broach Tool Types
For The Right Holders

0828 TOOL HEX SIZES



Designed For GenSwiss 2160 Holders



0832 TOOL HEX SIZES



Designed For Competitors' Holders



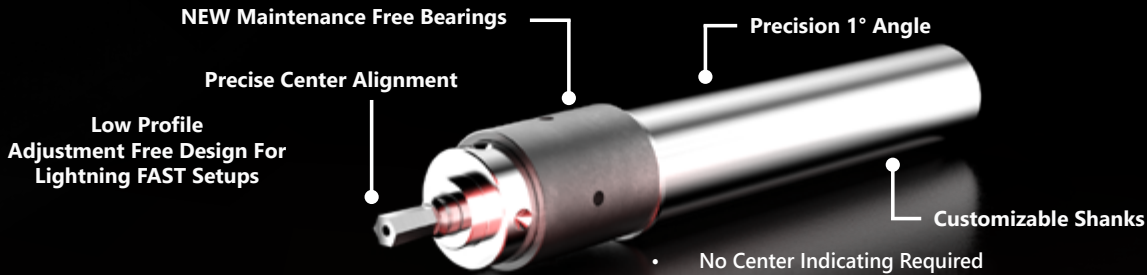
NOW AVAILABLE!
1/2in TOOL SHANK SIZES



Designed For Competitors' Holders

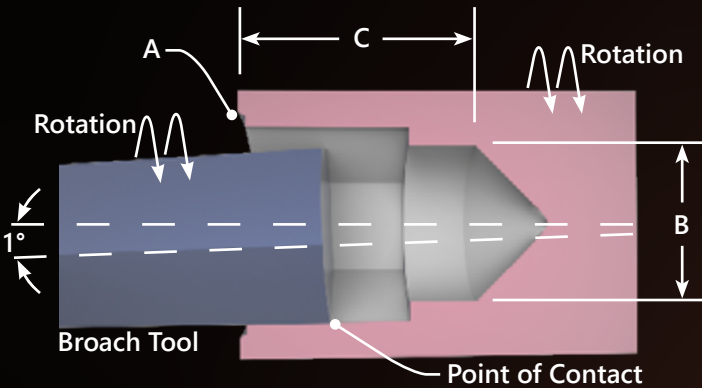
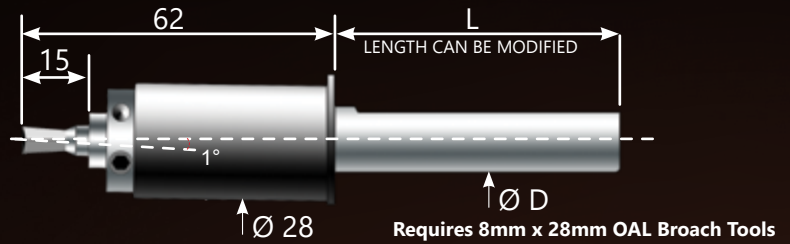
Swiss-Type Rotary Broach Holders

2160 Series - Best Choice For Swiss Machines



- No Center Indicating Required
- Ideal for medical & aerospace fastener applications
- Low profile; fits machines with minimal interference
- Shank Length is customizable, No need for bushings
- Short head length is ideal for sub-spindle applications
- Longer OAL broach tools can be used by adjusting x-axis

Item No.	Part No.	Inch	D	L
3010-000113	RBH-2160-158-038	.625"	.625"	1.50"
3010-000115	RBH-2160-190-100	.750"	.750"	4.00"
3010-000119	RBH-2160-254-120	1.00"	1.00"	4.75"
	Part No.	Metric	D	L
3010-000112	RBH-2160-120-038	12mm	12mm	38mm
3010-000147	RBH-2160-140-038	14mm	14mm	38mm
3010-000114	RBH-2160-160-038	16mm	16mm	38mm
3010-000116	RBH-2160-200-100	20mm	20mm	100mm
3010-000117	RBH-2160-220-100	22mm	22mm	100mm
3010-000136	RBH-2160-230-100	23mm	23mm	100mm
3010-000118	RBH-2160-250-120	25mm	25mm	120mm

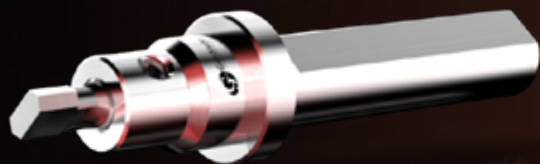


Internal Broaching Tips

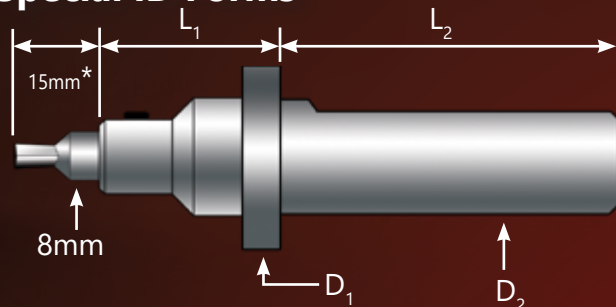
- Prepare the broach hole with a 60-90° chamfer slightly larger than the largest dimension of the broach tool.
- The hole diameter should be drilled approximately 1% larger than the length across the flats of the hex shape.
- Drill the hole to a length 1.4 times the length across the flats of the hex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



Item No.	Part No.	D1	D2	L1	L2
3011-000100	SBH-158250-125-8M	1.00"	.625"	1.25"	2.5"
3011-000101	SBH-190250-125-8M	1.00"	.750"	1.25"	2.5"
3011-000102	SBH-200250-125-8M	1.00"	20mm	1.25"	2.5"
3011-000103	SBH-220250-125-8M	1.00"	22mm	1.25"	2.5"
3011-000104	SBH-254250-125-8M	1.10"	1.00"	1.25"	2.5"

*Only applies when standard 2110 series broaches are used