

Broaching Heads

Broaching Head Code 265

Capacity 1.5mm - 6mm (.50" - 1/4")

A broaching head designed primarily to produce hexagonal holes without stopping the spindle.

This is the smallest of the range designed to suit the smaller auto or CNC lathe - available in 5/8" or 16mm shanks.



Broaching Head Code 275

Capacity 2mm - 10mm (5/64" - 3/8")

This head is designed primarily for producing hexagonal holes. A micro screw is provided to set the cutting bit on the machine center line. The inner shaft is mounted on sealed ball races for precision and long life. Right hand and left hand rotation is possible to produce a component. The cutting bits can be rapidly replaced and are available in a range of both metric and imperial sizes. Various shank sizes are available.

Metric: 16 - 20 - 25

Imperial: 5/8" - 3/4" - 1"



Broaching Head Code 295

Capacity 8mm - 19mm (5/16" - 3/4")

A larger version of Code 275 but with increased capacity. All technical features remain the same. Various shank sizes are available.

Metric: 20 - 25 - 32

Imperial: 3/4" - 1" - 1-1/4"



Broaching Head Code 1500

The external broaching head has been developed to produce primarily hexagonal forms on turned parts during the turning cycle on capstans, autos, CNC lathes, etc.

Recommended feed rate 0.0015"-0.002" per revolution. Spindle speeds 885-1500 rpm pre-turn bar by 0.010"-0.015" below A/C dimension minimum. Chamfer to A/F diameter minimum.

At present for use on mechanical feed type machines only. Depending on material and work holding facilities, designed to produce 3mm-16mm (1/8"-5/8") A/F hexagon with length of flats 1.5 X A/F max. It is also possible to produce squares with limited application. The external broaching head complements the internal head and is available with various shank diameters, including VDI.



For further information please contact our sales office.

Broaching Heads

Broaching Head Code 1600

External Broach Diameter 20mm

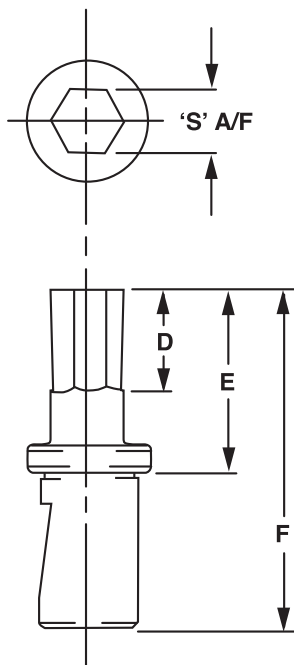
Internal Capacity 1.5mm - 10mm (0.05 - 3/8")

This universal model offers the versatility of being both an internal and external head, easily converted from one to the other with the exchange of operating shafts code 1602 and 1612. Various shank sizes available.

Metric: 16 - 20 - 25

Imperial: 5/8" - 3/4" - 1"

Standard Broach Bit Dimensions



8mm Shank

Code No.	NOM. AF. Size	To Cut AF. Size	'S' AF.	'D'
283-2	2	2.02/2.11	2.06/2.11	3.0/4.0
283-2.5	2.5	2.52/2.61	2.56/2.61	3.8/4.8
283-3	3	3.02/3.77	3.06/3.11	4.5/5.5
283-4	4	4.03/4.15	4.09/4.15	6.0/7.0
283-5	5	5.01/5.15	5.09/5.15	7.5/8.5
283-6	6	6.03/6.15	6.09/6.15	9.0/10.0
283-8	8	8.04/8.19	8.12/8.19	12.0/13.0
284-5/64	5/64	.0781/.0791	.0783/.0790	3.0/4.0
284-3/32	3/32	.0937/.0952	.0940/.0950	3.8/4.8
284-1/8	1/8	.1250/.1270	.1258/.1268	4.8/5.8
284-5/32	5/32	.1562/.1587	.1572/.1586	6.0/7.0
284-3/16	3/16	.1875/.1900	.1885/1898	7.2/8.2
284-7/32	7/32	.2187/.2217	.2197/.2213	8.3/9.3
284-1/4	1/4	.2500/.2530	.2512/.2526	9.5/10.5
284-9/32	9/32	.2812/.2840	.2822/.2836	10.7/11.7
284-5/16	5/16	.3125/.3160	.3138/.3156	12.0/13.0

12mm Shank

Code No.	NOM. AF. Size	To Cut AF. Size	'S' AF.	'D'	'E'	'F'
296-8	8	8.19/8.04	8.18/8.11	12.5/13.5	25.25/25.0	42.5/42.0
296-10	10	10.19/10.04	10.18/10.11	15.5/16.5	25.25/25.0	42.5/42.0
296-12	12	12.23/12.05	12.21/12.14	18.5/19.5	25.25/25.0	42.5/42.0
296-14	14	14.23/14.05	14.21/14.14	21.5/22.5	25.25/25.0	42.5/42.0
296-17	17	17.23/17.05	17.21/17.14	21.5/22.5	32.25/32.0	52.5/52.0
296-19	19	19.27/19.07	19.25/19.16	21.5/22.5	32.25/32.0	52.5/52.0
297-5/16	5/16	.3160/.3125	.3156/.3138	12.5/13.5	25.25/25.0	42.5/42.0
297-3/8	3/8	.3790/.3750	.3786/.3768	15.0/16.0	25.25/25.0	42.5/42.0
297-1/2	1/2	.5050/.5000	.5042/.5020	19.5/20.5	25.25/25.0	42.5/42.0
297-9/16	9/16	.5680/.5625	.5672/.5650	22.0/23.0	25.25/25.0	42.5/42.0
297-5/8	5/8	.6310/.6250	.6302/.6275	22.0/23.0	32.25/32.0	52.5/52.0
297-3/4	3/4	.7570/.7500	.7562/.7525	22.0/23.0	32.25/32.0	52.5/52.0

We also produce square broaches and special dimensions to customer requirements.

