

Welcome to the world of Rotary Broaching . . .

An exclusive, fast, amazing and accurate method of producing internal and external polygon forms on the end of a workpiece while the machine spindle is rotating.

The Rotary Broach Tool Holder is for use on any type CNC or manual turning, milling, drilling or screw machine.

The Rotary Broach Tool holder has an internal live spindle which holds an end cutting broach tool. The Holder along with the end cutting broach tool is designed for producing polygon forms while the machine spindle is rotating in a forward or reverse direction.

In a turning or screw machine, the Holder is mounted stationary while its internal live spindle along with the end cutting broach tool rotate with and are driven by the workpiece rotation. While rotating with the work piece, the end cutting broach tool's pressure and contacting points are continually changing contact points on the workpiece (*wobbling type action*) making broached forms easily produced.

In a milling or drilling machine the Holder is mounted into and rotates with the machine spindle while its internal live spindle along with the end cutting broach tool remain stationary upon contact to the workpiece. While the machine spindle is rotating, the end cutting broach tool's pressure and contacting points are continually changing contact points on the workpiece (*wobbling type action*) making broached forms easily produced.

Form sizes can be broached up to 2 inches in aluminum, 1-1/2 inches in brass and 1 inch in steel. Of course many other materials and depths have been successfully achieved and this is only a point of reference.

The practical forming length of rotary broaching is up to 1-1/2 times the distance across flats or the diameter of the inscribed circle of the profile to be broached.

Internal and external forms require a pilot diameter and a lead chamfer. (*Refer to page 4 for further information*)

Cycle times for rotary broaching forms are rapid. (*Refer to page 5*)

Rotary Broach Tool Holders and Broaches are sold separately, and are available from stock for immediate delivery.

Special order size and form broaches require a copy of part print stating part material and type and capacity of machine, model number of Rotary Broach Holder and broach tool mounting size. For your convenience, Slater Tools has provided you with **easy order** faxable forms on pages 21-23.

Upon receipt of special order request, a quote will be submitted for your consideration.

Broach Tool Materials Available:

M-2 H.S.S. (standard) or **P-M4 H.S.S.** (Premium)

Broach Tool Coatings Available:

Titanium Nitride (TiN) or
Titanium Carbonitride (TiCN)

Slater Tools Is Number One For Rotary Broaching!