WORKING PARAMETERS

NUMBER OF REVOLUTIONS

Internal broaching tool holders:

Model	Micro	0100N	0200N	0500N	1100N 1100S	2100N 2100S	3100N 3100S	4100XS
RPM	2000	1500	1500	1500	1200	1000	800	800

External broaching tool holders:

Model	0200E	0500E	5100E	2100N 2100S	3100N 3100S	4100XS
RPM	2000	1500	1200	1000	800	800

STANDARD FEEDS FOR INTERNAL SLOTS
For external slots use halve feeds

MATERIALE DA LAVORARE	AVANZAMENTO IN mm/giro PER ESAGONI Per quadri, torx e speciali dimezzare avanzamenti
Soft steel up to 1.000 kg/mm² (AVP, C40...)	0,10
Hard steel over 1.000 kg/mm² (k100, k720...)	0,06
Stainless steel	0,07
Cast iron	0,10
Aluminium	0,15
Brass	0,15
Bronze	0,10
Titanium	0,03

Pre-hole for hexagons: MUST be as the inscribed diameter, but recommended 5% larger.
Pre-drilling for squares or other: MUST be as the inscribed diameter, but recommended 10% larger.
Rotary broaching, thanks to stripping grades obtained by Poliangolar products, reduces by 70% the effort that would be required if the same work were to be carried out by press.