ROTARY BROACHING INSTRUCTION MANUAL

RECOMMENDATION AND PART PREPARATION

This guide provides some basic rules and tips for successfully producing forms using the rotary broaching process.
Rotary broaching requires two components: a rotary braoch tool holder and a broach.
Rotary broaching can be performed in almost any turning center: lathe (manual or CNC) or mill.
The only difference is that in a lathe the tool holder is stationary and the part is turning whereas in a mill, the rotary broach tool holder is rotated in the machine spindle and the part is stationary.

TOOL HOLDER SETUP

The Poliangolar tool holders have completely sealed bearing. Therefore, there is no need for constant greasing.
Poliangolar tool holders are completely adjustment-free. Alignment between the rotary broach to the center of the workpiece is extremely important. Broken rotary broaches or uneven form configuration can result from improperly centered broaching. As long as the toolholder block on your turret (or machine spindle on a mill) is centered with your workpiece, simply insert the tool holder and clamp it down.

COOLANT & FLUIDS

Fluids play a minor role in rotary broaching being, generally, a low heat operation. However, the use of cutting oil is recommended as an alternative conventional water-based coolant.