ROTARY BROACHING ORIENTATION LEVER

The rotary boaching orientation lever is used to index the broach to the workpiece.
In lathe application the equipment syncronized the rotation of the broach and the working piece while the tool holder stationary against the stop rod as the tool holder body rotates.





SPEEDS & FEEDS

Many factors affect speeds and feeds, including material, pre-broach drill diameter and form being broached.
It is good practice to set the rotation speed between 50 and 100 RPM in the initial phase of contact between the working piece and the tool (the feed can be the same as the machining). Maintain these rotational speeds until the broach perimeter has fully entered the workpiece (consider that 0,5 mm depth is sufficient for a 10 mm hex).
Then you can set the machine tool to the recommended RPM. This will avoid hopping on the surface of the working piece and will reduce the risk of chipping or breakage of the tool.
Contact Poliangolar for the best solution on your specific application.
A better finish of the working piece is obtained by reducing the feed.
Use rapid movement when retracting the tool keeping the same RPM.