Signature Series **Rotary Broaching**
Designed & Manufactured To The Highest Industry Standard

Rotary / Wobble Broaching on Swiss Type CNC Machines is a cost effective way to produce hex, square and hexlobular drive features and internal polygon forms in one operation. The Broaching process takes only seconds to produce the profile and parts can be finished complete out of the machine without the need for the broaching to be performed as a secondary operation.

The **PREMIERE** Holder For Swiss-Type Rotary Broaching
The First Of Its Kind

Medical • Automotive • Aerospace

NEW! Signature Series Broach Tools

**Swiss-Type Rotary Broach Holders**
- Eliminates Indicating For Center Location
- Low Profile & Compact
- Ideal For Aerospace, Automotive, & Medical Applications

**Static Punch Broach Holders**
- Create Specialized ID Forms
- Rigid With High Repeatability
- Create Forms At Specific Locations

**Robust Broach Holders**
- For Turning Centers & CNC Lathes
- Use With 12mm Sank Broaches
- Robust Bearings Endure High Forces

**Precision Ground**
To ±.0002in Tolerance

**Hexagonal & Hexalobular Sizes Available**

Pressure Vents Prevent Hydraulic Locking

**TOOL HEX SIZES**

<table>
<thead>
<tr>
<th>Hex Sizes</th>
<th>S (in)</th>
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<tr>
<td>8mm</td>
<td>1¼in</td>
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Vented Broach Tools

Micro Hexagon
Hexalobular
A.) Prepare the broach hole with a 60-90° chamfer slightly larger than the largest dimension of the broach tool.

B.) The hole diameter should be drilled approximately 1% larger than the length across the flats of the hex shape.

C.) Drill the hole to a length 1.4 times the length across the flats of the hex shape. If chips need to be removed, re-drill the hole with a slightly smaller drill size.

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**Internal Broaching Tips**

A.) Prepare the broach hole with a 60-90° chamfer slightly larger than the largest dimension of the broach tool.

B.) The hole diameter should be drilled approximately 1% larger than the length across the flats of the hex shape.

C.) Drill the hole to a length 1.4 times the length across the flats of the hex shape. If chips need to be removed, re-drill the hole with a slightly smaller drill size.

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**Static Punch Broach Holders & Tools**

For Making Special ID Forms

- Partial Form Broaches Reduce Cutting Pressure
- No Push Back or Moving During Broaching
- Precise Positioning & Timing Of Broach Forms
- Available For Citizen, Star, Tsugami, Tornos, & Other Swiss Turning Centers

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**Part No.** | **D**  | **L**
---|---|---
RBH-2160-158-038 | .625" | 1.50"
RBH-2160-190-100 | .750" | 4.00"
RBH-2160-254-120 | 1.00" | 4.75"

**Part No.** | **D**  | **L**
---|---|---
RBH-2160-120-038 | 12 | 38
RBH-2160-140-038 | 14 | 38
RBH-2160-160-038 | 16 | 38
RBH-2160-200-100 | 20 | 100
RBH-2160-220-100 | 22 | 100
RBH-2160-250-100 | 25 | 100

**Part No.** | **D**  | **L**
---|---|---
RBH-158250-125-8M | 1.00" | .625" | 1.25" | 2.5"
RBH-190250-125-8M | 1.00" | .750" | 1.25" | 2.5"
RBH-200250-125-8M | 1.00" | 20mm | 1.25" | 2.5"
RBH-220250-125-8M | 1.00" | 22mm | 1.25" | 2.5"
RBH-254250-125-8M | 1.10" | 1.00" | 1.25" | 2.5"

*Only applies when standard 2110 series broaches are used*