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

Precision Ground
To ±.0002in Tolerance

Hexagonal
Sizes Available

Pressure Vents Prevent Hydraulic Locking

Two Broach Tool Types
Choose The Right Tool For The Right Holder
See Below

0828 TOOL HEX SIZES
* 28mm OAL
8mm
S (in)
6mm
Hex

Designed For GenSwiss 2160 Holders

0832 TOOL HEX SIZES
* 1¼in OAL
8mm
S (in)
6mm
Hex

Designed For Competitors’ Holders
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.

**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.

**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