

Centering Offset Internal/ External Rotary Broach Tool Holder

For Holder Numbers:

ORB00, 0S, 0, 2, 3, 4, HD & HDS/ ORBX00, 0S, 0, 2, 3, 4, HD & HDS

1) Install the broach to be used (or a centering pin that is the same length of the broach) in the spindle of the holder

2) Measure the outer diameter/ across the points for the internal broach, or the minimum diameter/ across flats for the external broach (Fig 1.)

3) Prepare a hole to .001 above measured dimension (internal)/ turn diameter .001 below measure dimension (external)

4) Secure the holder in the machine's turret to prevent rotation (Fig 2.)

5) Loosen the two cap screws that secure the holder body to the shank flange to about 3/16" out. (Fig 3.)

6) While holding the body to the shank flange, manually bring broach face to within .030" of the face of the prepared hole (internal)/ turned diameter (external) (Fig 4.)

7) By hand slide broach into the prepared hole (internal)/ over turned diameter (external) (Fig 4.)

8) Move turret in so body flange is no longer separated from shank flange

9) Hand tighten the two cap screws while freely rotating spindle of broach holder (Fig 5.)

10) Fully tighten* the two cap screws (Fig 6.) making sure the spindle of broach holder can still rotate freely.

*(Recommended Torque for cap screws: ORB(X)00,0S: 14 [ft-lb]; ORB(X)0,2,3,4: 29 [ft-lb]; ORB(X)HS,HDS: 49 [ft-lb])



Figure 1.

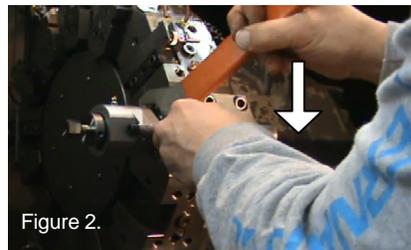


Figure 2.

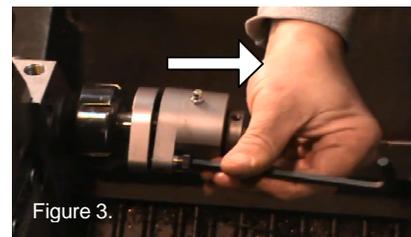


Figure 3.

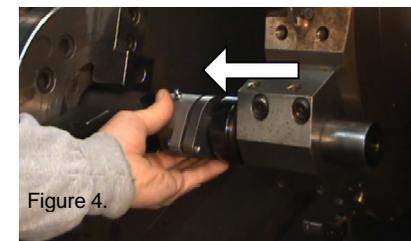


Figure 4.



Figure 5.



Figure 6.



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