

ACROPOLE

Porte-outils à brocher Broaching tool holders



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Porte outils à brocher réglable type 175 - Adjustable broaching tool holder type 175

Utilisation du porte outils à brocher

- Diamètre de perçage

Diamètre identique au brochage à effectuer (P). Il est possible de réaliser un trou légèrement plus grand de 1% à 3% selon appréciation personnelle pour faciliter le guidage de l'outil de brochage.

- Vitesse de rotation

Paramètres recommandés : 1 000 à 2 000 (tr/min)

- Avance

Paramètres recommandés : 0,01 à 0,03 (mm/tr)

- Longueur de brochage

Vous pouvez utiliser plusieurs longueurs (X), selon la profondeur à réaliser

- Centrage de la broche

Le réglage se fait par les vis (Y et W) pour le centrage au point (K) en ligne avec le point (d).



USE AND ADVANTAGES OF USING THIS BROACHING TOOL

- Drilling diameter

Same size (P) as the broach to be machined. It is in any event better, if possible, to make this hole slightly larger, maybe 1% to 3% depending on your personal judgement, to facilitate the drive of the broaching tool.

- Rotation Speed

Recommended parameters: 1000 - 2000 (rpm)

- Feed

Recommended parameters: 0,01 - 0,03 (mm/rpm)

- Broaching length

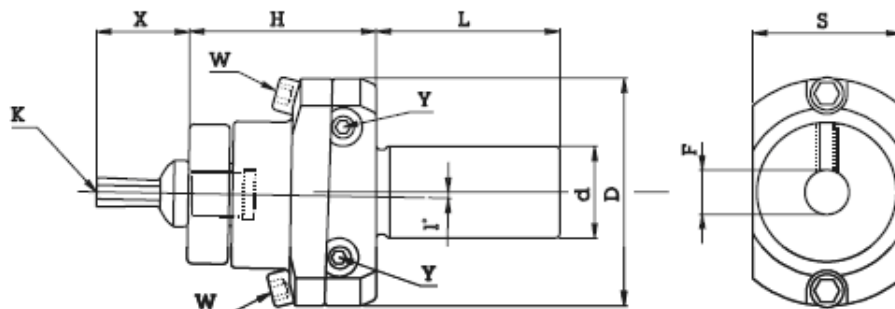
You can use different broaching lengths (parameter X), so that you can even broach inside quite deep chambers.

- Broach centring

By adjusting screws (Y) sideways and screws (W) vertically, you can centre point (K) compared to the centre-line of the shaft (d), which is more precise compared to traditional broaching toolholders that are not adjustable.

- Turn offset

If the shaft is not lodged in the machine centred with the chuck of the head stock, you can correct this offset, again by adjusting screws (y) and (w).



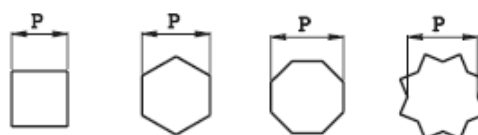
Code						
ART.	d	H	L	D	F	S
175.102	C.M.2	34	68	50	8	30
175.110	10	34	35	50	8	30
175.112	12	34	35	50	8	30
175.114	14	34	35	50	8	30
175.115	15.875	34	35	50	8	30
175.116	16	34	35	50	8	30
175.119	19.05	34	46	50	8	30
175.120	20	34	46	50	8	30
175.125	25	34	46	50	8	30
175.126	25.40	34	46	50	8	30

Su questo brocciatore va montata la broccia art. Z801 descritta a pag. 90-91
Broach code Z801 described in page 90-91
is fitted on this broach toolholder

Code						
ART.	d	H	L	D	F	S
175.202	C.M.2	52	68	62	12	40.5
175.219	19.05	52	50	62	12	40.5
175.220	20	52	50	62	12	40.5
175.222	22	52	50	62	12	40.5
175.225	25	52	50	62	12	40.5
175.226	25.40	52	50	62	12	40.5
175.230	30	52	50	62	12	40.5
175.231	31.75	52	50	62	12	40.5
175.232	32	52	50	62	12	40.5

Su questo brocciatore va montata la broccia art. Z800 descritta a pag. 90-91
Broach code Z800 described in page 90-91
is fitted on this broach toolholder

Esempi di alcune figure di brocche
Broach example



Porte outils à brocher type 175 - Broaching tool holder type 175

Code						
ART.	d	I	L	D	F	H
175.508	8	34	35	22	5	10
175.510	10	34	35	22	5	10
175.512	12	34	35	22	5	10
175.514	14	34	35	22	5	10
175.515	15.875	34	35	22	5	10
175.516	16	34	35	22	5	10
175.519	19.05	34	46	22	5	10
175.520	20	34	46	22	5	10
175.522	22	34	46	22	5	10

Ces porte-outils brochantes se montent à broches art. 7803 décrites à page 80 et

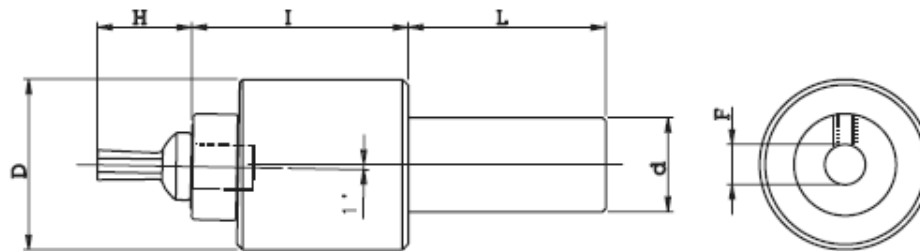
Utilisation avec broches type Z803

Broach code Z803 is fitted on this broaching tool holder

Code						
ART.	d	I	L	D	F	H
175.602	C.M.2	38	69	32	8	18
175.610	10	38	35	32	8	18
175.612	12	38	35	32	8	18
175.614	14	38	35	32	8	18
175.615	15.875	38	35	32	8	18
175.616	16	38	35	32	8	18
175.619	19.05	38	50	32	8	18
175.620	20	38	50	32	8	18
175.622	22	38	50	32	8	18
175.625	25	38	50	32	8	18
175.626	25.40	38	50	32	8	18

Utilisation avec broches type Z801

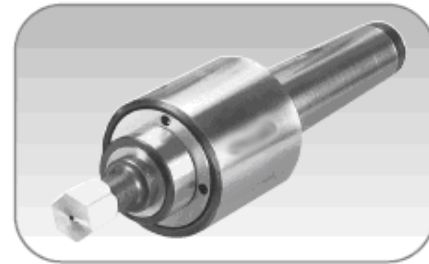
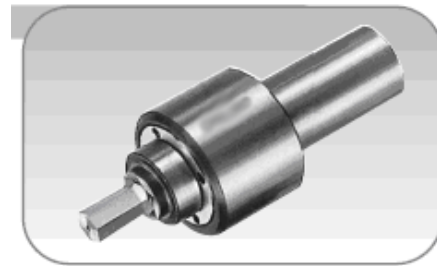
Broach code Z801 is fitted on this broaching tool holder



Code						
ART.	d	I	L	D	F	H
175.803	C.M.3	76	85	58	16	40
175.804	C.M.4	76	109	58	16	40
175.820	20	76	50	58	16	40
175.825	25	76	50	58	16	40
175.826	25.40	76	50	58	16	40
175.830	30	76	50	58	16	40
175.831	31.75	76	50	58	16	40
175.832	32	76	50	58	16	40
175.840	40	76	80	58	16	40

Utilisation avec broches type Z802

Broach code Z802 is fitted on this broaching tool holder



Code						
ART.	d	I	L	D	F	H
175.702	C.M.2	46	69	44	12	25
175.716	16	46	50	44	12	25
175.719	19.05	46	50	44	12	25
175.720	20	46	50	44	12	25
175.722	22	46	50	44	12	25
175.725	25	46	50	44	12	25
175.726	25.40	46	50	44	12	25
175.732	32	46	50	44	12	25

Utilisation avec broches type Z800

Broach code Z800 is fitted on this broaching tool holder

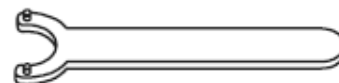
Remarque

Pour ce porte outils à brocher il est important d'utiliser des broches type « H » comme dans la table

In this tool holders is important to use broaches that have « H » like in tablet

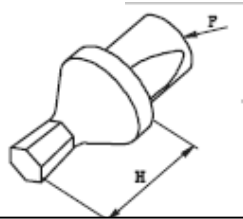
Clé pour démontage

Spanner for repair



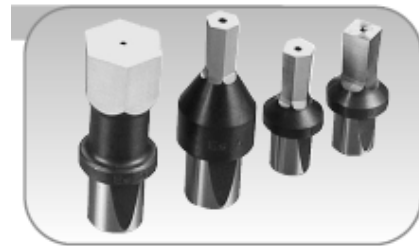
Code	For Broach toolholder
ART.	Per Brocciatore
175.500 H	175.500
175.600 H	175.600
175.700 H	175.700
175.800 H	175.800

Broche type 800 – 801 – 803 - Broach type 800 – 801 - 803



Broche disponible également en TIN

Broach TIN coating can be supplied on request



Hexagonal Broche type 803 Carré (square)

Code			hexag.
ART.	F	H	esagono
803001	5	10	1
8030015	5	10	1.5
803002	5	10	2
8030025	5	10	2.5
803003	5	10	3
8030035	5	10	3.5
803004	5	10	4
803005	5	10	5
8030055	5	10	5.5
803006	5	10	6

Code			square
ART.	F	H	quadro
803101	5	10	1
8031015	5	10	1.5
803102	5	10	2
8031025	5	10	2.5
803103	5	10	3
8031035	5	10	3.5
803104	5	10	4
803105	5	10	5
8031055	5	10	5.5
803106	5	10	6

Hexagonal Broche type 801 Carré (square)

Code			hexag.
ART.	F	H	esagono
801001	8	18	1
8010015	8	18	1.5
801002	8	18	2
8010025	8	18	2.5
801003	8	18	3
8010035	8	18	3.5
801004	8	18	4
801005	8	18	5
8010055	8	18	5.5
801006	8	18	6
801007	8	18	7
801008	8	18	8

Code			square
ART.	F	H	quadro
801102	8	18	2
8011025	8	18	2.5
8011003	8	18	3
80110035	8	18	3.5
801104	8	18	4
801105	8	18	5
8011055	8	18	5.5
801106	8	18	6
801107	8	18	7

Hexagonal Broche type 800 Carré (square)

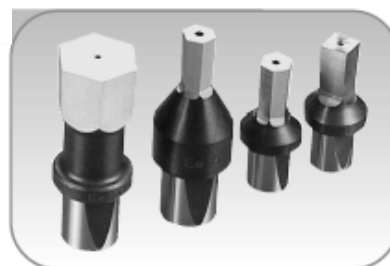
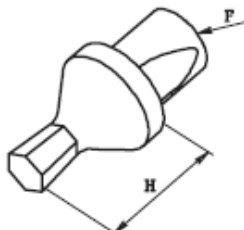
Code			hexag.
ART.	F	H	esagono
800001	12	25	1
8000015	12	25	1.5
800002	12	25	2
8000025	12	25	2.5
800003	12	25	3
8000035	12	25	3.5
800004	12	25	4
800005	12	25	5
8000055	12	25	5.5
800006	12	25	6
800007	12	25	7
800008	12	25	8
800009	12	25	9
800010	12	25	10
800011	12	25	11
800012	12	25	12
800013	12	25	13
800014	12	25	14

Code			square
ART.	F	H	quadro
800102	12	25	2
8001025	12	25	2.5
800103	12	25	3
8001035	12	25	3.5
800104	12	25	4
800105	12	25	5
8001055	12	25	5.5
800106	12	25	6
800107	12	25	7
800108	12	25	8
800109	12	25	9
800110	12	25	10
800111	12	25	11
800112	12	25	12
800113	12	25	13

Broche type 802 - Broach type 802

Broche disponible également en TIN

Broach TIN coating can be supplied on request



Hexagonal				Broche type 802				Carré (square)			
Code			hexag.	Code			square	Code			square
ART.	F	H	esagono	ART.	F	H	quadro	ART.	F	H	quadro
802003	16	40	3	802104	16	40	4	802104	16	40	4
8020035	16	40	3.5	802105	16	40	5	802105	16	40	5
802004	16	40	4	802106	16	40	6	802106	16	40	6
802005	16	40	5	802107	16	40	7	802107	16	40	7
802006	16	40	6	802108	16	40	8	802108	16	40	8
802007	16	40	7	802109	16	40	9	802109	16	40	9
802008	16	40	8	802110	16	40	10	802110	16	40	10
802009	16	40	9	802111	16	40	11	802111	16	40	11
802010	16	40	10	802112	16	40	12	802112	16	40	12
802011	16	40	11	802113	16	40	13	802113	16	40	13
802012	16	40	12	802114	16	40	14	802114	16	40	14
802013	16	40	13	802115	16	40	15	802115	16	40	15
802014	16	40	14	802116	16	40	16	802116	16	40	16
802015	16	40	15	802117	16	40	17	802117	16	40	17
802016	16	40	16	802118	16	40	18	802118	16	40	18
802017	16	40	17	802119	16	40	19	802119	16	40	19
802018	16	40	18	802120	16	40	20	802120	16	40	20
802019	16	40	19	802121	16	40	21	802121	16	40	21
802020	16	40	20	802122	16	40	22	802122	16	40	22
802021	16	40	21	802123	16	40	23	802123	16	40	23
802022	16	40	22	802124	16	40	24	802124	16	40	24
802023	16	40	23	802125	16	40	25	802125	16	40	25
802024	16	40	24								
802025	16	40	25								

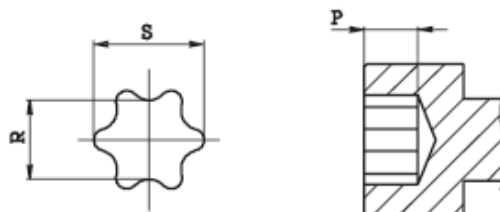
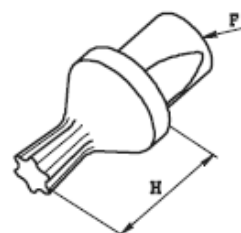
Broche type 802 – 801 - Broach type 802 - 801

Broche torx 801 – Torx broach 801

ART. (code)	F	H	P	S	R	torx*
801206	8	18	0,50-0,70	1,80	1,29	6
801208	8	18	0,70-0,90	2,45	1,80	8
801210	8	18	1,00-1,30	2,85	2,07	10
801215	8	18	1,30-1,50	3,38	2,44	15
801220	8	18	1,50-1,60	3,96	2,86	20
801225	8	18	1,60-2,00	4,55	3,28	25
801227	8	18	2,00-2,40	5,10	3,65	27
801230	8	18	2,60-3,00	5,65	4,07	30

Broche torx 801 – Torx broach 802

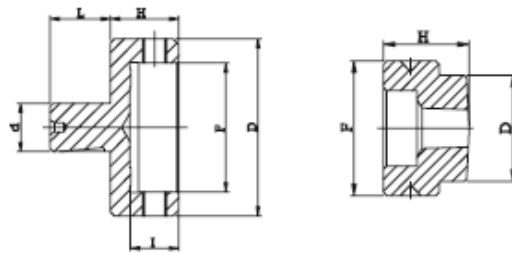
ART. (code)	F	H	P	S	R	torx*
800206	12	25	0,50-0,70	1,80	1,29	6
800208	12	25	0,70-0,90	2,45	1,80	8
800210	12	25	1,00-1,30	2,85	2,07	10
800215	12	25	1,30-1,50	3,38	2,44	15
800220	12	25	1,50-1,60	3,96	2,86	20
800225	12	25	1,60-2,00	4,55	3,28	25
800227	12	25	2,00-2,40	5,10	3,65	27
800230	12	25	2,60-3,00	5,65	4,07	30
800240	12	25	3,00-3,30	6,80	4,88	40
800245	12	25	3,50-4,00	7,97	5,68	45
800250	12	25	4,00-4,50	8,99	6,50	50



* Torx est ne marque déposée de Textron inc. Providence (USA)

* Torx is a trade mark registered by Textron inc. Providence (USA)

Broche extérieur type 806 - External Broach type 806



Porte broche dia. 12 – *Outside broach holder 12*

ART.	d	L	H	I	F	D
175790	12	15	17	12	32	44

Utilisation avec les porte outils ci-dessous
Use this broach with below holder type

175200 – 175700 – 9R2.20.12 – 9R2.30.12 – 9R2.40.12

Porte broche dia. 16 – *Outside broach holder 16*

ART.	d	L	H	I	F	D
175890	16	19	32	12	32	44

Utilisation avec les porte outils ci-dessous
Use this broach with below holder type

175800 – 9R2.30.16 – 9R2.40.16

Broche extérieur type 806 - External Broach type 806

Code	F	D	H	hexagonal esagono
Z 806003	32	25,3	20,5	3
Z 806004	32	25,3	20,5	4
Z 806005	32	25,3	20,5	5
Z 806006	32	25,3	20,5	6
Z 806007	32	25,3	20,5	7
Z 806008	32	25,3	20,5	8
Z 806009	32	25,3	20,5	9
Z 806010	32	25,3	20,5	10
Z 806011	32	25,3	20,5	11
Z 806012	32	25,3	20,5	12
Z 806013	32	25,3	20,5	13
Z 806014	32	25,3	20,5	14
Z 806015	32	25,3	20,5	15
Z 806016	32	30	20,5	16
Z 806017	32	30	20,5	17
Z 806018	32	30	20,5	18
Z 806019	32	30	20,5	19
Z 806020	32	30	20,5	20

Code	F	D	H	square quadro
Z 806103	32	25,3	20,5	3
Z 806104	32	25,3	20,5	4
Z 806105	32	25,3	20,5	5
Z 806106	32	25,3	20,5	6
Z 806107	32	25,3	20,5	7
Z 806108	32	25,3	20,5	8
Z 806109	32	25,3	20,5	9
Z 806110	32	25,3	20,5	10
Z 806111	32	25,3	20,5	11
Z 806112	32	25,3	20,5	12
Z 806113	32	25,3	20,5	13
Z 806114	32	30	20,5	14
Z 806115	32	30	20,5	15
Z 806116	32	30	20,5	16
Z 806117	32	30	20,5	17
Z 806118	32	30	20,5	18

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Equipements – Pièces détachées – Pincettes – accessoires
Equipment – Spare parts – Collets - Accessories



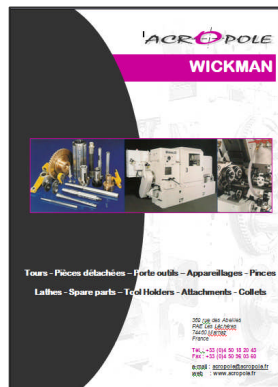
GILDEMEISTER
AS16 – GM16 – AS20 – GS20 –
GM20



GILDEMEISTER
GM32 – GM35 – GM42



GILDEMEISTER
AS25 – AS32 – AS48 – AS67 –
AS82 – AS100



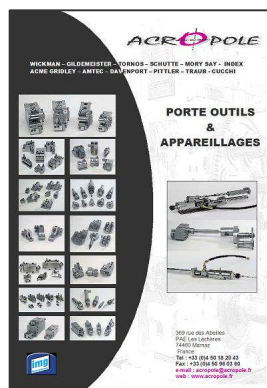
WICKMAN



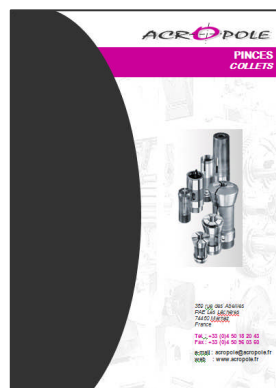
TORNOS
AS14 – SAS16 – BS20



SCHÜTTE



Porte outils – Appareillages
Tours Multibroches
Tool holders - Attachments



Pincettes
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