



Broaching of internal splines

max. part dimensions:

max. external- \varnothing	550 mm
max. height	420 mm
max. weight	250 kg

Data sheet
 Broaching machine
 Klink
11/13

20130320 / Ko

Technical Data of the machine

Maximal tensile force	1000 kN
Nominal broaching range	2750 mm
Maximal length of tool	2950 mm

Maximal dimensions of part:

Maximal external- \varnothing	550 mm
Maximal height	420 mm
Maximal weight	250 kg

Important notes

Preparation of parts to be broached

In order that broaching work can be done with the requested precision, all axial run-outs have to be aligned accurately with the boring to be broached.

Length of broaching

Possible broaching length of profiles are listed in below table.

Entgraten der Räumteile

Broached parts will not be burred by company Rollstar. We recommend to chamfer the outline of the toothing on both sides adequately.

In order to consult you in an optimal way concerning broaching process, we kindly invite you to contact us.

Profile / broaching tools

Module	Nominal dimension [mm]	Number of teeth	Internal diameter D1 [mm]	Length of broaching [mm]
3	N90x3 DIN5480	28	$\varnothing 84$ H7	40-65
3	Z87 M3	37	$\varnothing 108,3$ H7	33
3	Z50 M3	50	$\varnothing 147,2$ H7	42
5	N130x5 DIN5480	24	$\varnothing 120$ H7	40-95
5	N150x5 DIN5480	28	$\varnothing 140$ H7	92-98
5	N170x5 DIN5480	32	$\varnothing 160$ H7	92
5	N180x5 DIN5480	34	$\varnothing 170$ H7	100
5	N220x5 DIN5480	42	$\varnothing 210$ H7	145
	A10x82x88 DIN5462	Splined hub profile	$\varnothing 82$ H7	65

