

# Round Broaches

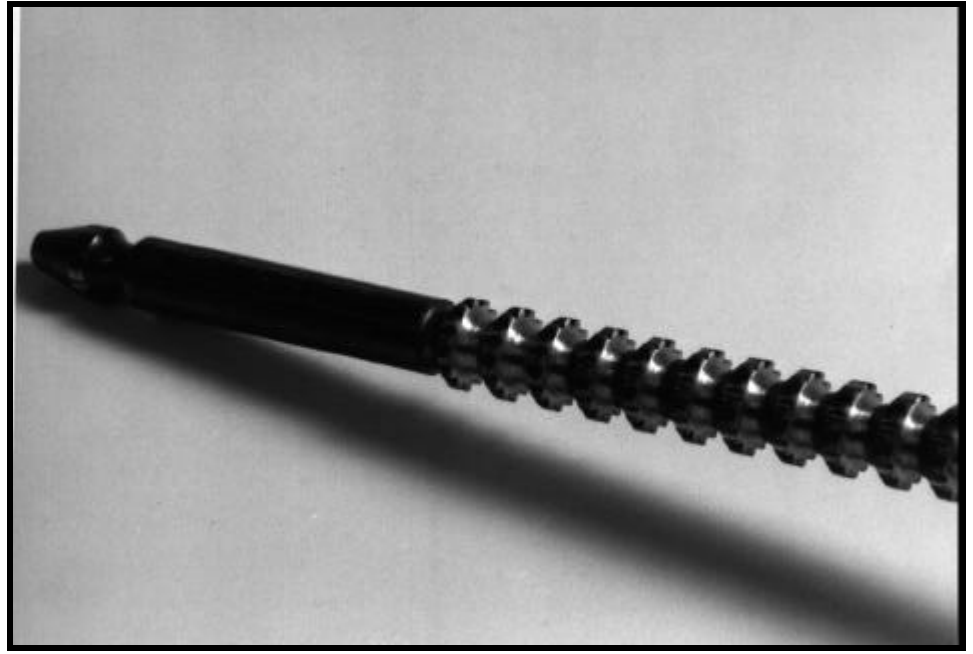
## Application Sheet #515

### Description

Manufacturing or regrinding round broaches.

### Application

- CNC grinding produces an accurate tooth profile and improves broach performance.
- CNC resharpener removes a controlled amount of material from each tooth, extending tool life.
- Sizes range from rifle broaches ½ in. (12.7 mm) diameter and 24 in. (609.6 mm) long. To button and spiral broaches 6 in. (152.4 mm) diameter and 96 in. (2,438.4 mm) long.
- Grinding under high-pressure flood coolant allows faster grinding speeds and reduces heat-induced stress.



### Process

Round broaches are mounted between centers and dogged. The integrated contact probe is used for determining the broach location and for verifying the first tooth and pitch spacing. These individual locations are then utilized by the grinding program for positioning the grinding wheel.

- A single-wheel setup is required for broach resharpener (gullets only).
- A dual-wheel setup is required for broach manufacturing (gullets and OD).

### Material

- Hardened tool steel

### Features and Benefits

- Huffman Broach Grinders include the HS-856, HS-130 and HS-160 Series Grinders.
- A contact probe is used for determining broach location in either a manufacturing or regrind application. For regrinding only, the probe is used for locating the first tooth and for verifying pitch spacing. For manufacturing, only the broach location is required.
- The A-axis and tailstock are necessary for either resharpener or manufacturing.
- The B and C axes are available as manual axes or under CNC control.
- An optional integrated wheel truing system is available.
- Chipbreakers are available as an option.

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