

# BROACH HOLDERS/ARBOR PRESSES

B

LATHES CHUCKS  
LIVE CENTERS

VICE JAWS  
VICE ACCESSORIES

STRAIGHT SHANK  
COLLET HOLDERS

LATHES BUSHINGS  
DRILL CHUCKS

CARBIDE INSERTS  
THREADING/GROOVING

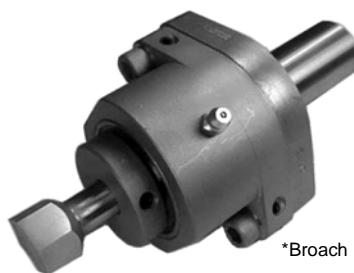
CUTTING TOOLS  
MACHINERY

PRECISION TOOLS  
DEBURRING

COOLANT/FLUIDS  
TOOL STORAGE



**NEW ITEM!**



\*Broach Not Included

## ROTARY BROACH HOLDERS

**Rotary/Punch Broaches** can be used in a variety of machines to cut polygons in blind holes. Any type of CNC or manual turning, milling, drilling or screw machine. The practical forming length of rotary/punch broaching is usually up to 1-1/2 times the size of the broach (measured across flats).

**Rotary Broach Holders:** For optimal tool life in large production settings these broaches are used in Rotary Broach Holders. Holders and broaches are sold separately and available from stock for immediate delivery. These holders are for use on any type CNC or manual turning, milling, drilling or screw machine. The holder has an internal live spindle, which holds the end cutting broach tool. The centerline of the cutting tool is offset at 1" from the centerline of the work piece. This causes the broach to wobble creating a shearing effect as the broach is advanced into the work piece or vice versa as described below:

**Broaching A Rotating Work Piece:** In a turning or screw machine, the holder is mounted stationary while its internal live spindle and the broach rotates after contact with the rotating work piece (Diagram A). At the appropriate feed, the work piece is "sheared" by the pressure of the broach through a wobbling type action producing the polygon shape desired.

**Broaching A Stationary Work Piece:** In a milling or drilling machine, the holder is mounted into and rotates with the machine spindle while its internal live spindle along with the broach remains stationary upon contact with the stationary work piece (Diagram B). While the machine spindle is rotating, the broach's pressure shears the polygon shape into the work piece (wobbling type action).

**Punching Versus Rotary Broaching:** Many applications can be achieved without the rotary broach holder. For the purpose of merely punching a polygon into an existing pilot hole, these broaches have successfully been used with universal machining methods.

OAL	Shank Dia	Shank Length	Broach Shank Depth	Part Number	Price
<b>For Broaches With .315 diameter shanks</b>					
3-27/64	5/8"	1-1/2"	9/16	HS-P67040	\$980.00
3-59/64	3/4"	2"	9/16	HS-P67048S	\$1,012.00
<b>For Broaches With .500 diameter shanks</b>					
4-17/32	3/4"	2"	.742	HS-P67048S	\$1,095.00
	1"	2"	.742	HS-P67064	\$1,127.00
5-17/32	1-1/4"	3"	.742	HS-P67068	\$1,160.00
	1-1/2"	3"	.742	HS-P67072	\$1,195.00
<b>For Broaches With .750 diameter shanks</b>					
7-9/16	1-1/2"	3"	1.250	HS-P67072HDS	\$2,162.00
	1-3/4"	3"	1.250	HS-P67076HS	\$2,162.00

## SINGLE LEVERAGE ARBOR PRESSES

**NEW ITEM!**

- Shimmed ram cap permits take-up for potential wear
- Adjustable handle allows convenient handle positioning
- Smooth action gears permits finite ram control
- Base opening and slotted table plate for arbor work on models noted
- Pedestals also available



Force Ton	Leverage Ratio	Table Type	RAM Size	Max Work Dia	Throat	Base Dimension	Wgt	Part Number	Price Each
1	25:1	Solid	1" x 1" x 7-1/2"	7"	3-1/2"	4-1/4" x 9-1/2"	25 lbs	DAKE-01001	\$285.00
1-1/2	32:1	Solid	1" x 1" x 12"	9"	4-1/2"	6" x 15"	60 lbs	DAKE-01002	\$395.00
1	25:1	Slotted	1" x 1" x 7-1/2"	7"	3-1/2"	4-1/4" x 9"	25 lbs	DAKE-01004	\$285.00
1-1/2	32:1	Slotted	1" x 1" x 12"	9"	4-1/2"	6" x 14"	65 lbs	DAKE-01005	\$395.00
3	36:1	Slotted	1-1/4" x 1-1/4" x 16-1/2"	14"	7"	7-1/4" x 18"	130 lbs	DAKE-01006	\$595.00

### Pedestals For Arbor Presses

Description	Dimension w.x.d x h	Wgt	Part Number	Price
Pedestal for Models 01002 & 01005	10" X 18" X 36"	50	DAKE-01003	\$305.00
Pedestal for Model 01006	12" x 21" x 36"	70	DAKE-01007	480.00

## ARBOR PRESSES

The Palmgren arbor press delivers the heavy force needed for riveting, squeezing, punching, bending, and other pressing applications. Sturdy, cast-iron construction. Removable machined steel anvil provides accurate work support in four slot positions. Rugged steel ram is driven by a machined pinion. Punches or tools may be added to the end of the ram with the aid of a magnetic insert. Base drilled for mounting on a bench or pedestal. PALM-61101 is equipped with a hand-wheel to perform light and quick press work.

The Arbor Press Stand provides a sturdy base and optimal height for easy operation. It has a slot on the top for pieces which need to extend below the base of the press table. Stand comes with built-in cup for catching expressed pieces. Base and top are cast iron; body of welded steel. Fits all 2-4 ton presses.



Force Ton	Swing	Anvil Dia.	Max Work Hgt.	Ram Dim.	Height	Base Dimension	Wgt	Part Number	Price Each
0.5	7-1/2"	3-3/8"	4-1/2"	3/4" x 3/4"	9-3/8"	5-1/8" x 9-3/8"	22 lbs	PALM-61051	\$54.40
1	8"	4-7/16"	6-1/8"	1" x 1"	11-1/8"	6-5/16 x 10-3/4"	27 lbs	PALM-61101	\$74.80
2	11-7/8"	6-5/8"	8"	1-1/4" x 1-1/4"	15-1/8"	11-1/8 x 16"	64 lbs	PALM-61201	\$149.60
3	12-1/2"	6-5/8"	12-5/8"	1-1/2" x 1-1/2"	21"	7-7/8 x 17-7/8"	102 lbs	PALM-61301	\$221.00

### Arbor Press Stand

Top Dimension	Base Dimension	Height	Wgt	Part Number	Price Each
11-13/16" x 22-1/16"	11-13/16" x 22-1/4"	33-13/16"	100 lbs	PALM-70103	\$192.10

Arbor Press Stand  
PALM-70103



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2010-11 Master Catalog

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