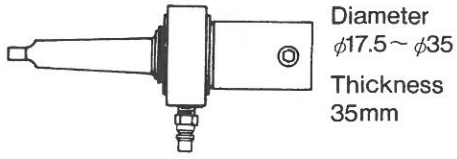


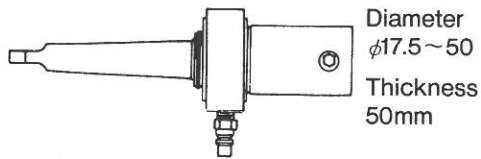
BROACH HOLDER

Instruction Manual

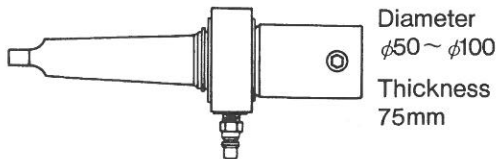
BHM-02035 (M.T. No.2)



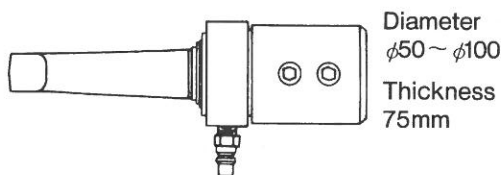
BHM-03050 (M.T. No.3)



BHM-13075 (M.T. No.3)



BHM-14075 (M.T. No.4)



9-4, Nakaikegami 2-chome, Ohta-ku, Tokyo, Japan
Tel: Tokyo 3755-1111 Cable Address: NITOHIND TOKYO
Fax: 3753-8791

Pilot Pin by feeding slightly, expel the cutting lubricant. Cutting lubricant will not be expelled unless the Pilot Pin is drawn in.

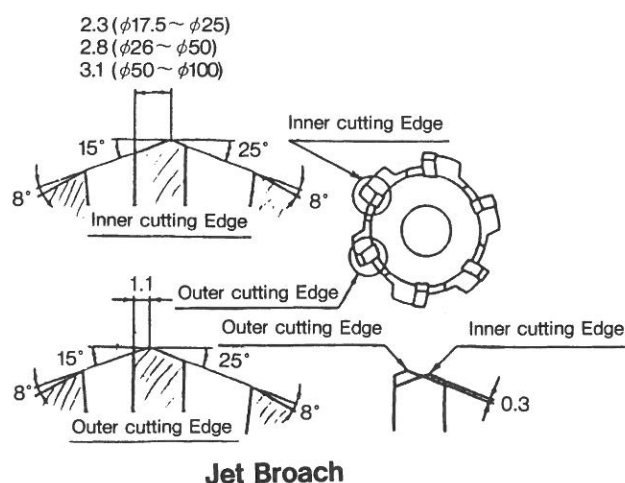
- When beginning drilling, drill in slowly to a depth of 2-3mm. If drilling at the beginning is attempted by applying excess force, misalignment of center or damage to the Jet Broach may result.
- When drilling is just before conclusion of cut, feed the drill slowly. If feeded too rapidly, drilling fragments may become easily clogged inside the Jet Broach.
- After the drilling operation, pull out the Jet Broach leaving it rotating.

3. Cautions for Use

- Do not make holes without applying cutting oil.
- Always make sure to expel a sufficient amount of cutting lubricant when drilling. When using machines that are not equipped with devices for supplying cutting lubricant, use the Oil Cup Complete Assembly (TB00350) available as an option.
- Before operation, make sure that no slugs or chips are left inside of the cutter. If a slug is clogged inside of the cutter, take it out tapping symmetrically with a needle or a like.
- Never stop rotation during operation. After pulling the Jet Broach out of the material, stop the rotation.
- Feed slowly and carefully when digging the black coated part of material.
- Do not make a hole onto the piled plates.
- On completion of making a hole, pay attention to a slug popping down off.

4. Resharpener of Jet Broach

When Jet Broach becomes blunt, please sharpen the portions indicated below.



Preface

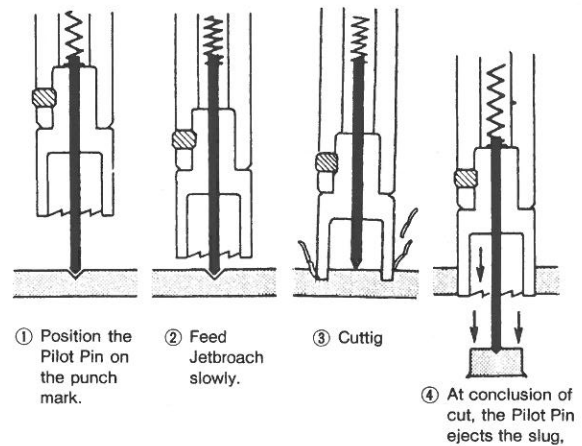
Thank you very much for purchasing Broach Holder.

When performing drilling work using drilling machine, lathe, milling machine or machining center, drilling accuracy and efficiency will be improved by using the tungsten carbide-tipped Jet Broach in place of a twist drill. In addition, since resharpener is possible, the drilling process becomes more economical. We recommend that you carefully read this instruction manual prior to use to ensure efficient and effective operation.

1. Preparations for Use

- Install the Broach Holder on the machine.
- Attach the Oil Ring Stopper (rod which prevents rotation) onto the Oil Ring and set in position so that the Oil Ring does not rotate together with the Broach Holder.
- Attach a Coupler (02SH) to one side of the tube and attach the cutting lubricant discharge outlet of the machine to the opposite side.
- Connect the tube to the Oil Ring with the Coupler.

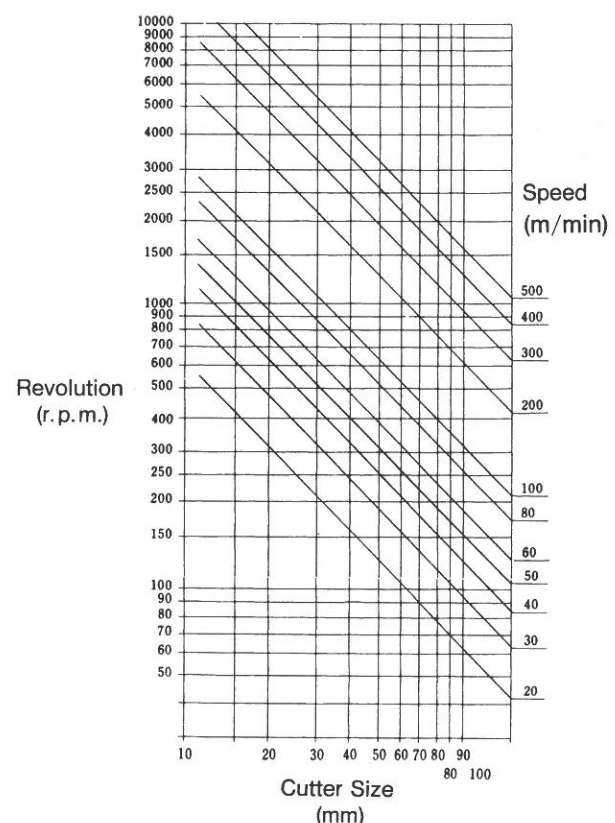
Cutting procedure by Jetbroach



2. Operation

- Take enough space (thickness of the material plus about 10 mm) under the drilling point when fixing the material to be drilled.
- Insert the Pilot Pin into the Jet Broach and attach to the Broach Holder.
- Set rotating speed and feeding speed according to the size of the Jet Broach. In addition, when the amount of cutting lubricant is low, we recommend drilling by manual feeding.
- Align the end of the Pilot Pin with the punched hole and after drawing in the

5. A guide to the selection of surface cutting speeds



Speed

	Speed m/min
Mild Steel	30 ~ 50
Stainless Steel	20 ~ 40
Aluminum	70 ~ 90
Cast Iron	30 ~ 50
Brass	50 ~ 70

Feed Speed

0.02 ~ 0.1mm/rev

6. Optional Jet Broaches













Part No.	Size (mm)
TJ16538	φ17.5×35 ℓ
TJ16539	φ19×35 ℓ
TJ16571	φ19.5×35 ℓ
TJ16540	φ20×35 ℓ
TJ16572	φ20.5×35 ℓ
TJ16541	φ21×35 ℓ
TJ16573	φ21.5×35 ℓ
TJ16542	φ22×35 ℓ
TJ16574	φ22.5×35 ℓ
TJ16543	φ23×35 ℓ
TJ16575	φ23.5×35 ℓ
TJ16544	φ24×35 ℓ
TJ16576	φ24.5×35 ℓ
TJ16545	φ25×35 ℓ
TJ16546	φ26×35 ℓ
TJ16547	φ27×35 ℓ
TJ16548	φ28×35 ℓ
TJ16549	φ29×35 ℓ
TJ16550	φ30×35 ℓ
TJ16551	φ31×35 ℓ
TJ16552	φ32×35 ℓ
TJ16553	φ33×35 ℓ
TJ16554	φ34×35 ℓ
TJ16555	φ35×35 ℓ

Part No.	Size (mm)
TK00042	φ17.5×50 ℓ
TK00043	φ18×50 ℓ
TK00044	φ19×50 ℓ
TK00045	φ19.5×50 ℓ
TK00031	φ20×50 ℓ
TK00046	φ20.5×50 ℓ
TK00047	φ21×50 ℓ
TK00048	φ21.5×50 ℓ
TK00049	φ22×50 ℓ
TK00050	φ22.5×50 ℓ
TK00032	φ23×50 ℓ
TK00051	φ23.5×50 ℓ
TK00052	φ24×50 ℓ
TK00053	φ24.5×50 ℓ
TK00054	φ25×50 ℓ
TK00055	φ26×50 ℓ
TK00057	φ27×50 ℓ
TK00058	φ28×50 ℓ
TK00059	φ29×50 ℓ
TK00060	φ30×50 ℓ
TK00061	φ31×50 ℓ
TK00062	φ32×50 ℓ
TK00063	φ33×50 ℓ
TK00064	φ34×50 ℓ
TK00065	φ35×50 ℓ
TJ16556	φ36×50 ℓ
TJ16557	φ37×50 ℓ
TJ16558	φ38×50 ℓ
TJ16559	φ39×50 ℓ
TJ16560	φ40×50 ℓ
TJ16561	φ41×50 ℓ
TJ16562	φ42×50 ℓ
TJ16563	φ43×50 ℓ
TJ16564	φ44×50 ℓ
TJ16565	φ45×50 ℓ
TJ16566	φ46×50 ℓ
TJ16567	φ47×50 ℓ
TJ16568	φ48×50 ℓ
TJ16569	φ49×50 ℓ
TJ16570	φ50×50 ℓ

Part No.	Size (mm)
TJ17924	φ50×75 ℓ
TJ17925	φ51×75 ℓ
TJ17926	φ52×75 ℓ
TJ17927	φ53×75 ℓ
TJ17928	φ54×75 ℓ
TJ17929	φ55×75 ℓ
TJ17930	φ56×75 ℓ
TJ17931	φ57×75 ℓ
TJ17932	φ58×75 ℓ
TJ17933	φ59×75 ℓ
TJ17934	φ60×75 ℓ
TJ17935	φ61×75 ℓ
TK00052	φ62×75 ℓ
TJ17937	φ63×75 ℓ
TJ17938	φ64×75 ℓ
TJ17939	φ65×75 ℓ
TJ17940	φ66×75 ℓ
TJ17941	φ67×75 ℓ
TJ17942	φ68×75 ℓ
TJ17943	φ69×75 ℓ
TJ17944	φ70×75 ℓ
TJ17945	φ71×75 ℓ
TJ17946	φ72×75 ℓ
TJ17947	φ73×75 ℓ
TJ17948	φ74×75 ℓ
TJ17949	φ75×75 ℓ
TJ17950	φ76×75 ℓ
TJ17951	φ77×75 ℓ
TJ17952	φ78×75 ℓ
TJ17953	φ79×75 ℓ
TJ17954	φ80×75 ℓ
TJ17955	φ81×75 ℓ
TJ17956	φ82×75 ℓ
TJ17957	φ83×75 ℓ
TJ17958	φ84×75 ℓ
TJ17969	φ85×75 ℓ
TJ17970	φ86×75 ℓ
TJ17971	φ87×75 ℓ
TJ17971	φ88×75 ℓ
TJ17973	φ89×75 ℓ
TJ17974	φ90×75 ℓ
TJ17975	φ91×75 ℓ
TJ17976	φ92×75 ℓ
TJ17977	φ93×75 ℓ
TJ17978	φ94×75 ℓ
TJ17979	φ95×75 ℓ
TJ17980	φ96×75 ℓ
TJ17981	φ97×75 ℓ
TJ17982	φ98×75 ℓ
TJ17983	φ99×75 ℓ
TJ17984	φ100×75 ℓ

1/2 Inch size are available only for NORTH AMERICA.

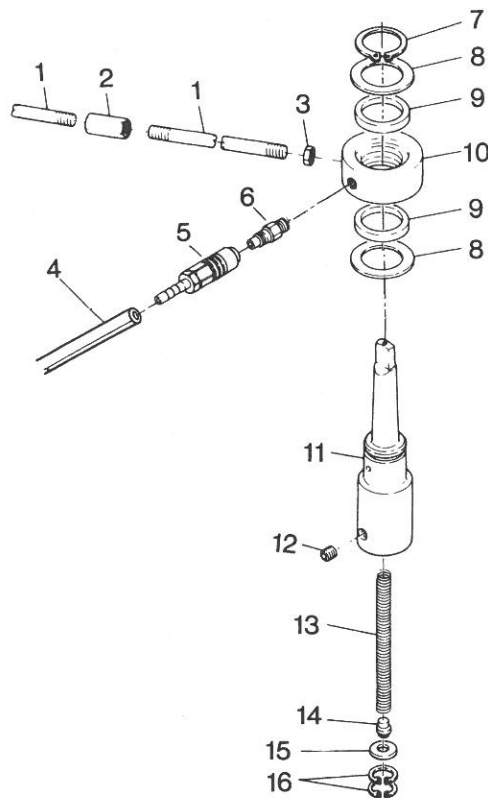
7.

<p>● BHM-02035 (M.T. No.2)</p> 	Pilot Pin 08035	Jet Broach
		
	φ17.5~φ35 (Thickness 35mm)	
<p>● BHM-03050 (M.T. No.3)</p> 	Pilot Pin 08035	Jet Broach
		
	φ17.5~φ35 (Thickness 35mm)	
<p>● BHM-13075 (M.T. No.3)</p> 	Pilot Pin 08050	Jet Broach
		
	φ17.5~φ50 (Thickness 50mm)	
<p>● BHM-14075 (M.T. No.4)</p> 	Pilot Pin 12075	Jet Broach
		
	φ50~φ100 (Thickness 75mm)	

8. Ordering Service Parts

- For further operational and handling information or for replacement of parts and components, contact the sale agent from whom you purchased the tool or the service division of our company.
- In ordering parts and components, give each part number, name and quantity.

9. Broach Holder Assembly and Parts List



SAVE THIS MANUAL



No.	Part No.	Part Name	Quantity			
			BHM-02035	BHM-03050	BHM-13075	BHM-14075
1	TPI5252	Oil Ring Stopper	1	2	2	2
2	TPI5253	Nut 8×30	—	1	1	1
3	TP08584	Hexagon Nut M8	1	1	1	1
4	TPI7680	Tube 8×12×1000	1	1	1	1
5	—	O2SH	1	1	1	1
6	—	O1PM	1	1	1	1
7	TPI5239	Retaining Ring C-28	1	1	—	—
7	TPI4969	Retaining Ring ISTW-38	—	—	1	1
8	TPI5240	Washer 28.5×42×1	2	2	—	—
8	TPI2773	Washer 38.5×54×1	—	—	2	2
9	TPI5246	Oil Seal GD28×37×4	2	2	—	—
9	TPI4499	Oil Seal GD38×48×4	—	—	2	2
10	TQ00447	Oil Ring	1	1	—	—
10	TPI7674	Oil Ring	—	—	1	1
11	TPI5850	Holder MT 02035	1	—	—	—
	TPI5942	Holder MT 03050	—	1	—	—
	TPI7675	Holder MT 13075	—	—	1	—
	TPI7681	Holder MT 14075	—	—	—	1
12	TPI6723	Hexagon Socket Set Screw 12×9.5	1	1	—	—
	TPI7679	Hexagon Socket Set Screw 16×14	—	—	2	2
13	TPI5846	Spring 1.4×8.2×117	1	—	—	—
	TPI5943	Spring 1.6×12.8×135	—	1	—	—
	TPI7678	Spring 1.6×11×155	—	—	1	—
	TPI7685	Spring 1.8×17×115	—	—	—	1
14	TPI5847	Pilot Spacer	1	—	—	—
	TPI5944	Pilot Spacer	—	1	—	—
	TPI7677	Pilot Spacer	—	—	1	—
	TPI7684	Pilot Spacer	—	—	—	1
15	TPI5848	Spacer 9.5×18.85×5	1	1	—	—
	TPI7676	Spacer 18×31.5×6	—	—	1	—
15	TPI7683	Spacer 16×26×9	—	—	—	1
16	TPI3905	Retaining Ring RTW-19	2	2	—	—
	TP07623	Retaining Ring C-32	—	—	2	—
	TPI7682	Retaining Ring C-26	—	—	—	2
TP00170	Hexagon Wrench Key 6	1	1	—	—	
TP03249	Hexagon Wrench Key 8	—	—	1	1	
TPI5859	Pilot Pin 08035	1	1	—	—	
TPI6019	Pilot Pin 08050	—	Option	—	—	
TA9A210	Pilot Pin 12075 Sub Ass'y	—	—	1set	1set	