

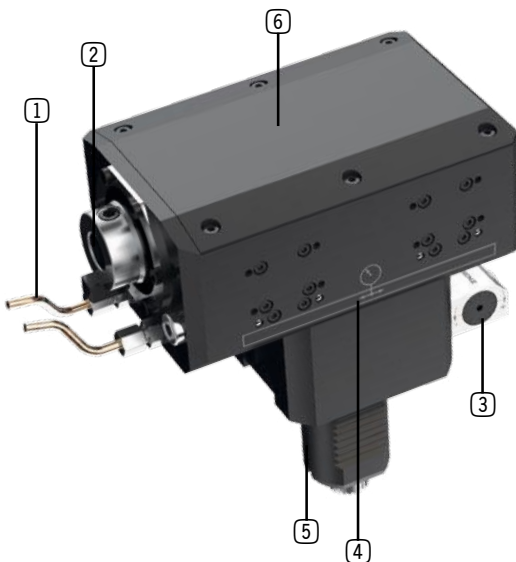
BROACHING UNITS FOR TURNING CENTERS

SYSTEM DESIGN

► BENZ LINA (RADIAL)

2

Turning centers / Broaching units



- ① **Coolant nozzle**
- ② **Tool insert**
- For holding the clamping holder
- ③ **Alignment system**
- For aligning driven tools
- ④ **Alignment area**
- For aligning driven tools
- ⑤ **Base holder (adjusted)**
- Adjusted for the turret type
- Wide variety of drive variants and shanks available
- ⑥ **Permanent grease lubrication**
- Lubrication for the life of the tool with no need to re-lubricate

SEMI-MODULAR DESIGN

- Broaching unit
- Base holder (adjusted)



The principle behind the shaping/broaching process
See p. 12

Optional: Equipment variants

STROKE COUNTER



p. 38

ALIGNMENT OPTION FOR CLAMPING HOLDER*



p. 38



Videos



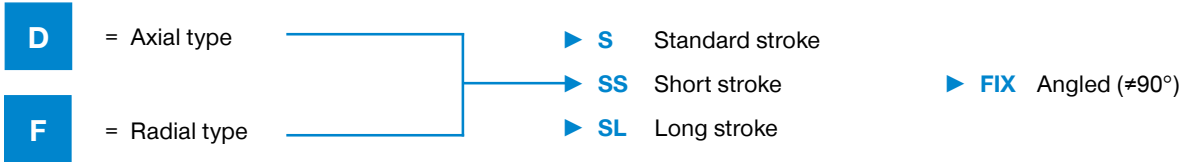
► BENZ LinA - in use

Scan the adjacent QR code with a smartphone and see a demonstration of the BENZ LinA in action. Alternatively, you can visit our YouTube channel to view the video: www.youtube.com/BENZWerkzeugssysteme

*Depending on the broaching unit type

▶ TYPE OVERVIEW

▶ BENZ LinA - driven



- | | | |
|------------------|---|-------------------|
| ▶ DS | Axial type | Standard stroke |
| ▶ DSS | Axial type | With short stroke |
| ▶ FS | Radial type | Standard stroke |
| ▶ FSS | Radial type | With short stroke |
| ▶ FSL | Radial type | With long stroke |
| ▶ FS-FIX | Radial type, angled ($\neq 90^\circ$) | Standard stroke |
| ▶ FSS-FIX | Radial type, angled ($\neq 90^\circ$) | With short stroke |
| ▶ FSL-FIX | Radial type, angled ($\neq 90^\circ$) | With long stroke |

Note:



Trifix®

- ▶ The products displayed in this catalog are standard components. We would be happy to develop a suitable solution together with you to meet your specific requirements.
- ▶ Delivery does not include equipment variants or accessories. Please order these separately at your preferred cutting insert manufacturer. We offer starter kits consisting of a broaching unit and predefined clamping holders to help get you started with your shaping operation quickly.
- ▶ Trifix®: Units for Trifix® turrets including fixed flange connection are available.

BROACHING UNITS FOR TURNING CENTERS

BENZ LINA - RADIAL

▶ PRODUCT IN OVERVIEW



- ▶ max. groove width 8-10 mm
- ▶ Ratio 1:1
- ▶ max. feed per stroke 0.15 mm
- ▶ max. speed 1,200 rpm

▶ TYPE

FS **FSS** **FSL**

▶ TURRET INTERFACE



VDI



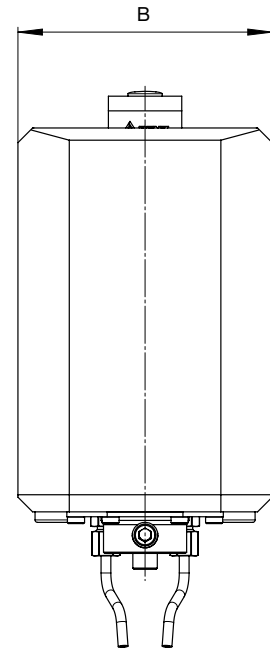
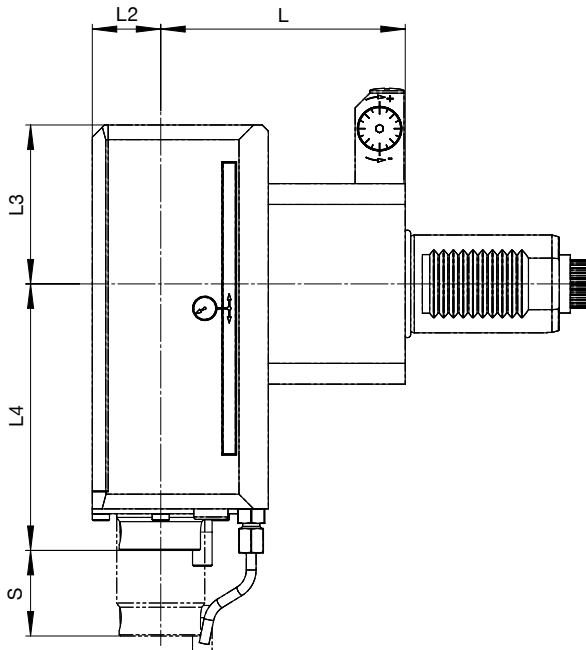
BMT



CDI



More on request



FS	
Usable working stroke	= 32 mm
Total stroke	= 35 mm
Material strength _{max}	= 900 N/mm ²
No. of strokes/speed _{max}	= 1,000 rpm

► **Technical data**

L2 [mm]	L3 [mm]	L4 [mm]	B [mm]	S [mm]	L* [mm]	Weight [kg]*
28	65	109	104	32/35	65-160	approx. 10

FSS	
Usable working stroke	= 17 mm
Total stroke	= 19 mm
Material strength _{max}	= 1,100 N/mm ²
No. of strokes/speed _{max}	= 1,200 rpm

► **Technical data**

L2 [mm]	L3 [mm]	L4 [mm]	B [mm]	S [mm]	L* [mm]	Weight [kg]*
28	65	109	104	17/19	65-160	approx. 10

FSL	
Usable working stroke	= 51 mm
Total stroke	= 53 mm
Material strength _{max}	= 900 N/mm ²
No. of strokes/speed _{max}	= 750 rpm

► **Technical data**

L2 [mm]	L3 [mm]	L4 [mm]	B [mm]	S [mm]	L* [mm]	Weight [kg]*
32	85	135	129	51/53	70-165	approx. 15



*Varies based on base holder