

MOTORIZED CHARPY NOTCH BROACHING MACHINE



- * **FAST**
- * **ACCURATE**
- * **RELIABLE**



**DESIGNED TO CORRECTLY CUT ' V ' OR ' U ' NOTCHES
IN CHARPY TEST SPECIMENS**



Both motor operated machines are now supplied with a broach guard assembly to comply with safety regulations during the broach cutting operations.

Clamp your 10mm square Charpy or Izod test specimen in the adjustable base jaw, push the reverse starter button and wait **JUST 10 SECONDS** as a 17" long broaching tool with it's 57 cutting teeth eases through your specimen. The final four teeth provide precision material removal of .0001" each to ensure optimum surface finish and dimensions of the notch as specified by ASTM standard designation E-23.



The broach itself is drawn by a twin lead screw mechanism geared together and driven by a 1/4 hp motor mounted in the unit. Controls consist only of a reverse starter switch for the cut and return stroke of the broach. Limit switches within the machine shut off the motor at the completion of each stroke. This floor standing model gives a comfortable working height at the base jaw clamp. Engineering reports throughout industry indicate that the milled notch doesn't compare to the superior quality of our broached notch. Results are more consistent and reliable with no worry of dull mill cutters causing notch surface finish deterioration, critical dimension change or induced cold working. **SAVES TIME.** Technicians will be testing impact specimens rather than practicing continuous shadowgraph inspection or other time consuming checks.

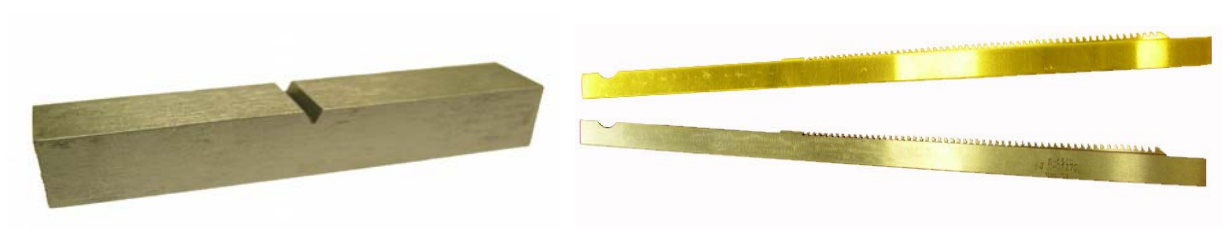
CNB - 31 motor operated single speed (approx. 4.75/ft. min.) to produce ' V ' or ' U ' notches in 10 mm (0.394") impact test specimens. 220V, 50/60 cycle single phase **ONLY** (broach not included)

CNB- 33 variable speed (approx. 1.4 to 7.45/ft. min. to produce ' V ' or ' U ' notches in 10 mm (0.394") impact test specimens. 220V, 50/60 cycle single phase **ONLY** (broach not included) The vari speed machine is made available to satisfy demands for broaching notches in material up to RC60. The slower cutting speed is also desirable to extend the life of the broaching tools between sharpening when cutting these harder materials.

CHARPY NOTCH BROACHING TOOLS



NOTCH	DEPTH	RADIUS	RC APPLICATION	CAT #
V	2MM	.25MM (.010")	52	NBT-V1*
V	2MM	.003"	52	NBT-V2
U	2MM	2MM (.079")	42	NBT-U1
U	3MM	2MM (.079")	35	NBT-U2
U	5MM	2MM (.079")	25	NBT-U3



* This most popular broaching tool is now offered with TiN (titanium nitride) coating to extend the tool life. Additional price is \$60.00 with this coating.