MQL Broach

Longer tool life

New coating and high-grade broach material give longer tool life than with conventional wet broaching

Process reduction

Newly developed proprietary chip suction equipment eliminates the use of a centrifugal oil remover. Chips do not have chlorine content and require special industrial waste disposal.

Environmental Improvement

Only a small quantity of vegetable based oil or synthetic oil is used as fine mist, which is beneficial to the environment



MQL Broach / Product Description

Improving the work environment



Semi-dry processing machine



Wet processing machine

Enables the workpiece washing process to be eliminated



Chips from semi-dry machining

Chips from wet machining (non water soluble)

Reduced power consumption



Semi-dry machining

Cutting Oil (Oleaginous) + conventional broaching Synthetic ester oil semi-dry + semi-dry broaching



Material		S45C(200HB)
Broach specification		m2xPA30xNT16
Cutting condition	Cutting speed	5m/min
	Depth of cut	0.06m /dia.
Machine	Model	NBV-5-10SA
	Max. drawing force	50kN(5TON)
	Max. stroke	1,000mm

Spiral gullet broach (1)

Low vibrations during broaching, energy saving operation





Spiral gullet broaching (2)





Chips from spiral gullet broaching



Chips from conventional axis-perpendicular gullet broaching



Chips are removed and dropped easily

Chip collection ratio approx. 100%