

DUAL RAM VERTICAL BROACHING MACHINES

CAPACITY RANGES

5 TON CAPACITY

48" STROKE

THROUGH

15 TON CAPACITY

72" STROKE



The Ohio Broach & Machine Company

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ISO 9001 Certified

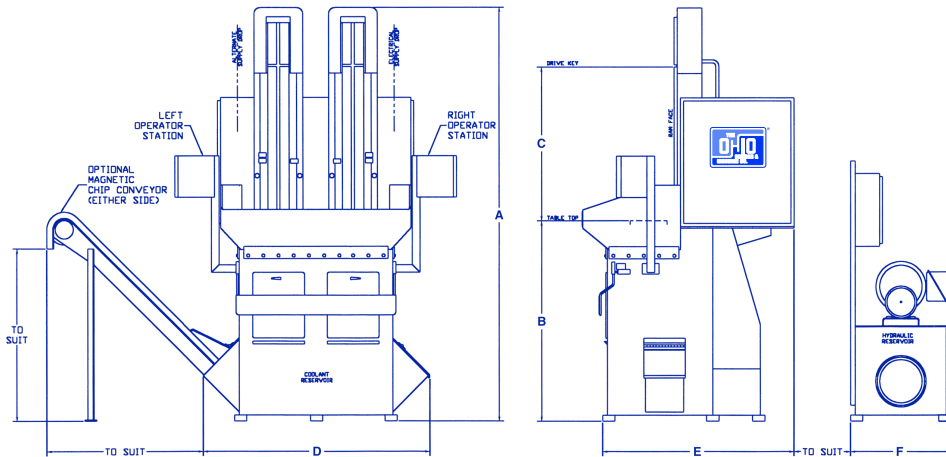
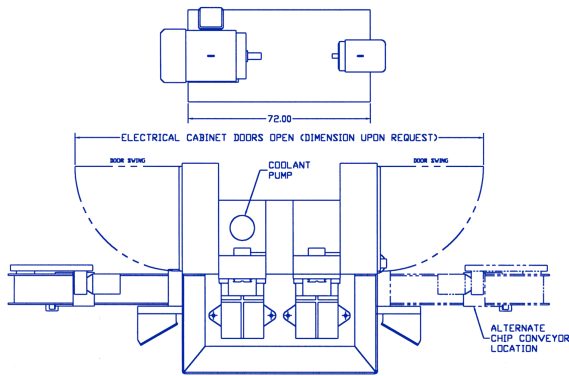
DUAL RAM VERTICAL BROACHING MACHINES

MACHINE SPECIFICATIONS

MACHINE	DRVSH-548	DRVSH-554	DRVSH-566	DRVSH-572	DRVSH-7.566	DRVSH-7.572	DRVSH-1048	DRVSH-1054	DRVSH-1066	DRVSH-1072	DRVSH-1566	DRVSH-1572
TONNAGE	5	5	5	5	7.5	7.5	10	10	10	10	15	15
STROKE*	48"	54"	66"	72"	66"	72"	48"	54"	66"	72"	66"	72"
(LBS.) Normal Capacity	10,000	10,000	10,000	10,000	15,000	15,000	20,000	20,000	20,000	20,000	30,000	30,000
Broaching** Speed Max.	100 FPM	100 FPM	100 FPM	100 FPM	70 FPM	70 FPM	70 FPM	70 FPM	70 FPM	70 FPM	45 FPM	45 FPM
Type Hyd. Pump	"Vickers" Vane	"Vickers" Vane	"Vickers" Vane	"Vickers" Vane	"Vickers" Vane	"Vickers" Vane	"Vickers" Vane	"Vickers" Vane	"Vickers" Vane	"Vickers" Vane	"Vickers" Vane	"Vickers" Vane
Main Hyd. Motor H.P.	30 HP	30 HP	40 HP	40 HP	40 HP	40 HP	50 HP	50 HP	50 HP	50 HP	50 HP	50 HP
Coolant Motor H.P.	2 HP	2 HP	3 HP	3 HP	3 HP	3 HP	3 HP	3 HP	3 HP	3 HP	3 HP	3 HP
Hyd. Tank Capacity	150 Gallons	150 Gallons	300 Gallons	300 Gallons	300 Gallons	300 Gallons	300 Gallons	300 Gallons	300 Gallons	300 Gallons	300 Gallons	300 Gallons
Coolant Tank	115 Gallons	115 Gallons	250 Gallons	250 Gallons	250 Gallons	250 Gallons	275 Gallons	275 Gallons	275 Gallons	275 Gallons	275 Gallons	275 Gallons

* 24", 36" and Special Stroke machines available.

** Other speed ranges avail



MACHINE DIMENSIONS

MACHINE	A	B	C	D	E	F
DRVSH-548	135-3/4	67	49-5/8	73-1/2	54-1/2	36
DRVSH-554	147-3/4	73	55-5/8	79-1/2	60-1/2	36
DRVSH-566	186	90	67-5/8	97	92	36
DRVSH-572	198	96	73-5/8	97	92	36
DRVSH-7.566	186	90	67-5/8	97	92	36
DRVSH-7.572	198	96	73-5/8	97	92	36
DRVSH-1048	151	71	49-5/8	94-1/2	92-1/2	36
DRVSH-1054	166	77	55-5/8	94-1/2	77-1/2	36
DRVSH-1066	189	92	67-5/8	92-1/2	85	36
DRVSH-1072	201	98	73-5/8	92-1/2	97-1/2	36
DRVSH-1566	189	92	67-5/8	92-1/2	85	36
DRVSH-1572	201	98	73-5/8	92-1/2	97-1/2	36

NOTE: The photos, drawings and dimensions contained herein are for illustrative purposes only. Should certified dimensions be required, please consult our factory.

Ohio Broach

MACHINE FEATURES

Hardened and Ground Steel Ways – The machine ways for this Model Series are composed of High Carbon Steel, hardened and tempered, then ground to closely controlled tolerances, to provide long service life and durability.

Precision Ram Slide – The Ram Slides are manufactured from close-grain, high-tensile, cast-iron material. Slide surfaces are hand-scraped for a precise fit and then flaked for maximum lubrication penetration.

Lubrication System – All Heavy-Duty Models utilize TRABON Pressurized, individual point lubrication. No “tree-type” lube circuits are employed. Standard system features include low reservoir level indication, anti-start interlocking (in AUTOMATIC control mode), and high pressure indication for detecting an impaired normal flow condition.

Hydraulics – A high-performance VICKERS fixed-displacement, vane pump is used in conjunction with other VICKERS valves and controls to form the basis of the standard machine drive system. This type of system is a reliable, industrial “open-loop” design. The pump(s) and valves are mounted on a stand-alone hydraulic reservoir.

Machine Frame – The Ram Slide and Table sub-assemblies are mounted on a rigid base weldment. The lower portion of this weldment serves as a coolant reservoir for the machine. This affords a compact design that uses a minimum of expensive plant floor space.

Standard Colors are Machine Tool Grey and Vista Green. Additional colors are available.

Standard Voltage is 440/480, 3 Phase, 60 Hz.

A-B Programmable Controller

OPTIONAL EQUIPMENT

The following optional tables may be added to any Heavy-Duty Machine. All table designs are equipped with cross keyways to aid repetitive fixture changeover and include the necessary tie-in to hydraulic and electric systems.

PLATEN-TYPE TABLE A platen, non-moving table is furnished with the standard machine.

TIP BACK TABLE Tilts the work-holding fixture back 35° from horizontal to allow the operator more convenient access for loading and unloading of workpieces.

INFEED SHUTTLE TABLE A “fore-and-aft” sliding table that permits multiple repetitive broach cuts. The Infeed Shuttle moves in-and-out on a horizontal plane allowing the machine to make repeated passes until a predetermined depth of cut is obtained.

INFEED SHUTTLE/TIP BACK COMBINATION TABLE This patented table affords the user the maximum in versatility. It combines features of both the TIP BACK and Infeed Shuttle Tables into one compact unit.

INDEPENDENT RAM OPERATION Two separate hydraulic systems permit the independent function of each ram while mounted on a common base.

This machine is normally fitted with the above combination table.

The following options may be added to upgrade manual-type work-holding fixture clamping operations:

AIR/OIL POWER CLAMPING This option provides a single-acting, air-oil booster type, power source for fixture clamping.

AUXILIARY HYDRAULIC CLAMPING This option provides a double-acting hydraulic power source for clamping of work-holding fixtures.

The following optional equipment may also be added to any model:

CHIP REMOVAL CONVEYOR All machines are designed to accept conveyors that automatically remove chips from the machine base.

OPERATOR PLATFORM Heavy-duty construction.



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