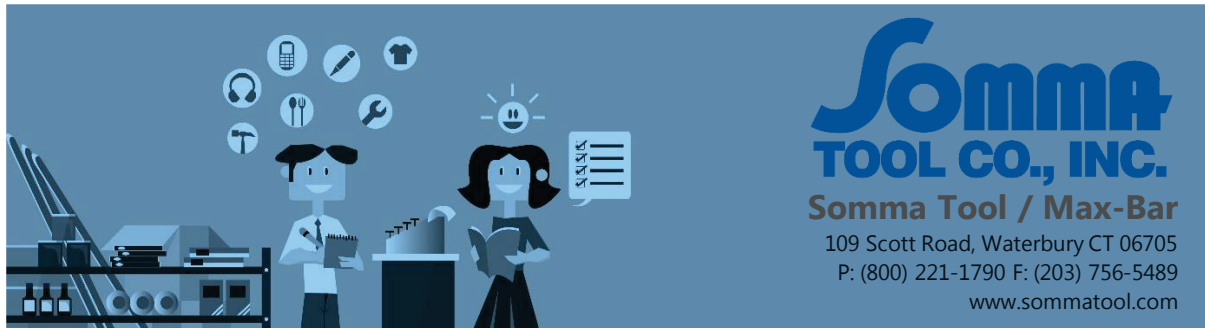


Recommended Broaching Speeds & Feeds



Speeds

ORB00 & ORBSW Holders	800-1200 RPM typical. Can go up to 3400 RPM if needed.
ORB2 & ORBHD Holders	800-1200 RPM

Feed Rates		
Feed rates are not material-dependent		
Hex or Square Up to Size...	Hex Feed IPR (inches per revolution)	Square Feed IPR (inches per revolution)
1/8" (.125)	.001/.002	.001/.002
1/4" (.250)	.002/.004	.002/.004
3/8" (.375)	.003/.005	.003/.005
1/2" (.500)	.004/.006	.003/.005
5/8" (.625)	.005/.007	.004/.006
3/4" (.750)	.005/.006	.004/.006
7/8" (.875)	.004/.005	.002/.004
1" (1.000)	.002/.004	.001/.003