



CATALOGO PRODOTTI

PRODUCTS CATALOGUE



## PORTA UTENSILI A BROCCIARE BROACH TOOL HOLDERS



**BROCCIATORI FISSI; BROCCIATORI REGISTRABILI;  
ATTACCHI VDI, CONO MORSE E CILINDRICO;  
BROCCE ESAGONALI, QUADRE E SPECIALI.**



**FIXED BROACH TOOL HOLDERS; ADJUSTABLE BROACH  
TOOL HOLDERS;  
VDI, VICE TAPER AND CYLINDRICAL FITTINGS;  
HEXAGONAL, SQUARE AND SPECIAL BROACHES.**



**CHIA-MO SRL**  
VIA CADUTI DI SABBIVNO, 12  
40011 ANZOLA DELL'EMILIA  
BOLOGNA ITALY

TEL +39 051734153  
FAX +39 051734958

WWW.CHIAMO.IT  
INFO@CHIAMO.IT



**BROCCIATORE REGISTRABILE Tipo 175**

**ADJUSTABLE BROACH TOOLHOLDER**



**USO E VANTAGGI NELL'UTILIZZO DI QUESTO ATTREZZO PER BROCCIATURA**

**- Diametro di foratura**

Uguale alla quota (p) della brocciatura da eseguire. È comunque meglio, se possibile, eseguire detta foratura maggiorata, a vostro giudizio, dal 1% al 3%, questo per rendere meno gravoso l'avanzamento dell'utensile che broccia.

**- Giri della broccia**

Parametri consigliati: 1000 - 2000 (giri/min)

**- Avanzamento della broccia**

Parametri consigliati: 0,01 - 0,03 (mm/giro)

**- Lunghezza delle brocche**

Si possono usare brocche di diversa lunghezza (quota x), consentendo così di eseguire brocciature all'interno di incamerature relativamente profonde.

**- Centatura della broccia**

Permette, grazie alla registrazione mediante le viti (y) in senso laterale e le viti (w) in senso verticale, di ottenere la centatura del punto (k) rispetto all'asse del codolo (d) più precisa rispetto ai tradizionali brocciatori non registrabili.

**- Disassamento torretta**

Permette, nei casi in cui l'alloggiamento in macchina del codolo (d) non sia in asse con il mandrino della fantina, di correggere tale disassamento agendo sempre sulle viti di registrazione (y) e (w).

**USE AND ADVANTAGES OF USING THIS BROACHING TOOL**

**- Drilling diameter**

Same size (P) as the broach to be machined. It is in any event better, if possible, to make this hole slightly larger, maybe 1% to 3% depending on your personal judgement, to facilitate the drive of the broaching tool.

**- Rotation Speed**

Recommended parameters: 1000 - 2000 (rpm)

**- Feed**

Recommended parameters: 0,01 - 0,03 (mm/rpm)

**- Broaching length**

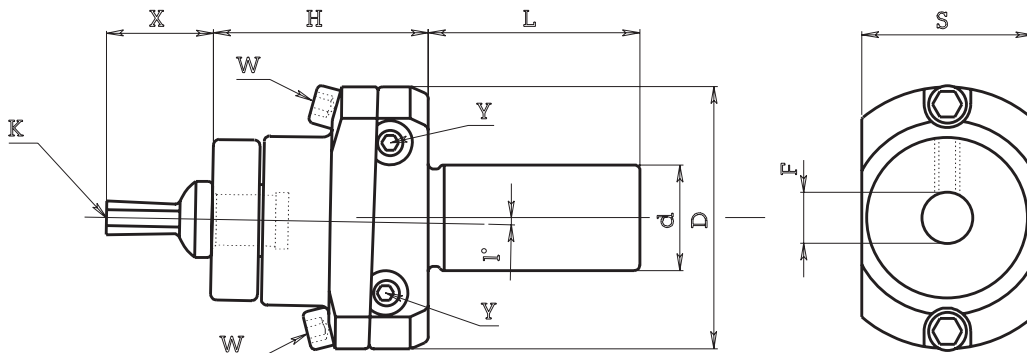
You can use different broaching lengths (parameter X), so that you can even broach inside quite deep chambers.

**- Broach centring**

By adjusting screws (Y) sideways and screws (W) vertically, you can centre point (K) compared to the centre-line of the shaft (d), which is more precise compared to traditional broaching toolholders that are not adjustable.

**- Turret offset**

If the shaft is not lodged in the machine centred with the chuck of the head stock, you can correct this offset, again by adjusting screws (y) and (w).



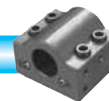
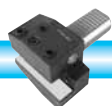
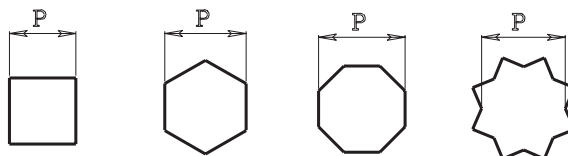
Code						
ART.	d	H	L	D	F	S
175.102	C.M.2	34	68	50	8	30
175.110	10	34	35	50	8	30
175.112	12	34	35	50	8	30
175.114	14	34	35	50	8	30
175.115	15.875	34	35	50	8	30
175.116	16	34	35	50	8	30
175.119	19.05	34	46	50	8	30
175.120	20	34	46	50	8	30
175.125	25	34	46	50	8	30
175.126	25.40	34	46	50	8	30

Code						
ART.	d	H	L	D	F	S
175.202	C.M.2	52	68	62	12	40.5
175.219	19.05	52	50	62	12	40.5
175.220	20	52	50	62	12	40.5
175.222	22	52	50	62	12	40.5
175.225	25	52	50	62	12	40.5
175.226	25.40	52	50	62	12	40.5
175.230	30	52	50	62	12	40.5
175.231	31.75	52	50	62	12	40.5
175.232	32	52	50	62	12	40.5

Su questo brocciatore va montata  
la broccia art. Z801 descritta a pag. 90-91  
Broach code Z801 described in page 90-91  
is fitted on this broach toolholder

Su questo brocciatore va montata  
la broccia art. Z800 descritta a pag. 90-91  
Broach code Z800 described in page 90-91  
is fitted on this broach toolholder

Esempi di alcune figure di brocche  
Broach example





**BROCCIATORE FISSO Tipo 175**

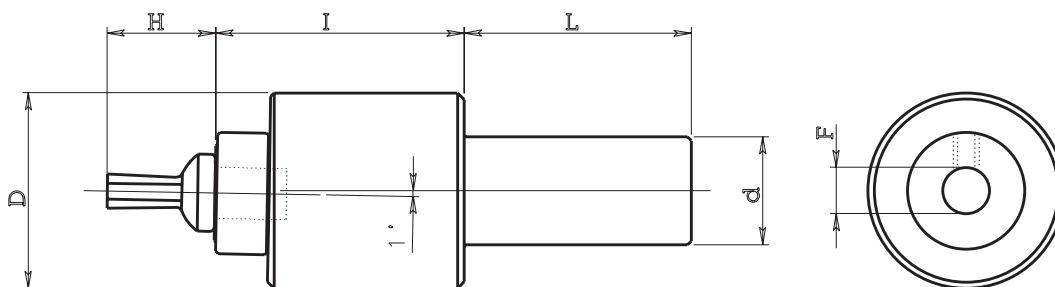
**BROACH TOOLHOLDER**

Code						
ART.	d	I	L	D	F	H
175.508	8	34	35	22	5	10
175.510	10	34	35	22	5	10
175.512	12	34	35	22	5	10
175.514	14	34	35	22	5	10
175.515	15.875	34	35	22	5	10
175.516	16	34	35	22	5	10
175.519	19.05	34	46	22	5	10
175.520	20	34	46	22	5	10
175.522	22	34	46	22	5	10

Su questo brocciatore va montata la broccia art. Z803 descritta a pag. 90-91  
Broach code Z803 described in page 90-91 is fitted on this broach toolholder

Code						
ART.	d	I	L	D	F	H
175.602	C.M.2	38	69	32	8	18
175.610	10	38	35	32	8	18
175.612	12	38	35	32	8	18
175.614	14	38	35	32	8	18
175.615	15.875	38	35	32	8	18
175.616	16	38	35	32	8	18
175.619	19.05	38	50	32	8	18
175.620	20	38	50	32	8	18
175.622	22	38	50	32	8	18
175.625	25	38	50	32	8	18
175.626	25,40	38	50	32	8	18

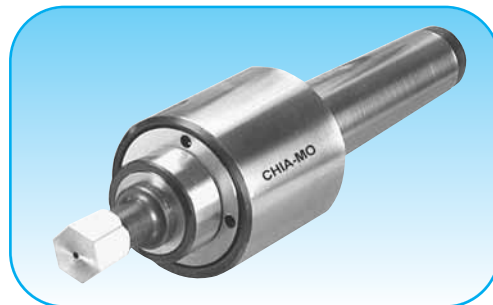
Su questo brocciatore va montata la broccia art. Z801 descritta a pag. 90-91  
Broach code Z801 described in page 90-91 is fitted on this broach toolholder



**NOTA BENE.**  
Per questi brocciatori è importante utilizzare brocche con quota "H" come da tabella  
In this toolholders is important to use broaches that have "H" like in tablet

Code						
ART.	d	I	L	D	F	H
175.803	C.M.3	76	85	58	16	40
175.804	C.M.4	76	109	58	16	40
175.820	20	76	50	58	16	40
175.825	25	76	50	58	16	40
175.826	25.40	76	50	58	16	40
175.830	30	76	50	58	16	40
175.831	31.75	76	50	58	16	40
175.832	32	76	50	58	16	40
175.840	40	76	80	58	16	40

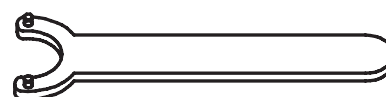
Su questo brocciatore va montata la broccia art. Z802 descritta a pag. 90-91  
Broach code Z802 described in page 90-91 is fitted on this broach toolholder



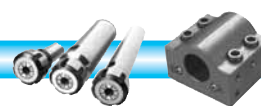
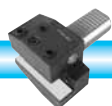
Code						
ART.	d	I	L	D	F	H
175.702	C.M.2	46	69	44	12	25
175.716	16	46	50	44	12	25
175.719	19.05	46	50	44	12	25
175.720	20	46	50	44	12	25
175.722	22	46	50	44	12	25
175.725	25	46	50	44	12	25
175.726	25.40	46	50	44	12	25
175.732	32	46	50	44	12	25

Su questo brocciatore va montata la broccia art. Z800 descritta a pag. 90-91  
Broach code Z800 described in page 90-91 is fitted on this broach toolholder

**CHIAVI PER SMONTARE CUSCINETTI**  
Remove bearing wrenchs



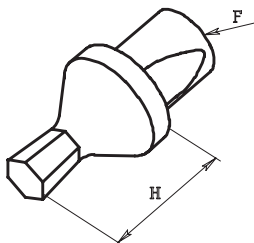
Code	For Broach toolholder
ART.	Per Brocciatore
175.500 H	175.500
175.600 H	175.600
175.700 H	175.700
175.800 H	175.800



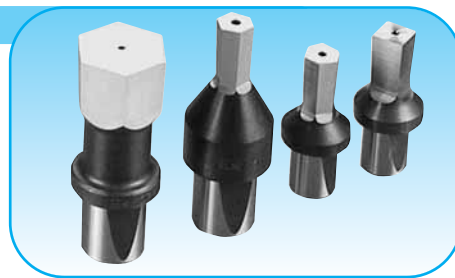


**BROCCE Tipo 800 - 801 - 803**

**BROACH**



Le brocche possono essere fornite su richiesta con ricopertura "TiN" Broach "TiN" coating can be supplied on request



**Esagono (hexagonal)**

**BROCCIA Tipo 803**

**Quadro (square)**

Code			hexag.
ART.	F	H	esagono
803001	5	10	1
8030015	5	10	1.5
803002	5	10	2
8030025	5	10	2.5
803003	5	10	3
8030035	5	10	3.5
803004	5	10	4
803005	5	10	5
8030055	5	10	5.5
803006	5	10	6

Code			square
ART.	F	H	quadro
803101	5	10	1
8031015	5	10	1.5
803102	5	10	2
8031025	5	10	2.5
803103	5	10	3
8031035	5	10	3.5
803104	5	10	4
803105	5	10	5
8031055	5	10	5.5
803106	5	10	6

**Esagono (hexagonal)**

**BROCCIA Tipo 801**

**Quadro (square)**

Code			hexag.
ART.	F	H	esagono
801001	8	18	1
8010015	8	18	1.5
801002	8	18	2
8010025	8	18	2.5
801003	8	18	3
8010035	8	18	3.5
801004	8	18	4
801005	8	18	5
8010055	8	18	5.5
801006	8	18	6
801007	8	18	7
801008	8	18	8

Code			square
ART.	F	H	quadro
801102	8	18	2
8011025	8	18	2.5
801003	8	18	3
8010035	8	18	3.5
801104	8	18	4
801105	8	18	5
8011055	8	18	5.5
801106	8	18	6
801107	8	18	7

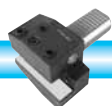
**Esagono (hexagonal)**

**BROCCIA Tipo 800**

**Quadro (square)**

Code			hexag.
ART.	F	H	esagono
800001	12	25	1
8000015	12	25	1.5
800002	12	25	2
8000025	12	25	2.5
800003	12	25	3
8000035	12	25	3.5
800004	12	25	4
800005	12	25	5
8000055	12	25	5.5
800006	12	25	6
800007	12	25	7
800008	12	25	8
800009	12	25	9
800010	12	25	10
800011	12	25	11
800012	12	25	12
800013	12	25	13
800014	12	25	14

Code			square
ART.	F	H	quadro
800102	12	25	2
8001025	12	25	2.5
800103	12	25	3
8001035	12	25	3.5
800104	12	25	4
800105	12	25	5
8001055	12	25	5.5
800106	12	25	6
800107	12	25	7
800108	12	25	8
800109	12	25	9
800110	12	25	10
800111	12	25	11
800112	12	25	12
800113	12	25	13

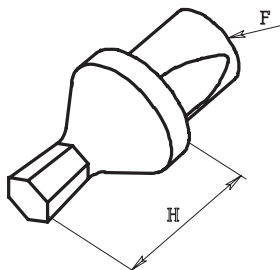




**BROCCE Tipo 802**

**BROACH**

Le brocche possono essere fornite su richiesta con ricopertura "TiN"  
Broach "TiN" coating can be supplied on request



**Esagono (hexagonal)**

**BROCCIA Tipo 802**

**Quadro (square)**

Code	hexag.		
ART.	F	H	esagono
802003	16	40	3
8020035	16	40	3.5
802004	16	40	4
802005	16	40	5
802006	16	40	6
802007	16	40	7
802008	16	40	8
802009	16	40	9
802010	16	40	10
802011	16	40	11
802012	16	40	12
802013	16	40	13
802014	16	40	14
802015	16	40	15
802016	16	40	16
802017	16	40	17
802018	16	40	18
802019	16	40	19
802020	16	40	20
802021	16	40	21
802022	16	40	22
802023	16	40	23
802024	16	40	24
802025	16	40	25

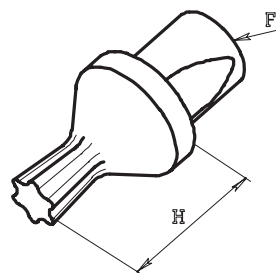
Code	square		
ART.	F	H	quadro
802104	16	40	4
802105	16	40	5
802106	16	40	6
802107	16	40	7
802108	16	40	8
802109	16	40	9
802110	16	40	10
802111	16	40	11
802112	16	40	12
802113	16	40	13
802114	16	40	14
802115	16	40	15
802116	16	40	16
802117	16	40	17
802118	16	40	18
802119	16	40	19
802120	16	40	20
802121	16	40	21
802122	16	40	22
802123	16	40	23
802124	16	40	24
802125	16	40	25

**BROCCE PER CHIAVI TORX\* 801 - 802**

**BROACH FOR TORX\* KEYS**

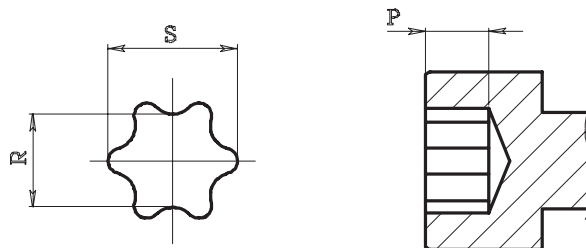
**BROCCIA Torx\* Tipo 801**

ART. (code)	F	H	P	S	R	torx*
801206	8	18	0,50-0,70	1,80	1,29	6
801208	8	18	0,70-0,90	2,45	1,80	8
801210	8	18	1,00-1,30	2,85	2,07	10
801215	8	18	1,30-1,50	3,38	2,44	15
801220	8	18	1,50-1,60	3,96	2,86	20
801225	8	18	1,60-2,00	4,55	3,28	25
801227	8	18	2,00-2,40	5,10	3,65	27
801230	8	18	2,60-3,00	5,65	4,07	30

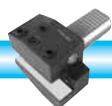


**BROCCIA Torx\* Tipo 800**

ART. (code)	F	H	P	S	R	torx*
800206	12	25	0,50-0,70	1,80	1,29	6
800208	12	25	0,70-0,90	2,45	1,80	8
800210	12	25	1,00-1,30	2,85	2,07	10
800215	12	25	1,30-1,50	3,38	2,44	15
800220	12	25	1,50-1,60	3,96	2,86	20
800225	12	25	1,60-2,00	4,55	3,28	25
800227	12	25	2,00-2,40	5,10	3,65	27
800230	12	25	2,60-3,00	5,65	4,07	30
800240	12	25	3,00-3,30	6,80	4,88	40
800245	12	25	3,50-4,00	7,97	5,68	45
800250	12	25	4,00-4,50	8,99	6,50	50



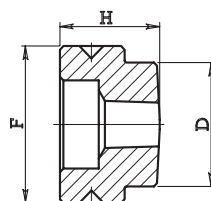
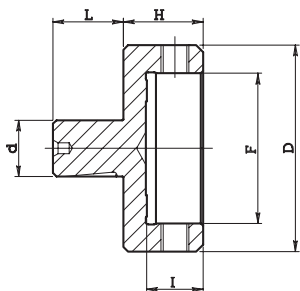
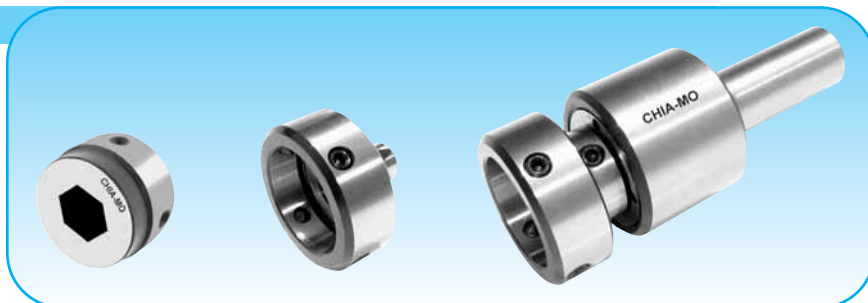
\* Torx: marchio registrato dalla Textron inc. Providence (Usa)  
\* Torx: trade mark registered by Textron inc. Providence (Usa)







**BROCCE PER ESTERNI Tipo 806**  
**OUTSIDE BROACH**



**PORTA BROCCE PER ESTERNI DIAMETRO 12**  
**OUTSIDE BROACH HOLDER D. 12**

ART.	d	L	H	I	F	D
175790	12	15	17	12	32	44

Questo porta brocche viene montato sui brocciatori articolo:  
Use this broach holder on code:

175200 (p. 88), 175700 (p. 89), 9R2.20.12 (p. 53),  
9R2.30.12 (p. 53) e 9R2.40.12 (p. 53)

**PORTA BROCCE PER ESTERNI DIAMETRO 16**  
**OUTSIDE BROACH HOLDER D. 16**

ART.	d	L	H	I	F	D
175890	16	19	32	12	32	44

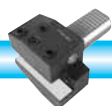
Questo porta brocche viene montato sui brocciatori articolo:  
Use this broach holder on code:

175800 (p. 89), 9R2.30.16 (p. 53) e 9R2.40.16 (p. 53)

**BROCCE PER ESTERNI Tipo 806**  
**OUTSIDE BROACH**

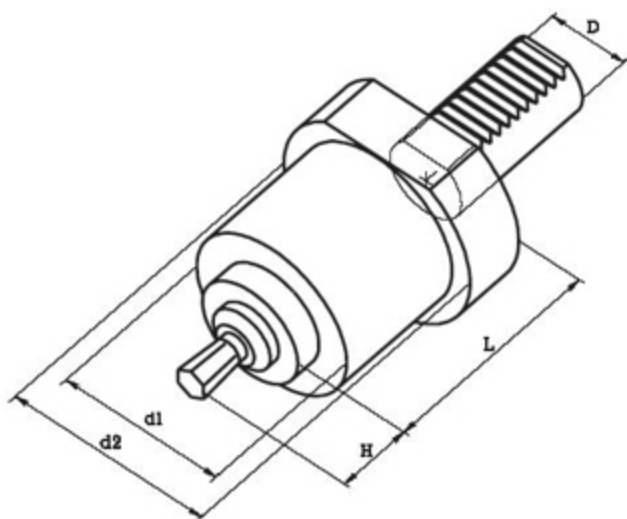
Code	F	D	H	hexagonal
ART.	F	D	H	esagono
Z 806003	32	25,3	20,5	3
Z 806004	32	25,3	20,5	4
Z 806005	32	25,3	20,5	5
Z 806006	32	25,3	20,5	6
Z 806007	32	25,3	20,5	7
Z 806008	32	25,3	20,5	8
Z 806009	32	25,3	20,5	9
Z 806010	32	25,3	20,5	10
Z 806011	32	25,3	20,5	11
Z 806012	32	25,3	20,5	12
Z 806013	32	25,3	20,5	13
Z 806014	32	25,3	20,5	14
Z 806015	32	25,3	20,5	15
Z 806016	32	30	20,5	16
Z 806017	32	30	20,5	17
Z 806018	32	30	20,5	18
Z 806019	32	30	20,5	19
Z 806020	32	30	20,5	20

Code	F	D	H	square
ART.	F	D	H	quadro
Z 806103	32	25,3	20,5	3
Z 806104	32	25,3	20,5	4
Z 806105	32	25,3	20,5	5
Z 806106	32	25,3	20,5	6
Z 806107	32	25,3	20,5	7
Z 806108	32	25,3	20,5	8
Z 806109	32	25,3	20,5	9
Z 806110	32	25,3	20,5	10
Z 806111	32	25,3	20,5	11
Z 806112	32	25,3	20,5	12
Z 806113	32	25,3	20,5	13
Z 806114	32	30	20,5	14
Z 806115	32	30	20,5	15
Z 806116	32	30	20,5	16
Z 806117	32	30	20,5	17
Z 806118	32	30	20,5	18





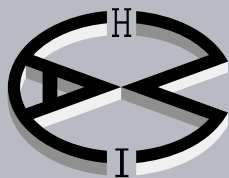
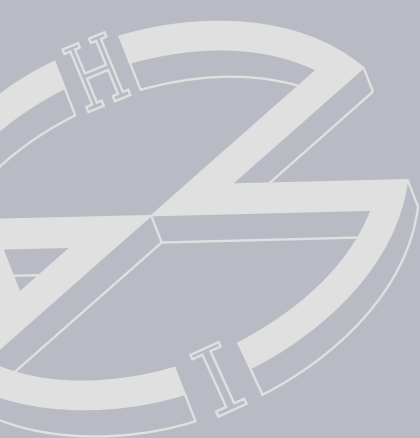
**BROCCIATORE**  
BROACH TOOLHOLDER



A pag. 90-91 sono descritte le brocche disponibili a magazzino.  
Broaches available from warehouse are listed on pag. 83-84.

Code						hole
ART.	D	d1	d2	L	H	Foro
9 R2.20.12	20	44	50	57	25	12
9 R2.30.12	30	58	68	83	25	12
9 R2.30.16	30	58	68	83	40	16
9 R2.40.12	40	58	83	83	25	12
9 R2.40.16	40	58	83	83	40	16





# CHIA-MO

ITALY

## DOVE SIAMO WHERE WE ARE



**CHIA-MO**

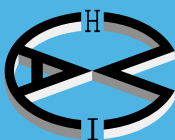
Via Caduti di Sabbiuno, 12

40011 Anzola dell'Emilia (Bologna) Italy

Tel. +39 051 734153 - Fax +39 051 734958

info@chiamo.it - www.chiamo.it





**CHIA-MO**  
ITALY



Via Caduti di Sabbiano, 12  
40011 Anzola dell'Emilia (Bologna) Italy  
Tel. +39 051 734153 - Fax +39 051 734958  
info@chiamo.it - www.chiamo.it



Regione Emilia-Romagna