



# PHZ-2



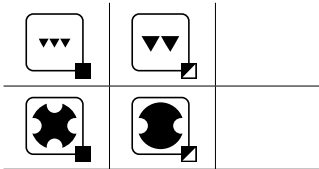
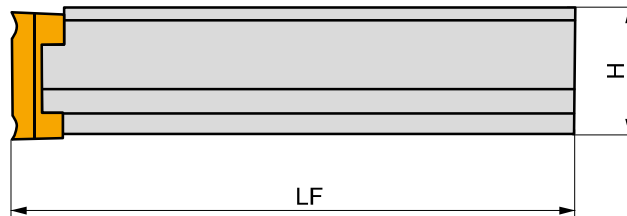
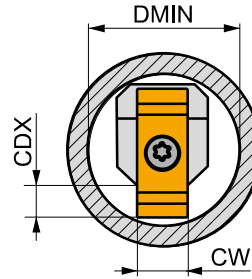
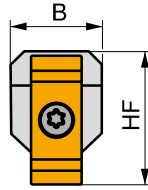
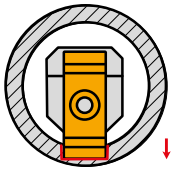
PRAMET

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## Int. Broaching Tool Holder for Larger Diameters with Double-Sided HZ Inserts

Internal tool holder for broaching up to 20 mm width. Minimum internal diameter Ø44 mm. Body treated for longer tool life.



Product	H	HF	B	OAL	CW	DMIN	CDX	kg		
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]			
<b>N</b> PHZ/2 3625-14	36	37.5	25	300	-	44	-	1.86	GI235	SH23
	PHZ/2 4832-18	48	50	32	400	-	58	2.00	GI241	SH24

GI235	HZ/2 14-14	HZ/2 16-16
GI241	HZ/2 18-18	HZ/2 20-20

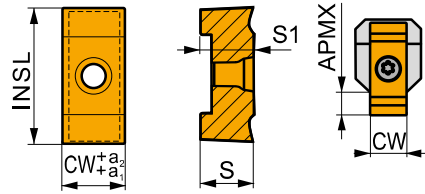
SH23	5513 020-14	8.5	M 6	18	TX225PLUS
SH24	5513 021-03	13.0	M 8	22	DMN 3124



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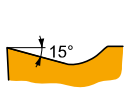


	INSL	APMX	S	S1	CW
	[mm]	[mm]	[mm]	[mm]	[mm]
14-14	36.0	8.00	13.90	14.00	14.00
16-16	36.0	9.00	13.90	14.00	16.00
18-18	45.0	12.00	15.90	16.00	18.00
20-20	45.0	13.00	15.90	16.00	20.00



Suitability and starting values for cutting speed (vc) and feed (fz). Refer to our Machining Calculator app for further calculations.

Product	RE	P		M		K		N		S		H		CW	CWTOLL	CWTOLU
		vc	fz	vc	fz	vc	fz	vc	fz	vc	fz	vc	fz			
	[mm]	[m/min]	[mm/tooth]	[m/min]	[mm/tooth]	[m/min]	[mm/tooth]	[m/min]	[mm/tooth]	[m/min]	[mm/tooth]	[m/min]	[mm/tooth]	[mm]	[mm]	[mm]



Positive geometry for broaching (two cutting edges).

HZ/2 14-14 C11	333TN	—	■	50	0.10	☑	30	0.09	☑	45	0.10	—	—	—	—	14.00	0.10	0.21
HZ/2 14-14 H7	333TN	—	■	50	0.10	☑	30	0.09	☑	45	0.10	—	—	—	—	14.00	0.00	0.02
HZ/2 14-14 P9	333TN	—	■	50	0.10	☑	30	0.09	☑	45	0.10	—	—	—	—	14.00	-0.06	-0.02
HZ/2 16-16 C11	333TN	—	■	50	0.10	☑	30	0.09	☑	45	0.10	—	—	—	—	16.00	0.10	0.21
HZ/2 16-16 H7	333TN	—	■	50	0.10	☑	30	0.09	☑	45	0.10	—	—	—	—	16.00	0.00	0.02
HZ/2 16-16 P9	333TN	—	■	50	0.10	☑	30	0.09	☑	45	0.10	—	—	—	—	16.00	-0.06	-0.02
HZ/2 18-18 C11	333TN	—	■	50	0.10	☑	30	0.09	☑	45	0.10	—	—	—	—	18.00	0.10	0.21
HZ/2 18-18 H7	333TN	—	■	50	0.10	☑	30	0.09	☑	45	0.10	—	—	—	—	18.00	0.00	0.02
HZ/2 18-18 P9	333TN	—	■	50	0.10	☑	30	0.10	☑	45	0.10	—	—	—	—	18.00	-0.06	-0.02
HZ/2 20-20 C11	333TN	—	■	50	0.10	☑	30	0.09	☑	45	0.10	—	—	—	—	20.00	0.11	0.24
HZ/2 20-20 H7	333TN	—	■	50	0.10	☑	30	0.09	☑	45	0.10	—	—	—	—	20.00	0.00	0.02
HZ/2 20-20 P9	333TN	—	■	50	0.10	☑	30	0.10	☑	45	0.10	—	—	—	—	20.00	-0.07	-0.02