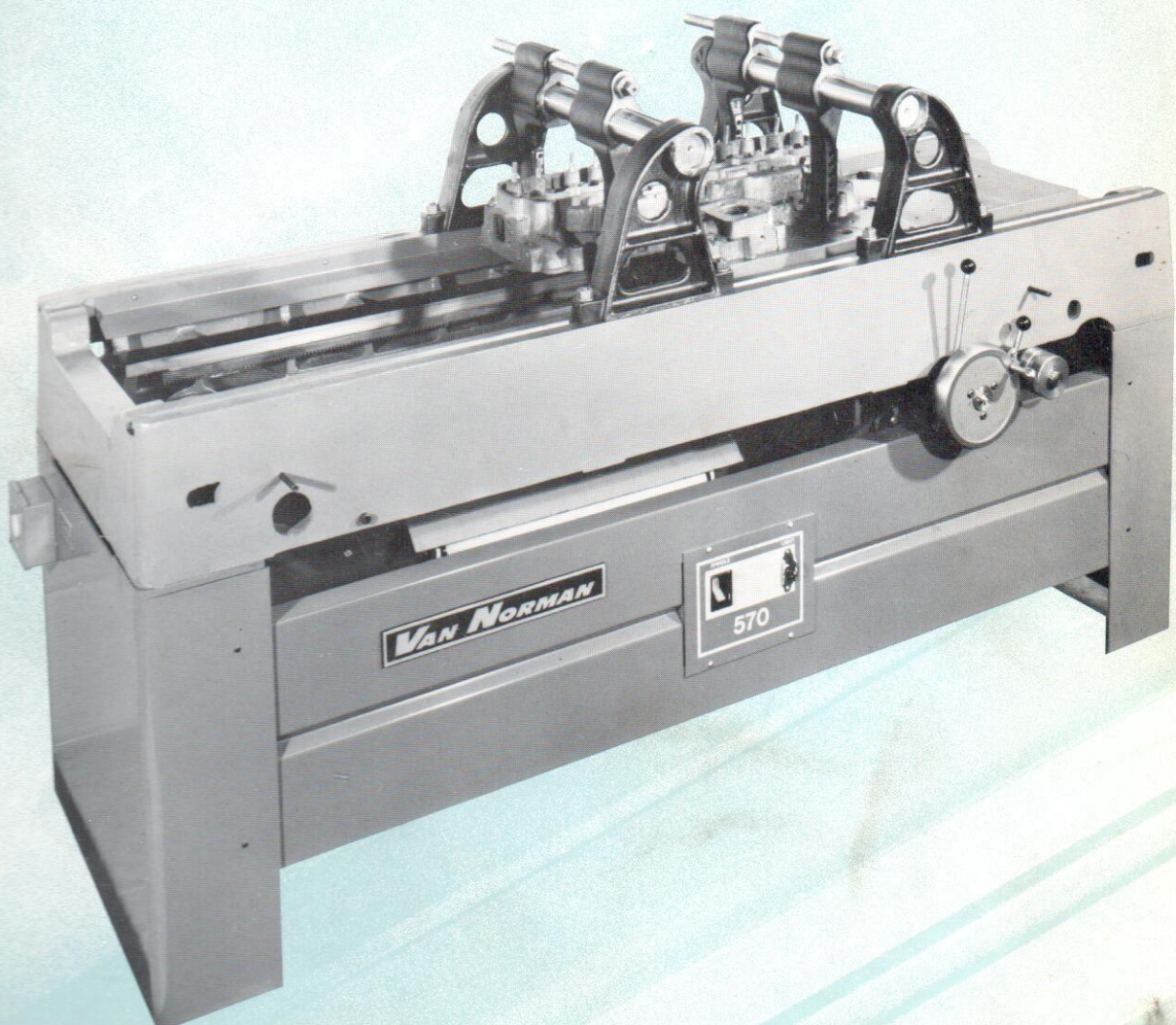


# 570 ROTARY BROACH



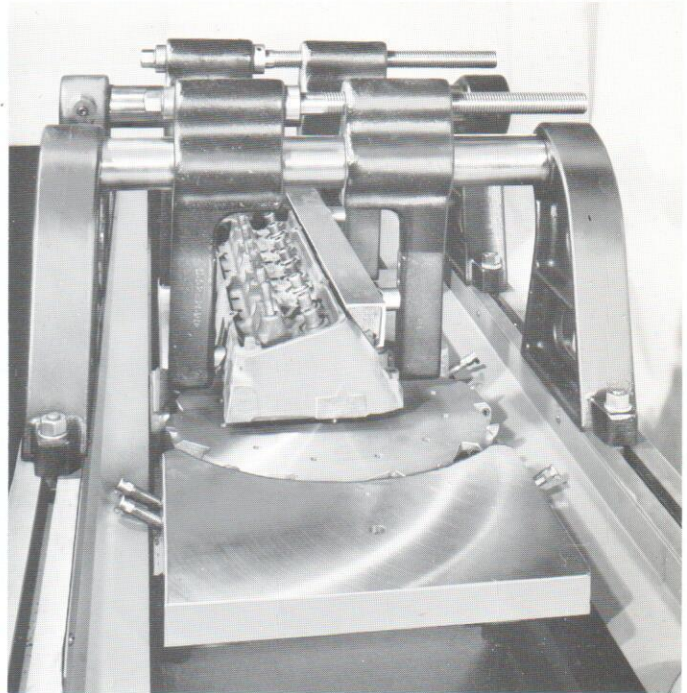
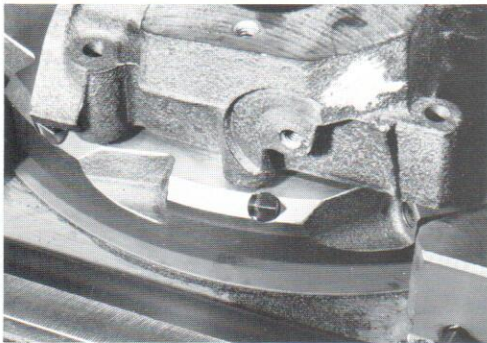
**VAN NORMAN**



## Head Resurfacing

Cylinder head in positive self-aligning clamping fixture. Built-in master locating table assures positive location instantaneously. Time-consuming levelling devices are not necessary.

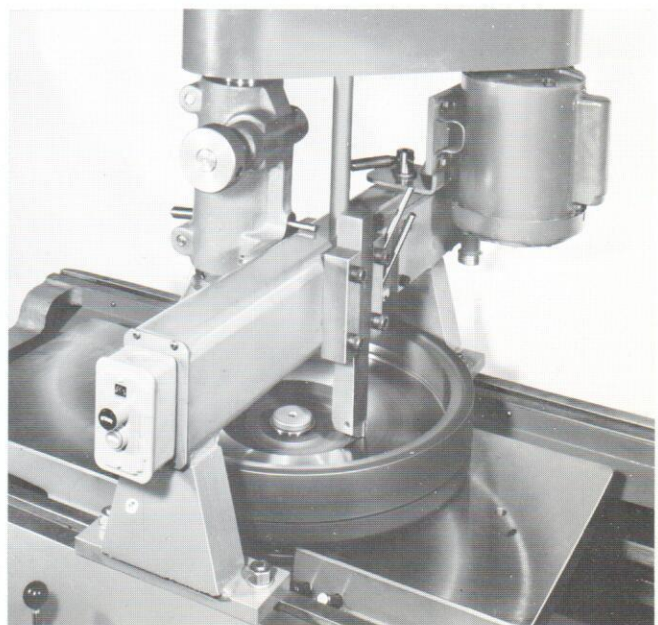
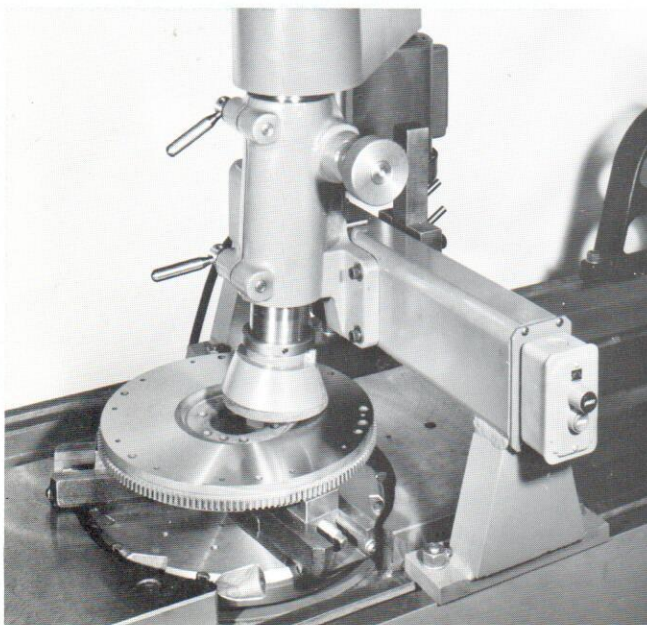
Close up of General Motors 250 cubic inch cylinder head with integral intake manifold showing one pass resurfacing of the 13" wide gasket surface. Straight line traverse design provides maximum cutter utilization.



## Flywheel Refinishing

Optional flywheel and pressure plate refinisher no. 575 provides for turning and grinding a wide range of cup and flat type flywheels and cover plates.

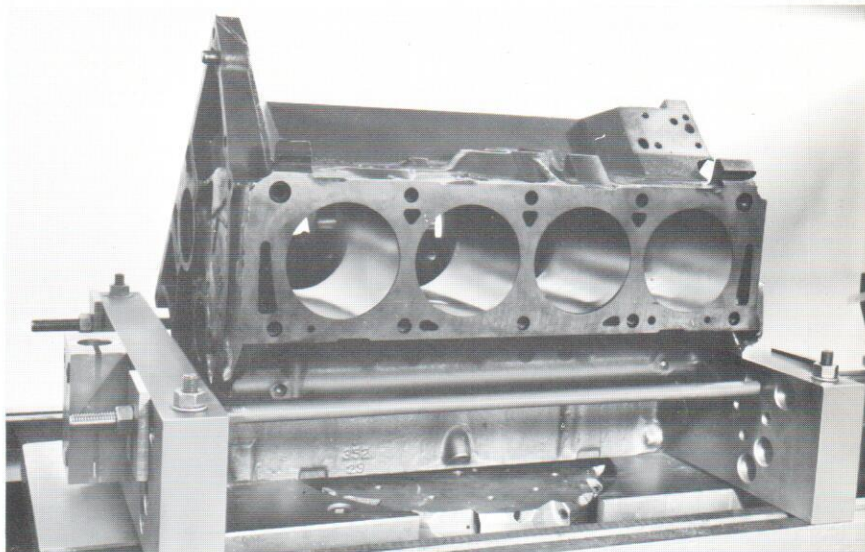
Turning a large cup flywheel. Note massive  $1\frac{1}{4}$ " square turning tool with carbide bit.



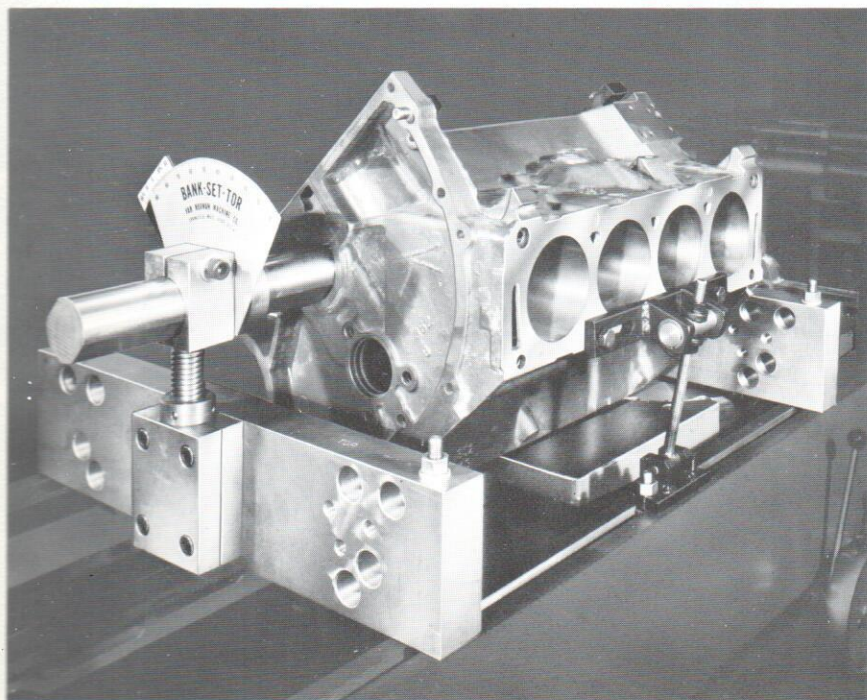


# Block Resurfacing

The standard holding fixture readily accommodates in-line and "V" configuration blocks. It's designed to accurately hold the workpiece in any plane during resurfacing. Blocks can be machined with main bearing caps torqued in place to eliminate distortion.



Optional block decking and gauging fixture no. 570-07297 for the specialist in performance work and/or industrial block rebuilding where fast set-up and ease of positioning are required. Quick reference is provided by an exclusive vernier caliper gauge, used for holding fire deck angularity to less than a minute.





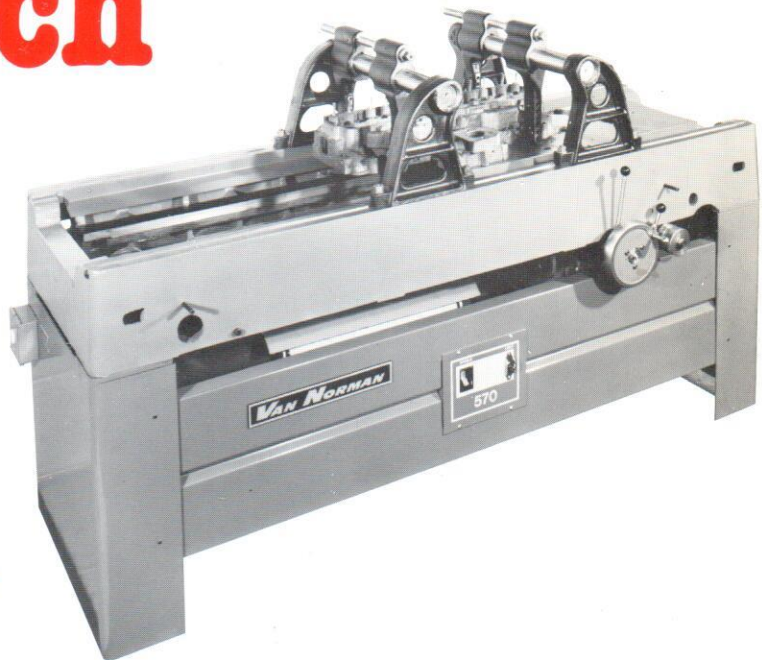
# Model 570 Broach

The Van Norman Model 570 Broach provides simple, accurate and efficient resurfacing of cylinder heads by dry cutting action. Top side set-up provides unlimited workpiece height capability. The exclusive 570 self-centering bridge holding fixture clamps from the side preventing workpiece distortion.

**Fast**— With set-up time of less than five minutes combined with one six-to-eight-minute pass to remove up to 50 thousandths of stock.

**Simple**— Positioning the workpiece above the cutter permits working on an assembled block or head without fear of contaminating it with gritty coolant or metal chips. One pass surfacing permits one tool setting and semi-automatic operation, freeing the operator to perform other work while the machine is in operation.

**Capable**— Consistent 80-90 micro finish from pre-set feeds and speeds of the cutter head and table traverse. Low chip load design will cut 300 to 500 heads before cutter resharp-ening is required.



Centrally located spindle power and workpiece lighting switches.



Controls provide automatic table traverse with built-in feeds  $3\frac{1}{2}''$ ,  $2\frac{1}{4}''$ ,  $1\frac{3}{32}''$  and  $\frac{9}{32}''$  per minute. Rapid return traverse  $55''$  and  $36''$  per minute. Automatic stop at both ends of table travel.

# Specifications

Machine Length (table fully extended) . . . 85"  
 Machine Height (with bridge clamp) . . . 47"  
 Machine Width . . . 27"  
 Maximum workpiece resurfacing length . . . 42"  
 Maximum workpiece resurfacing width . . . 14"  
 Maximum flywheel work diameter . . . 21"  
 Maximum workpiece height . . . None  
 Maximum table travel . . . 53"  
 Automatic traverse cutting feeds . . .  $3\frac{1}{2}''/2\frac{1}{4}''/1\frac{3}{32}''/9/32''$   
 Rapid return traverse . . . 36''/55'' minute  
 Cutter assembly speed . . . 58 - 85 rpm  
 Cutter assembly diameter . . . 14"  
 Cutter assembly vertical travel . . . 1"

Horizontal cutter travel . . . 53"  
 Main drive motor . . . 2HP/230/460/60/3  
 Main drive motor . . . 2HP/115/230/60/1  
 Flywheel attachment motor . . .  $\frac{3}{4}$ HP/115/60/1  
 Boring Motor . . .  $\frac{3}{4}$ HP/115/60/1  
 Net weight . . . 1900  
 Crated weight . . . 2400

Block Boring Attachment	Standard	Optional
Maximum boring length	40"	60"
Maximum boring diameter	$3\frac{11}{16}''$	8"
Minimum boring diameter	2"	$1\frac{3}{4}''$

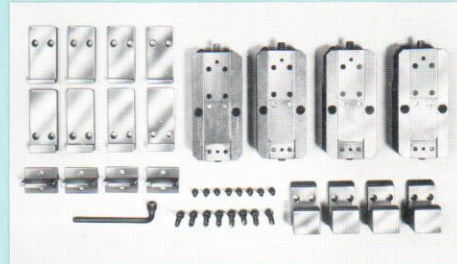
## Extra Equipment



570-70900 Tool Bit Lapping Fixture Set



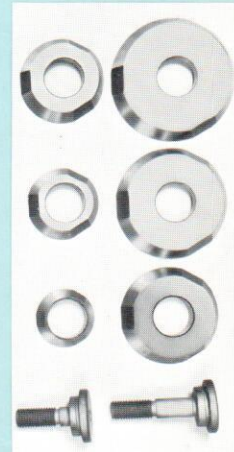
Boring Bar Standard Equipment



570-70184 Universal Jaws and Fixture Set



Cylinder Head Angle Adaptors



570-07245  
Flywheel Centering Kit

**VAN NORMAN**  
 AUTOMOTIVE SERVICE EQUIPMENT

SPRINGFIELD, MASSACHUSETTS 01107, U.S.A.