

**duMONT****Keyway broach HSS Fit JS9, Type: 4B1****Order data**

Order number	290405 4B1
GTIN	662600444037
Item class	29J

**Description****Application:**

**For production of keyways to DIN 6885.**

**Supplied with:**

Broaches including the necessary shims.

**Note:**

- **Broaches for high tensile materials, increased number of passes or special applications available (on request).**
- **After first and second of three passes, back the broach off slightly – the broach will then align itself.**
- **Coated broaches and inch size broaches available on request.**
- **BROACHING PRESSES can be found in Volume 2 (Hand tools and metrology).**
- **Size 28; 32 and 36 available on request, on short lead times.**

Tool material: HSS

Broach length: 172 mm

Keyway width: 4 mm

Keyway depth: 1.8 mm

for bore Ø to DIN 6885: 11 - 12 mm

Broaching length in steel: 8 - 42 mm

necessary broaching force for St50 and max. broaching length: 550 kg

## Technical description

Keyway width	4 mm
necessary broaching force for St50 and max. broaching length	550 kg
Number of passes	2
Broach length	172 mm
Broaching length in steel	8 - 42 mm
for bore Ø to DIN 6885	11 - 12 mm
Keyway depth	1.8 mm
Back width	6.46 mm
Tool material	HSS
Type of product	Broach

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable only under restricted conditions		
Aluminium (short chipping)	suitable		
Alu > 10% Si	suitable only under restricted conditions		
Steel < 500 N/mm <sup>2</sup>	suitable		
Steel < 750 N/mm <sup>2</sup>	suitable		
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions		
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions		
GG(G)	suitable		
CuZn	suitable		
Graphite, GRP, CRP	suitable only under restricted conditions		

Oil

suitable

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**Accessories**

Shim for keyway broach No. 290405 – 407 Type 4B1

290410 4B1