

## duMONT

### Keyway broach HSS Fit JS9, Type: 4B1



#### Order data

Order number	290420 4B1
GTIN	662600555115
Item class	29J

#### Description

**Version:**

**Sizes 4B1 to 8C1 additionally with 45° edge breaker.**

This deburrs the sharp edges of the groove.

**Application:**

For efficient cutting of splines to DIN 6885 in a single pass.

**Note:**

- **For size 2A please use part No. 290405 2A.**
- **Fits P9 and H9 available on request.**
- **After 1/3 and 2/3 of the pass, back the broach off slightly – the broach will then align itself.**

#### Technical description

Broach length	273 mm
Keyway depth	1.8 mm
necessary broaching force for St50 and max. broaching length	450 kg
Broaching length in steel	8 - 40 mm

Back width	6.46 mm
for bore Ø to DIN 6885	11 - 12 mm
Keyway width	4 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		