

duMONT**Keyway broach HSS Fit P9, Type: 22F1****Order data**

Order number	290406 22F1
GTIN	662600888138
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.**

Technical description

Broaching length in steel	25 - 150 mm
Broach length	505 mm
Back width	25.72 mm

Number of passes	5
Keyway depth	5.4 mm
for bore Ø to DIN 6885	75 - 85 mm
Keyway width	22 mm
necessary broaching force for St50 and max. broaching length	4300 kg
Tool material	HSS
Type of product	Broach

User data

	Suitability	V _c	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 ²	suitable		
Steel < 750 N/mm ²	suitable		
Steel < 900 N/mm ²	suitable only under restricted conditions		
INOX < 900 N/mm ²	suitable only under restricted conditions		
GG(G)	suitable		
CuZn	suitable		
Graphite, GRP, CRP	suitable only under restricted conditions		
Oil	suitable		