

duMONT

Keyway broach HSS Fit H9, Type: 18E1



Order data

Order number	290407 18E1
GTIN	662600888404
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

Number of passes	4
Broach length	394 mm
Keyway width	18 mm

Broaching length in steel	25 - 150 mm
Keyway depth	4.4 mm
necessary broaching force for St50 and max. broaching length	4800 kg
Back width	19.34 mm
for bore Ø to DIN 6885	58 - 65 mm
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		

Accessories

Shim for keyway broach No. 290405 – 407 Type 16-18E1

290410 16-18E1