

duMONT

Keyway broach HSS Fit P9, Type: 4B1



Order data

Order number	290406 4B1
GTIN	662600888039
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

for bore \varnothing to DIN 6885	11 - 12 mm
Broaching length in steel	8 - 42 mm
Number of passes	2

necessary broaching force for St50 and max. broaching length	550 kg
Broach length	172 mm
Back width	6.46 mm
Keyway depth	1.8 mm
Keyway width	4 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 4B1

290410 4B1