

duMONT

Keyway broach HSS Fit H9, Type: 4B1



Order data

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| Order number | 290407 4B1 |
| GTIN | 662600888220 |
| 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

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| necessary broaching force for St50 and max. broaching length | 550 kg |
| Keyway width | 4 mm |

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|---------------------------|------------|
| Keyway depth | 1.8 mm |
| for bore Ø to DIN 6885 | 11 - 12 mm |
| Broaching length in steel | 8 - 42 mm |
| Broach length | 172 mm |
| Back width | 6.46 mm |
| Number of passes | 2 |
| 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