

Keyway Broaches with Shims

High Speed Steel

- Specialty tools designed for cutting keyways in machined holes.
- Well suited for use in a variety of ferrous and non-ferrous materials.
- Hardened and ground bars with cutting teeth on one side.
- Size and proportioned to afford a good cutting range and ample rigidity.
- Replacement shims are also available.
- Broach is tapered, allowing teeth to cut keyway to proper depth.
- Made to cut either inch or millimeter size keyways.
- Bright finish.



Inch Size

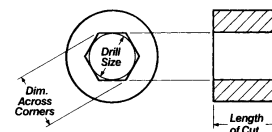
Broach Size	Type	Broach Dimensions	Shims Required	Length of Cut Min.	Length of Cut Max.	Tolerances	Order No.	TIN-Coated Order No.
1/16"	A	1/8x5"	0	13/64"	1-1/8"	.0625-.0635	395-1004	396-1004
3/32	A	1/8x5	0	13/64	1-1/8	.0938-.0948	395-1006	396-1006
1/8	A	1/8x5	1	13/64	1-1/8	.1252-.1262	395-1008	396-1008
3/32	B	3/16x6-3/4	0	19/64	1-11/16	.0937-.0947	395-1106	396-1106
1/8	B	3/16x6-3/4	1	19/64	1-11/16	.1252-.1262	395-1108	396-1108
5/32	B	3/16x6-3/4	1	19/64	1-11/16	.1564-.1574	395-1110	396-1110
3/16	B	3/16x6-3/4	1	19/64	1-11/16	.1877-.1887	395-1112	396-1112
3/16	C	3/8x11-3/4	1	25/64	2-1/2	.1877-.1887	395-1212	396-1212
1/4	C	3/8x11-3/4	1	25/64	2-1/2	.2502-.2512	395-1216	396-1216
5/16	C	3/8x11-3/4	2	25/64	2-1/2	.3127-.3137	395-1220	396-1220
3/8	C	3/8x11-3/4	2	25/64	2-1/2	.3755-.3765	395-1224	396-1224
5/16	D	9/16x13-7/8	2	1	6	.3127-.3137	395-1324	396-1324
3/8	D	9/16x13-7/8	2	1	6	.3755-.3765	395-1328	396-1328
7/16	D	9/16x13-7/8	3	1	6	.4380-.4390	395-1332	396-1332
1/2	D	9/16x13-7/8	3	1	6	.5006-.5016	395-1336	396-1336
5/8	E	3/4x15-1/2	4	1	6	.6260-.6270	395-1440	396-1440
3/4	E	3/4x15-1/2	5	1	6	.7515-.7525	395-1448	396-1448
7/8	F	1x20-1/4	6	1	6	.8765-.8775	395-1556	396-1556
1	F	1x20-1/4	7	1	6	1.0015-1.0025	395-1564	396-1564
1-1/8		1-1/8x20-1/4	8	1	6	1.1265-1.1275	395-1570	396-1570
1-1/4		1-1/4x20-1/4	9	1-1/2	8	1.2520-1.2530	395-1572	396-1572
1-3/8		1-3/8x20-1/4	10	1-1/2	8	1.3770-1.3780	395-1574	396-1574
1-1/2		1-1/2x20-1/4	11	1-1/2	8	1.5020-1.5030	395-1576	396-1576

Metric Size

Size	S.Keys	Piece of Shim	Dimension	Tooth Pitch	Teeth	Length of Cut Min.	Length of cut Max.	Tolerance	Order No.	TIN-Coated Order No.
2mm-A	2x2		1/8x5"	3/16"	18	13/64"	1-1/8"	.0782-.0791	395-2006	396-2006
3mm-A	3x3	1	1/8x5	3/16	18	13/64	1-1/8	.1176-.1185	395-2008	396-2008
4mm-B-1	4x4	1	1/4x6-3/4	9/32	16	19/64	1-11/16	.1569-.1579	395-2110	396-2110
5mm-B-1	5x5	1	1/4x6-3/4	9/32	16	19/64	1-11/16	.1963-.1972	395-2112	396-2112
5mm-C	5x5	1	3/8x11-3/4	3/8	22	25/64	2-1/2	.1963-.1972	395-2212	396-2212
6mm-C-1	6x6	1	3/8x11-3/4	3/8	22	25/64	2-1/2	.2356-.2366	395-2216	396-2216
8mm-C-1	8x7	2	3/8x11-3/4	3/8	22	25/64	2-1/2	.3143-.3155	395-2220	396-2220
10mm-D-1	10x8	2	9/16x13-7/8	5/8	17	1	6	.3930-.3942	395-2224	396-2224
12mm-D-1	12x8	2	9/16x13-7/8	5/8	17	1	6	.4716-.4730	395-2324	396-2324
14mm-D-1	14x9	2	9/16x13-7/8	5/8	17	1	6	.5503-.5517	395-2328	396-2328
16mm-E-1	16x10	3	3/4x15-1/2	5/8	20	1	6	.6290-.6304	395-2332	396-2332
18mm-E-1	18x11	3	3/4x15-1/2	5/8	20	1	6	.7078-.7092	395-2336	396-2336
20mm-F-1	20x12	3	1x20-1/4	5/8	26	1	6	.7864-.7880	395-2440	396-2440
22mm-F-1	22x14	4	1x20-1/4	5/8	26	1	6	.8651-.8667	395-2448	396-2448
24mm-F	24x14	5	1x20-1/4	5/8	26	1	6	.9439-.9455	395-2556	396-2556
25mm-F-1	25x14	4	1x20-1/4	5/8	26	1	6	.9832-.9848	395-2564	396-2564

Hexagon Push Broaches

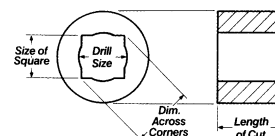
- For cutting hexagonal shaped hole in round machined holes.
- Used to re-cut a round hole into a hole having a hexagonal shape in a single pass through the workpiece.
- Well suited for use in a variety of ferrous and non-ferrous materials.
- Broach is tapered, allowing teeth to cut hole to proper depth and width.
- Bright finish.



Broach Size	Broach Length	Pilot Dia.	Drill Size	Length of Cut Min.	Length of Cut Max.	Tolerance	Order No.
1/8"	4-1/8"	1/8"	1/8"	3/16"	3/8"	.1255-.1260	395-5996
5/32	4-15/16	5/32	5/32	1/4	1/2	.1565-.1570	395-5998
3/16	5-1/16	3/16	3/16	1/4	5/8	.1880-.1890	395-6002
7/32	5-3/8	7/32	7/32	1/4	3/4	.2190-.2200	395-6004
1/4	6	1/4	1/4	1/4	3/4	.2505-.2515	395-6006
9/32	7-1/4	9/32	9/32	5/16	1	.2815-.2825	395-6008
5/16	7-3/4	5/16	5/16	3/8	1	.3130-.3140	395-6010
11/32	7-3/4	11/32	11/32	3/8	1-1/4	.3440-.3450	395-6012
3/8	8-1/2	3/8	3/8	3/8	1-1/4	.3755-.3765	395-6014
13/32	9-5/8	13/32	13/32	1/2	1-3/8	.4065-.4075	395-6016
7/16	10-5/8	7/16	7/16	1/2	1-3/8	.4385-.4395	395-6018
15/32	11-7/8	15/32	15/32	1/2	1-3/8	.4690-.4700	395-6020
1/2	11-7/8	1/2	1/2	1/2	1-3/8	.5005-.5015	395-6022
9/16	13-3/4	9/16	9/16	1/2	1-5/8	.5630-.5640	395-6024
5/8	16-1/4	5/8	5/8	5/8	2	.6260-.6270	395-6026
11/16	16-3/4	11/16	11/16	5/8	2	.6880-.6890	395-6030
3/4	17-1/4	3/4	3/4	5/8	2	.7510-.7520	395-6032
7/8	18-1/2	7/8	7/8	5/8	2	.8765-.8775	395-6034
1	19-3/4	1	1	5/8	2	1.002-1.003	395-6038

Square Push Broaches

- For cutting hexagonal shaped hole in round pilot holes.
- Used to re-cut a round hole into a hole having a square shape in a single pass through the workpiece.
- Well suited for use in a variety of ferrous and non-ferrous materials.
- Broach is tapered, allowing teeth to cut hole to proper depth and width.
- Bright finish.



Broach Size	Broach Length	Pilot Dia.	Drill Size	Length of Cut Min.	Length of Cut Max.	Tolerance	Order No.
1/8"	4-1/8 "	.1285"	#30	3/16"	1/2"	.1250-.1260	395-4002
5/32	5-1/8	.1590	#21	1/4	1/2	.1565-.1575	395-4004
3/16	5-9/16	.1935	#10	1/4	5/8	.1880-.1890	395-4006
7/32	6-3/8	.2280	#1	1/4	3/4	.2190-.2200	395-4010
1/4	6-1/2	17/64	17/64	1/4	3/4	.2505-.2515	395-4014
9/32	7-3/4	19/64	19/64	5/16	1	.2815-.2825	395-4016
5/16	7-7/8	21/64	21/64	5/16	1	.3130-.3140	395-4018
11/32	9-3/8	23/64	23/64	3/8	1-1/4	.3440-.3450	395-4020
3/8	9-3/8	25/64	25/64	3/8	1-1/4	.3755-.3765	395-4022
13/32	10-5/8	27/64	27/64	1/2	1-3/8	.4065-.4075	395-4023
7/16	10-7/8	29/64	29/64	1/2	1-3/8	.4385-.4395	395-4024
15/32	12	1/2	1/2	1/2	1-3/8	.4690-.4700	395-4025
1/2	12	17/32	17/32	1/2	1-3/8	.5005-.5015	395-4026
9/16	14-3/4	19/32	19/32	1/2	1-1/2	.5630-.5640	395-4028
5/8	16-5/16	21/32	21/32	5/8	1-5/8	.6260-.6270	395-4030
11/16	17-3/4	3/4	3/4	5/8	1-5/8	.6885-.6895	395-4034
3/4	17-3/4	13/16	13/16	5/8	1-5/8	.7510-.7520	395-4038
7/8	22-3/4	15/16	15/16	1/2	2	.8765-.8775	395-4056
1	24-1/8	1-3/32	1-3/32	1/2	2	1.0020-1.0030	395-4064