

▶ Keyway broach

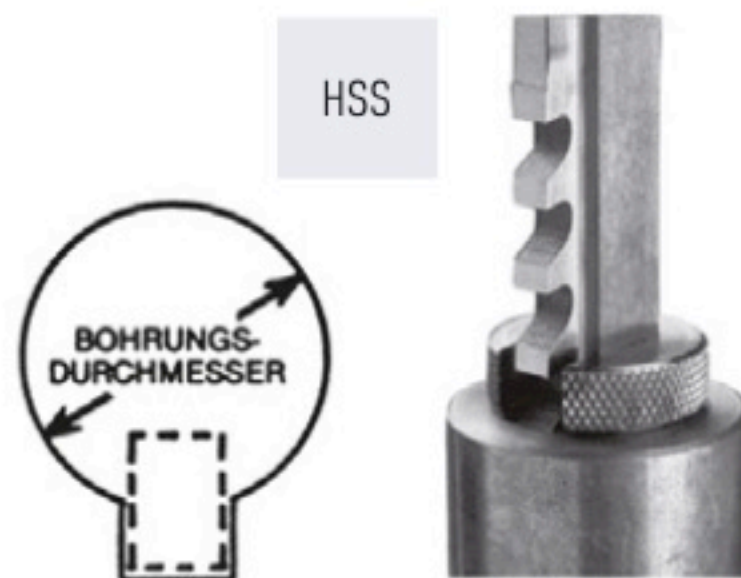
Design:

- tooth form and relief grinding ensure a clean surface
- tolerance JS 9
- delivery complete with calibrated shims (e.g. for 3 strokes with 2 shims)
- guide bushes see 115700

115600: Fitting shim

Use:

For the production of keyways to DIN 6885. Operated on mechanical arbor presses or hydraulic presses



Item no.	115500	Keyway width mm	Wedge size mm	Back width mm	Length mm	Bore Ø from-to mm	Broaching length mm	Broaching force N	Cycles	Number of shims
2/1	○	2	2×2	3,18	133	6-10	6-30	2300	1	0
3/1	●	3	3×3	3,18	133	6-10	6-30	3300	2	1
4/2	●	4	4×4	6,35	178	11-19	8-43	5200	2	1
5/2	●	5	5×5	6,35	178	11-19	8-43	9300	2	1
5/3	○	5	5×5	9,53	302	17-36	10-64	7600	2	1
6/3	●	6	6×6	9,53	302	17-36	10-64	8600	2	1
8/3	●	8	8×7	9,53	302	17-36	10-64	18000	2	1
10/4	●	10	10×8	14,29	352	32-56	20-150	36000	3	2
12/4	●	12	12×8	14,29	352	32-56	20-150	48000	3	2
14/4	●	14	14×9	14,29	352	32-56	20-150	50000	3	2
16/5	○	16	16×10	19,05	387	52×72	20-150	52000	4	3
18/5	○	18	18×11	19,05	387	52×72	20-150	55000	4	3

Item no.	115600 Spare shim	Keyway width mm	Thickness of the inserts mm
3/1	●	3	0,787
4/2	●	4	0,965
5/2	●	5	1,27
5/3	○	5	1,194
6/3	●	6	1,575
8/3	●	8	1,981
10/4	○	10	1,422
12/4	○	12	1,422
14/4	○	14	1,575
16/5	○	16	1,575
18/5	○	18	1,575