

16880

Sets of Push Broaches (Keyway Broaches)

Type

Rake angle 8-10°.

Each broach comes with bases

(e.g. 3 strokes= 2 bases). Delivered in wooden box.

Use

For machining keyways in compliance with

DIN 6885. For cast iron, steel, brass and aluminium.

Specially for use in hand-operated arbor presses.

Short broaching time (60 seconds), short set-up

time and easy to use. Guide bushes and bases are

used to precisely align keyways with the borehole

and to determine the proper depth.

Quality

HSS.

16880



Set size	Broaches	Guide bush Ø (d ₁) mm	For bore Ø mm	Broaching length mm	16880	...
210	2 pcs. RD I (b ₁ = 2 / 3 mm)	6 / 7 / 8 / 9 / 10	6 - 10	6 - 30		101
218	2 pcs. RD II (b ₁ = 4 / 5 mm)	12 / 14 / 15 / 16	12 - 28	8 - 43		202
	2 pcs. RD III (b ₁ = 6 / 8 mm)	18 / 20 / 22 / 24 / 25		10 - 64		
240	2 pcs. RD I (b ₁ = 2 / 3 mm)	8 / 10	8 - 36	6 - 30		203
	2 pcs. RD II (b ₁ = 4 / 5 mm)	12 / 14 / 15 / 16		8 - 43		
	2 pcs. RD III (b ₁ = 6 / 8 mm)	18 / 20 / 22 / 24 / 25 / 28 / 30		10 - 64		
224	3 pcs. RDI V (b ₁ = 10 / 12 / 14 mm)	32 / 35 / 38 / 40 / 42 / 45 / 50	34 - 48	20 - 150		204
212	2 pcs. RD V (b ₁ = 16 / 18 mm)	52 / 55 / 58 / 60 / 65	54 - 64	20 - 150		205

16881

Push Broaches (Keyway Broaches)

Type

Rake angle 8-10°.

Each broach comes with bases

(e.g. 3 strokes= 2 bases).

cat.-no. 16881 101 without base.

Guide bushes not included (see cat.-no. 16882).

Use

For machining keyways in compliance with

DIN 6885. For cast iron, steel, brass and aluminium.

Specially for use in hand-operated arbor presses.

Short broaching time (60seconds), short set-up time

and easy to use. Guide bushes and bases are used

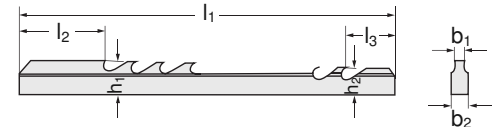
to precisely align keyways with the borehole and to

determine the proper depth.

Quality

HSS.

16881



Type	b ₁ mm	b ₂ mm	l ₁ mm	l ₂ mm	l ₃ mm	h ₁ mm	h ₂ mm	keyway depth mm	for boreholes Ø mm	broach length mm	number of strokes	tolerance mm	16881	...
RD I	2	3,18	133	32	15	6,18	5,00	1,10	6 - 8	6 - 30	1	+/-0,011		101
RD I	3	3,18	133	32	15	5,75	4,85	1,50	8 - 10	6 - 30	2	+/-0,012		102
RD II	4	6,35	178	48	23	9,90	8,77	1,90	10 - 12	8 - 43	2	+/-0,015		103
RD II	5	6,35	178	49	22	10,03	8,59	2,40	12 - 17	8 - 43	2	+/-0,015		104
RD III	5	9,63	302	65	23	16,39	14,95	2,40	17 - 22	10 - 64	2	+/-0,015		105
RD III	6	9,63	302	65	26	16,55	14,87	2,90	17 - 22	10 - 64	2	+/-0,015		106
RD III	8	9,63	302	65	23	16,64	14,55	3,50	22 - 30	10 - 64	2	+/-0,018		107
RD IV	10	14,29	340	65	33	23,99	22,29	3,50	30 - 38	20 - 150	3	+/-0,018		108
RD IV	12	14,29	340	65	35	23,74	22,05	3,50	38 - 44	20 - 150	3	+/-0,021		109
RD IV	14	14,29	340	65	33	23,69	21,71	4,00	44 - 50	20 - 150	3	+/-0,021		110
RD V	16	19,05	387	48	40	24,24	22,47	4,50	50 - 58	20 - 150	4	+/-0,021		111
RD V	18	19,05	387	48	41	24,06	22,22	4,60	58 - 65	20 - 150	4	+/-0,021		112
RD VI	20	25,4	489	65	39	31,80	30,11	5,10	65 - 75	20 - 150	5	+/-0,026		113
RD VI	22	25,4	489	65	39	31,54	29,99	5,60	75 - 85	20 - 150	5	+/-0,026		114
RD VI	24	25,4	489	65	37	31,17	29,66	5,60	85 - 95	20 - 150	5	+/-0,026		115
RD VI	25	25,4	489	65	39	30,98	29,46	5,60	85 - 95	20 - 150	5	+/-0,026		116



Guide Bushes | Replacement Bases for Push Broaches

16882

Guide Bushes

Type

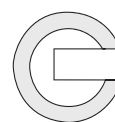
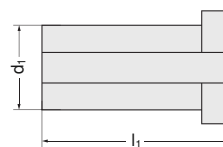
Hole tolerance H 7.

Up to RD III 36 x 65 mm with collar.

Use

For push broaches (keyway broaches)

cat.-no. 16881.



for type	d ₁ x l ₁ mm	16882	...
RD I	6 x 32		101
RD I	7 x 32		102
RD I	8 x 32		103
RD I	9 x 32		104
RD I	10 x 32		105
RD II	11 x 46		110
RD II	12 x 46		111
RD II	13 x 46		112
RD II	14 x 46		113
RD II	15 x 46		114
RD II	16 x 46		115
RD II	17 x 46		116
RD II	18 x 46		117
RD II	19 x 46		118
RD III	17 x 65		130
RD III	18 x 65		131
RD III	19 x 65		132
RD III	20 x 65		133
RD III	22 x 65		135
RD III	24 x 65		137

for type	d ₁ x l ₁ mm	16882	...
RD III	25 x 65		138
RD III	26 x 65		139
RD III	27 x 65		140
RD III	28 x 65		141
RD III	30 x 65		142
RD III	32 x 65		143
RD III	34 x 65		144
RD III	35 x 65		145
RD III	36 x 65		146
RD IV	32 x 102		150
RD IV	34 x 102		151
RD IV	35 x 102		152
RD IV	36 x 102		153
RD IV	38 x 102		154
RD IV	40 x 102		155
RD IV	42 x 102		156
RD IV	44 x 102		157
RD IV	45 x 127		158
RD IV	46 x 127		159
RD IV	48 x 127		160

for type	d ₁ x l ₁ mm	16882	...
RD IV	50 x 127		161
RD IV	52 x 127		162
RD IV	54 x 127		163
RD IV	55 x 127		164
RD IV	56 x 127		165
RD V	52 x 127		175
RD V	54 x 127		176
RD V	55 x 127		177
RD V	56 x 127		178
RD V	58 x 127		179
RD V	60 x 154		180
RD V	62 x 154		181
RD V	64 x 154		182
RD V	65 x 154		183
RD V	66 x 154		184
RD V	68 x 154		185
RD V	70 x 154		186
RD V	72 x 154		187
RD VI	70 x 154		193

16883

Replacement Bases for Push Broaches

Use

For push broaches (keyway broaches)

cat.-no. 16881.

16883



Size mm	thickness mm	for type	16883	...
3	0,787	I		101
4	0,965	II		102
5	1,270	II		103
5	1,194	III		104
6	1,448	III		105

Size mm	thickness mm	for type	16883	...
8	1,879	III		106
10	1,422	IV		107
12	1,492	IV		108
14	1,575	IV		109
16	1,575	V		110

Size mm	thickness mm	for type	16883	...
18	1,575	V		111
20	1,575	VI		112
22	1,575	VI		113
24	1,575	VI		114
25	1,575	VI		115

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