

Rotary Broach Kit Instructions

1. When Broaching the bore diameter must be greater than or equal to the opposite edge size of the cutter.
2. The depth of the hole is 1.3 - 1.4 times the diameter.
3. Before broaching the hole must be chamfered, with a Chamfer angle of 90 degrees.
4. Spindle speeds of between 800 - 1800 rpm and a feed rate of 0.02-1mm/rev.
5. A small force should be applied so that the tool is pressed into the workpiece before rotating the tool.
6. The cutting tool should be cooled with oil.

Broach Size	Bore ø	Chamfer ø
2	2 - 2.1mm	≥ 2.5mm
3	3 - 3.1mm	≥ 3.6mm
4	4 - 4.1mm	≥ 5mm
5	5 - 5.1mm	≥ 6mm
6	6 - 6.2mm	≥ 7mm
8	8 - 8.3mm	≥ 9.5mm
10	10.1 - 10.3mm	≥ 11.8mm
12	12.1 - 12.3mm	≥ 14mm

Suitable for machining low hardness materials up to 30HRC