

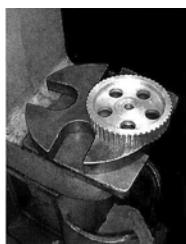
Heavy Duty Keyway Sets

American Standard

Heavy Duty Set 4-E		EDP No. 15012
2 Broaches and 6 Plain Bushings		
12 Keyway Combinations		Wt. 74 lbs.
Keyway Size	Broach Style	Bushing Diameters (Hole Sizes)
5/8	V	2 3/8, 2 1/2, 2 5/8
3/4	V	2 3/4, 2 7/8, 3
Heavy Duty Set 4-F		EDP No. 15014
2 Broaches and 6 Plain Bushings		
12 Keyway Combinations		Wt. 74 lbs.
Keyway Size	Broach Style	Bushing Diameters (Hole Sizes)
5/8	V	2 5/16, 2 7/16, 2 9/16
3/4	V	2 11/16, 2 13/16, 2 15/16
Heavy Duty Set 5		EDP No. 15026
3 Broaches and 17 Plain Bushings		
26 Keyway Combinations		Wt. 175 lbs.
Keyway Size	Broach Style	Bushing Diameters (Hole Sizes)
1/2	IV	2, 2 1/16, 2 1/8, 2 3/16, 2 1/4, 2 5/16, 2 3/8, 2 7/16
5/8	V	2 1/2, 2 9/16, 2 5/8, 2 11/16
3/4	V	2 3/4, 2 13/16, 2 7/8, 2 15/16, 3

Standard Push Broaching Technique

Push broaches are easy to use. A hydraulic press is required. Some larger size keyways need repeated passes with shims. Always clean chips from the broach and remember to flood the broach with high quality cutting oil during the entire cut.



Place the workpiece on the table of the hydraulic press with the area to be broached over the opening on table.



Select a bushing that will fit the prepared hole in the workpiece and place the bushing into the hole.



Select a broach of the proper keyway width and place the broach into the bushing slot.



Make sure the broach is straight before pressing it through the workpiece.



Press the broach through the keyway of workpiece. Make appropriate number of passes with shims to desired depth of keyway.

This cursory view of push broaching is presented here to explain the basic procedure of broaching for those who may be unfamiliar with broaching and it's many applications. Many variables may apply to your specific application and requirements. Please address any specific questions about broaching to our technical staff. We will be glad to assist you in any way we can.