

Keyway Broaches

American Standard

Broach	EDP No.	Keyway Width Tolerance	Dimensions In Inches	No. of Shims	Minimum Length of Cut	Maximum Length of Cut	Pressure Required for Max. l/c
1/16-I	10104	.0625-.0635	1/8 x 5 1/4	0	13/64	1 1/8	270 lbs.
3/32-I	10106	.0932-.0947	1/8 x 5 1/4	0	13/64	1 1/8	810 lbs.
1/8-I	10108	.1252-.1262	1/8 x 5 1/4	1	13/64	1 1/8	720 lbs.
3/32-II	10206	.0937-.0947	3/16 x 7	0	19/64	1 11/16	990 lbs.
1/8-II	10208	.1252-.1262	3/16 x 7	1	19/64	1 11/16	780 lbs.
5/32-II	10210	.1564-.1574	3/16 x 7	1	19/64	1 11/16	1,560 lbs.
3/16-II	10212	.1877-.1887	3/16 x 7	1	19/64	1 11/16	2,100 lbs.
3/16-III	10312	.1877-.1887	3/8 x 11 7/8	1	13/32	2 1/2	1,440 lbs.
1/4-III	10316	.2502-.2512	3/8 x 11 7/8	1	13/32	2 1/2	2,580 lbs.
5/16-III	10320	.3127-.3137	3/8 x 11 7/8	1	13/32	2 1/2	4,200 lbs.
3/8-III	10324	.3755-.3765	3/8 x 11 7/8	2	13/32	2 1/2	3,600 lbs.
5/16-IV	10420	.3127-.3137	9/16 x 13 7/8	1	3/4	6	9,250 lbs.
3/8-IV	10424	.3755-.3765	9/16 x 13 7/8	2	3/4	6	8,000 lbs.
7/16-IV	10428	.4380-.4390	9/16 x 13 7/8	2	3/4	6	11,750 lbs.
1/2-IV	10432	.5006-.5016	9/16 x 13 7/8	3	3/4	6	11,000 lbs.
9/16-IV	10436	.5630-.5640	9/16 x 13 7/8	3	3/4	6	11,100 lbs.
5/8-V	10540	.6260-.6270	3/4 x 15 1/4	4	3/4	6	11,500 lbs.
3/4-V	10548	.7515-.7525	3/4 x 15 1/4	5	3/4	6	13,500 lbs.
7/8-VI	10656	.8765-.8775	1 x 19 1/4	6	3/4	6	11,000 lbs.
1-VI	10664	1.0015-1.0025	1 x 19 1/4	7	3/4	6	14,000 lbs.
1 1/8	10666	1.1260-1.1270	1 1/8 x 23	8	3/4	6	15,750 lbs.
1 1/4	10668	1.2510-1.2520	1 1/4 x 23	9	3/4	6	17,500 lbs.
1 3/8	10670	1.3760-1.3770	1 3/8 x 23	10	3/4	6	19,250 lbs.
1 1/2	10672	1.5020-1.5030	1 1/2 x 23	11	3/4	6	21,000 lbs.

NOTES Hassay Savage HSS keyway broaches are available as standard items in sizes from 1/16" to 1".

Rake and relief angles are precisely made for efficient broaching of mild steel. Pressures listed above are for maximum

length of cut. If these lengths must be exceeded, a special Hassay Savage keyway broach should be ordered for minimum length of cut. Pieces may be broached by stacking and clamping.

For special widths and depths, custom keyway broaches are also available within a 2-week period. This is an excellent turnaround for the buyer looking for a special application in production or prototype research.

One Pass Keyway Broaches American Standard

Broach	EDP No.	Keyway Width Tolerance	Dimensions In Inches	Minimum Length of Cut	Maximum Length of Cut	Pressure Required for Max. l/c
1/8-II	10208-COP**	.1252-.1262	3/16 x 10 3/4	1/4	1 1/2	780 lbs.
5/32-II	10210-COP**	.1564-.1574	3/16 x 10 3/4	1/4	1 1/2	1,370 lbs.
3/16-II	10212-OP**	.1877-.1887	3/16 x 10 3/4	1/4	1 1/2	1,930 lbs.
3/16-III	10312-COP**	.1877-.1887	3/8 x 18 1/2	5/16	1 11/16	1,090 lbs.
1/4-III	10316-COP**	.2502-.2512	3/8 x 18 1/2	5/16	1 11/16	1,840 lbs.
5/16-III	10320-COP**	.3127-.3137	3/8 x 18 1/2	5/16	1 11/16	2,860 lbs.
3/8-III	10324-OP**	.3755-.3765	3/8 x 18 1/2	5/16	1 11/16	4,030 lbs.

One Pass Metric Keyway Broaches to ISO H9 Tolerance

Broach	EDP No.	Keyway Width Tolerance	For Standard Millimeter Keys	Dimensions In Inches	Minimum Length of Cut	Maximum Length of Cut	Pressure Required for Max. l/c
3mm-I	11103-OP*	.1185-.1190	3mm x 3mm	1/8 x 8 1/2	13/64	1 1/8	720 lbs.
4mm-II	11204-COP**	.1581-.1585	4mm x 4mm	1/4 x 10 3/4	1/4	1 1/2	1,510 lbs.
5mm-II	11205-COP**	.1975-.1979	5mm x 5mm	1/4 x 10 3/4	1/4	1 1/2	2,325 lbs.
6mm-III	11306-COP**	.2372-.2376	6mm x 6mm	3/8 x 18 1/2	5/16	1 11/16	1,920 lbs.
8mm-III	11308-COP**	.3159-.3163	8mm x 8mm	3/8 x 18 1/2	5/16	1 11/16	3,020 lbs.

* OP designates one-pass, no chamfer.

** COP designates chamfer, one-pass.

