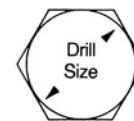


Hexagonal Broaches



American Standard

Hex Size	EDP No.	Tolerance	Diagonal Dimension	Pilot Diam.	Drill Size	Broach Length	Min. Length of Cut	Max. Length of Cut	Pressure for Max. L/C
1/8	12008	.1255-.1260	.1450-.1470	.1245	1/8	4 5/8	3/16	3/8	120 lbs.
5/32	12010	.1565-.1570	.1800-.1820	.1557	5/32	5 1/2	1/4	1/2	340 lbs.
3/16	12012	.1880-.1890	.2145-.2155	.1870	3/16	5 9/16	1/4	5/8	520 lbs.
7/32	12014	.2190-.2200	.2500-.2520	.2182	7/32	6	1/4	3/4	890 lbs.
1/4	12016	.2505-.2515	.2865-.2875	.2495	1/4	6 1/2	1/4	3/4	1,250 lbs.
9/32	12018	.2815-.2825	.3220-.3240	.2807	9/32	7 3/4	3/8	1	1,650 lbs.
5/16	12020	.3130-.3140	.3580-.3590	.3120	5/16	8 1/4	3/8	1	2,175 lbs.
11/32	12022	.3440-.3450	.3950-.3970	.3432	11/32	8 1/4	3/8	1 1/4	3,500 lbs.
3/8	12024	.3755-.3765	.4300-.4310	.3745	3/8	9	3/8	1 1/4	3,700 lbs.
13/32	12026	.4065-.4075	.4670-.4690	.4057	13/32	10	1/2	1 3/8	4,100 lbs.
7/16	12028	.4385-.4395	.5020-.5030	.4370	7/16	10 3/4	1/2	1 3/8	4,575 lbs.
15/32	12030	.4690-.4700	.5390-.5410	.4682	15/32	12 3/8	1/2	1 3/8	4,700 lbs.
1/2	12032	.5005-.5015	.5740-.5750	.4995	1/2	12 1/2	1/2	1 3/8	5,300 lbs.
9/16	12036	.5630-.5640	.6480-.6500	.5620	9/16	14 1/4	1/2	1 1/2	6,700 lbs.
5/8	12040	.6260-.6270	.7170-.7185	.6245	5/8	16 7/8	5/8	1 5/8	7,250 lbs.
11/16	12044	.6880-.6890	.7930-.7950	.6870	11/16	17	5/8	1 5/8	9,300 lbs.
3/4	12048	.7510-.7520	.8610-.8625	.7495	3/4	17 7/8	5/8	1 5/8	13,500 lbs.
7/8	12056	.8755-.8765	1.0060-1.0075	.8745	7/8	18 7/8	5/8	1 5/8	18,500 lbs.
1	12064	1.0020-1.0030	1.1520-1.1530	.9995	1	19 7/8	5/8	1 5/8	20,050 lbs.

Metric

Hex Size	EDP No.	Tolerance*	Diagonal Dimension	Pilot Diam.	Drill Size	Broach Length	Min. Length of Cut	Max. Length of Cut	Pressure for Max. L/C
4mm	12104	.1580-.1585	.1820-.1830	.1575	4.0	5 1/2	1/4	1/2	340 lbs.
5mm	12105	.1973-.1983	.2270-.2280	.1968	5.0	6	1/4	3/4	890 lbs.
6mm	12106	.2367-.2377	.2730-.2740	.2362	6.0	6 1/2	1/4	3/4	1,250 lbs.
7mm	12107	.2760-.2770	.3180-.3190	.2756	7.0	7 3/4	3/8	1	1,650 lbs.
8mm	12108	.3155-.3165	.3634-.3644	.3150	8.0	8 1/4	3/8	1	2,175 lbs.
10mm	12110	.3942-.3952	.4543-.4553	.3937	10.0	10	1/2	1	4,100 lbs.
12mm	12112	.4729-.4739	.5452-.5462	.4724	12.0	12 3/8	1/2	1 3/8	4,700 lbs.
14mm	12114	.5517-.5527	.6332-.6342	.5512	14.0	14 1/4	1/2	1 3/8	6,700 lbs.
16mm	12116	.6310-.6320	.7248-.7258	.6290	16.0	16 7/8	5/8	1 1/2	7,250 lbs.
18mm	12118	.7092-.7102	.8150-.8160	.7087	18.0	17	5/8	1 5/8	9,400 lbs.
20mm	12120	.7879-.7889	.9049-.9059	.7874	20.0	17 7/8	5/8	1 5/8	14,150 lbs.
22mm	12122	.8666-.8676	.9958-.9968	.8661	22.0	18 7/8	5/8	1 5/8	18,500 lbs.
24mm	12124	.9454-.9464	1.0868-1.0878	.9449	24.0	19 7/8	5/8	1 5/8	20,500 lbs.
25mm	12125	.9848-.9858	1.1323-1.1333	.9842	25.0	19 7/8	5/8	1 5/8	22,000 lbs.

*Tolerance considerations are based on preferred metric limits and fits--ANSI B4.2-1978.

NOTES: Hassay Savage standard hexagon broaches are HSS push type; designed for one-pass finishing when used with arbor or hydraulic press, or vertical broaching machine.

Special Hexagon Broaches: If your application cannot be handled with the standard hexagon broaches listed, send us a sample or print of the part to be broached.

Include the following data:

Hole: dimensions before and after broaching, with tolerances, and whether cast, drilled or reamed; length required.

Material: specifications, and whether bar, cast or forged stock; appropriate hardness before broaching.

