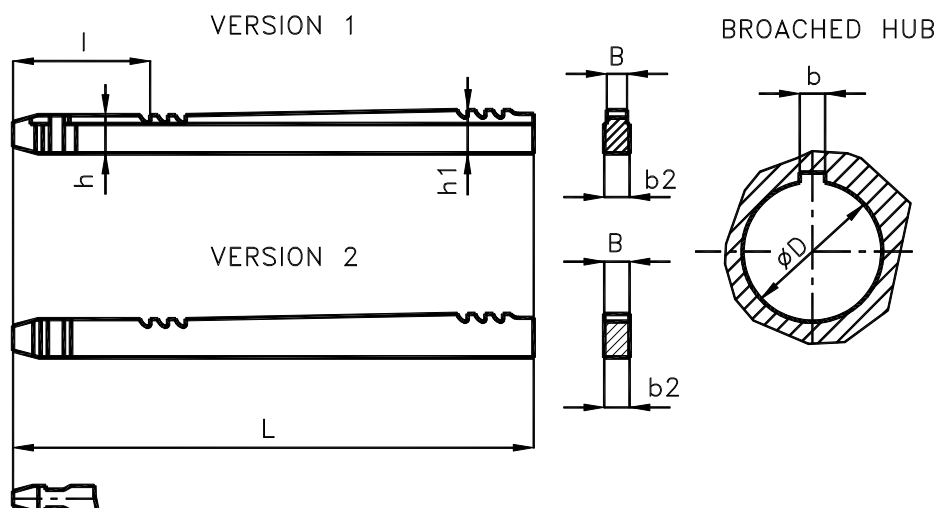


FLAT PULL BROACHES
ČSN 22 1810


The broaches of high – speed steel (HSS) or extra high – speed steel (HSSE) are available. They are delivered with the relevant rests ČSN (22 1890) and or with the guiding inserts – catalogue No 21895. In a standard version, broaches with chuck arbor according to ČSN 22 0480, are available. For $b = 3-6$ broaches in version 1, while for $b = 8 - 20$ broaches of version 2 are being produced. In a special version, broaches with chuck arbor at the option of the customer and/or with rear arbor or which other tolerance of the b flute, are available. Also broaches for other dimensions of the hub profile b od, l_p , are available.

b P9	Hub		l_p	Pull broach							x	y	G
	over	to		B	$b_2 f_7$	h	h_1	l	L				
3	8	10	$10 \div 15$	3	4	5.22	7	195	440	1	-	0.08	
4	10	12	$12 \div 18$	4	5	6.32	8.5	205	475			0.13	
5	12	17	$16 \div 25$	5	6	7.2	10	210	640			0.23	
6	17	22	$23 \div 35$	6	7	10.8	12.5	225	555	2	1	0.31	
8	22	30	$25 \div 45$	8	8	14.05	16	235	620			0.57	
10	30	38	$30 \div 60$	10	10	20.72	23	245	740			1.25	
12	38	44	$35 \div 70$	12	12	24.7	27	255	820	3	2	1.94	
14	44	50	$35 \div 80$	14	14	28.47	31	265	900			2.88	
16	50	58	$45 \div 90$	16	16	31.10	33	275	805			3.2	
18	58	65	$45 \div 100$	18	18	35.94	38	285	905	3	2	4.67	
20	65	75	$50 \div 120$	20	20	39.76	42	305	995			6.75	

Dimension in mm.

Legend:

- l_p ... broached length
- B ... width of tool which broaches the flute b P9 in the hub
- x ... number of pulls
- y ... number of necessary rests
- G ... weight [kg]