

**16880**

**Push-type broach (keyways broach) sets**

**Design**

**Chip angle 8–10°.**

Each broach **complete with inserts**

(e.g. for 3 strokes = 2 inserts).

Delivered in wooden case.

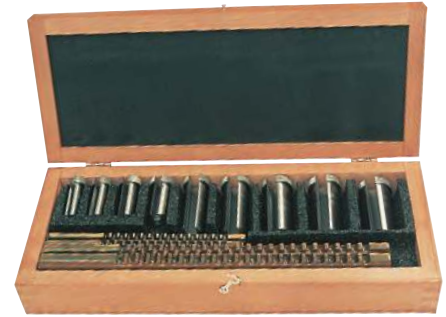
**Applications**

For the production of **keyways in accordance with DIN 6885**. For cast iron, steel, brass and aluminium. Use especially on manually operated arbor presses. Short sweeping time (60 seconds), low set-up time and easy handling. Clear specification of a groove for hole and the groove depth through the guide bush and inserts.

**Quality**

**HSS.**

**16880**



Set size	Broaches	Guide bush Ø (d <sub>1</sub> ) mm	for holes Ø mm	Sweeping length mm	16880	...
210	2 pcs. RD I (b <sub>1</sub> = 2/3 mm)	6/ 7/8/9/10	6–10	6–30		101
218	2 pcs. RD II (b <sub>1</sub> = 4/5 mm)	12/14/15/ 16	12–28	8–43		202
	2 pcs. RD III (b <sub>1</sub> = 6/8 mm)	18/20/22/24/25		10–64		
240	2 pcs. RD I (b <sub>1</sub> = 2/3 mm)	8/10	8–36	6–30		203
	2 pcs. RD II (b <sub>1</sub> = 4/5 mm)	12/14/15/16		8–43		
	2 pcs. RD III (b <sub>1</sub> = 6/8 mm)	18/20/22/24/25/28/30		10–64		
224	3 pcs. RD IV (b <sub>1</sub> = 10 / 12/14 mm)	32/35/38/40/42/45/50	34–48	20–150		204
212	2 pcs. RD V (b <sub>1</sub> = 16/18 mm)	52/55/58/60/65	54–64	20–150		205

**16881**

**Push-type broach (keyways broaches)**

**Design**

**Chip angle 8–10°.**

Each broach **complete with inserts**

(e.g. for 3 strokes = 2 inserts).

Art. no. 16881 101 without insert.

Delivery without guide bushes

(see art. no. 16882).

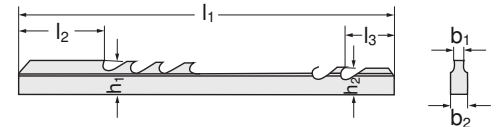
**Applications**

For the production of **keyways in accordance with DIN 6885**. For cast iron, steel, brass and aluminium. Use especially on manually operated arbor presses. Short sweeping time (60 seconds), low set-up time and easy handling. Clear specification of a groove for hole and the groove depth through the guide bush and inserts.

**Quality**

**HSS.**

**16881**



Type	b <sub>1</sub> mm	b <sub>2</sub> mm	l <sub>1</sub> mm	l <sub>2</sub> mm	l <sub>3</sub> mm	h <sub>1</sub> mm	h <sub>2</sub> mm	Groove depth mm	for holes Ø mm	Sweeping length mm	Number of strokes	Tolerance mm	16881	...
RD I	2	3.18	133	32	15	6.18	5.00	1.10	6–8	6–30	1	+/-0.011	101	
RD I	3	3.18	133	32	15	5.75	4.85	1.50	8–10	6–30	2	+/-0.012	102	
RD II	4	6.35	178	48	23	9.90	8.77	1.90	10–12	8–43	2	+/-0.015	103	
RD II	5	6.35	178	49	22	10.03	8.59	2.40	12–17	8–43	2	+/-0.015	104	
RD III	5	9.53	302	65	23	16.39	14.95	2.40	17–22	10–64	2	+/-0.015	105	
RD III	6	9.53	302	65	26	16.55	14.87	2.90	17–22	10–64	2	+/-0.015	106	
RD III	8	9.53	302	65	23	16.64	14.55	3.50	22–30	10–64	2	+/-0.018	107	
RD IV	10	14.29	352	65	33	23.99	22.29	3.50	30–38	20–150	3	+/-0.018	108	
RD IV	12	14.29	352	65	35	23.74	22.05	3.50	38–44	20–150	3	+/-0.021	109	
RD IV	14	14.29	352	65	33	23.69	21.71	4.00	44–50	20–150	3	+/-0.021	110	
RD V	16	19.05	387	48	40	24.24	22.47	4.50	50–58	20–150	4	+/-0.021	111	
RD V	18	19.05	387	48	41	24.06	22.22	4.60	58–65	20–150	4	+/-0.021	112	
RD VI	20	25.4	489	65	39	31.80	30.11	5.10	65–75	20–150	5	+/-0.026	113	
RD VI	22	25.4	489	65	39	31.54	29.99	5.60	75–85	20–150	5	+/-0.026	114	
RD VI	24	25.4	489	65	37	31.17	29.66	5.60	85–95	20–150	5	+/-0.026	115	
RD VI	25	25.4	489	65	39	30.98	29.46	5.60	85–95	20–150	5	+/-0.026	116	

16882

Guide bushes

Design

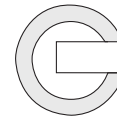
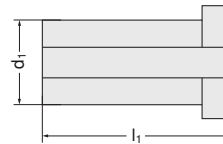
Bore tolerance H 7.

Up to RD III 36 x 65 mm with collar.

Applications

For push-type broaches (keyways broaches)

art. no. 16881.



16882

For type	d <sub>1</sub> x l <sub>1</sub> mm	16882	...
RD I	6 x 32	101	
RD I	7 x 32	102	
RD I	8 x 32	103	
RD I	9 x 32	104	
RD I	10 x 32	105	
RD II	11 x 46	110	
RD II	12 x 46	111	
RD II	13 x 46	112	
RD II	14 x 46	113	
RD II	15 x 46	114	
RD II	16 x 46	115	
RD II	17 x 46	116	
RD II	18 x 46	117	
RD II	19 x 46	118	
RD III	17 x 65	130	
RD III	18 x 65	131	
RD III	19 x 65	132	
RD III	20 x 65	133	
RD III	22 x 65	135	
RD III	24 x 65	137	

For type	d <sub>1</sub> x l <sub>1</sub> mm	16882	...
RD III	25 x 65	138	
RD III	26 x 65	139	
RD III	27 x 65	140	
RD III	28 x 65	141	
RD III	30 x 65	142	
RD III	32 x 65	143	
RD III	34 x 65	144	
RD III	35 x 65	145	
RD III	36 x 65	146	
RD IV	32 x 102	150	
RD IV	34 x 102	151	
RD IV	35 x 102	152	
RD IV	36 x 102	153	
RD IV	38 x 102	154	
RD IV	40 x 102	155	
RD IV	42 x 102	156	
RD IV	44 x 102	157	
RD IV	45 x 127	158	
RD IV	46 x 127	159	
RD IV	48 x 127	160	

For type	d <sub>1</sub> x l <sub>1</sub> mm	16882	...
RD IV	50 x 127	161	
RD IV	52 x 127	162	
RD IV	54 x 127	163	
RD IV	55 x 127	164	
RD IV	56 x 127	165	
RD V	52 x 127	175	
RD V	54 x 127	176	
RD V	55 x 127	177	
RD V	56 x 127	178	
RD V	58 x 127	179	
RD V	60 x 154	180	
RD V	62 x 154	181	
RD V	64 x 154	182	
RD V	65 x 154	183	
RD V	66 x 154	184	
RD V	68 x 154	185	
RD V	70 x 154	186	
RD V	72 x 154	187	
RD VI	70 x 154	193	

16883

Replacement inserts for push-type broaches

Applications

For push-type broaches (keyways broaches)

art. no. 16881.



16883

Size mm	Thickness mm	For type	16883	...
3	0.787	I	101	
4	0.965	II	102	
5	1.270	II	103	
5	1.194	III	104	
6	1.575	III	105	

Size mm	Thickness mm	For type	16883	...
8	1.981	III	106	
10	1.422	IV	107	
12	1.422	IV	108	
14	1.575	IV	109	
16	1.575	V	110	

Size	Thickness mm	For type mm	...	
16883	18	1.575	V	111
	20	1.575	VI	112
	22	1.575	VI	113
	24	1.575	VI	114
	25	1.575	VI	115