

0.229 Rad. Run out str.

0.067 Over Roller # 2, 54
0.054

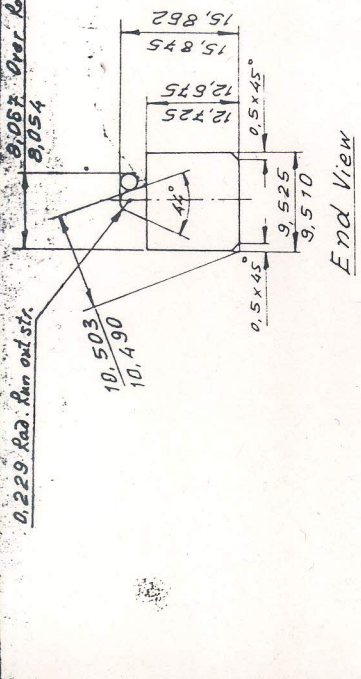
0.281 Over 2 Rollers
0.267 # 0.889

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0.267 # 0.889

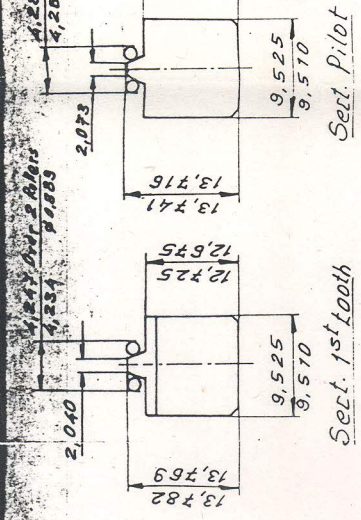
0.281 Over 2 Rollers
0.267 # 0.889

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0.267 # 0.889

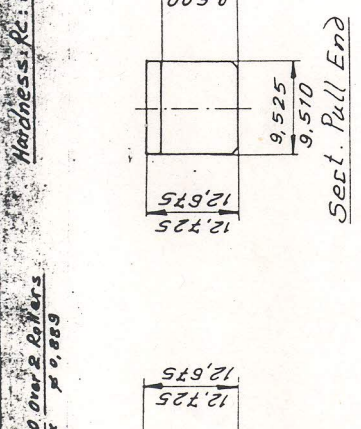
Hardness Rc: 63-65



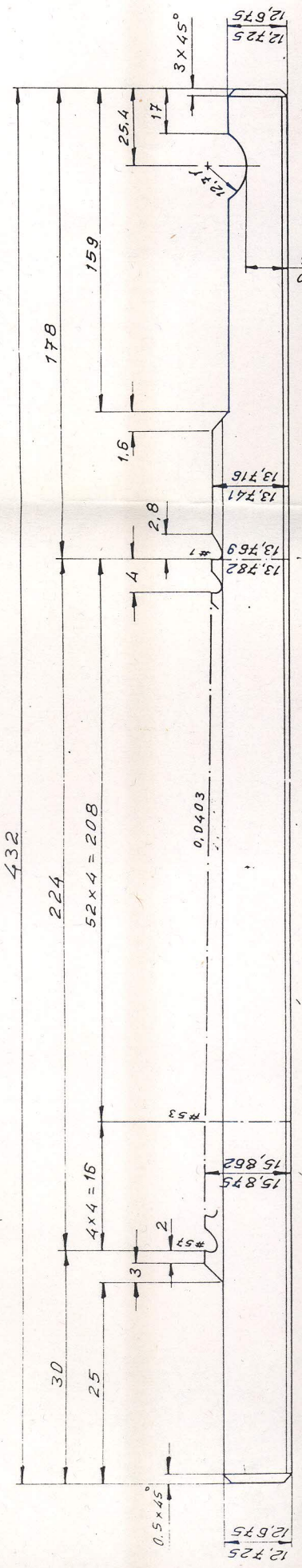
End View



Sect. 1st tooth

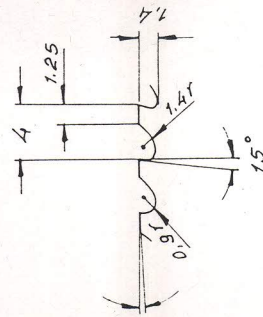


Sect. Pull End



Max. Permissible Bend 0.050mm.

0.45 # 54, 6 # 57
1.30 # 16 # 53

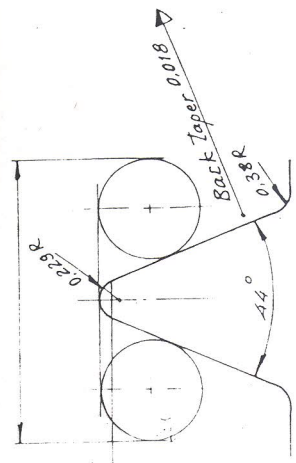


NO NICK

BROACHING LENGTH : 10mm
 DIMENSIONS IN : mm
 MATL TO BE BROACHED : LOW ALLOY STEELS
 MARTENSITIC SS.
 (HARDNESS 360 BHN)
 BROACH MATL : HSS - M42
 BROACH HARDNESS : 62-64 HRC.

Stamp:
 WFP 8272
 2 mm deep slot
 Max. Capacity 15/32
 L 46

Over 2 Rollers $\phi 1.778 = 4.719 / 4.707$
 Over 2 Rollers $\phi 0.889 = 2.512 / 2.499$



Enlarged View

CHS. *Olom* 16.3.2k
 DRG.No: ML-002