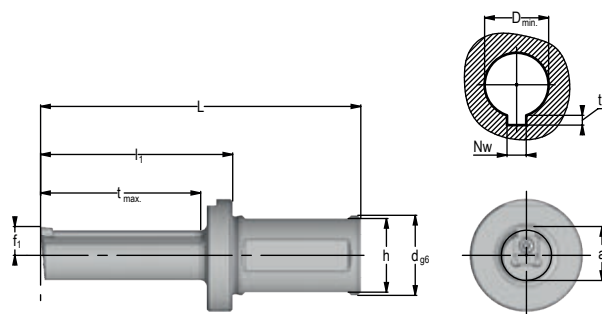


For process reliable broaching.
We call it BR20.

Broaching Tool BR20

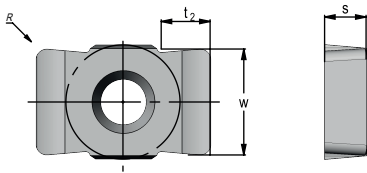


- < double-cutting indexable insert
- < best cutting and gliding characteristics
- < high cutting data at low machine performance levels
- < highly stable cutting edge support
- < internal cooling



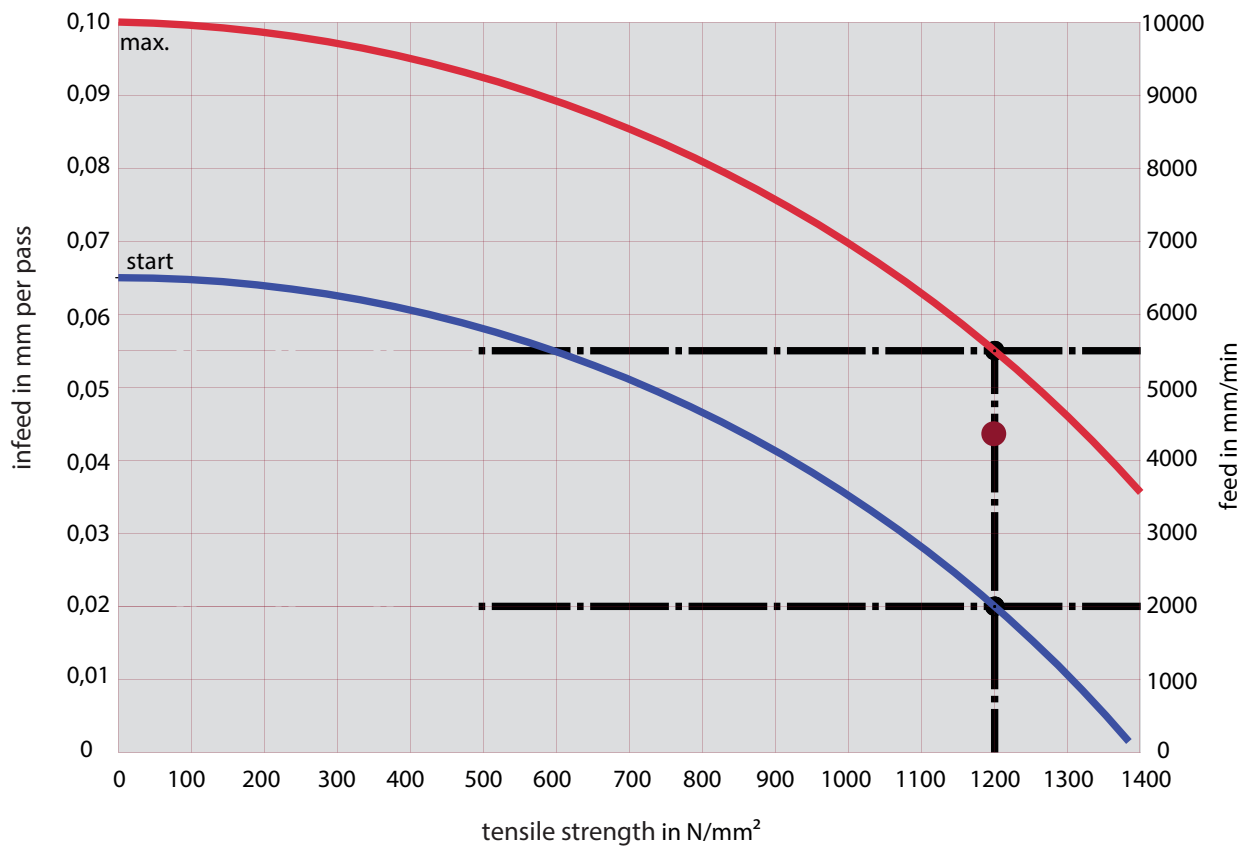
Broaching tool BR20

article	d_{g6}	h	L	l_1	t_{max}	D_{min}	f_1	a	ic	Kg	insert	Nw
17BR.1604.001	25	23	80	40	30	14	7	14,05	yes	0,2	BR.15T3.007.01	4C11
17BR.2206.001	25	23	100	60	50	17,5	9	16,85	yes	0,28	BR.15T3.007.02	6C11
17BR.2707.001	25	23	100	60	50	19	9	18,15	yes	0,3	BR.15T3.007.03	7C11
17BR.3208.001	25	23	100	60	50	24	11,25	22	yes	0,3	BR.2005.007.01	8C11
17BR.4010.001	32	30	102	62	52	26,5	13	25,21	yes	0,5	BR.2504.007.01	10C11
17BR.5012.001	32	30	102	62	52	30,5	14,95	29,2	yes	0,6	BR.2504.007.02	12C11



insert	Nw	w	S	t ₂	R
BR.15T3.007.01	4C11	4,11	3,97	2,1	0,5
BR.15T3.007.02	6C11	6,11	3,97	2,6	0,8
BR.15T3.007.03	7C11	7,12	3,97	3,3	0,8
BR.2005.007.01	8C11	8,12	5,00	3,4	1,0
BR.2504.007.01	10C11	10,12	4,76	4,2	1,0
BR.2504.007.02	12C11	12,15	4,76	5,1	1,2

Cutting data diagram - approximate value



● Example

material : tool steel 1.2312
 tensile strength: 1200 N/mm²
 feed: 4500 mm/min
 infeed per pass: 0,045mm

insert		
BR.15T3..		08B.0309.7991 TX208
BR.2005..		08B.3511.7991 TX215
BR.2504..		08B.4511.7992 TX220