


**DETAIL A
SCALE 15 : 1**

NOTES, UNLESS OTHERWISE SPECIFIED:

1. 17 GROOVES GIVES 18 TEETH
2. CLEARANCE ANGLE 3°
3. FACE/RAKE ANGLE = 0°
4. REFER "BROACHES AND BROACHING" MACHINERY'S HANDBOOK FOR OTHER MATERIALS
5. FIRST 3 TEETH OUTFEED = 0.07MM
6. REMAINING TEETH OUTFEED = 0.08MM
7. CONSIDER FURTHER DESTIBUTING CHIP LOAD AWAY FROM FIRST TEETH TO LAST
8. CONSIDER FILING RELIEF BEHIND FLAT SECTIONS IF HOLE DEPTH IS GREATER THAN TWICE PILOT DIAMETER

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS	TITLE:	
UNLESS OTHERWISE SPECIFIED, TOLERANCES: LINEAR: DIMENSIONS UNDER 15 MM ± 0.1 DIMENSIONS 15 MM AND OVER ± 1 ANGULAR: ±0.5°	3.4mm SQUARE BROACH BRASS ONLY	
REMOVE ALL BURRS AND SHARP EDGES 0.50 RADIUS OR CHAMFER MAX	 <a data-bbox="1635 1452 2083 1492" href="http://CLICKSPRINGPROJECTS.COM">CLICKSPRINGPROJECTS.COM	A4
MATERIAL: O1 TOOL STEEL		
WEIGHT: 5.58 G	SCALE: 5:1	SHEET 1 OF 1