

KEYWAY BROACHES # KBR

High Speed Steel - Including Necessary Shims - Genuine Minute Man® - Made in USA



SIZE mm	TOLERANCE Inch	KEYWAY WIDTH mm	STANDARD KEY SIZE mm	SHIM Reg'd	NUMBER OF TEETH	LENGTH OF CUT		OVERALL LENGTH Inch	REQUIRED PRESSURE Lbs.
						MIN. Inch	MAX. Inch		
A 2	.0782 - .0792	2	2 x 2	0	18	13/64	1 1/8	5	720
A 3	.1176 - .1186	3	3 x 3	1	18	13/64	1 1/8	5	650
B 4	.1568 - .1581	4	4 x 4	1	16	19/64	1 11/16	6 3/4	1140
B 5	.1963 - .1974	5	5 x 5	1	16	19/64	1 11/16	6 3/4	1860
C 5	.1963 - .1974	5	5 x 5	1	22	25/64	2 1/2	11 3/4	1470
C 6	.2356 - .2368	6	6 x 6	1	22	25/64	2 1/2	11 3/4	2100
C 8	.3143 - .3157	8	8 x 7	2	22	25/64	2 1/2	11 3/4	2680
D 10	.3930 - .3944	10	10 x 8	2	17	1	6	13 7/8	6500
D 12	.4716 - .4733	12	12 x 8	2	17	1	6	13 7/8	8400
D 14	.5503 - .5520	14	14 x 9	2	17	1	6	15 1/2	11100
E 16	.6290 - .6307	16	16 x 10	3	20	1	6	15 1/2	9400
E 18	.7078 - .7095	18	18 x 11	3	20	1	6	20 1/4	10600
F 20	.7864 - .7884	20	20 x 12	3	26	1	6	20 1/4	8800
F 22	.8651 - .8671	22	22 x 14	4	26	1	6	20 1/4	9400
F 24	.9439 - .9459	24	24 x 14	4	26	1	6	20 1/4	10600
F 25	.9832 - .9852	25	25 x 14	4	26	1	6	20 1/4	12300

Broaches are made with 8° to 10° rake and relieved for cutting steels and cast iron. If keyways are to be cut in brass or other soft materials, the rake should be removed.

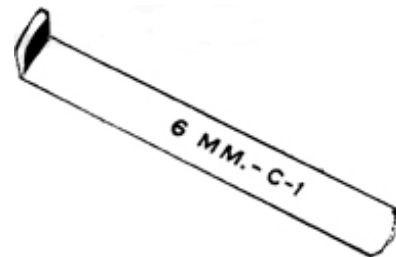
REPLACEMENT SHIMS # KBSH

For Metric Keyway Broaches

All Minute Man® Metric Standard Broaches are furnished with the required number of shims.

Shims are not required when using the smallest broaches.

SIZE	BROACH SIZE mm	SHIM THICKNESS mm
A 3	3	0.787
B 4	4	0.965
B 5	5	1.270
C 5	5	1.194
C 6	6	1.588
C 8	8	1.270
D 10	10	1.422
D 12	12	1.422
D 14	14	1.588
E 16	16	1.422
E 18	18	1.422
F 20	20	1.588
F 22	22	1.422
F 24	24	1.588
F 25	25	1.422



How to Order

Item #: KBU
Size: D 42
Quantity: 2
Tel: 1-888-966-MMCC

Please note: To reduce friction, always lubricate the back of the Keyway Broach regardless of the material to be cut. Length of cut and required pressure are based on mild steel.