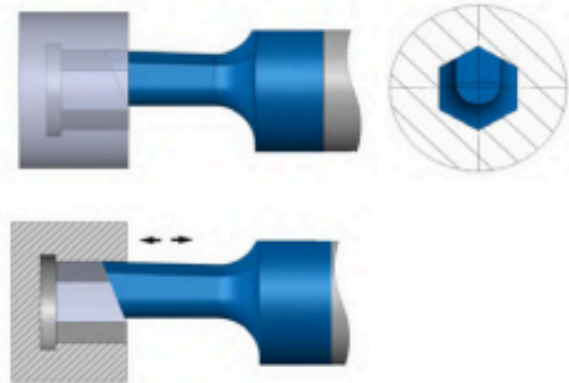


HK Broaching Tools for Hexagon Keys

The HK broaching system have been developed to machine internal keyways inside blind or through holes, using CNC machines.

- To use with Carmex standard SIM Bar Holders
- The holder can be located directly in the turret or the machine spindle
- Holder with rear clamping screw for full support during operation
- Available in **BMK** Grade only.

Working Demo



Cutting Data

Material Tensile Strength (N/mm ²)	Feed rate (mm/min)	In-feed per stroke (mm)
400-650	7000-9000	0.06-0.09
700-850	5000-6500	0.04-0.07
900-1000	4000-5500	0.03-0.05
1100-1200	3000-4500	0.02-0.04

The cutting data above is an initial recommendation and depends on the machine condition, workpiece profile and the application clamping

- A relief groove is highly recommended, if not possible a gradual volume decrease should be made at the end of the broaching groove
- The HK tool must be positioned outside of the hole/groove before each stroke
- After setup and first stroke, we recommend to observe the tool and the application to make sure no collision occurred