

BR-G16

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BM-250

BRIGHETTI MECCANICA

Made in Italy since 1977

2026/03/30

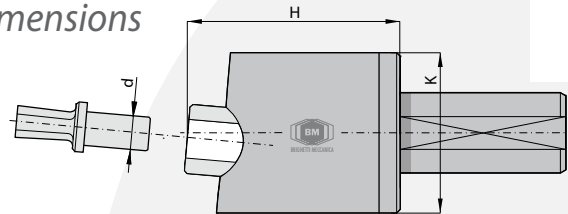


Brocciatori Standard serie "BR"

- Caratteristiche tecniche e dimensioni

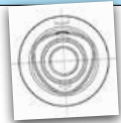
Standard Broaching Heads "BR" series

- Technical characteristics and dimensions



CARATTERISTICHE / FEATURES	dim.	BROCCIATORE (BR) / BROACHING HEAD (BR)										
		BR-G5	BR-G8			BR-G12		BR-G16			BR-G25	
			BR-G8S	BR-G8M	BR-G8	BR-G12B	BR-G12	BR-G16	BR-G16M	BR-G16L		
GAMBO DELLA BROCCIA SHANK OF THE BROACH	d	mm	Ø5	Ø8	Ø8	Ø8	Ø12	Ø12	Ø16	Ø16	Ø16	Ø25
CAPACITA' CAVE ESAGONALI HEXAGONAL SLOT CAPACITY		mm	1÷6	1÷8	1÷8	1÷10	1÷13	1÷15	2÷25	5÷30	4÷30	15÷40
CAPACITA' CAVE QUADRE SQUARE SLOT CAPACITY		mm	1÷4	1÷6	1÷6	1÷8	1÷10	1÷12	2÷15	5÷20	4÷25	15÷25
CAPACITA' CAVE TORX® TORX® SLOT CAPACITY	T		3÷25	3÷40	3÷40	3÷40	3÷60	3÷60	10÷70	20÷70	30÷70	(*)
CAPACITA' CAVE TORX® PLUS TORX® PLUS SLOT CAPACITY	IP		6÷25	6÷40	6÷40	6÷40	6÷60	6÷60	10÷70	20÷70	30÷70	(*)
PROFONDITA' MAX DI LAVORO MAXIMUM WORKING DEPTH		mm	7,5	15	15	15	21	21	21	30	40	65
DIMENSIONE CORPO BODY DIMENSIONS	H	mm	35	36,5	47,5	55	66,5	81,5	87	91	99	115,5
DIMENSIONE CORPO BODY DIMENSIONS	K	mm	Ø24	Ø37	Ø29,5	Ø37	Ø47	Ø58	Ø68	Ø68	Ø79	Ø91
PESO (indicativo) WEIGHT (indicative)		gr.	181	412	338	525	851	1653	2628	1830	3500	4850

TIPO DI ATTACCO / CONNECTIONS		BROCCIATORE (BR) / BROACHING HEAD (BR)									
		BR-G5	BR-G8			BR-G12		BR-G16			BR-G25
			BR-G8S	BR-G8M	BR-G8	BR-G12B	BR-G12	BR-G16	BR-G16M	BR-G16L	
CODOLO CILINDRICO CYLINDRICAL CONNECTION	Ø 8	10	10	10	16	20	25	25	25	25	32
	Ø 10	12	12	12	19,05	25	32	32	32	32	40
	Ø 12 (*)	16	16	16	20	32	40	40	40		
	Ø 16	19,05	19,05	19,05	22						
	Ø 19,05	20	20	20	25						
	Ø 20	22	22	22	25,40						
	Ø 22 (*)	25	25	25							
	Ø	25,40	25,40 (*)	25,40							
CODOLO CONO MORSE "CM" "CM" MORSE TAPER CONNECTION					2	3	3-4	3-4	4-5	4-5	
A RICHIESTA / On request: CODOLO "ISO - DIN 69871 / DIN 2080" "ISO-DIN 69871 / DIN 2080" CONNECTION						30-40	40	40-50	40-50	40-50	
CODOLO "VDI" "VDI" CONNECTION						VDI 30	VDI 30	VDI 30	VDI 40	VDI 40	
							VDI 40	VDI 40			
CODOLO "CAPTO ISO-26623" "CAPTO ISO-26623" CONNECTION						3	4-5	4-5	4-5		



(*) a richiesta / on request

A RICHIESTA / On request:
CODOLO "HSK"
DIN 69893-1 / ISO-12164
FORMA ...
"HSK" CONNECTION
DIN 69893-1 / ISO-12164
SHAPE ...

In fase di richiesta specificare con disegno il tipo di attacco richiesto
When submitting a request, specify the type of connection required with a drawing

Brocciatori REGISTRABILI > vedi pag.12
Adjustable Broaching Head > see page 12

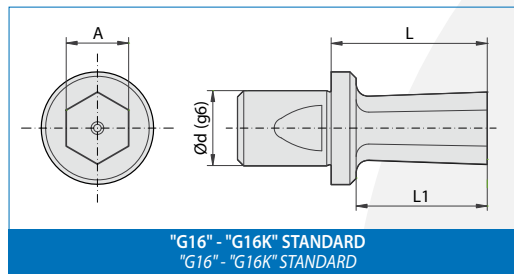


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BROCCHE G16 - DIAMETRO "d" DEL GAMBO: 16 mm
G16 BROACHES - 16 mm SHANK DIAMETER ("d")

Sezione ESAGONALE standard (E)
Standard HEXAGONAL section (E)



ARTICOLO (materiale) ITEM (material)		DIMENSIONI - DIMENSIONS				Utilizzo su Brocciatori/ Use on Broaching heads
HSS	SINTERIZZATO SINTERED	d	A	L1	L	
Standard	Standard					Standard BR-G16
G16-E-2	G16K-E-2	16	2 +0,05 +0,07	5	25	
G16-E-2,5	G16K-E-2,5	16	2,5 +0,05 +0,07	6	25	
G16-E-3	G16K-E-3	16	3 +0,06 +0,08	7	25	
G16-E-3,5	G16K-E-3,5	16	3,5 +0,06 +0,08	8	25	
G16-E-4	G16K-E-4	16	4 +0,07 +0,09	9	25	
G16-E-4,5	G16K-E-4,5	16	4,5 +0,07 +0,09	9	25	
G16-E-5	G16K-E-5	16	5 +0,08 +0,10	11	25	
G16-E-5,5	G16K-E-5,5	16	5,5 +0,08 +0,10	11	25	
G16-E-6	G16K-E-6	16	6 +0,08 +0,10	13	25	
G16-E-7	G16K-E-7	16	7 +0,08 +0,10	15	25	
G16-E-8	G16K-E-8	16	8 +0,08 +0,10	17	25	
G16-E-9	G16K-E-9	16	9 +0,09 +0,11	19	25	
G16-E-10	G16K-E-10	16	10 +0,10 +0,12	21	25	
G16-E-11	G16K-E-11	16	11 +0,10 +0,12	21	25	
G16-E-12	G16K-E-12	16	12 +0,11 +0,13	21	25	
G16-E-13	G16K-E-13	16	13 +0,11 +0,13	21	25	
G16-E-14	G16K-E-14	16	14 +0,12 +0,14	21	25	
G16-E-15	G16K-E-15	16	15 +0,13 +0,15	21	25	
G16-E-16	G16K-E-16	16	16 +0,13 +0,15	21	25	
G16-E-17	G16K-E-17	16	17 +0,14 +0,16	21	25	
G16-E-18	G16K-E-18	16	18 +0,15 +0,17	21	25	
G16-E-19	G16K-E-19	16	19 +0,16 +0,18	21	25	
G16-E-20	G16K-E-20	16	20 +0,18 +0,20	21	25	
G16-E-21	G16K-E-21	16	21 +0,18 +0,20	21	25	
G16-E-22	G16K-E-22	16	22 +0,19 +0,21	21	25	
G16-E-23	G16K-E-23	16	23 +0,20 +0,22	21	25	
G16-E-24	G16K-E-24	16	24 +0,21 +0,23	21	25	
G16-E-25	G16K-E-25	16	25 +0,22 +0,24	21	25	

In questi articoli possiamo eseguire i seguenti rivestimenti: **WONDER, TiN, INOX PLUS e ZIRINOS** > vedi pag.18
 Available coatings for the up above mentioned items: **WONDER, TiN, INOX PLUS and ZIRINOS** > see page 18

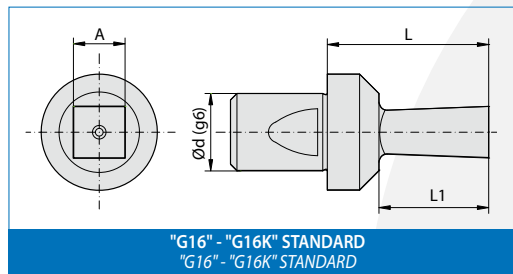


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BROCCE G16 - DIAMETRO "d" DEL GAMBO: 16 mm
G16 BROACHES - 16 mm SHANK DIAMETER ("d")

Sezione QUADRA standard (Q)
Standard SQUARE section (Q)



ARTICOLO (materiale) ITEM (material)		DIMENSIONI - DIMENSIONS				Utilizzo su Brocciatori/ Use on Broaching heads
HSS	SINTERIZZATO SINTERED	d	A	L1	L	
Standard <input type="checkbox"/>	Standard <input type="checkbox"/>					Standard BR-G16
G16-Q-2	G16K-Q-2	16	2 +0,05 +0,07	5	25	
G16-Q-2,5	G16K-Q-2,5	16	2,5 +0,05 +0,07	6	25	
G16-Q-3	G16K-Q-3	16	3 +0,06 +0,08	7	25	
G16-Q-3,5	G16K-Q-3,5	16	3,5 +0,07 +0,09	8	25	
G16-Q-4	G16K-Q-4	16	4 +0,07 +0,09	9	25	
G16-Q-4,5	G16K-Q-4,5	16	4,5 +0,07 +0,09	9	25	
G16-Q-5	G16K-Q-5	16	5 +0,08 +0,10	11	25	
G16-Q-5,5	G16K-Q-5,5	16	5,5 +0,08 +0,10	11	25	
G16-Q-6	G16K-Q-6	16	6 +0,08 +0,10	13	25	
G16-Q-7	G16K-Q-7	16	7 +0,08 +0,10	15	25	
G16-Q-8	G16K-Q-8	16	8 +0,08 +0,10	17	25	
G16-Q-9	G16K-Q-9	16	9 +0,09 +0,11	19	25	
G16-Q-10	G16K-Q-10	16	10 +0,10 +0,12	21	25	
G16-Q-11	G16K-Q-11	16	11 +0,10 +0,12	21	25	
G16-Q-12	G16K-Q-12	16	12 +0,11 +0,13	21	25	
G16-Q-13	G16K-Q-13	16	13 +0,11 +0,13	21	25	
G16-Q-14	G16K-Q-14	16	14 +0,12 +0,14	21	25	
G16-Q-15	G16K-Q-15	16	15 +0,13 +0,15	21	25	

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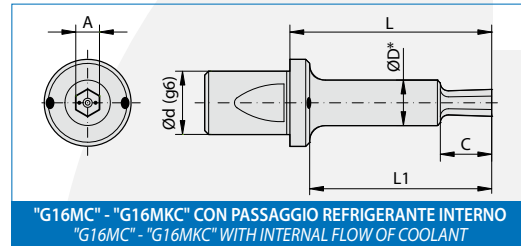
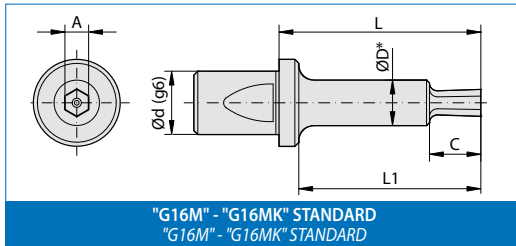


BROCCHE G16M E G16MC - DIAMETRO "d" DEL GAMBO: 16 mm
G16M AND G16MC BROACHES - 16 mm SHANK DIAMETER ("d")

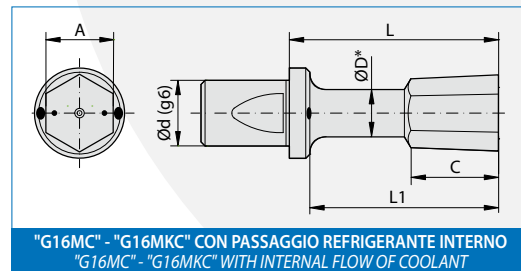
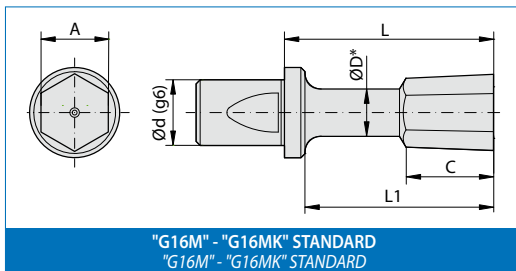
Per Brocciatori /
For Broaching Heads
BR-G16M



Sezione ESAGONALE (E)
HEXAGONAL section (E)



ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS						Utilizzo su Brocciatori / Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L1	L	C	D*	
Standard	Ref. / Cool.	Standard	Ref. / Cool.							
G16M-E-5	G16MC-E-5	G16MK-E-5	G16MKC-E-5	16	5 +0,08 +0,10	31	35	11	9,4	Standard BR-G16M
G16M-E-5,5	G16MC-E-5,5	G16MK-E-5,5	G16MKC-E-5,5	16	5,5 +0,08 +0,10	31	35	11	9,4	
G16M-E-6	G16MC-E-6	G16MK-E-6	G16MKC-E-6	16	6 +0,08 +0,10	31	35	13	9,4	Refrig. / Cool. BRC-G16M
G16M-E-7	G16MC-E-7	G16MK-E-7	G16MKC-E-7	16	7 +0,08 +0,10	31	35	15	9,4	



G16M-E-8	G16MC-E-8	G16MK-E-8	G16MKC-E-8	16	8 +0,08 +0,10	31	35	16	5,8	Standard BR-G16M
G16M-E-9	G16MC-E-9	G16MK-E-9	G16MKC-E-9	16	9 +0,09 +0,11	31	35	15	8	
G16M-E-10	G16MC-E-10	G16MK-E-10	G16MKC-E-10	16	10 +0,10 +0,12	31	35	15	8	Refrig. / Cool. BRC-G16M
G16M-E-11	G16MC-E-11	G16MK-E-11	G16MKC-E-11	16	11 +0,10 +0,12	31	35	15	9	
G16M-E-12	G16MC-E-12	G16MK-E-12	G16MKC-E-12	16	12 +0,11 +0,13	31	35	15	10	Standard BR-G16M
G16M-E-13	G16MC-E-13	G16MK-E-13	G16MKC-E-13	16	13 +0,11 +0,13	31	35	15	11	
G16M-E-14	G16MC-E-14	G16MK-E-14	G16MKC-E-14	16	14 +0,12 +0,14	31	35	15	12	Refrig. / Cool. BRC-G16M
G16M-E-15	G16MC-E-15	G16MK-E-15	G16MKC-E-15	16	15 +0,13 +0,15	31	35	15	13	
G16M-E-16	G16MC-E-16	G16MK-E-16	G16MKC-E-16	16	16 +0,13 +0,15	31	35	15	14	Standard BR-G16M
G16M-E-17	G16MC-E-17	G16MK-E-17	G16MKC-E-17	16	17 +0,14 +0,16	31	35	15	15	
G16M-E-18	G16MC-E-18	G16MK-E-18	G16MKC-E-18	16	18 +0,15 +0,17	31	35	15	16	Refrig. / Cool. BRC-G16M
G16M-E-19	G16MC-E-19	G16MK-E-19	G16MKC-E-19	16	19 +0,16 +0,18	31	35	13,5	17	
G16M-E-20	G16MC-E-20	G16MK-E-20	G16MKC-E-20	16	20 +0,18 +0,20	31	35	13,5	18	Standard BR-G16M
G16M-E-21	G16MC-E-21	G16MK-E-21	G16MKC-E-21	16	21 +0,18 +0,20	31	35	13	19	
G16M-E-22	G16MC-E-22	G16MK-E-22	G16MKC-E-22	16	22 +0,19 +0,21	31	35	13	20	

C = Profondità utile di brocciatura / C = Depth of the shape
 L1 = Profondità max. di lavoro / L1 = Maximum broaching depth

segue / continued >>

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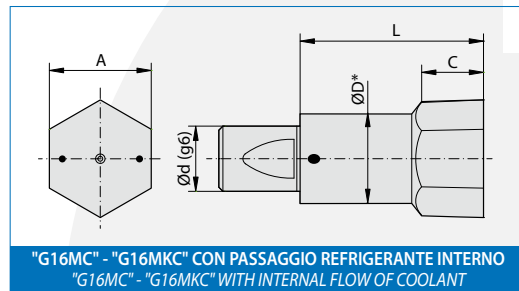
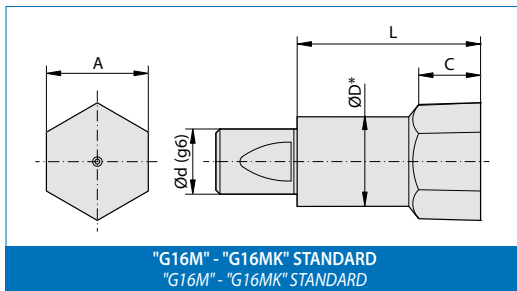


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>> segue / continued

BROCCE G16M E G16MC - DIAMETRO "d" DEL GAMBO: 16 mm
 G16M AND G16MC BROACHES - 16 mm SHANK DIAMETER ("d")



ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS					Utilizzo su Brocciatori/ Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L	C	D*	
Standard	Ref. / Cool.	Standard	Ref. / Cool.						
G16M-E-23	G16MC-E-23	G16MK-E-23	G16MKC-E-23	16	23 +0,20 +0,22	35	13,2	22	Standard BR-G16M
G16M-E-24	G16MC-E-24	G16MK-E-24	G16MKC-E-24	16	24 +0,21 +0,23	35	13,2	22	
G16M-E-25	G16MC-E-25	G16MK-E-25	G16MKC-E-25	16	25 +0,22 +0,24	35	11,5	22	
G16M-E-27	G16MC-E-27	G16MK-E-27	G16MKC-E-27	16	27 +0,22 +0,24	35	11,5	22	Refrig. / Cool. BRC-G16M
G16M-E-28	G16MC-E-28	G16MK-E-28	G16MKC-E-28	16	28 +0,22 +0,24	35	11,5	22	
G16M-E-30	G16MC-E-30	G16MK-E-30	G16MKC-E-30	16	30 +0,23 +0,25	35	11,5	22	

* la quota D può essere modificata a seconda delle necessità del cliente. Contattare la Brighetti Meccanica.
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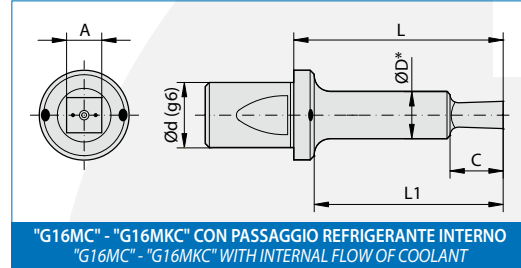
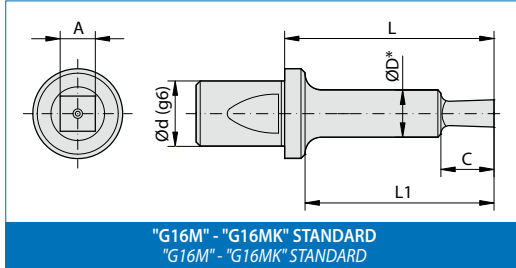


BROCCIE G16M E G16MC - DIAMETRO "d" DEL GAMBO: 16 mm
G16M AND G16MC BROACHES - 16 mm SHANK DIAMETER ("d")

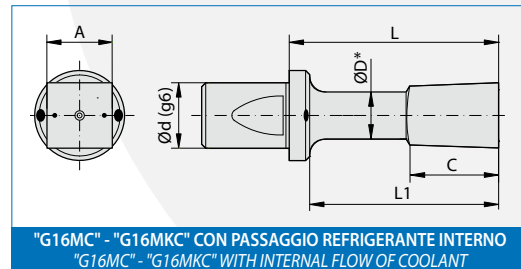
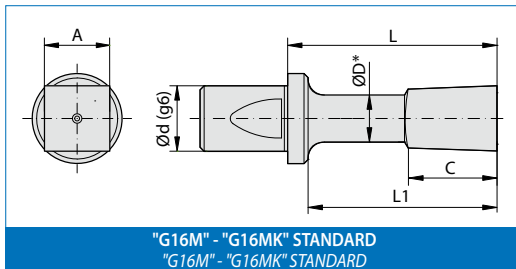
**Per Brocciatori /
 For Broaching Heads
 BR-G16M**



Sezione QUADRA (Q)
SQUARE section (Q)



ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS						Utilizzo su Brocciatori/ Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L1	L	C	D*	
Standard <input type="checkbox"/>	Ref. / Cool. <input type="checkbox"/>	Standard <input type="checkbox"/>	Ref. / Cool. <input type="checkbox"/>							Standard BR-G16M Refrig. / Cool. BRC-G16M
G16M-Q-5	/	G16MK-Q-5	/	16	5 +0,08 +0,10	11	35	11	10	
G16M-Q-5,5	/	G16MK-Q-5,5	/	16	5,5 +0,08 +0,10	11	35	13	10	
G16M-Q-6	G16MC-Q-6	G16MK-Q-6	G16MKC-Q-6	16	6 +0,08 +0,10	13	35	13	10	



G16M-Q-7	G16MC-Q-7	G16MK-Q-7	G16MKC-Q-7	16	7 +0,08 +0,10	31	35	14	4,2	Standard BR-G16M
G16M-Q-8	G16MC-Q-8	G16MK-Q-8	G16MKC-Q-8	16	8 +0,08 +0,10	31	35	14,5	5	
G16M-Q-9	G16MC-Q-9	G16MK-Q-9	G16MKC-Q-9	16	9 +0,09 +0,11	31	35	14,5	6	
G16M-Q-10	G16MC-Q-10	G16MK-Q-10	G16MKC-Q-10	16	10 +0,10 +0,12	31	35	14,5	7,2	
G16M-Q-11	G16MC-Q-11	G16MK-Q-11	G16MKC-Q-11	16	11 +0,10 +0,12	31	35	15	8	
G16M-Q-12	G16MC-Q-12	G16MK-Q-12	G16MKC-Q-12	16	12 +0,11 +0,13	31	35	15	9	
G16M-Q-13	G16MC-Q-13	G16MK-Q-13	G16MKC-Q-13	16	13 +0,11 +0,13	31	35	13,5	10	
G16M-Q-14	G16MC-Q-14	G16MK-Q-14	G16MKC-Q-14	16	14 +0,12 +0,14	31	35	13,5	11	
G16M-Q-15	G16MC-Q-15	G16MK-Q-15	G16MKC-Q-15	16	15 +0,13 +0,15	31	35	13,5	12	
G16M-Q-16	G16MC-Q-16	G16MK-Q-16	G16MKC-Q-16	16	16 +0,13 +0,15	31	35	13,5	13	
G16M-Q-17	G16MC-Q-17	G16MK-Q-17	G16MKC-Q-17	16	17 +0,14 +0,16	31	35	13	14	
G16M-Q-18	G16MC-Q-18	G16MK-Q-18	G16MKC-Q-18	16	18 +0,15 +0,17	31	35	13	15	
G16M-Q-19	G16MC-Q-19	G16MK-Q-19	G16MKC-Q-19	16	19 +0,16 +0,18	31	35	13	16	
G16M-Q-20	G16MC-Q-20	G16MK-Q-20	G16MKC-Q-20	16	20 +0,18 +0,20	31	35	13	17	Refrig. / Cool. BRC-G16M

C = Profondità utile di brocciatura / C = Depth of the shape
 L1 = Profondità max. di lavoro / L1 = Maximum broaching depth

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 Available coatings for the up above mentioned items: **WONDER, TiN, INOX PLUS and ZIRINOS** > see page 18



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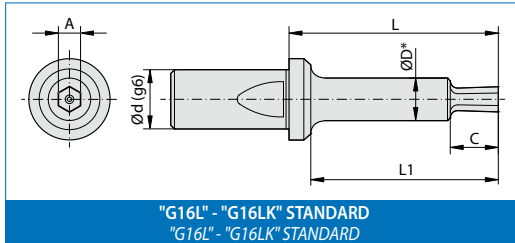


Per Brocciatori /
For Broaching Heads
BR-G16L

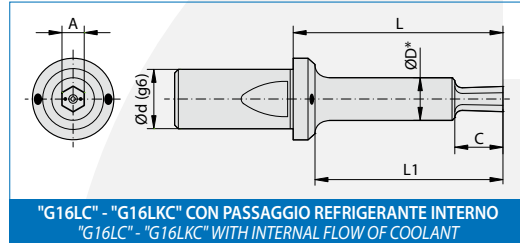


BROCCIE G16L E G16LC - DIAMETRO "d" DEL GAMBO: 16 mm
G16L AND G16LC BROACHES - 16 mm SHANK DIAMETER ("d")

Sezione ESAGONALE (E)
HEXAGONAL section (E)

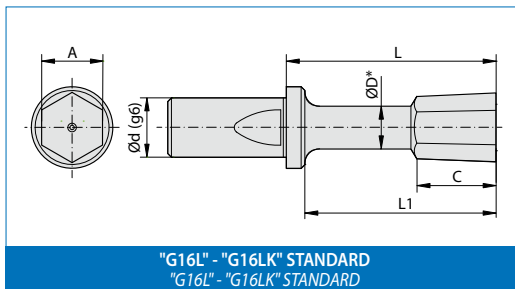


"G16L" - "G16LK" STANDARD
"G16L" - "G16LK" STANDARD

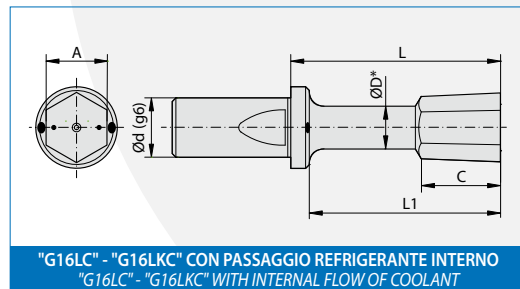


"G16LC" - "G16LKC" CON PASSAGGIO REFRIGERANTE INTERNO
"G16LC" - "G16LKC" WITH INTERNAL FLOW OF COOLANT

ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS						Utilizzo su Brocciatori / Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L1	L	C	D*	
Standard	Ref. / Cool.	Standard	Ref. / Cool.							Standard BR-G16L Refrig. / Cool. BRC-G16L
G16L-E-4	/	G16LK-E-4	/	16	4 +0,07+0,09	41	45	9	7,5	
G16L-E-5	/	G16LK-E-5	/	16	5 +0,08+0,10	41	45	13	9	
G16L-E-6	/	G16LK-E-6	/	16	6 +0,08+0,10	41	45	15	9	



"G16L" - "G16LK" STANDARD
"G16L" - "G16LK" STANDARD



"G16LC" - "G16LKC" CON PASSAGGIO REFRIGERANTE INTERNO
"G16LC" - "G16LKC" WITH INTERNAL FLOW OF COOLANT

G16L-E-7	/	G16LK-E-7	/	16	7 +0,08+0,10	41	45	16	6,5	Standard BR-G16L Refrig. / Cool. BRC-G16L
G16L-E-8	G16LC-E-8	G16LK-E-8	G16LKC-E-8	16	8 +0,08+0,10	41	45	16	6,5	
G16L-E-9	G16LC-E-9	G16LK-E-9	G16LKC-E-9	16	9 +0,09+0,11	41	45	16	7,5	
G16L-E-10	G16LC-E-10	G16LK-E-10	G16LKC-E-10	16	10 +0,10+0,12	41	45	15	7	
G16L-E-11	G16LC-E-11	G16LK-E-11	G16LKC-E-11	16	11 +0,10+0,12	41	45	15	8	
G16L-E-12	G16LC-E-12	G16LK-E-12	G16LKC-E-12	16	12 +0,11+0,13	41	45	15	9	
G16L-E-13	G16LC-E-13	G16LK-E-13	G16LKC-E-13	16	13 +0,11+0,13	41	45	15	10	
G16L-E-14	G16LC-E-14	G16LK-E-14	G16LKC-E-14	16	14 +0,12+0,14	41	45	15	11	
G16L-E-15	G16LC-E-15	G16LK-E-15	G16LKC-E-15	16	15 +0,13+0,15	41	45	15	12	
G16L-E-16	G16LC-E-16	G16LK-E-16	G16LKC-E-16	16	16 +0,13+0,15	41	45	15	13	
G16L-E-17	G16LC-E-17	G16LK-E-17	G16LKC-E-17	16	17 +0,14+0,16	41	45	15	14	
G16L-E-18	G16LC-E-18	G16LK-E-18	G16LKC-E-18	16	18 +0,15+0,17	41	45	15	15	
G16L-E-19	G16LC-E-19	G16LK-E-19	G16LKC-E-19	16	19 +0,16+0,18	41	45	15	16	
G16L-E-20	G16LC-E-20	G16LK-E-20	G16LKC-E-20	16	20 +0,18+0,20	41	45	17	17	
G16L-E-21	G16LC-E-21	G16LK-E-21	G16LKC-E-21	16	21 +0,18+0,20	41	45	17	18	
G16L-E-22	G16LC-E-22	G16LK-E-22	G16LKC-E-22	16	22 +0,19+0,21	41	45	17	19	
G16L-E-23	G16LC-E-23	G16LK-E-23	G16LKC-E-23	16	23 +0,20+0,22	41	45	17	20	
G16L-E-24	G16LC-E-24	G16LK-E-24	G16LKC-E-24	16	24 +0,21+0,23	41	45	17	21	

C = Profondità utile di brocciatura / C = Depth of the shape
L1 = Profondità max. di lavoro / L1 = Maximum broaching depth

segue / continued >>

In questi articoli possiamo eseguire i seguenti rivestimenti: **WONDER, TiN, INOX PLUS e ZIRINOS** > vedi pag.18
Available coatings for the up above mentioned items: **WONDER, TiN, INOX PLUS and ZIRINOS** > see page 18

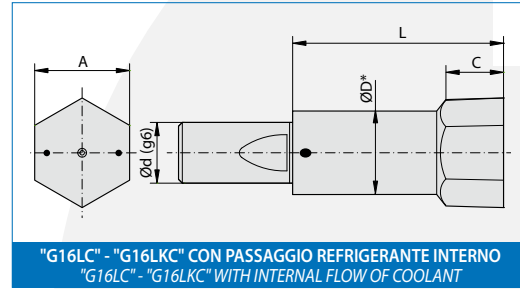
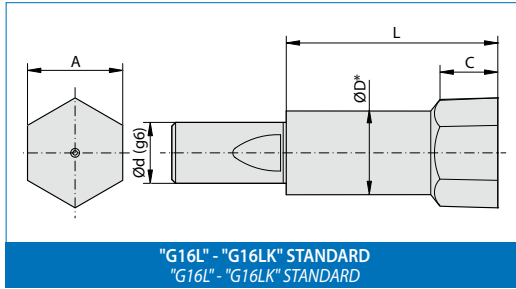


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>> segue / continued

BROCCHE G16L E G16LC - DIAMETRO "d" DEL GAMBO: 16 mm
G16L AND G16LC BROACHES - 16 mm SHANK DIAMETER ("d")



ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS					Utilizzo su Brocciatori/ Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L	C	D*	
Standard	Ref. / Cool.	Standard	Ref. / Cool.						
G16L-E-25	G16LC-E-25	G16LK-E-25	G16LKC-E-25	16	25 +0,22 +0,24	45	17	22	Standard BR-G16L Refrig. / Cool. BRC-G16L
G16L-E-27	G16LC-E-27	G16LK-E-27	G16LKC-E-27	16	27 +0,22 +0,24	45	17	22	
G16L-E-28	G16LC-E-28	G16LK-E-28	G16LKC-E-28	16	28 +0,22 +0,24	45	17	22	
G16L-E-30	G16LC-E-30	G16LK-E-30	G16LKC-E-30	16	30 +0,23 +0,25	45	17	22	

C = Profondità utile di brocciatura / C = Depth of the shape
 L1 = Profondità max. di lavoro / L1 = Maximum broaching depth

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 the dimension D can be modified according to the customer's needs. Contact Brighetti Meccanica.

In questi articoli possiamo eseguire i seguenti rivestimenti: **WONDER, TiN, INOX PLUS e ZIRINOS** > vedi pag.18
 Available coatings for the up above mentioned items: **WONDER, TiN, INOX PLUS and ZIRINOS** > see page 18

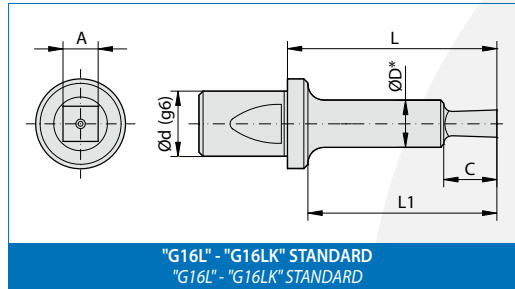


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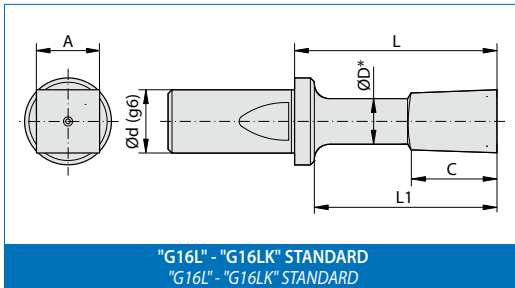
BROCCIE G16L E G16LC - DIAMETRO "d" DEL GAMBO: 16 mm
G16L AND G16LC BROACHES - 16 mm SHANK DIAMETER ("d")

Sezione QUADRA (Q)
SQUARE section (Q)

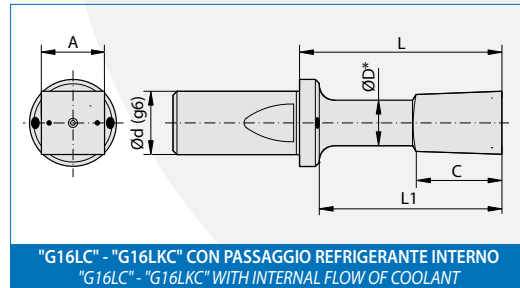


"G16L" - "G16LK" STANDARD
 "G16L" - "G16LK" STANDARD

ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS						Utilizzo su Brocciatori/ Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L1	L	C	D*	
Standard	Ref. / Cool.	Standard	Ref. / Cool.							
G16L-Q-6	/	G16LK-Q-6	/	16	6 +0,08+0,10	41	45	15	7,5	Standard BR-G16L Refrig./Cool. BRC-G16L



"G16L" - "G16LK" STANDARD
 "G16L" - "G16LK" STANDARD



"G16LC" - "G16LKC" CON PASSAGGIO REFRIGERANTE INTERNO
 "G16LC" - "G16LKC" WITH INTERNAL FLOW OF COOLANT

G16L-Q-7	/	G16LK-Q-7	/	16	7 +0,08+0,10	41	45	15	6	Standard BR-G16L Refrig./Cool. BRC-G16L
G16L-Q-8	/	G16LK-Q-8	/	16	8 +0,08+0,10	41	45	15	7	
G16L-Q-9	/	G16LK-Q-9	/	16	9 +0,09+0,11	41	45	15	8	
G16L-Q-10	G16LC-Q-10	G16LK-Q-10	G16LKC-Q-10	16	10 +0,10+0,12	41	45	17	7,2	
G16L-Q-11	G16LC-Q-11	G16LK-Q-11	G16LKC-Q-11	16	11 +0,10+0,12	41	45	17	8	
G16L-Q-12	G16LC-Q-12	G16LK-Q-12	G16LKC-Q-12	16	12 +0,11+0,13	41	45	17	9	
G16L-Q-13	G16LC-Q-13	G16LK-Q-13	G16LKC-Q-13	16	13 +0,11+0,13	41	45	18	10	
G16L-Q-14	G16LC-Q-14	G16LK-Q-14	G16LKC-Q-14	16	14 +0,12+0,14	41	45	18	11	
G16L-Q-15	G16LC-Q-15	G16LK-Q-15	G16LKC-Q-15	16	15 +0,13+0,15	41	45	18	12	
G16L-Q-16	G16LC-Q-16	G16LK-Q-16	G16LKC-Q-16	16	16 +0,13+0,15	41	45	18	13	
G16L-Q-17	G16LC-Q-17	G16LK-Q-17	G16LKC-Q-17	16	17 +0,14+0,16	41	45	18	14	
G16L-Q-18	G16LC-Q-18	G16LK-Q-18	G16LKC-Q-18	16	18 +0,15+0,17	41	45	17	15	
G16L-Q-19	G16LC-Q-19	G16LK-Q-19	G16LKC-Q-19	16	19 +0,16+0,18	41	45	17	16	
G16L-Q-20	G16LC-Q-20	G16LK-Q-20	G16LKC-Q-20	16	20 +0,18+0,20	41	45	17	17	
G16L-Q-21	G16LC-Q-21	G16LK-Q-21	G16LKC-Q-21	16	21 +0,18+0,20	41	45	17	18	
G16L-Q-22	G16LC-Q-22	G16LK-Q-22	G16LKC-Q-22	16	22 +0,19+0,21	41	45	16,5	18,5	
G16L-Q-23	G16LC-Q-23	G16LK-Q-23	G16LKC-Q-23	16	23 +0,20+0,22	41	45	16,5	19,5	

C = Profondità utile di brocciatura / C = Depth of the shape
 L1 = Profondità max. di lavoro / L1 = Maximum broaching depth

In questi articoli possiamo eseguire i seguenti rivestimenti: **WONDER, TiN, INOX PLUS e ZIRINOS** > vedi pag.18
 Available coatings for the up above mentioned items: **WONDER, TiN, INOX PLUS and ZIRINOS** > see page 18

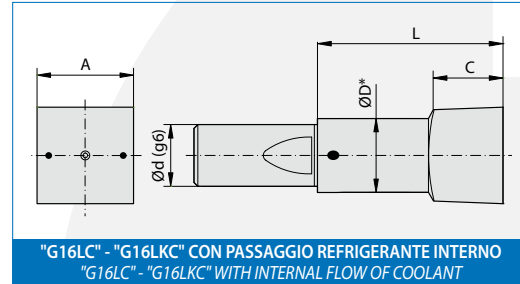
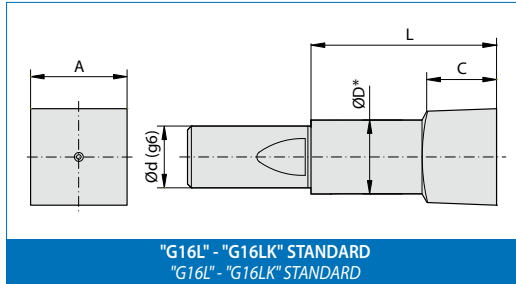


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>> segue / continued

BROCCHE G16L E G16LC - DIAMETRO "d" DEL GAMBO: 16 mm
 G16L AND G16LC BROACHES - 16 mm SHANK DIAMETER ("d")



ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS						Utilizzo su Brocciatori/ Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L1	L	C	D*	
Standard	Ref. / Cool.	Standard	Ref. / Cool.							
G16L-Q-24	G16LC-Q-24	G16LK-Q-24	G16LKC-Q-24	16	24 +0,21 +0,23	/	45	16	20	Standard BR-G16L
G16L-Q-25	G16LC-Q-25	G16LK-Q-25	G16LKC-Q-25	16	25 +0,22 +0,24	/	45	16	21	
										Refrig. / Cool. BRC-G16L

C = Profondità utile di brocciatura / C = Depth of the shape
 L1 = Profondità max. di lavoro / L1 = Maximum broaching depth

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 the dimension D can be modified according to the customer's needs. Contact Brighetti Meccanica.

In questi articoli possiamo eseguire i seguenti rivestimenti: **WONDER, TiN, INOX PLUS e ZIRINOS** > vedi pag.18
 Available coatings for the up above mentioned items: **WONDER, TiN, INOX PLUS and ZIRINOS** > see page 18



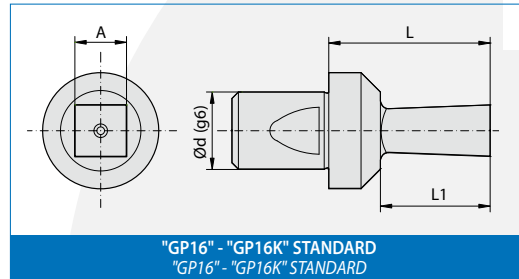
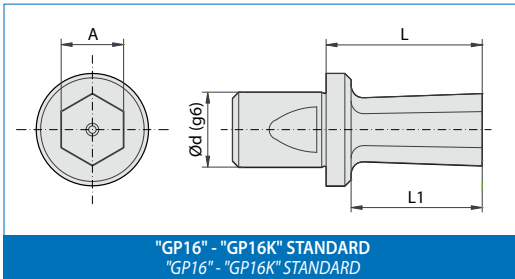
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BROCCE GP16 - DIAMETRO "d" DEL GAMBO: 16 mm - MISURE IN POLLICI
GP16 BROACHES - 16 mm SHANK DIAMETER ("d") - SIZES IN INCHES

Sezione ESAGONALE standard (E)
Standard HEXAGONAL section (E)

Sezione QUADRA standard (Q)
Standard SQUARE section (Q)



ESAGONALE / HEXAGONAL	
ARTICOLO (materiale) ITEM (material)	
HSS	SINTERIZZATO SINTERED
Standard	Standard
GP16-E-3/32"	GP16K-E-3/32"
GP16-E-1/8"	GP16K-E-1/8"
GP16-E-5/32"	GP16K-E-5/32"
GP16-E-3/16"	GP16K-E-3/16"
GP16-E-7/32"	GP16K-E-7/32"
GP16-E-1/4"	GP16K-E-1/4"
GP16-E-9/32"	GP16K-E-9/32"
GP16-E-5/16"	GP16K-E-5/16"
GP16-E-3/8"	GP16K-E-3/8"
GP16-E-7/16"	GP16K-E-7/16"
GP16-E-1/2"	GP16K-E-1/2"
GP16-E-9/16"	GP16K-E-9/16"
GP16-E-5/8"	GP16K-E-5/8"
GP16-E-3/4"	GP16K-E-3/4"
GP16-E-7/8"	GP16K-E-7/8"
GP16-E-1"	GP16K-E-1"

QUADRA / SQUARE	
ARTICOLO (materiale) ITEM (material)	
HSS	SINTERIZZATO SINTERED
Standard	Standard
GP16-Q-3/32"	GP16K-Q-3/32"
GP16-Q-1/8"	GP16K-Q-1/8"
GP16-Q-5/32"	GP16K-Q-5/32"
GP16-Q-3/16"	GP16K-Q-3/16"
GP16-Q-7/32"	GP16K-Q-7/32"
GP16-Q-1/4"	GP16K-Q-1/4"
GP16-Q-9/32"	GP16K-Q-9/32"
GP16-Q-5/16"	GP16K-Q-5/16"
GP16-Q-3/8"	GP16K-Q-3/8"
GP16-Q-7/16"	GP16K-Q-7/16"
GP16-Q-1/2"	GP16K-Q-1/2"
GP16-Q-9/16"	GP16K-Q-9/16"
GP16-Q-5/8"	GP16K-Q-5/8"
/	/

DIMENSIONI - DIMENSIONS				Utilizzo su Brocciatori/ Use on Broaching heads
d	A	L1	L	
16	2,38 +0,06 +0,08	5	25	Standard BR-G16
16	3,17 +0,07 +0,09	6	25	
16	3,97 +0,08 +0,10	8	25	
16	4,76 +0,08 +0,10	9	25	
16	5,55 +0,08 +0,10	11	25	
16	6,35 +0,08 +0,10	15	25	
16	7,14 +0,09 +0,11	16	25	
16	7,93 +0,09 +0,11	16	25	
16	9,52 +0,10 +0,12	18	25	
16	11,11 +0,11 +0,13	21	25	
16	12,70 +0,12 +0,14	21	25	
16	14,28 +0,12 +0,14	21	25	
16	15,87 +0,13 +0,15	21	25	
16	19,05 +0,17 +0,19	21	25	
16	22,22 +0,21 +0,23	21	25	
16	25,40 +0,22 +0,24	21	25	

In questi articoli possiamo eseguire i seguenti rivestimenti: **WONDER, TiN, INOX PLUS e ZIRINOS** > vedi pag.18
 Available coatings for the up above mentioned items: **WONDER, TiN, INOX PLUS and ZIRINOS** > see page 18



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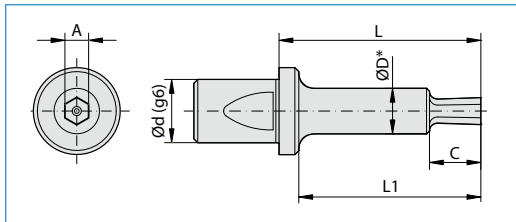
**BROCCHE GP16M E GP16MC - DIAMETRO "d" DEL GAMBO: 16 mm
MISURE IN POLLICI**

GP16M AND GP16MC BROACHES - 16 mm SHANK DIAMETER ("d")
SIZES IN INCHES

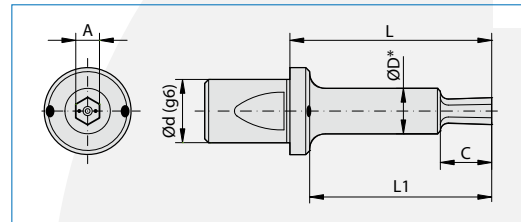
**Per Brocciatori /
For Broaching Heads
BR-G16M**



**Sezione ESAGONALE (E)
HEXAGONAL section (E)**

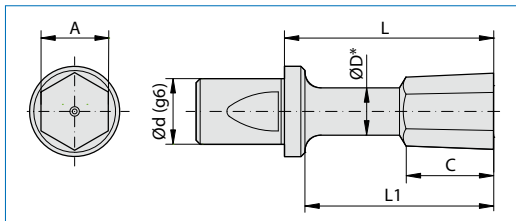


"GP16M" - "GP16MK" STANDARD
"GP16M" - "GP16MK" STANDARD

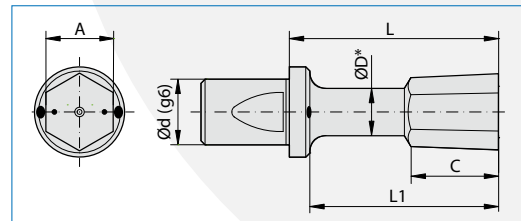


"GP16MC" - "GP16MK" CON PASSAGGIO REFRIGERANTE INTERNO
"GP16MC" - "GP16MK" WITH INTERNAL FLOW OF COOLANT

ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS						Utilizzo su Brocciatori / Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L1	L	C	D*	
Standard	Ref. / Cool.	Standard	Ref. / Cool.							
GP16M-E-1/4"	GP16MC-E-1/4"	GP16MK-E-1/4"	GP16MKC-E-1/4"	16	6,35 +0,08 +0,10	15	35	13	9,4	Standard BR-G16M Refrig. / Cool. BRC-G16M
GP16M-E-9/32"	GP16MC-E-9/32"	GP16MK-E-9/32"	GP16MKC-E-9/32"	16	7,14 +0,09 +0,11	16	35	15	9,4	



"GP16M" - "GP16MK" STANDARD
"GP16M" - "GP16MK" STANDARD



"GP16MC" - "GP16MK" CON PASSAGGIO REFRIGERANTE INTERNO
"GP16MC" - "GP16MK" WITH INTERNAL FLOW OF COOLANT

GP16M-E-5/16"	GP16MC-E-5/16"	GP16MK-E-5/16"	GP16MKC-E-5/16"	16	7,93 +0,09 +0,11	16	35	16	5,8	Standard BR-G16M
GP16M-E-3/8"	GP16MC-E-3/8"	GP16MK-E-3/8"	GP16MKC-E-3/8"	16	9,52 +0,10 +0,12	18	35	15	8	
GP16M-E-7/16"	GP16MC-E-7/16"	GP16MK-E-7/16"	GP16MKC-E-7/16"	16	11,11 +0,11 +0,13	31	35	15	9	Refrig. / Cool. BRC-G16M
GP16M-E-1/2"	GP16MC-E-1/2"	GP16MK-E-1/2"	GP16MKC-E-1/2"	16	12,70 +0,12 +0,14	31	35	15	11	
GP16M-E-9/16"	GP16MC-E-9/16"	GP16MK-E-9/16"	GP16MKC-E-9/16"	16	14,28 +0,12 +0,14	31	35	15	12	Refrig. / Cool. BRC-G16M
GP16M-E-5/8"	GP16MC-E-5/8"	GP16MK-E-5/8"	GP16MKC-E-5/8"	16	15,87 +0,13 +0,15	31	35	15	14	
GP16M-E-3/4"	GP16MC-E-3/4"	GP16MK-E-3/4"	GP16MKC-E-3/4"	16	19,05 +0,17 +0,19	31	35	13,5	17	Refrig. / Cool. BRC-G16M
GP16M-E-7/8"	GP16MC-E-7/8"	GP16MK-E-7/8"	GP16MKC-E-7/8"	16	22,22 +0,21 +0,23	31	35	13	20	
GP16M-E-1"	GP16MC-E-1"	GP16MK-E-1"	GP16MKC-E-1"	16	25,40 +0,22 +0,24	31	35	11,5	22	

C = Profondità utile di brocciatura / C = Depth of the shape
L1 = Profondità max. di lavoro / L1 = Maximum broaching depth

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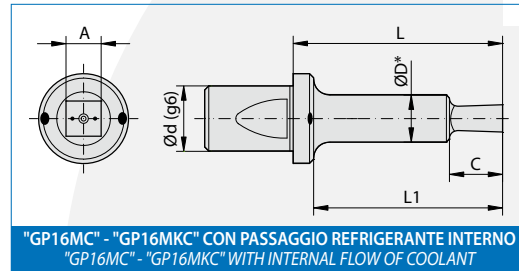
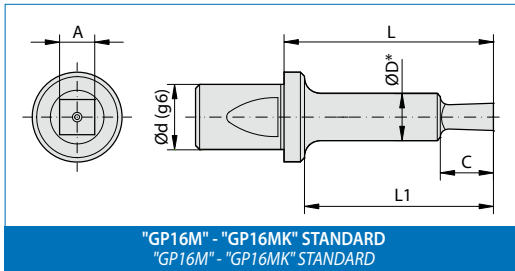


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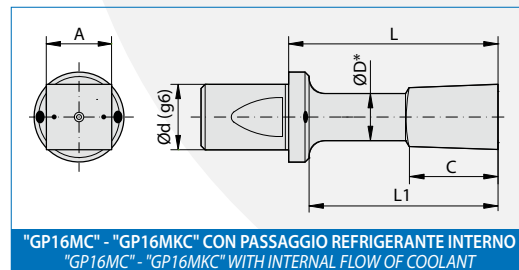
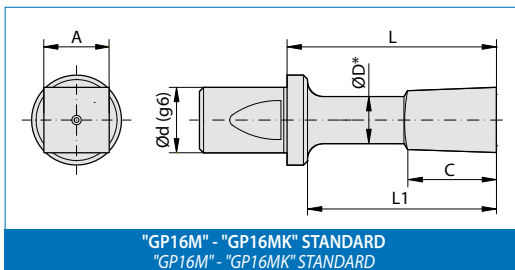


BROCCHE GP16M E GP16MC - DIAMETRO "d" DEL GAMBO: 16 mm
MISURE IN POLLICI
GP16M AND GP16MC BROACHES - 16 mm SHANK DIAMETER ("d")
SIZES IN INCHES

Sezione QUADRA (Q)
SQUARE section (Q)



ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS						Utilizzo su Brocciatori / Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L1	L	C	D*	
Standard <input type="checkbox"/>	Ref. / Cool. <input type="checkbox"/>	Standard <input type="checkbox"/>	Ref. / Cool. <input type="checkbox"/>							Standard BR-G16M Refrig. / Cool. BRC-G16M
GP16M-Q-1/4"	GP16MC-Q-1/4"	GP16MK-Q-1/4"	GP16MKC-Q-1/4"	16	6,35 +0,08 +0,10	15	35	13	10	



GP16M-Q-9/32"	GP16MC-Q-9/32"	GP16MK-Q-9/32"	GP16MKC-Q-9/32"	16	7,14 +0,09 +0,11	16	35	14	4,2	Standard BR-G16M
GP16M-Q-5/16"	GP16MC-Q-5/16"	GP16MK-Q-5/16"	GP16MKC-Q-5/16"	16	7,93 +0,09 +0,11	16	35	14,5	5	
GP16M-Q-3/8"	GP16MC-Q-3/8"	GP16MK-Q-3/8"	GP16MKC-Q-3/8"	16	9,52 +0,10 +0,12	18	35	14,5	7,2	Refrig. / Cool. BRC-G16M
GP16M-Q-7/16"	GP16MC-Q-7/16"	GP16MK-Q-7/16"	GP16MKC-Q-7/16"	16	11,11 +0,11 +0,13	31	35	15	8	
GP16M-Q-1/2"	GP16MC-Q-1/2"	GP16MK-Q-1/2"	GP16MKC-Q-1/2"	16	12,70 +0,12 +0,14	31	35	13,5	10	Refrig. / Cool. BRC-G16M
GP16M-Q-9/16"	GP16MC-Q-9/16"	GP16MK-Q-9/16"	GP16MKC-Q-9/16"	16	14,28 +0,12 +0,14	31	35	13,5	11	
GP16M-Q-5/8"	GP16MC-Q-5/8"	GP16MK-Q-5/8"	GP16MKC-Q-5/8"	16	15,87 +0,13 +0,15	31	35	13,5	13	
GP16M-Q-3/4"	GP16MC-Q-3/4"	GP16MK-Q-3/4"	GP16MKC-Q-3/4"	16	19,05 +0,17 +0,19	31	35	13	16	

C = Profondità utile di brocciatura / C = Depth of the shape
 L1 = Profondità max. di lavoro / L1 = Maximum broaching depth

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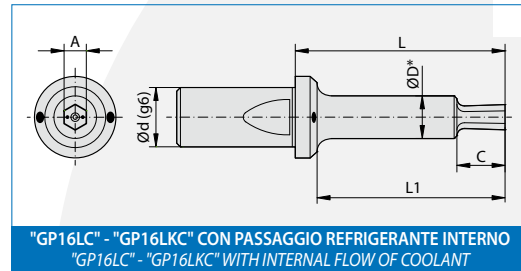
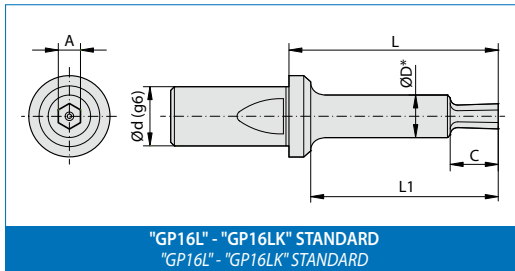


**BROCCHE GP16L E GP16LC - DIAMETRO "d" DEL GAMBO: 16 mm
MISURE IN POLLICI**
GP16L AND GP16LC BROACHES - 16 mm SHANK DIAMETER ("d")
SIZES IN INCHES

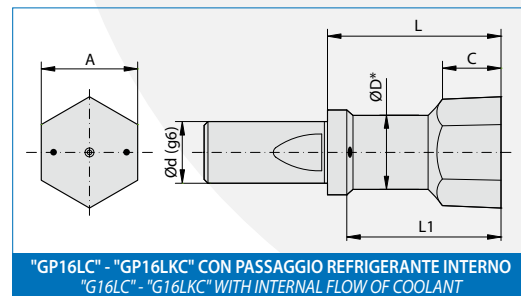
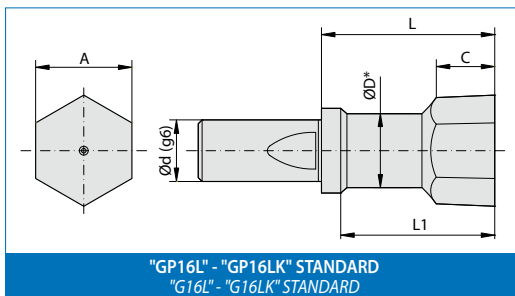
Per Brocciatori /
For Broaching Heads
BR-G16L



Sezione ESAGONALE (E) / HEXAGONAL section (E)



ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS						Utilizzo su Brocciatori/ Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L1	L	C	D*	
Standard	Ref. / Cool.	Standard	Ref. / Cool.							Standard BR-G16L Refrig. / Cool. BRC-G16L
GP16L-E-1/4"	GP16LC-E-1/4"	GP16LK-E-1/4"	GP16LKC-E-1/4"	16	6,35 +0,08 +0,10	41	45	13	9	
GP16L-E-9/32"	GP16LC-E-9/32"	GP16LK-E-9/32"	GP16LKC-E-9/32"	16	7,14 +0,09 +0,11	41	45	15	9	
GP16L-E-5/16"	GP16LC-E-5/16"	GP16LK-E-5/16"	GP16LKC-E-5/16"	16	7,93 +0,09 +0,11	41	45	16	9	
GP16L-E-3/8"	GP16LC-E-3/8"	GP16LK-E-3/8"	GP16LKC-E-3/8"	16	9,52 +0,10 +0,12	41	45	17	9	



GP16L-E-7/16"	GP16LC-E-7/16"	GP16LK-E-7/16"	GP16LKC-E-7/16"	16	11,11 +0,11 +0,13	41	45	17	9	Standard BR-G16L
GP16L-E-1/2"	GP16LC-E-1/2"	GP16LK-E-1/2"	GP16LKC-E-1/2"	16	12,70 +0,12 +0,14	41	45	17	10,5	
GP16L-E-9/16"	GP16LC-E-9/16"	GP16LK-E-9/16"	GP16LKC-E-9/16"	16	14,28 +0,12 +0,14	41	45	17	12,5	Refrig. / Cool. BRC-G16L
GP16L-E-5/8"	GP16LC-E-5/8"	GP16LK-E-5/8"	GP16LKC-E-5/8"	16	15,87 +0,13 +0,15	41	45	17	13,5	
GP16L-E-3/4"	GP16LC-E-3/4"	GP16LK-E-3/4"	GP16LKC-E-3/4"	16	19,05 +0,17 +0,19	41	45	17	16,5	
GP16L-E-7/8"	GP16LC-E-7/8"	GP16LK-E-7/8"	GP16LKC-E-7/8"	16	22,22 +0,21 +0,23	41	45	17	19,5	
GP16L-E-1"	GP16LC-E-1"	GP16LK-E-1"	GP16LKC-E-1"	16	25,40 +0,22 +0,24	41	45	17	21,5	

C = Profondità utile di brocciatura / C = Depth of the shape
L1 = Profondità max. di lavoro / L1 = Maximum broaching depth

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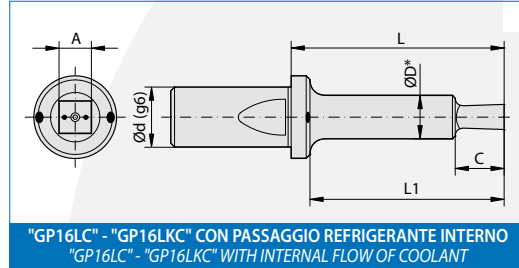
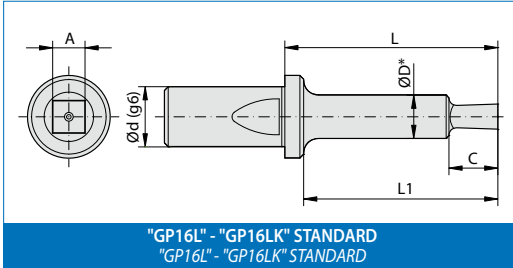


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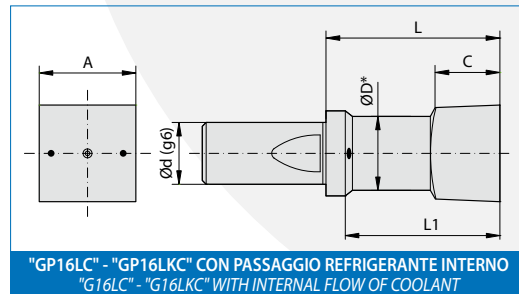
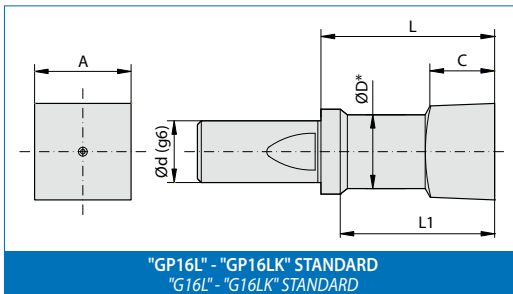


BROCCHE GP16L E GP16LC - DIAMETRO "d" DEL GAMBO: 16 mm
MISURE IN POLLICI
GP16L AND GP16LC BROACHES - 16 mm SHANK DIAMETER ("d")
SIZES IN INCHES

Sezione QUADRA (Q) / SQUARE section (Q)



ARTICOLO (materiale) - ITEM (material)				DIMENSIONI - DIMENSIONS						Utilizzo su Brocciatori / Use on Broaching heads
HSS		SINTERIZZATO / SINTERED		d	A	L1	L	C	D*	
Standard <input type="checkbox"/>	Ref. / Cool. <input type="checkbox"/>	Standard <input type="checkbox"/>	Ref. / Cool. <input type="checkbox"/>							Standard BR-G16L Refrig. / Cool. BRC-G16L
GP16L-Q-1/4"	/	GP16LK-Q-1/4"	/	16	6,35 +0,08 +0,10	41	45	13	9	
GP16L-Q-9/32"		GP16LK-Q-9/32"		16	7,14 +0,09 +0,11	41	45	15	9	
GP16L-Q-5/16"		GP16LK-Q-5/16"		16	7,93 +0,09 +0,11	41	45	16	9	
GP16L-Q-3/8"	GP16LC-Q-3/8"	GP16LK-Q-3/8"	GP16LKC-Q-3/8"	16	9,52 +0,10 +0,12	41	45	17	9	



GP16L-Q-7/16"	GP16LC-Q-7/16"	GP16LK-Q-7/16"	GP16LKC-Q-7/16"	16	11,11 +0,11 +0,13	41	45	17	9	Standard BR-G16L
GP16L-Q-1/2"	GP16LC-Q-1/2"	GP16LK-Q-1/2"	GP16LKC-Q-1/2"	16	12,70 +0,12 +0,14	41	45	17	10,5	
GP16L-Q-9/16"	GP16LC-Q-9/16"	GP16LK-Q-9/16"	GP16LKC-Q-9/16"	16	14,28 +0,12 +0,14	41	45	17	12,5	Refrig. / Cool. BRC-G16L
GP16L-Q-5/8"	GP16LC-Q-5/8"	GP16LK-Q-5/8"	GP16LKC-Q-5/8"	16	15,87 +0,13 +0,15	41	45	17	13,5	
GP16L-Q-3/4"	GP16LC-Q-3/4"	GP16LK-Q-3/4"	GP16LKC-Q-3/4"	16	19,05 +0,17 +0,19	41	45	17	16,5	
GP16L-Q-7/8"	GP16LC-Q-7/8"	GP16LK-Q-7/8"	GP16LKC-Q-7/8"	16	22,22 +0,21 +0,23	41	45	17	19,5	
GP16L-Q-1"	GP16LC-Q-1"	GP16LK-Q-1"	GP16LKC-Q-1"	16	25,40 +0,22 +0,24	41	45	17	21,5	

C = Profondità utile di brocciatura / C = Depth of the shape
 L1 = Profondità max. di lavoro / L1 = Maximum broaching depth

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Brocche Standard e con passaggio refrigerante per chiavi TORX® Standard Broaches and with internal flow of coolant for TORX® wrenches

per Brocciatori Standard serie "BR"
for "BR" Standard Broaching Heads series

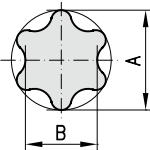


per Brocciatori serie "BRC"
for Broaching Heads "BRC" series



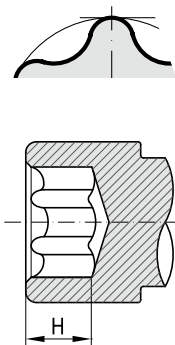
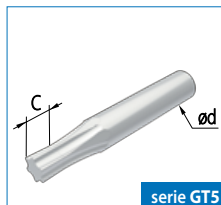
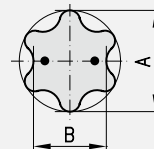
I L'originale disegno delle cave per chiavi TORX® consente, in dimensioni contenute, di esercitare una coppia di serraggio molto elevata senza compromettere l'integrità della cava.

GB The original design of the holes for TORX® wrenches makes it possible to exert a very high torque, despite the limited dimensions, without damaging the hole.



I Brocche per realizzazione di cave per chiavi TORX® per utilizzo su brocciatori serie "BRC" con passaggio refrigerante interno per poter avere una maggiore durata della broccia, una minore rugosità e poter lavorare materiali molto tenaci.

GB Broaches for TORX profiles suitable for broaching heads BRC series with internal flow of coolant. The flow of coolant increases the broach productivity, assures a minor roughness on the work-piece and helps to machine harder materials.



					per brocciatori serie for broaching heads BR-G5		per brocciatori serie for broaching heads BR-G8S / BR-G8M / BR-G8 / BR-G8A BRC-G8M / BRC-G8 / BRC-G8HP			
					ød = 5		ød = 8 / L = 18			
					ARTICOLO (materiale) ITEM (material)		ARTICOLO (materiale) ITEM (material)			
A	B	C	H max (*)	TORX®	HSS	SINTERIZ.	HSS		SINTERIZZATO / SINTERED	
					Standard	Standard	Standard	Ref. / Cool.	Standard	Ref. / Cool.
1,214	0,884	1,2	0,40	3	GT5-T3	GT5K-T3	GT8-T3		GT8K-T3	
1,374	0,996	1,2	0,50	4	GT5-T4	GT5K-T4	GT8-T4		GT8K-T4	
1,499	1,097	1,5	1,00	5	GT5-T5	GT5K-T5	GT8-T5	/	GT8K-T5	/
1,778	1,293	1,7	1,20	6	GT5-T6	GT5K-T6	GT8-T6		GT8K-T6	
2,095	1,521	1,7	1,50	7	GT5-T7	GT5K-T7	GT8-T7		GT8K-T7	
2,418	1,756	2,0	1,70	8	GT5-T8	GT5K-T8	GT8-T8	GT8C-T8	GT8K-T8	GT8KC-T8
2,603	1,889	2,0	1,70	9	GT5-T9	GT5K-T9	GT8-T9	GT8C-T9	GT8K-T9	GT8KC-T9
2,844	2,057	2,0	2,00	10	GT5-T10	GT5K-T10	GT8-T10	GT8C-T10	GT8K-T10	GT8KC-T10
3,378	2,438	3,0	3,00	15	GT5-T15	GT5K-T15	GT8-T15	GT8C-T15	GT8K-T15	GT8KC-T15
3,962	2,857	3,5	3,00	20	GT5-T20	GT5K-T20	GT8-T20	GT8C-T20	GT8K-T20	GT8KC-T20
4,559	3,276	4,0	3,50	25	GT5-T25	GT5K-T25	GT8-T25	GT8C-T25	GT8K-T25	GT8KC-T25
5,118	3,672	4,0	3,50	27			GT8-T27	GT8C-T27	GT8K-T27	GT8KC-T27
5,651	4,064	4,5	3,50	30	/	/	GT8-T30	GT8C-T30	GT8K-T30	GT8KC-T30
6,807	4,889	5,0	4,00	40			GT8-T40	GT8C-T40	GT8K-T40	GT8KC-T40



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					per brocciatori serie for broaching heads BR-G12 / BR-G12B / BR-G12A / BRC-G12 / BRC-G12B				per brocciatori serie for broaching heads BR-G16		
					ød = 12 / L = 25				ød = 16 / L = 25		
A	B	C	H max (*)	TORX®	ARTICOLO (materiale) ITEM (material)				ARTICOLO (materiale) ITEM (material)		
					HSS		SINTERIZZATO / SINTERED		HSS		SINTERIZ.
					Standard	Ref. / Cool.	Standard	Ref. / Cool.	Standard	Standard	
1,214	0,884	1,2	0,40	3	GT12-T3			GT12K-T3			
1,374	0,996	1,2	0,50	4	GT12-T4			GT12K-T4			
1,499	1,097	1,5	1,00	5	GT12-T5	/		GT12K-T5	/		
1,778	1,293	1,7	1,20	6	GT12-T6			GT12K-T6		/	
2,095	1,521	1,7	1,50	7	GT12-T7			GT12K-T7		/	
2,418	1,756	2,0	1,70	8	GT12-T8	GT12C-T8		GT12K-T8	GT12KC-T8		
2,603	1,889	2,0	1,70	9	GT12-T9	GT12C-T9		GT12K-T9	GT12KC-T9		
2,844	2,057	2,0	2,00	10	GT12-T10	GT12C-T10		GT12K-T10	GT12KC-T10	GT16-T10	
3,378	2,438	3,0	3,00	15	GT12-T15	GT12C-T15		GT12K-T15	GT12KC-T15	GT16-T15	
3,962	2,857	3,5	3,00	20	GT12-T20	GT12C-T20		GT12K-T20	GT12KC-T20	GT16-T20	
4,559	3,276	4,0	3,50	25	GT12-T25	GT12C-T25		GT12K-T25	GT12KC-T25	GT16-T25	
5,118	3,672	4,0	3,50	27	GT12-T27	GT12C-T27		GT12K-T27	GT12KC-T27	GT16-T27	
5,651	4,064	4,5	3,50	30	GT12-T30	GT12C-T30		GT12K-T30	GT12KC-T30	GT16-T30	
6,807	4,889	5,0	4,00	40	GT12-T40	GT12C-T40		GT12K-T40	GT12KC-T40	GT16-T40	
7,975	5,689	5,5	5,20	45	GT12-T45	GT12C-T45		GT12K-T45	GT12KC-T45	GT16-T45	
8,991	6,502	6,0	6,00	50	GT12-T50	GT12C-T50		GT12K-T50	GT12KC-T50	GT16-T50	
11,404	8,089	7,0	7,00	55	GT12-T55	GT12C-T55		GT12K-T55	GT12KC-T55	GT16-T55	
13,487	9,677	7,5	7,50	60	GT12-T60	GT12C-T60		GT12K-T60	GT12KC-T60	GT16-T60	
15,773	11,264	8,0	8,00	70	/	/		/	/	GT16-T70	

					per brocciatori serie for broaching heads BR-G16M / BRC-G16M				per brocciatori serie for broaching heads BR-G16L / BRC-G16L			
					ød = 16 / L = 35				ød = 16 / L = 45			
A	B	C	H max (*)	TORX®	ARTICOLO (materiale) ITEM (material)				ARTICOLO (materiale) ITEM (material)			
					HSS		SINTERIZZATO / SINTERED		HSS		SINTERIZZATO / SINTERED	
					Standard	Ref. / Cool.	Standard	Ref. / Cool.	Standard	Ref. / Cool.	Standard	Ref. / Cool.
3,962	2,857	3,5	3,00	20	GT16M-T20	GT16MC-T20	GT16MK-T20	GT16MKC-T20				
4,559	3,276	4,0	3,50	25	GT16M-T25	GT16MC-T25	GT16MK-T25	GT16MKC-T25	/	/	/	/
5,118	3,672	4,0	3,50	27	GT16M-T27	GT16MC-T27	GT16MK-T27	GT16MKC-T27				
5,651	4,064	4,5	3,50	30	GT16M-T30	GT16MC-T30	GT16MK-T30	GT16MKC-T30	GT16L-T30	GT16LC-T30	GT16LK-T30	GT16LKC-T30
6,807	4,889	5,0	4,00	40	GT16M-T40	GT16MC-T40	GT16MK-T40	GT16MKC-T40	GT16L-T40	GT16LC-T40	GT16LK-T40	GT16LKC-T40
7,975	5,689	5,5	5,20	45	GT16M-T45	GT16MC-T45	GT16MK-T45	GT16MKC-T45	GT16L-T45	GT16LC-T45	GT16LK-T45	GT16LKC-T45
8,991	6,502	6,0	6,00	50	GT16M-T50	GT16MC-T50	GT16MK-T50	GT16MKC-T50	GT16L-T50	GT16LC-T50	GT16LK-T50	GT16LKC-T50
11,404	8,089	7,0	7,00	55	GT16M-T55	GT16MC-T55	GT16MK-T55	GT16MKC-T55	GT16L-T55	GT16LC-T55	GT16LK-T55	GT16LKC-T55
13,487	9,677	7,5	7,50	60	GT16M-T60	GT16MC-T60	GT16MK-T60	GT16MKC-T60	GT16L-T60	GT16LC-T60	GT16LK-T60	GT16LKC-T60
15,773	11,264	8,0	8,00	70	GT16M-T70	GT16MC-T70	GT16MK-T70	GT16MKC-T70	GT16L-T70	GT16LC-T70	GT16LK-T70	GT16LKC-T70

(*) = quota di profondità MAX standard su impronta di vite commerciale / Measure of MAX standard depth imprint by commercial screws

In questi articoli possiamo eseguire i seguenti rivestimenti: **WONDER, TiN, INOX PLUS e ZIRINOS** > vedi pag.18
 Available coatings for the up above mentioned items: **WONDER, TiN, INOX PLUS and ZIRINOS** > see page 18



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2026/03/30



Brocche Standard e con passaggio refrigerante per chiavi TORX® PLUS Standard Broaches and with internal flow of coolant for TORX® PLUS wrenches

per Brocciatori Standard serie "BR"
for "BR" Standard Broaching Heads series

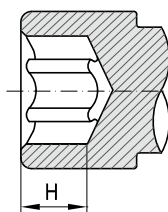
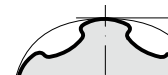
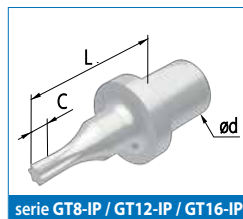
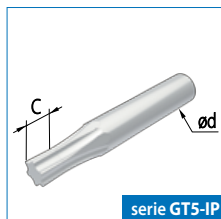
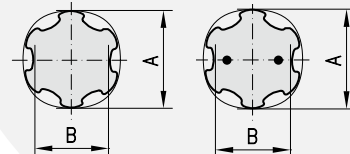


per Brocciatori serie "BRC"
for Broaching Heads "BRC" series



I Il profilo TORX® PLUS è un'evoluzione della precedente impronta TORX®. La variante TORX® PLUS consente una maggiore forza di presa sul pezzo e conseguentemente una elevata tenuta della coppia di serraggio. Ciò significa che l'impronta esalobata richiede una profondità della cava relativamente inferiore rispetto alla versione TORX® e nello stesso tempo garantisce più a lungo l'integrità della figura stessa. La geometria ellittica del profilo TORX® PLUS amplia la superficie di contatto consentendo un migliore e più efficace accoppiamento della chiave con la cava esalobata. In questo modo si garantisce una riduzione dello stress di torsione e di conseguenza una vita più lunga dell'utensile. Anche per il profilo TORX e TORX PLUS esiste la versione per brocciatori serie "BRC" che consente di poter lavorare materiali molto tenaci e avere una maggiore durata della broccia e una minore rugosità della cava.

GB TORX® PLUS profile is an enhancement of the older TORX® shape. TORX® PLUS drive system maximizes engagement between driver and fastener and optimizes torque transmission. This means the depth of the profile can be shorter than TORX® old version, even if at the same time TORX® PLUS assures a much longer life of the tools. The elliptically based geometry of the TORX® PLUS profile broadens contact surface guaranteeing a better engagement between driver and fastener than old TORX® shape. This feature virtually eliminates radial stresses and increase tool life. Broaches suitable for broaching heads with internal flow of coolant BRC series are available with TORX PLUS profiles too. The internal flow of coolant helps to machine harder materials and assures a higher broach productivity and a minor roughness on the work-piece.



					per brocciatori serie for broaching heads BR-G5		per brocciatori serie for broaching heads BR-G8S / BR-G8M / BR-G8 / BR-G8A BRC-G8M / BRC-G8 / BRC-G8HP			
					ød = 5		ød = 8 / L = 18			
					ARTICOLO (materiale) ITEM (material)		ARTICOLO (materiale) ITEM (material)			
					HSS	SINTERIZ.	HSS		SINTERIZZATO / SINTERED	
					Standard	Standard	Standard	Ref. / Cool.	Standard	Ref. / Cool.
1,778	1,381	1,7	1,20	6	GT5-IP6	GT5K-IP6	GT8-IP6	/	GT8K-IP6	/
2,095	1,606	1,7	1,50	7	GT5-IP7	GT5K-IP7	GT8-IP7	/	GT8K-IP7	/
2,418	1,860	2,0	1,70	8	GT5-IP8	GT5K-IP8	GT8-IP8	GT8C-IP8	GT8K-IP8	GT8KC-IP8
2,603	2,014	2,0	1,70	9	GT5-IP9	GT5K-IP9	GT8-IP9	GT8C-IP9	GT8K-IP9	GT8KC-IP9
2,844	2,174	2,0	2,00	10	GT5-IP10	GT5K-IP10	GT8-IP10	GT8C-IP10	GT8K-IP10	GT8KC-IP10
3,378	2,606	3,0	3,00	15	GT5-IP15	GT5K-IP15	GT8-IP15	GT8C-IP15	GT8K-IP15	GT8KC-IP15
3,962	3,088	3,5	3,00	20	GT5-IP20	GT5K-IP20	GT8-IP20	GT8C-IP20	GT8K-IP20	GT8KC-IP20
4,559	3,492	4,0	3,50	25	GT5-IP25	GT5K-IP25	GT8-IP25	GT8C-IP25	GT8K-IP25	GT8KC-IP25
5,651	4,391	4,5	3,50	30	/	/	GT8-IP30	GT8C-IP30	GT8K-IP30	GT8KC-IP30
6,807	5,283	5,0	4,00	40	/	/	GT8-IP40	GT8C-IP40	GT8K-IP40	GT8KC-IP40



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					per brocciatori serie for broaching heads BR-G12 / BR-G12B / BR-G12A / BRC-G12 / BRC-G12B				per brocciatori serie for broaching heads BR-G16			
					ød = 12 / L = 25				ød = 16 / L = 25			
A	B	C	H max (*)	TORX®	ARTICOLO (materiale) ITEM (material)				ARTICOLO (materiale) ITEM (material)			
					HSS		SINTERIZZATO / SINTERED		HSS		SINTERIZ.	
					Standard	Ref. / Cool.	Standard	Ref. / Cool.	Standard	Standard		
1,778	1,381	1,7	1,20	6	GT12-IP6		GT12K-IP6					
2,095	1,606	1,7	1,50	7	GT12-IP7	/	GT12K-IP7	/				
2,418	1,860	2,0	1,70	8	GT12-IP8	GT12C-IP8	GT12K-IP8	GT12KC-IP8	/	/		
2,603	2,014	2,0	1,70	9	GT12-IP9	GT12C-IP9	GT12K-IP9	GT12KC-IP9				
2,844	2,174	2,0	2,00	10	GT12-IP10	GT12C-IP10	GT12K-IP10	GT12KC-IP10	GT16-IP10	GT16K-IP10		
3,378	2,606	3,0	3,00	15	GT12-IP15	GT12C-IP15	GT12K-IP15	GT12KC-IP15	GT16-IP15	GT16K-IP15		
3,962	3,088	3,5	3,00	20	GT12-IP20	GT12C-IP20	GT12K-IP20	GT12KC-IP20	GT16-IP20	GT16K-IP20		
4,559	3,492	4,0	3,50	25	GT12-IP25	GT12C-IP25	GT12K-IP25	GT12KC-IP25	GT16-IP25	GT16K-IP25		
5,651	4,391	4,5	3,50	30	GT12-IP30	GT12C-IP30	GT12K-IP30	GT12KC-IP30	GT16-IP30	GT16K-IP30		
6,807	5,283	5,0	4,00	40	GT12-IP40	GT12C-IP40	GT12K-IP40	GT12KC-IP40	GT16-IP40	GT16K-IP40		
7,975	6,141	5,5	5,20	45	GT12-IP45	GT12C-IP45	GT12K-IP45	GT12KC-IP45	GT16-IP45	GT16K-IP45		
8,991	6,923	6,0	6,00	50	GT12-IP50	GT12C-IP50	GT12K-IP50	GT12KC-IP50	GT16-IP50	GT16K-IP50		
11,385	8,766	7,0	7,00	55	GT12-IP55	GT12C-IP55	GT12K-IP55	GT12KC-IP55	GT16-IP55	GT16K-IP55		
13,442	10,350	7,5	7,50	60	GT12-IP60	GT12C-IP60	GT12K-IP60	GT12KC-IP60	GT16-IP60	GT16K-IP60		
15,773	12,156	8,0	8,00	70	/	/	/	/	GT16-IP70	GT16K-IP70		

					per brocciatori serie for broaching heads BR-G16M / BRC-G16M				per brocciatori serie for broaching heads BR-G16L / BRC-G16L			
					ød = 16 / L = 35				ød = 16 / L = 45			
A	B	C	H max (*)	TORX®	ARTICOLO (materiale) ITEM (material)				ARTICOLO (materiale) ITEM (material)			
					HSS		SINTERIZZATO / SINTERED		HSS		SINTERIZZATO / SINTERED	
					Standard	Ref. / Cool.	Standard	Ref. / Cool.	Standard	Ref. / Cool.	Standard	Ref. / Cool.
3,962	3,088	3,5	3,00	20	GT16M-IP20	GT16MC-IP20	GT16MK-IP20	GT16MKC-IP20	/	/	/	/
4,559	3,492	4,0	3,50	25	GT16M-IP25	GT16MC-IP25	GT16MK-IP25	GT16MKC-IP25				
5,651	4,391	4,5	3,50	30	GT16M-IP30	GT16MC-IP30	GT16MK-IP30	GT16MKC-IP30	GT16L-IP30	GT16LC-IP30	GT16LK-IP30	GT16LKC-IP30
6,807	5,283	5,0	4,00	40	GT16M-IP40	GT16MC-IP40	GT16MK-IP40	GT16MKC-IP40	GT16L-IP40	GT16LC-IP40	GT16LK-IP40	GT16LKC-IP40
7,975	6,141	5,5	5,20	45	GT16M-IP45	GT16MC-IP45	GT16MK-IP45	GT16MKC-IP45	GT16L-IP45	GT16LC-IP45	GT16LK-IP45	GT16LKC-IP45
8,991	6,923	6,0	6,00	50	GT16M-IP50	GT16MC-IP50	GT16MK-IP50	GT16MKC-IP50	GT16L-IP50	GT16LC-IP50	GT16LK-IP50	GT16LKC-IP50
11,385	8,766	7,0	7,00	55	GT16M-IP55	GT16MC-IP55	GT16MK-IP55	GT16MKC-IP55	GT16L-IP55	GT16LC-IP55	GT16LK-IP55	GT16LKC-IP55
13,442	10,350	7,5	7,50	60	GT16M-IP60	GT16MC-IP60	GT16MK-IP60	GT16MKC-IP60	GT16L-IP60	GT16LC-IP60	GT16LK-IP60	GT16LKC-IP60
15,773	12,156	8,0	8,00	70	GT16M-IP70	GT16MC-IP70	GT16MK-IP70	GT16MKC-IP70	GT16L-IP70	GT16LC-IP70	GT16LK-IP70	GT16LKC-IP70

(*) = quota di profondità MAX standard su impronta di vite commerciale / Measure of MAX standard depth imprint by commercial screws

In questi articoli possiamo eseguire i seguenti rivestimenti: **WONDER, TiN, INOX PLUS e ZIRINOS** > vedi pag.18
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2026/03/30



BRIGHETTI MECCANICA

*Made in Italy
since 1977*





Pre-foro per brocciatura profili esagonali, quadri, Torx® e Torx® Plus

Pre-hole broaching: exagonal, square, Torx® and Torx® Plus

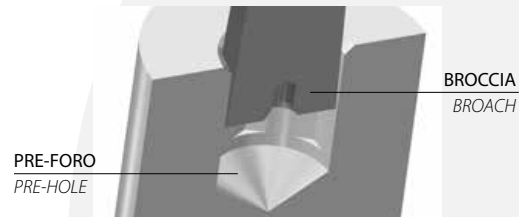
I Prima della procedura di brocciatura è fondamentale generare uno smusso in testa al pre foro. La profondità del pre-foro si incrementa del 20%-40% rispetto al profilo utile da eseguire. La soluzione ottimale, comunque, sarebbe quella di eseguire una gola di scarico alla fine del foro, per agevolare ulteriormente lo scarico del truciolo.

GB Before the broaching procedure it is essential to create a chamfer on the pre-hole. The depth of the pre-hole is increased by: 20% -40% compared to the profile to be obtained; the best solution, however, it's to get a chip discharge groove, at the end of the profile, to facilitate the chip evacuation.



BROCCHE ESAGONALI / EXAGONAL BROACHES

dimens.	PRE FORO / PRE-HOLE	dimens.	PRE FORO / PRE-HOLE
1	Ø 1,05 +0,10/0	19	Ø 20,60 +0,20/0
1,5	Ø 1,55 +0,10/0	20	Ø 19,55 +0,20/0
2	Ø 2,10 +0,10/0	21	Ø 21,60 +0,20/0
2,5	Ø 2,60 +0,10/0	22	Ø 22,65 +0,20/0
3	Ø 3,10 +0,10/0	23	Ø 23,65 +0,20/0
3,5	Ø 3,60 +0,10/0	24	Ø 24,70 +0,20/0
4	Ø 4,15 +0,10/0	25	Ø 25,75 +0,30/0
4,5	Ø 4,60 +0,10/0	26	Ø 26,80 +0,30/0
5	Ø 5,15 +0,10/0	27	Ø 27,80 +0,30/0
5,5	Ø 5,75 +0,10/0	28	Ø 28,85 +0,30/0
6	Ø 6,20 +0,10/0	29	Ø 29,90 +0,30/0
7	Ø 7,20 +0,15/0	30	Ø 30,90 +0,30/0
8	Ø 8,25 +0,15/0	31	Ø 32,00 +0,30/0
9	Ø 9,25 +0,15/0	32	Ø 33,20 +0,30/0
10	Ø 10,30 +0,15/0	33	Ø 34,30 +0,30/0
11	Ø 11,30 +0,15/0	34	Ø 35,35 +0,30/0
12	Ø 12,35 +0,15/0	35	Ø 36,40 +0,40/0
13	Ø 13,40 +0,15/0	36	Ø 37,45 +0,40/0
14	Ø 14,40 +0,15/0	37	Ø 38,50 +0,40/0
15	Ø 15,45 +0,20/0	38	Ø 39,50 +0,40/0
16	Ø 16,45 +0,20/0	39	Ø 40,65 +0,45/0
17	Ø 17,50 +0,20/0	40	Ø 42,00 +0,45/0
18	Ø 18,55 +0,20/0		



PRE-FORO
PRE-HOLE

BROCCIA
BROACH



BROCCHE QUADRE / SQUARE BROACHES

dimens.	PRE FORO / PRE-HOLE	dimens.	PRE FORO / PRE-HOLE
1	Ø 1,15 +0,05/0	11	Ø 12,90 +0,15/0
1,5	Ø 1,75 +0,05/0	12	Ø 14,20 +0,15/0
2	Ø 2,40 +0,05/0	13	Ø 15,50 +0,15/0
2,5	Ø 2,85 +0,05/0	14	Ø 16,90 +0,15/0
3	Ø 3,40 +0,05/0	15	Ø 18,20 +0,20/0
3,5	Ø 3,95 +0,05/0	16	Ø 19,50 +0,20/0
4	Ø 4,50 +0,05/0	17	Ø 20,60 +0,20/0
4,5	Ø 5,20 +0,05/0	18	Ø 21,70 +0,20/0
5	Ø 5,70 +0,10/0	19	Ø 23,00 +0,20/0
5,5	Ø 6,40 +0,10/0	20	Ø 24,10 +0,20/0
6	Ø 6,80 +0,10/0	21	Ø 25,30 +0,20/0
7	Ø 8,00 +0,10/0	22	Ø 26,50 +0,20/0
8	Ø 9,00 +0,10/0	23	Ø 27,70 +0,20/0
9	Ø 10,30 +0,10/0	24	Ø 28,90 +0,20/0
10	Ø 11,50 +0,15/0	25	Ø 30,00 +0,20/0



BROCCHE ESAGONALI IN POLLICI / EXAGONAL INCHES BROACHES

dimens.	PRE FORO / PRE-HOLE	dimens.	PRE FORO / PRE-HOLE
3/32"	Ø 2,45 +0,10/0	3/8"	Ø 9,80 +0,15/0
1/8"	Ø 3,25 +0,10/0	7/16"	Ø 11,50 +0,15/0
5/32"	Ø 4,10 +0,10/0	1/2"	Ø 13,10 +0,15/0
3/16"	Ø 4,90 +0,10/0	9/16"	Ø 14,70 +0,15/0
7/32"	Ø 5,70 +0,10/0	5/8"	Ø 16,35 +0,20/0
1/4"	Ø 6,55 +0,10/0	3/4"	Ø 19,60 +0,20/0
9/32"	Ø 7,35 +0,15/0	7/8"	Ø 22,90 +0,20/0
5/16"	Ø 8,15 +0,15/0	1"	Ø 26,30 +0,30/0



BROCCHE QUADRE IN POLLICI / SQUARE INCHES BROACHES

dimens.	PRE FORO / PRE-HOLE	dimens.	PRE FORO / PRE-HOLE
3/32"	Ø 2,80 +0,05/0	3/8"	Ø 11,10 +0,15/0
1/8"	Ø 3,80 +0,05/0	7/16"	Ø 13,10 +0,15/0
5/32"	Ø 4,50 +0,05/0	1/2"	Ø 15,30 +0,15/0
3/16"	Ø 5,50 +0,10/0	9/16"	Ø 17,40 +0,20/0
7/32"	Ø 6,40 +0,10/0	5/8"	Ø 19,50 +0,20/0
1/4"	Ø 7,25 +0,10/0	3/4"	Ø 23,00 +0,25/0
9/32"	Ø 8,00 +0,10/0	7/8"	Ø 27,10 +0,25/0
5/16"	Ø 9,00 +0,10/0	1"	Ø 31,00 +0,25/0



BROCCHE TORX / TORX BROACHES

dimens.	PRE FORO / PRE-HOLE	dimens.	PRE FORO / PRE-HOLE
T3	Ø 0,95 +0,05/0	T25	Ø 3,40 +0,10/0
T4	Ø 1,05 +0,05/0	T27	Ø 3,80 +0,10/0
T5	Ø 1,20 +0,05/0	T30	Ø 4,15 +0,10/0
T6	Ø 1,40 +0,10/0	T40	Ø 5,10 +0,15/0
T7	Ø 1,60 +0,10/0	T45	Ø 6,00 +0,15/0
T8	Ø 1,90 +0,10/0	T50	Ø 6,85 +0,20/0
T9	Ø 1,95 +0,10/0	T55	Ø 9,10 +0,20/0
T10	Ø 2,20 +0,10/0	T60	Ø 11,10 +0,20/0
T15	Ø 2,60 +0,10/0	T70	Ø 13,40 +0,20/0
T20	Ø 3,00 +0,10/0		



BROCCHE TORX PLUS / TORX PLUS BROACHES

dimens.	PRE FORO / PRE-HOLE	dimens.	PRE FORO / PRE-HOLE
IP6	Ø 1,45 +0,10/0	IP27	Ø 4,15 +0,10/0
IP7	Ø 1,80 +0,10/0	IP30	Ø 4,60 +0,10/0
IP8	Ø 1,95 +0,10/0	IP40	Ø 5,50 +0,10/0
IP9	Ø 2,10 +0,10/0	IP45	Ø 6,55 +0,10/0
IP10	Ø 2,30 +0,10/0	IP50	Ø 7,30 +0,15/0
IP15	Ø 2,75 +0,10/0	IP55	Ø 9,50 +0,15/0
IP20	Ø 3,25 +0,10/0	IP60	Ø 11,10 +0,20/0
IP25	Ø 3,65 +0,10/0	IP70	Ø 13,40 +0,20/0



2026/03/30



Smussi per brocciatura profili esagonali, quadri, Torx® e Torx® Plus

Chamfer broaching: exagonal, square, Torx® and Torx® Plus

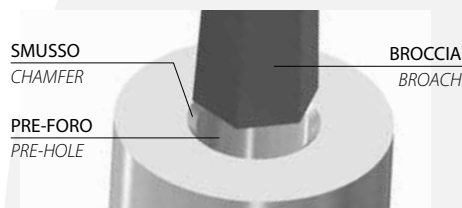
I Per effettuare una corretta brocciatura, è necessario realizzare uno smusso in testa al pre-foro. Questo smusso, ha la funzione di accompagnare la broccia verso il pre-foro evitando che si scheggi prima che essa cominci il lavoro di compressione del materiale. E' fondamentale appoggiare la broccia allo smusso a macchina ferma.

GB To carry out correct broaching, it is necessary to create a chamfer at the head of the pre-hole. This chamfer has the function of accompanying the broach towards the pre-hole, preventing it from chipping before it begins the work of compressing the material. It is essential to rest the broach on the chamfer with the machine stopped.



ESAGONI METRICI / METRIC HEXAGONS

dimens.	SMUSSO / CHAMFER	dimens.	SMUSSO / CHAMFER
1	Ø 1,25	19	Ø 22,15
1,5	Ø 1,90	20	Ø 23,30
2	Ø 2,40	21	Ø 24,50
2,5	Ø 3,00	22	Ø 25,60
3	Ø 3,60	23	Ø 26,80
3,5	Ø 4,15	24	Ø 28,00
4	Ø 4,75	25	Ø 29,10
4,5	Ø 5,35	26	Ø 30,25
5	Ø 5,90	27	Ø 31,45
5,5	Ø 6,50	28	Ø 32,60
6	Ø 7,05	29	Ø 33,75
7	Ø 8,20	30	Ø 34,90
8	Ø 9,35	31	Ø 36,10
9	Ø 10,50	32	Ø 37,20
10	Ø 11,67	33	Ø 38,40
11	Ø 12,85	34	Ø 39,55
12	Ø 14,00	35	Ø 40,70
13	Ø 15,15	36	Ø 41,90
14	Ø 16,30	37	Ø 42,95
15	Ø 17,50	38	Ø 44,10
16	Ø 18,65	39	Ø 45,26
17	Ø 19,80	40	Ø 46,45
18	Ø 21,00		



QUADRI METRICI / METRIC SQUARE

dimens.	SMUSSO / CHAMFER	dimens.	SMUSSO / CHAMFER
1	Ø 1,50	11	Ø 15,70
1,5	Ø 2,25	12	Ø 17,10
2	Ø 3,00	13	Ø 18,55
2,5	Ø 3,80	14	Ø 19,95
3	Ø 4,35	15	Ø 21,35
3,5	Ø 5,10	16	Ø 22,80
4	Ø 5,80	17	Ø 24,20
4,5	Ø 6,50	18	Ø 25,65
5	Ø 7,20	19	Ø 27,05
5,5	Ø 8,00	20	Ø 28,50
6	Ø 8,60	21	Ø 29,90
7	Ø 10,00	22	Ø 31,35
8	Ø 11,45	23	Ø 32,75
9	Ø 12,85	24	Ø 34,15
10	Ø 14,30	25	Ø 35,60



ESAGONI IN POLLICI / HEXAGONS IN INCHES

dimens.	SMUSSO / CHAMFER	dimens.	SMUSSO / CHAMFER
3/32"	Ø 2,95	3/8"	Ø 11,15
1/8"	Ø 3,75	7/16"	Ø 12,95
5/32"	Ø 4,70	1/2"	Ø 14,85
3/16"	Ø 5,60	9/16"	Ø 16,70
7/32"	Ø 6,55	5/8"	Ø 18,50
1/4"	Ø 7,45	3/4"	Ø 22,20
9/32"	Ø 8,90	7/8"	Ø 25,90
5/16"	Ø 9,30	1"	Ø 29,55



QUADRI IN POLLICI / SQUARE IN INCHES

dimens.	SMUSSO / CHAMFER	dimens.	SMUSSO / CHAMFER
3/32"	Ø 3,50	3/8"	Ø 13,80
1/8"	Ø 4,75	7/16"	Ø 16,00
5/32"	Ø 5,80	1/2"	Ø 18,30
3/16"	Ø 7,00	9/16"	Ø 20,50
7/32"	Ø 8,10	5/8"	Ø 22,80
1/4"	Ø 9,20	3/4"	Ø 27,40
9/32"	Ø 10,30	7/8"	Ø 32,00
5/16"	Ø 11,50	1"	Ø 36,50



TORX / TORX

dimens.	SMUSSO / CHAMFER	dimens.	SMUSSO / CHAMFER
T3	Ø 1,25	T25	Ø 4,60
T4	Ø 1,40	T27	Ø 5,15
T5	Ø 1,60	T30	Ø 5,65
T6	Ø 1,80	T40	Ø 6,85
T7	Ø 2,10	T45	Ø 8,00
T8	Ø 2,45	T50	Ø 9,00
T9	Ø 2,60	T55	Ø 11,40
T10	Ø 2,85	T60	Ø 13,50
T15	Ø 3,40	T70	Ø 15,80
T20	Ø 4,00		



BROCCIE TORX PLUS / TORX PLUS BROACHES

dimens.	SMUSSO / CHAMFER	dimens.	SMUSSO / CHAMFER
IP6	Ø 1,80	IP27	Ø 5,30
IP7	Ø 2,20	IP30	Ø 5,70
IP8	Ø 2,50	IP40	Ø 7,00
IP9	Ø 2,70	IP45	Ø 8,20
IP10	Ø 3,00	IP50	Ø 9,20
IP15	Ø 3,50	IP55	Ø 11,50
IP20	Ø 4,10	IP60	Ø 13,60
IP25	Ø 4,70	IP70	Ø 16,00



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Parametri di utilizzo per lavorazioni con brocche in HSS e Sinterizzato

Working parameters for broach machining made of HSS and sintered material

I La scelta se utilizzare brocche in ACCIAIO HSS o SINTERIZZATO può dipendere da alcuni aspetti:

GB The choice whether to use HSS STEEL or SINTERED broaches may depend on some aspects:

	ACCIAIO HSS / HSS STEEL	SINTERIZZATO / SINTERED
VANTAGGI ADVANTAGES	Massima flessibilità per tutti i materiali. Acciaio da utensili (super rapido) indicato per qualsiasi tipo di lavorazione. Rivestimenti consigliati vedi pag. 18. Maximum flexibility for all types of steel and alloys. Super high speed steel suitable for any type of processing. Recommended coatings see page. 18.	Altissima tenacità e durezza adatta per la lavorazione del titanio e acciai fino a MAX 32-33 HRC. Rivestimenti consigliati vedi pag. 18. Very high toughness and hardness suitable to work titanium and steels till MAX 32-33 HRC. Recommended coatings see page. 18.
SVANTAGGI DISADVANTAGES	Non idoneo a lavorare il Titanio e acciai fino a MAX 28-29 HRC. Not suitable for working titanium and steels till to MAX 28-29 HRC.	Estrema fragilità agli urti e vibrazioni, non consigliato a lavorare acciai Inox e acciai semplici. Extreme fragility to shocks and vibrations, not recommended to stainless steels and simple steels.

BROCCE IN ACCIAIO HSS

HSS STEEL BROACHES

ROTAZIONE MANDRINO: M3, M4
SPINDLE ROTATION: M3, M4

PROFILO PROFILE	dimensioni dimensions (mm)	MATERIALE DA LAVORARE / MATERIAL TO WORK																					
		ALLUMINIO ALUMINUM		ACCIAI / STEELS				ACCIAI INOX STAINLESS STEELS				GHISA CAST IRON	TITANIO (*) TITANIUM (*)	RAME COPPER	OTTONE/ BRONZO BRASS / BRONZE								
		TENERO MILD STEEL	COMUNE COMMON STEEL	LEGATO ALLOY STEEL	ACCIAI INOX STAINLESS STEELS		GHISA CAST IRON	TITANIO (*) TITANIUM (*)	RAME COPPER	OTTONE/ BRONZO BRASS / BRONZE													
		Vc m/min=55 Rm ≤ 350 (N/mm²)	Vc m/min=40 Rm ≤ 510 (N/mm²)	Vc m/min=38 Rm 510+680 (N/mm²)	Vc m/min=30 Rm 680+1050 (N/mm²)	Vc m/min=25 Rm ≤ 520 (N/mm²)	Vc m/min=20 Rm 520+1050 (N/mm²)	Vc m/min=30 Rm ≤ 400 (N/mm²)	Rm ≤ 350 (N/mm²)	Rm ≤ 200 (N/mm²)	Vc m/min=40 Rm ≤ 350 (N/mm²)	NON CONSIGLIATO NOT RECOMMENDED											
LUBRIFICAZIONE NECESSARIA / LUBRICATION REQUIRED																							
f	S	f	S	f	S	f	S	f	S	f	S					f	S	f	S	f	S		
ESAGONALE HEXAGONAL	1 - 12,9	0,11	1800/900	0,10	1500/850	0,08	1450/800	0,05	1400/750	0,07	1450/750					0,04	1200/700	0,07	1600/700	0,09	1600/950	0,10	1700/950
	13 - 23,9	0,08	900/550	0,08	850/500	0,06	800/400	0,02	750/400	0,06	750/500					0,03	700/450	0,05	700/500	0,07	950/600	0,07	950/700
	24 - 40	0,05	550/350	0,04	500/300	0,03	400/300	0,01	400/300	0,03	500/400					0,02	450/350	0,03	500/350	0,04	600/450	0,03	700/450
QUADRATO SQUARE	1 - 10,9	0,10	1800/900	0,06	1500/850	0,05	1450/800	0,02	1400/750	0,05	1450/750					0,03	1200/700	0,07	1600/700	0,10	1600/950	0,08	1700/950
	11 - 20,9	0,06	900/550	0,04	850/500	0,03	800/400	0,02	750/400	0,04	750/500					0,02	700/450	0,05	700/500	0,08	950/600	0,06	950/700
	21 - 25	0,03	550/350	0,02	500/300	0,02	400/300	0,01	400/300	0,02	500/400					0,01	450/350	0,03	500/350	0,06	600/450	0,04	700/450
TORX® (T) TORX®PLUS (IP)	T3 - T6	0,12	1800/900	0,10	1500/850	0,08	1450/800	0,05	1400/750	0,08	1450/750					0,045	1200/700	0,09	1600/700	0,12	1600/950	0,10	1700/950
	T7 - T27 IP6 - IP27	0,10	900/550	0,09	850/500	0,07	800/400	0,04	750/400	0,07	750/500	0,04	700/450	0,08	700/500	0,11	950/600	0,09	950/700				
	T30 - T70 IP30 - IP70	0,08	550/350	0,07	500/300	0,05	400/300	0,03	400/300	0,06	500/400	0,03	450/350	0,06	500/350	0,09	600/450	0,06	700/450				

f = avanzamento (mm/giro) / advancement (mm/round)
S = velocità (giri/min) / RPM (rounds/minute)
Vc = velocità di taglio (m/min) / cutting speed (meters/minute)

BROCCE IN ACCIAIO SINTERIZZATO

SINTERED STEEL BROACHES

ROTAZIONE MANDRINO: M3, M4
SPINDLE ROTATION: M3, M4

PROFILO PROFILE	dimensioni dimensions (mm)	MATERIALE DA LAVORARE / MATERIAL TO WORK																							
		ALLUMINIO ALUMINUM		ACCIAI / STEELS				ACCIAI INOX STAINLESS STEELS				GHISA CAST IRON	PARTICOLARMENTE CONSIGLIATO TITANIO (*) TITANIUM (*)	RAME COPPER	OTTONE BRASS										
		TENERO MILD STEEL	COMUNE COMMON STEEL	LEGATO ALLOY STEEL	ACCIAI INOX STAINLESS STEELS		GHISA CAST IRON	TITANIO (*) TITANIUM (*)	RAME COPPER	OTTONE BRASS															
		Rm ≤ 350 (N/mm²)	Rm ≤ 510 (N/mm²)	Rm 510+680 (N/mm²)	Rm 680+1050 (N/mm²)	Rm ≤ 520 (N/mm²)	Rm 520+1050 (N/mm²)	Rm ≤ 400 (N/mm²)	Rm ≤ 350 (N/mm²)	Rm ≤ 200 (N/mm²)	Rm ≤ 350 (N/mm²)	NON CONSIGLIATO NOT RECOMMENDED													
LUBRIFICAZIONE NECESSARIA / LUBRICATION REQUIRED																									
f	S	f	S	f	S	f	S	f	S	f	S					f	S	f	S	f	S				
ESAGONALE HEXAGONAL	1 - 12,9	0,14	2000/1000	0,12	1600/950	0,10	1600/900	0,07	1400/850	0,09	1600/850					0,055	1200/800	0,12	1700/1000	0,05	1000/750	0,16	1800/900	0,12	1800/1000
	13 - 23,9	0,11	1000/700	0,10	950/650	0,08	900/700	0,04	850/550	0,07	850/600					0,045	800/550	0,08	1000/650	0,04	750/550	0,12	900/750	0,09	1000/600
	24 - 40	0,08	700/500	0,07	650/450	0,05	700/400	0,015	550/400	0,05	600/450					0,025	550/350	0,05	650/350	0,02	550/400	0,08	750/500	0,06	600/400
QUADRATO SQUARE	1 - 10,9	0,11	2000/1000	0,08	1600/950	0,07	1600/900	0,05	1400/850	0,07	1600/850					0,045	1200/800	0,10	1700/1000	0,04	1000/750	0,12	1800/900	0,09	1800/1000
	11 - 20,9	0,08	1000/700	0,06	950/650	0,06	900/700	0,04	850/550	0,06	850/600					0,035	800/550	0,07	1000/650	0,04	750/550	0,10	900/750	0,07	1000/600
	21 - 25	0,06	700/500	0,04	650/450	0,04	700/400	0,02	550/400	0,04	600/450					0,015	550/350	0,04	650/350	0,02	550/400	0,07	750/500	0,04	600/400
TORX® (T) TORX®PLUS (IP)	T3 - T6	0,16	2000/1000	0,12	1600/950	0,10	1600/900	0,07	1400/850	0,09	1600/850					0,06	1200/800	0,12	1700/1000	0,05	1000/750	0,16	1800/900	0,13	1800/1000
	T7 - T27 IP6 - IP27	0,13	1000/700	0,11	950/650	0,09	900/700	0,06	850/550	0,08	850/600	0,045	800/550	0,10	1000/650	0,045	750/550	0,15	900/750	0,11	1000/600				
	T30 - T70 IP30 - IP70	0,11	700/500	0,10	650/450	0,08	700/400	0,05	550/400	0,07	600/450	0,04	550/350	0,09	650/350	0,04	550/400	0,12	750/500	0,09	600/400				

(*) adatto fino a classe 3, poco consigliato su classe 4, sconsigliato per classi 5 e 6 / suitable up to class 3, not recommended for class 4, not recommended for classes 5 and 6



2026/03/30



Rivestimenti per brocche Coatings for broaches

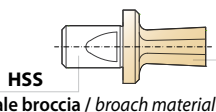


I A seconda della tipologia di materiale da lavorare, sulle brocche possono essere applicati rivestimenti per migliorarne la durata in termini di numero di pezzi prodotti, come **WONDER (TiALN*)**, **TiN**, **INOX PLUS** e **ZIRINOS**. Di seguito alcuni esempi di materiali da lavorare con i grafici che ne evidenziano la differenza fra l'utensile realizzato in HSS o SINTERIZZATO normale rispetto all'utensile rivestito.

GB Depending on the type of material to be machined, coatings can be applied to the broaches to improve their durability in terms of number of work-pieces produced, such as **WONDER (TiALN*)**, **TiN**, **INOX PLUS** and **ZIRINOS**. Here are some examples of materials to be machined with the graphs highlighting the difference between the tool made of normal HSS or SINTERED and the coated tool.

Materiale broccia Broach material	Materiale da lavorare Machined material		Rivestimento			
			TiN	WONDER/ TiALN *	INOX PLUS	ZIRINOS
HSS	ALLUMINIO / ALUMINUM	Rm ≤ 350 (N/mm²)				✓
HSS	ACCIAIO TENERO / MILD STEEL	Rm ≤ 510 (N/mm²)	✓			
HSS	ACCIAIO COMUNE / COMMON STEEL	Rm 510÷680 (N/mm²)	✓			
HSS	ACCIAIO LEGATO / ALLOY STEEL	Rm 680÷1050 (N/mm²)		✓		
HSS	ACCIAI INOX / STAINLESS STEELS	Rm ≤ 520 (N/mm²)			✓	
HSS		Rm 520÷1050 (N/mm²)			✓	
HSS	GHISA / CAST IRON	Rm ≤ 400 (N/mm²)	✓			
SINTERIZZATO	TITANIO / TITANIUM	Rm ≤ 350 (N/mm²)				✓
HSS	OTTONE-BRONZO / BRASS - BRONZE	Rm ≤ 350 (N/mm²)				✓

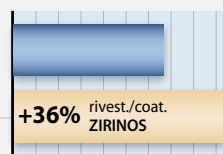
materiale da lavorare: **ALLUMINIO - OTTONE - BRONZO**
machined material: **ALUMINUM - BRASS - BRONZE**



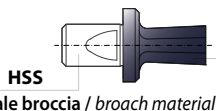
ZIRINOS
rivestimento applicato / applied coating

n°pz brocciati senza rivestimento
n°pcs broached without broached coating

n°pz brocciati con rivestimento
n°pcs broached coating



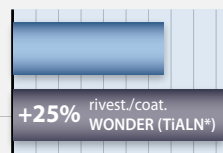
materiale da lavorare: **ACCIAIO BONIFICATI**
machined material: **HARDENED STEEL**



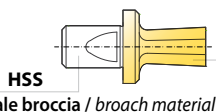
WONDER (TiALN*)
rivestimento applicato / applied coating

n°pz brocciati senza rivestimento
n°pcs broached without broached coating

n°pz brocciati con rivestimento
n°pcs broached coating



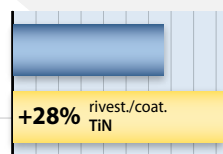
materiale da lavorare: **ACCIAIO TENERO/COMUNE - GHISA**
machined material: **MILD/COMMON STEEL - CAST IRON**



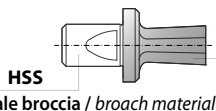
TiN
rivestimento applicato / applied coating

n°pz brocciati senza rivestimento
n°pcs broached without broached coating

n°pz brocciati con rivestimento
n°pcs broached coating



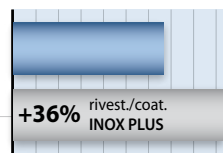
materiale da lavorare: **ACCIAI INOX**
machined material: **STAINLESS STEELS**



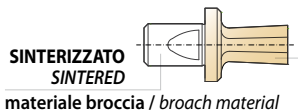
INOX PLUS
rivestimento applicato / applied coating

n°pz brocciati senza rivestimento
n°pcs broached without broached coating

n°pz brocciati con rivestimento
n°pcs broached coating



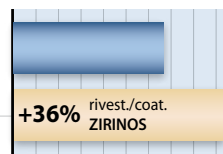
materiale da lavorare: **TITANIO**
machined material: **TITANIUM**



ZIRINOS
rivestimento applicato / applied coating

n°pz brocciati senza rivestimento
n°pcs broached without broached coating

n°pz brocciati con rivestimento
n°pcs broached coating



Per acciai e/o materiali non indicati in tabella, chiedere informazioni al nostro ufficio tecnico

(*) TiALN solo a richiesta, sostituito dal WONDER





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