Hexagon Push Broaches

1/8 thru 1 inch sizes | 4mm thru 25mm sizes

Applications: **Drives, jigs, fixtures and other hexagonal broaching operations**

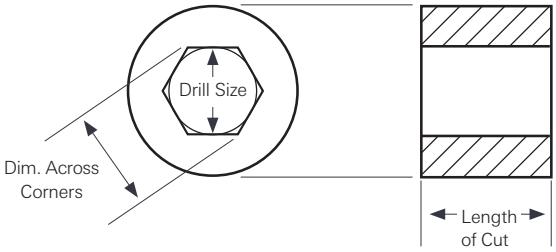
Hexagon Broaches

Our Hexagon Broaches are designed to generate in one-pass a Hexagon hole in a previously cast or drilled round hole. Available from stock in the most common American Standard / Metric sizes (1/8–1" & 4mm–25mm).

TiN or TiAlN coatings available.



American Standard / Metric Square Broach



Stock Hexagon Broaches — VER: BS-610 / GRP: HS-120

Hex Size (inch)	Tolerances	Broach Length	Pilot Diameter	Drill Size	Dimension Across Corners	Tooth Pitch	Length of Cut Min.	Length of Cut Max.	Pressure Required. for Max. L/C (lbs.)	EDP No. duMONT	EDP No. Hassay Sav
1/8	.1255 – .1265	4-1/8	1/8	1/8	.1445 – .1455	1/8	3/16	3/8	200	77701	12008
5/32	.1565 – .1575	4-15/16	5/32	5/32	.1800 – .1815	1/8	1/4	1/2	300	77702	12010
3/16	.1880 – .1890	5-1/16	3/16	3/16	.2160 – .2180	5/32	1/4	5/8	560	77703	12012
7/32	.2190 – .2200	5-3/8	7/32	7/32	.2500 – .2520	5/32	1/4	3/4	775	77704	12014
1/4	.2505 – .2515	6	1/4	1/4	.2870 – .2890	3/16			1,025	77705	12016
9/32	.2815 – .2825	7-1/4	9/32	9/32	.3230 – .3250	3/16	5/16	1	1,290	77706	12018
5/16	.3130 – .3140	7-3/4	5/16	5/16	.3590 – .3610	7/32	3/8	1	1,510	77707	12020
11/32	.3440 – .3450	7-3/4	11/32	11/32	.3950 – .3970	7/32	3/8	1-1/4	2,280	77708	12022
3/8	.3755 – .3765	8-1/2	3/8	3/8	.4310 – .4330				2,400	77709	12024
13/32	.4065 – .4075	9-5/8	13/32	13/32	.4670 – .4690	1/4	1/2	1-3/8	2,790	77710	12026
7/16	.4380 – .4390	10-1/2	7/16	7/16	.5040 – .5060				2,700	77711	12028
15/32	.4690 – .4700	11-7/8	15/32	15/32	.5390 – .5410	9/32	1/2	1-3/8	2,700	77712	12030
1/2	.5005 – .5015	11-7/8	1/2	1/2	.5750 – .5770				3,025	77713	12032
9/16	.5630 – .5640	13-3/4	9/16	9/16	.6480 – .6500	5/16	1/2	1-5/8	4,800	77714	12036
5/8	.6260 – .6270	16-1/4	5/8	5/8	.7200 – .7220	3/8	5/8	2	5,400	77715	12040
11/16	.6885 – .6895	16-3/4	11/16	11/16	.7920 – .7940				6,000	77716	12044
3/4	.7510 – .7520	17-1/4	3/4	3/4	.8650 – .8670				6,960	77717	12048
7/8	.8765 – .8775	18-1/2	7/8	7/8	1.0080 – 1.0100				8,400	77718	12056
1	1.0020 – 1.0030	19-3/4	1	1	1.1520 – 1.1540				11,100	77719	12064

Stock Metric Hexagon Broaches — VER: BS-620 / GRP: HS-121

Hexagon (mm)	Tolerances (Dec. Equiv.)	Broach Length	Pilot Diameter	Drill Size	Dimension Across Corners	Tooth Pitch	Length of Cut Min.	Length of Cut Max.	Pressure Required. for Max. L/C (lbs.)	EDP No. duMONT	EDP No. Hassay Savage
4	.1575 – .1580	4-15/16	.1575	4.0	.1810 – .1825	1/8	1/4	1/2	300	77750	12104
5	.1968 – .1973	5-3/8	.1968	5.0	.2260 – .2275	5/32	1/4	3/4	775	77751	12105
6	.2362 – .2370	6	.2362	6.0	.2710 – .2730	3/16	1/4	3/4	1,025	77752	12106
7	.2756 – .2764	7-1/4	.2756	7.0	.3170 – .3190	7/32	1/4	1	1,290	77753	12107
8	.3150 – .3158	7-3/4	.3150	8.0	.3620 – .3640		3/8	1	1,510	77754	12108
9	.3545 – .3555	8-1/2	.3543	9.0	.4090 – .4110	1/4	3/8	1-1/4	2,300	77759	-
10	.3937 – .3945	9-5/8	.3937	10.0	.4530 – .4550	9/32	1/2	1-3/8	2,790	77755	12110
12	.4724 – .4732	11-7/8	.4724	12.0	.5430 – .5450	5/16	1/2	1-3/8	2,700	77756	12112
14	.5512 – .5520	13-3/4	.5512	14.0	.6350 – .6370	3/8	1/2	1-5/8	4,800	77757	12114
16	.6302 – .6310	16-1/4	.6299	16.0	.7250 – .7270	3/8	5/8	2	5,400	77758	12116
18	.7092 – .7097	16-3/4	.7087	18.0	.8170 – .8190	3/8	5/8	2	6,400	77760	12118
20	.7876 – .7886	17-5/8	.7874	20.0	.9050 – .9070				7,200	77761	12120
22	.8664 – .8674	18-1/2	.8661	22.0	.9990 – 1.0010				8,200	77762	12122
24	.9450 – .9460	19-1/2	.9449	24.0	1.0890 – 1.0910				9,700	77763	12124
25	.9845 – .9855	19-3/4	.9842	25.0	1.1350 – 1.1370				11,000	77764	12125