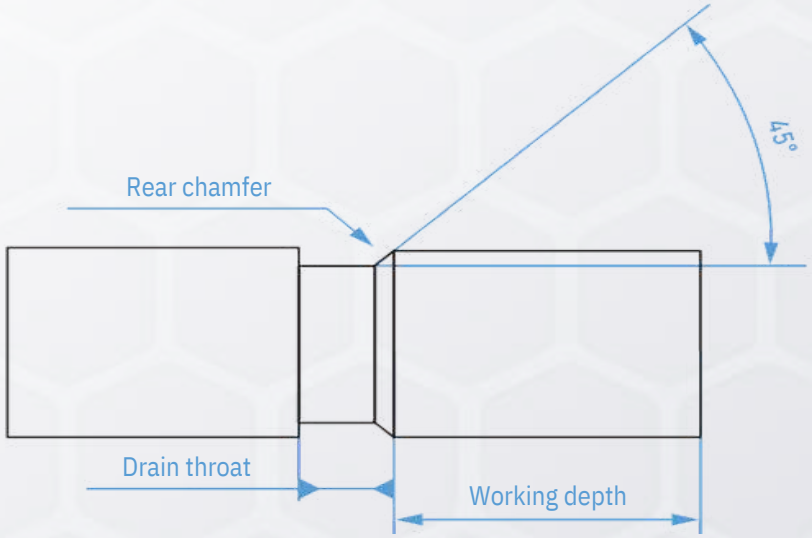
EXTERNAL BROACHING PART PREPARATION

PRE-TURN DIAMETER

Pre-turning the diameter of the workpiece is required for external broaching. The pre-turned diameter must be smaller than the major diameter of the broach. It is recommended to turn the workpiece diameter to the smallest allowable diameter so the broach will clear on the major diameter. Allowing for more clearance will reduce the required broaching pressure and increase tool life.



EXTERNAL FORM DEPTH

A back chamfer or undercut will allow swarf to break cleanly.