

## Keyway Broaches — Inch



- Specialty tools designed for cutting keyways in machined holes
- Typically used manually with an arbor press or hydraulic press to produce the keyways
- Well suited for use in a variety of ferrous and non-ferrous materials

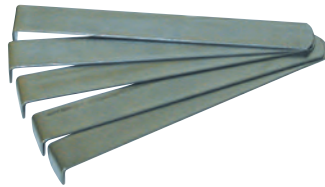


Broach	Keyway Width Tol.	Dim.	No. Shims	Cut Length Min/Max	Hassay EDP No.	Code No.	Price \$
1/16-I (A)	0.0625-0.0635	1/8 x 5-1/4	0	13/64-1-1/8	10104	182070	132.00
3/32-I (A)	0.0937-0.0947	1/8 x 5-1/4	0	13/64-1-1/8	10106	182072	132.00
1/8-I (A)	0.1252-0.1262	1/8 x 5-1/4	1	13/64-1-1/8	10108	182074	132.00
3/32-II (B)	0.0937-0.0947	3/16 x 7	0	19/64-1-11/16	10206	182076	156.81
1/8-II (B)	0.1252-0.1262	3/16 x 7	1	19/64-1-11/16	10208	182078	156.81
5/32-II (B)	0.1564-0.1574	3/16 x 7	1	19/64-1-11/16	10210	182080	156.81
3/16-II (B)	0.1877-0.1887	3/16 x 7	1	19/64-1-11/16	10212	182082	156.81
3/16-III (C)	0.1877-0.1887	3/8 x 11-7/8	1	13/32-2-1/2	10312	182084	197.69
1/4-III (C)	0.2502-0.2512	3/8 x 11-7/8	1	13/32-2-1/2	10316	182086	197.69
5/16-III (C)	0.3127-0.3137	3/8 x 11-7/8	1	13/32-2-1/2	10320	182088	197.69
3/8-III (C)	0.3755-0.3765	3/8 x 11-7/8	2	13/32-2-1/2	10324	182090	197.69
5/16-IV (D)	0.3127-0.3137	9/16 x 13-7/8	1	3/4-6	10420	182092	302.29
3/8-IV (D)	0.3755-0.3765	9/16 x 13-7/8	2	3/4-6	10424	182094	302.29
7/16-IV (D)	0.4380-0.4390	9/16 x 13-7/8	2	3/4-6	10428	182096	302.29
1/2-IV (D)	0.5006-0.5016	9/16 x 13-7/8	3	3/4-6	10432	182098	302.29
9/16-IV (D)	0.5630-0.5640	9/16 x 13-7/8	3	3/4-6	10436	182100	302.29
5/8-V (E)	0.6260-0.6270	3/4 x 15-1/4	4	3/4-6	10540	182102	504.53
3/4-V (E)	0.7515-0.7525	3/4 x 15-1/4	5	3/4-6	10548	182104	504.53
7/8-VI (F)	0.8765-0.8775	1 x 19-1/4	6	3/4-6	10656	182106	1,038.60
1-VI (F)	1.0015-1.0025	1 x 19-1/4	7	3/4-6	10664	182108	1,038.60
1-1/8	1.1260-1.1270	1-1/8 x 23	8	3/4-6	10666	182110	2,533.85
1-1/4	1.2510-1.2520	1-1/4 x 23	9	3/4-6	10668	182112	2,831.90
1-3/8	1.3760-1.3770	1-3/8 x 23	10	3/4-6	10670	182114	3,197.59
1-1/2	1.5020-1.5030	1-1/2 x 23	11	3/4-6	10672	182116	3,691.35

## Shim Sets For Keyway Broaches — Inch



**NOTE:**  
Extra shims are available in sets.  
Please refer to the column Shims  
Required in the broach chart. Note  
that shims correspond to broach size,  
not the bushing type.



Size	Thickness	Length x Width	Hassay EDP No.	Set Size	Code No.	Price \$
1/8-I (A)	0.031	1-3/8 x 1/8	30108	1	182140	9.73
1/8-II (B)	0.031	1-7/8 x 3/16	30208	1	182142	9.73
5/32-II (B)	0.042	1-7/8 x 3/16	30210	1	182144	9.73
3/16-II (B)	0.050	1-7/8 x 3/16	30212	1	182146	9.73
3/16-III (C)	0.050	2-7/8 x 3/8	30312	1	182148	9.73
1/4-III (C)	0.062	2-7/8 x 3/8	30316	1	182150	9.73
5/16-III (C)	0.078	2-7/8 x 3/8	30320	2	182152	19.19
3/8-III (C)	0.062	2-7/8 x 3/8	30324	2	182154	19.19
5/16-IV (D)	0.078	6-1/4 x 9/16	30420	2	182156	26.33
3/8-IV (D)	0.062	6-1/4 x 9/16	30424	2	182158	26.33
7/16-IV (D)	0.075	6-1/4 x 9/16	30428	3	182160	40.79
1/2-IV (D)	0.062	6-1/4 x 9/16	30432	3	182162	40.79
5/8-V (E)	0.062	6-3/4 x 3/4	30540	4	182164	54.89
3/4-V (E)	0.062	6-3/4 x 3/4	30548	5	182166	66.94
7/8-VI (F)	0.062	6-3/4 x 3/4	30656	6	182168	95.41
1-VI (F)	0.062	6-3/4 x 3/4	30664	7	182170	112.28
1-1/8	0.062	7 x 1-1/8	30740	8	182172	126.47
1-1/4	0.062	7 x 1-1/8	30750	9	182174	288.72

## Collared & Plain Bushings — Inch



- Used in conjunction with keyway broaches and shims to cut the keyway
- Used manually with an arbor press or hydraulic press and broaches to produce the keyways
- Straight precision slot acts as a guide for the broach



Diameter	Length	Hassay EDP No.	Code No.	Price \$
<b>I (A) Collared Bushings</b>				
1/4	1-1/8	20116	182180	38.91
5/16	1-1/8	20120	182182	38.91
3/8	1-1/8	20124	182184	38.91
7/16	1-1/8	20128	182186	36.32
1/2	1-1/8	20132	182188	38.91
<b>II (B) Collared Bushings</b>				
1/2	1-11/16	20232	182190	34.27
9/16	1-11/16	20236	182192	34.27
5/8	1-11/16	20240	182194	34.27
11/16	1-11/16	20244	182196	32.02
3/4	1-11/16	20248	182198	34.27
13/16	1-11/16	20252	182200	32.02
7/8	1-11/16	20256	182202	34.27
<b>III (C) Collared Bushings</b>				
3/4	2-1/2	20348	182204	43.91
13/16	2-1/2	20352	182206	43.91
7/8	2-1/2	20356	182208	43.91
15/16	2-1/2	20360	182210	43.91
1	2-1/2	20364	182212	43.91
1-1/16	2-1/2	20368	182214	43.91
1-1/8	2-1/2	20372	182216	48.64
1-3/16	2-1/2	20376	182218	51.23
1-1/4	2-1/2	20380	182220	51.23
1-5/16	2-1/2	20384	182224	47.87
1-3/8	2-1/2	20388	182226	51.23
1-7/16	2-1/2	20392	182228	51.23
1-1/2	2-1/2	20396	182230	51.23
1-9/16	2-1/2	20400	182232	51.23
<b>IV (D) Plain Bushings</b>				
1-7/16	4	21492	182238	50.09
1-1/2	4	21496	182240	53.55
1-9/16	4	21500	182242	55.96
1-5/8	4	21504	182246	55.96
1-11/16	4	21508	182248	68.15
1-3/4	4	21512	182250	72.92
1-13/16	5	21516	182252	70.56
1-7/8	5	21520	182254	75.51
1-15/16	5	21524	182256	77.83
2	5	21528	182258	77.83
2-1/16	5	21532	182260	72.76
2-1/8	5	21536	182262	77.83
2-3/16	5	21540	182264	80.24
2-1/4	5	21544	182266	102.10
2-5/16	5	21548	182268	95.44
2-3/8	6	21552	182270	107.10
2-7/16	6	21556	182272	100.07
2-1/2	6	21560	182274	100.07
2-9/16	6	21564	182276	138.78
2-5/8	6	21568	182278	138.78
2-11/16	6	21572	182280	129.68
2-3/4	6	21576	182282	138.78
2-13/16	6	21580	182284	138.78
2-7/8	6	21584	182286	138.78
2-15/16	6	21588	182288	141.10
3	6	21592	182290	141.10
<b>V (E) Plain Bushings</b>				
2-5/16	6	21688	182292	119.24
2-3/8	6	21692	182294	119.24
2-7/16	6	21696	182296	121.56
2-1/2	6	21700	182298	121.56
2-9/16	6	21704	182300	145.83
2-5/8	6	21708	182302	145.83
2-11/16	6	21712	182306	145.83
2-3/4	6	21716	182308	145.83
2-13/16	6	21720	182310	150.74
2-7/8	6	21724	182312	150.74
2-15/16	6	21728	182314	140.91
3	6	21732	182316	150.74