

Hexagonal Rotary Punch Broaches

MAX Proprietary Alloy for more difficult to machine materials

Hassay **MAX**

Manufactured from custom hardened alloys, these hex, square and punch rotary broaches are a specially formulated material that combines high hardness with exceptional abrasion resistance and toughness. They're ideal for sockets where long tool life is required and are intended for use on materials with hardness up to 50 HRC, such as:

- Cobalt-Chrome
- Custom 455
- Biodur 108 & 22-13-15
- 17-4 Stainless Steel
- Strain Hardened 316
- Titanium
- Inconel 718
- Monel
- Hardened A286/304
- 303 Stainless Steel

2X TOOL LIFE

Compared to a T-15

37% DECREASE

in overall CPP (cost per part)



Decrease in overall CPP (cost per part), compared to M41 & T-15.

Our rotary broaches offer many advantages over conventional coated and uncoated broaching tools, including:

- Edge toughness for high production applications
- Better heat resistance
- 2X-10X longer tool life

NEW from KAR, we now have Hassay Savage

Contact your local KAR Distributor for Complete Offering

YOUR AUTHORIZED KAR DISTRIBUTOR:

DURAMILL
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www.duramill.ca
 6877 Edwards Blvd., Mississauga, ON L5T 2T9

Rotary/Punch Broaches:

- Use in a variety of machines
- Cut polygons in blind holes
- Any type of CNC or manual turning, milling, drilling or screw machine



Punching versus Rotary Broaching:

Many applications can be achieved without the rotary broach holder.

For the purpose of merely punching a polygon into an existing pilot hole, these broaches have successfully been used with universal machining methods.

Hexagonal Rotary/Punch Broaches

1/2" - 0.500 Shank

Hex Size (Inch)	Across Flats +0.001/-0.000	Max. Depth of Cut	*Overall Length (Inch)	EDP	Code	Price
3/32	0.095	7/32	1-3/4	66106-M	621058	170.60
1/8	0.127	1/4		66108-M	621060	
5/32	0.158	5/16		66110-M	621062	
3/16	0.190	3/8		66112-M	621063	
1/4	0.252	7/16		66116-M	621065	
3/8	0.378	11/16		66124-M	621069	
1/2	0.504	5/8	66132-M	621073	203.67	

Hexagonal Rotary/Punch Broaches

8mm - 0.315 Shank

Hex Size (Inch)	Across Flats +0.001/-0.000	Max. Depth of Cut	*Overall Length (Inch)	EDP	Code	Price
3/32	0.095	7/32	1-1/4	66006-M	621022	137.26
1/8	0.127	1/4		66008-M	621024	
5/32	0.158	5/16		66010-M	621026	
3/16	0.190	11/32		66012-M	621027	
1/4	0.252	7/16		66016-M	621029	
3/8	0.378	1/2		66024-M	621033	

Metric

Hexagonal Rotary/Punch Broaches

1/2" - 0.500 Shank

Hex Size (Inch)	Across Flats +0.001/-0.000	Max. Depth of Cut	*Overall Length (Inch)	EDP	Code	Price
5.0	0.199	3/8	1-3/4	66305-M	621133	170.60
6.0	0.238	7/16		66306-M	621134	
8.0	0.320	1/2		66308-M	621136	
10.0	0.399	5/8		66310-M	621138	

Metric

Hexagonal Rotary/Punch Broaches

8mm - 0.315 Shank

Hex Size (Inch)	Across Flats +0.001/-0.000	Max. Depth of Cut	*Overall Length (Inch)	EDP	Code	Price
2.0	0.081	9/64	1-1/4	66202-M	621097	137.26
2.5	0.101	7/32		662025-M	621096	
3.0	0.120	1/4		66203-M	621099	
4.0	0.160	5/16		66204-M	621101	

*Overall Tool Length Tolerances +/-0.015

The practical forming length of rotary punch broaching is usually up to 1-1/2 times the size of the broach (measured across flats).

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OFFER VALID UNTIL DECEMBER 31, 2024