

Keyway Broaches

High Speed Steel & TiN Coated



Broach Size	Broach Dimensions (Inch)	No. of Shims Required	Tooth Pitch (Inch)	No. of Teeth	Minimum Length of Cut (Inch)	Maximum Length of Cut (Inch)	HSS	TiN Coated
							Code	Code
1/16 A	1/8 x 5	0	3/16	18	13/64	1-1/8	605515	605536
3/32 A	1/8 x 5	0	3/16	18	13/64	1-1/8	605516	605537
1/8 A	1/8 x 5	1	3/16	18	13/64	1-1/8	605517	605538
3/32 B	3/16 x 6-3/4	0	9/32	16	19/64	1-11/16	605518	605539
1/8 B	3/16 x 6-3/4	1	9/32	16	19/64	1-11/16	605519	605540
5/32 B	3/16 x 6-3/4	1	9/32	16	19/64	1-11/16	605520	605541
3/16 B	3/16 x 6-3/4	1	9/32	16	19/64	1-11/16	605521	605542
3/16 C	3/8 x 11-3/4	1	3/8	20	25/64	2-1/2	605522	605543
1/4 C	3/8 x 11-3/4	1	3/8	20	25/64	2-1/2	605523	605544
5/16 C	3/8 x 11-3/4	2	3/8	20	25/64	2-1/2	605524	605545
3/8 C	3/8 x 11-3/4	2	3/8	20	25/64	2-1/2	605525	605546
5/16 D	9/16 x 13-7/8	2	5/8	17	1	6	605526	605547
3/8 D	9/16 x 13-7/8	2	5/8	17	1	6	605527	605548
7/16 D	9/16 x 13-7/8	3	5/8	17	1	6	605528	605549
1/2 D	9/16 x 13-7/8	3	5/8	17	1	6	605529	605550
5/8 E	3/4 x 15-1/2	4	5/8	20	1	6	605530	605551
3/4 E	3/4 x 15-1/2	5	5/8	20	1	6	605531	605552
7/8 F	1 x 20-1/4	6	5/8	26	1	6	605532	605553
1 F	1 x 20-1/4	7	5/8	26	1	6	605533	605554
1-1/8	1-1/8 x 20-1/4	8	5/8	26	1	6	605534	-
1-1/4	1-1/4 x 20-1/4	9	3/4	22	1-1/2	8	605535	-

Broach Shims



Broach Size	Shim Thickness (Inch)	Code	Broach Size	Shim Thickness (Inch)	Code	Broach Size	Shim Thickness (Inch)	Code
1/8 A	0.0310	605555	5/16 C	0.0550	605561	5/8 E	0.0625	605567
1/8 B	0.0310	605556	3/8 C	0.0625	605562	3/4 E	0.0625	605568
5/32 B	0.0420	605557	5/16 D	0.0560	605563	7/8 F	0.0625	605569
3/16 B	0.0500	605558	3/8 D	0.0625	605564	1 F	0.0625	605570
3/16 C	0.0500	605559	7/16 D	0.0560	605565	1-1/8	0.0625	605571
1/4 C	0.0625	605560	1/2 D	0.0625	605566	1-1/4	0.0625	605572

Broach Bushings Collared & Plain Types



Diameter (Inch)	Collared Bushings						Plain Bushings			
	A Bushings for A Broaches		B Bushings for B Broaches		C Bushings for C Broaches		D Bushings for D Broaches		E Bushings for E Broaches	
	Length (Inch)	Code	Length (Inch)	Code	Length (Inch)	Code	Length (Inch)	Code	Length (Inch)	Code
1/4	1-1/8	605573	-	-	-	-	-	-	-	-
5/16	1-1/8	605574	-	-	-	-	-	-	-	-
3/8	1-1/8	605575	-	-	-	-	-	-	-	-
7/16	1-1/8	605576	-	-	-	-	-	-	-	-
1/2	1-1/8	605577	1-11/16	605578	-	-	-	-	-	-
9/16	-	-	1-11/16	605579	-	-	-	-	-	-
5/8	-	-	1-11/16	605580	-	-	-	-	-	-
11/16	-	-	1-11/16	605581	-	-	-	-	-	-
3/4	-	-	1-11/16	605582	2-1/2	605585	-	-	-	-
13/16	-	-	1-11/16	605583	2-1/2	605586	-	-	-	-
7/8	-	-	1-11/16	605584	2-1/2	605587	-	-	-	-
15/16	-	-	-	-	2-1/2	605588	-	-	-	-
1	-	-	-	-	2-1/2	605589	-	-	-	-
1-1/16	-	-	-	-	2-1/2	605590	-	-	-	-
1-1/8	-	-	-	-	2-1/2	605591	-	-	-	-
1-3/16	-	-	-	-	2-1/2	605592	-	-	-	-
1-1/4	-	-	-	-	2-1/2	605593	-	-	-	-
1-5/16	-	-	-	-	2-1/2	605594	-	-	-	-
1-3/8	-	-	-	-	2-1/2	605595	-	-	-	-
1-7/16	-	-	-	-	2-1/2	605596	4	605599	-	-
1-1/2	-	-	-	-	2-1/2	605597	4	605600	-	-
1-9/16	-	-	-	-	2-1/2	605598	4	605601	-	-
1-5/8	-	-	-	-	-	-	4	605602	-	-
1-11/16	-	-	-	-	-	-	4	605603	-	-
1-3/4	-	-	-	-	-	-	4	605604	-	-
1-13/16	-	-	-	-	-	-	5	605605	-	-
1-7/8	-	-	-	-	-	-	5	605606	-	-
1-15/16	-	-	-	-	-	-	5	605607	-	-
2	-	-	-	-	-	-	5	605608	-	-
2-1/16	-	-	-	-	-	-	5	605609	-	-
2-1/8	-	-	-	-	-	-	5	605610	-	-
2-3/16	-	-	-	-	-	-	5	605611	-	-
2-1/4	-	-	-	-	-	-	5	605612	-	-
2-5/16	-	-	-	-	-	-	5	605613	6	605625
2-3/8	-	-	-	-	-	-	6	605614	6	605626
2-7/16	-	-	-	-	-	-	6	605615	6	605627
2-1/2	-	-	-	-	-	-	6	605616	6	605628
2-9/16	-	-	-	-	-	-	6	605617	6	605629
2-5/8	-	-	-	-	-	-	6	605618	6	605630
2-11/16	-	-	-	-	-	-	6	605619	6	605631
2-3/4	-	-	-	-	-	-	6	605620	6	605632
2-13/16	-	-	-	-	-	-	6	605621	6	605633
2-7/8	-	-	-	-	-	-	6	605622	6	605634
2-15/16	-	-	-	-	-	-	6	605623	6	605635
3	-	-	-	-	-	-	6	605624	6	605636

Metric Keyway Broaches

High Speed Steel & TiN Coated



Keyway Width (mm)	Broach Dimensions (Inch)	Standard Keys (mm)	No. of Shims Required	Tooth Pitch (Inch)	Minimum Length of Cut (Inch)	Maximum Length of Cut (Inch)	HSS	TiN Coated
							Code	Code
2 A	1/8 x 5	2 x 2	0	3/16	13/64	1-1/8	605637	605653
3 A	1/8 x 5	3 x 3	1	3/16	13/64	1-1/8	605638	605654
4 B1	1/4 x 6-3/4	4 x 4	1	9/32	19/64	1-11/16	605639	605655
5 B1	1/4 x 6-3/4	5 x 5	1	9/32	19/64	1-11/16	605640	605656
5 C	3/8 x 11-3/4	5 x 5	1	3/8	25/64	2-1/2	605641	605657
6 C	3/8 x 11-3/4	6 x 6	1	3/8	25/64	2-1/2	605642	605658
8 C	3/8 x 11-3/4	8 x 7	2	3/8	25/64	2-1/2	605643	605659
10 D	9/16 x 13-7/8	10 x 8	2	5/8	1	6	605644	605660
12 D	9/16 x 13-7/8	12 x 8	2	5/8	1	6	605645	605661
14 D	9/16 x 13-7/8	14 x 9	2	5/8	1	6	605646	605662
16 E	3/4 x 15-1/2	16 x 10	3	5/8	1	6	605647	605663
18 E	3/4 x 15-1/2	18 x 11	3	5/8	1	6	605648	605664
20 F	1 x 20-1/4	20 x 12	3	5/8	1	6	605649	605665
22 F	1 x 20-1/4	22 x 14	4	5/8	1	6	605650	605666
24 F	1 x 20-1/4	24 x 14	5	5/8	1	6	605651	-
25 F	1 x 20-1/4	25 x 14	4	5/8	1	6	605652	-

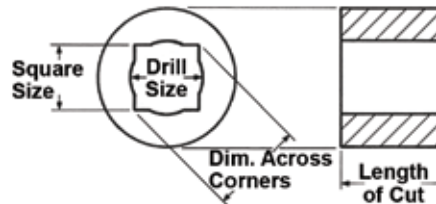
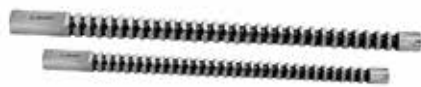
Metric Broach Shims



Broach Size	Shim Thickness (Inch)	Code	Broach Size	Shim Thickness (Inch)	Code	Broach Size	Shim Thickness (Inch)	Code
3 A	0.0310	605667	10 D	0.0560	605673	22 F	0.0560	605679
4 B1	0.0380	605668	12 D	0.0560	605674	24 F	0.0625	605680
5 B1	0.0500	605669	14 D	0.0625	605675	25 F	0.0560	605681
5 C	0.0470	605670	16 E	0.0560	605676			
6 C	0.0625	605671	18 E	0.0560	605677			
8 C	0.0500	605672	20 F	0.0625	605678			

Metric Square Broaches

High Speed Steel



Square Size (mm)	Tolerances Dec. Equiv. (Inch)	Broach Length (Inch)	Pilot Diameter (Inch)	Drill Size (mm)	Minimum Length of Cut (Inch)	Maximum Length of Cut (Inch)	Code
4	0.1575 - 0.1580	5-1/8	0.1614	4.10	1/4	1/2	605682
5	0.1968 - 0.1973	6-1/2	0.2047	5.20	1/4	1/2	605683
6	0.2362 - 0.2367	6-11/16	0.2510	6.40	1/4	3/4	605684
7	0.2756 - 0.2764	8	0.2913	7.40	3/8	1	605685
8	0.3150 - 0.3156	7-1/8	0.3307	8.40	3/8	1	605686
10	0.3937 - 0.3943	10-1/8	0.4094	10.40	3/8	1-1/4	605687
12	0.4724 - 0.4731	12	0.5039	12.80	1/2	1-3/8	605688
14	0.5512 - 0.5519	14-3/4	0.5826	14.80	1/2	1-1/2	605689

Metric Broach Bushings

Collared & Plain Types



Diameter (mm)	Collared Bushings			Plain Bushings		Diameter (mm)	Collared Bushings			Plain Bushings	
	A Bushings for A Broaches	B1 Bushings for B1 Broaches	C Bushings for C Broaches	D Bushings for D Broaches	E Bushings for E Broaches		A Bushings for A Broaches	B1 Bushings for B1 Broaches	C Bushings for C Broaches	D Bushings for D Broaches	E Bushings for E Broaches
6	605690	-	-	-	-	40	-	-	-	605720	-
8	605691	-	-	-	-	42	-	-	-	605721	-
10	605692	-	-	-	-	44	-	-	-	605722	-
12	605693	605695	-	-	-	45	-	-	-	605723	-
14	-	605696	-	-	-	46	-	-	-	605724	-
15	605694	605697	-	-	-	48	-	-	-	605725	-
16	-	605698	-	-	-	50	-	-	-	605726	-
17	-	605699	-	-	-	52	-	-	-	605727	605730
18	-	605700	605702	-	-	54	-	-	-	605728	605731
19	-	605701	605703	-	-	55	-	-	-	-	605732
20	-	-	605704	-	-	56	-	-	-	605729	605733
22	-	-	605705	-	-	58	-	-	-	-	605734
24	-	-	605706	-	-	60	-	-	-	-	605735
25	-	-	605707	-	-	62	-	-	-	-	605736
26	-	-	605708	-	-	63	-	-	-	-	605737
28	-	-	605709	-	-	64	-	-	-	-	605738
30	-	-	605710	-	-	65	-	-	-	-	605739
32	-	-	605711	605715	-	66	-	-	-	-	605740
34	-	-	605712	605716	-	68	-	-	-	-	605741
35	-	-	605713	605717	-	70	-	-	-	-	605742
36	-	-	605714	605718	-	72	-	-	-	-	605743
38	-	-	-	605719	-						

Square Broaches

High Speed Steel



Square Size (Inch)	Broach Length (Inch)	Pilot Diameter (Inch)	Drill Size	Minimum Length of Cut (Inch)	Maximum Length of Cut (Inch)	Code
1/8	4-1/8	0.1285	No. 30	3/16	1/2	605744
5/32	5-1/8	0.1590	No. 21	1/4	1/2	605745
3/16	5-9/16	0.1935	No. 10	1/4	5/8	605746
7/32	6-1/2	0.2280	No. 1	1/4	3/4	605747
1/4	6-1/2	0.2656	17/64	1/4	3/4	605748
9/32	7-3/4	0.2969	19/64	5/16	1	605749
5/16	7-7/8	0.3281	21/64	3/8	1	605750
11/32	9-3/8	0.3594	23/64	3/8	1-1/4	605751
3/8	9-3/8	0.3906	25/64	3/8	1-1/4	605752
13/32	10-5/8	0.4219	27/64	1/2	1-3/8	605753
7/16	10-7/8	0.4531	29/64	1/2	1-3/8	605754
15/32	12	0.5000	1/2	1/2	1-3/8	605755
1/2	12	0.5312	17/32	1/2	1-3/8	605756
9/16	14-3/4	0.5938	19/32	1/2	1-1/2	605757
5/8	16-5/16	0.6562	21/32	5/8	1-5/8	605758
11/16	17-3/4	0.7500	3/4	5/8	1-5/8	605759
3/4	17-3/4	0.8125	13/16	5/8	1-5/8	605760
7/8	22-3/4	0.9375	15/16	5/8	2	605761
1	24-1/8	1.0938	1-3/32	5/8	2	605762

Round Broaches High Speed Steel



Diameter (Inch)	Broach Length (Inch)	Pilot Diameter (Inch)	Drill Size (Inch)	Minimum Length of Cut (Inch)	Maximum Length of Cut (Inch)	Code
1/4	5-7/8	15/64	15/64	5/16	3/4	605763
5/16	5-7/8	19/64	19/64	5/16	3/4	605764
3/8	6-7/8	23/64	23/64	3/8	1	605765
7/16	6-7/8	27/64	27/64	3/8	1	605766
1/2	8	31/64	31/64	1/2	1-1/4	605767
5/8	8-1/2	39/64	39/64	1/2	1-1/4	605769
3/4	9-1/8	47/64	47/64	5/8	1-1/2	605771
7/8	9-1/4	55/64	55/64	5/8	1-1/2	605773
1	10-1/4	63/64	63/64	5/8	1-3/4	605775

Hexagonal Broaches High Speed Steel



Hex Size (Inch)	Broach Length (Inch)	Pilot Diameter (Inch)	Drill Size (Inch)	Minimum Length of Cut (Inch)	Maximum Length of Cut (Inch)	Code
1/8	4-1/8	1/8	1/8	3/16	3/8	605776
5/32	4-15/16	5/32	5/32	1/4	1/2	605777
3/16	5-1/16	3/16	3/16	1/4	5/8	605778
7/32	5-3/8	7/32	7/32	1/4	3/4	605779
1/4	6	1/4	1/4	1/4	3/4	605780
9/32	7-1/4	9/32	9/32	5/16	1	605781
5/16	7-3/4	5/16	5/16	3/8	1	605782
11/32	7-3/4	11/32	11/32	3/8	1-1/4	605783
3/8	8-1/2	3/8	3/8	3/8	1-1/4	605784
13/32	9-5/8	13/32	13/32	1/2	1-3/8	605785
7/16	10-5/8	7/16	7/16	1/2	1-3/8	605786
15/32	11-7/8	15/32	15/32	1/2	1-3/8	605787
1/2	11-7/8	1/2	1/2	1/2	1-3/8	605788
9/16	13-3/4	9/16	9/16	1/2	1-5/8	605789
5/8	16-1/4	5/8	5/8	5/8	2	605790
11/16	16-3/4	11/16	11/16	5/8	2	605791
3/4	17-1/4	3/4	3/4	5/8	2	605792
7/8	18-1/2	7/8	7/8	5/8	2	605793
1	19-3/4	1	1	5/8	2	605794

Keyseating Broaches High Speed Steel



Keyway Width (Inch)	Broach Length (Inch)	Tooth Pitch (Inch)	Height at Teeth (Inch)	Body Width (Inch)	Code
1/16	16	3/8	3/8	3/16	605795
3/32	16	3/8	3/8	3/16	605796
1/8	16	3/8	7/16	3/16	605797
5/32	16	3/8	1/2	5/32	605798
3/16	16	3/8	5/8	3/16	605799
1/4	16	3/8	3/4	1/4	605800
1/4	20	3/8	1	1/4	605801
5/16	16	3/8	7/8	5/16	605802
5/16	20	3/8	1	5/16	605803
3/8	16	17/32	7/8	3/8	605804
3/8	20	17/32	1	3/8	605805
7/16	20	17/32	1	7/16	605806
1/2	20	17/32	1	1/2	605807
9/16	20	17/32	1	9/16	605808
5/8	20	17/32	1	5/8	605809
3/4	20	17/32	1	3/4	605810
7/8	20	17/32	1	7/8	605811
1	20	17/32	1	1	605812

Production Broaches High Speed Steel



Shims or bushing not required

Broach Size (Inch)	Body Diameter (Inch)	Dimension (Inch)	Broach Length (Inch)	Minimum Length of Cut (Inch)	Maximum Length of Cut (Inch)	Code
1/16	3/16	0.224	5-5/8	13/64	1	605813
1/16	1/4	0.287	6-3/16	13/64	1	605814
1/8	3/8	0.437	8-1/2	17/64	1-1/4	605815
1/8	1/2	0.565	11-3/4	25/64	2-1/2	605816
1/8	9/16	0.630	11-3/4	25/64	2-1/2	605817
1/8	5/8	0.693	11-3/4	25/64	2-1/2	605818
3/16	5/8	0.716	14-3/4	25/64	2-1/2	605819
3/16	3/4	0.844	14-3/4	25/64	2-1/2	605820
3/16	7/8	0.970	14-3/4	25/64	2-1/2	605821
1/4	1	1.121	18	25/64	2-1/2	605822

One-Pass Broaches High Speed Steel



Style C bushings required

Broach Size (Inch)	Broach Dimensions (Inch)	Minimum Length of Cut (Inch)	Maximum Length of Cut (Inch)	Code
1/8 C	3/8 x 14-1/8	19/64	2	605823
5/32 C	3/8 x 14-1/8	19/64	2	605824
3/16 C	3/8 x 17	19/64	2	605825
1/4 C	3/8 x 17	19/64	2	605826
5/16 C	3/8 x 18-1/2	19/64	2	605827
3/8 C	3/8 x 18-1/2	19/64	2	605828

Metric Keyseating Broaches High Speed Steel



Broach Size (mm)	Keyway Width Tolerance (Inch)	Body Dimensions W x H x L	Minimum Length of Cut (Inch)	Maximum Length of Cut (Inch)	Code
2	0.0787 - 0.0792	3/16 x 3/8 x 16	5/8	1-7/8	605829
3	0.1181 - 0.1186	3/16 x 7/16 x 16	5/8	1-7/8	605830
4	0.1575 - 0.1580	3/16 x 1/2 x 16	5/8	1-7/8	605831
5	0.1968 - 0.1973	5 mm x 9/16 x 16	5/8	1-7/8	605832
6	0.2362 - 0.2367	6 mm x 3/4 x 16	5/8	1-7/8	605833
6	0.2362 - 0.2367	6 mm x 3/4 x 20	5/8	3-1/8	605834
8	0.3150 - 0.3155	8 mm x 7/8 x 16	1-1/16	3-3/16	605835
8	0.3150 - 0.3155	8 mm x 7/8 x 20	1-1/16	5-5/16	605836
10	0.3937 - 0.3942	10 mm x 7/8 x 20	1-1/16	5-5/16	605837
12	0.4724 - 0.4730	12 mm x 1 x 20	1-1/16	5-5/16	605838
13	0.5118 - 0.5125	13 mm x 1 x 20	1-1/16	5-5/16	605836
14	0.5612 - 0.5519	14 mm x 1 x 20	1-1/16	5-5/16	605840
16	0.8299 - 0.6306	16 mm x 1 x 20	1-1/16	5-5/16	605841
18	0.7087 - 0.7093	18 mm x 1 x 20	1-1/16	5-5/16	605842
20	0.7874 - 0.7883	20 mm x 1 x 20	1-1/16	5-5/16	605843
22	0.8661 - 0.8669	22 mm x 1 x 20	1-1/16	5-5/16	605844
24	0.9449 - 0.9458	24 mm x 1 x 20	1-1/16	5-5/16	605845
25	0.9843 - 0.9853	25 mm x 1 x 20	1-1/16	5-5/16	605846

NOW AVAILABLE



CNC Broaching System



- A patented solution for effective and efficient broaching and shaping operations
- For use with CNC lathes and machining centers, as well as conventional slotting and shaping machines
- Carbide inserts, tool holders and accessories designed for flexibility while delivery the rigidity and performance required

- Inch & Metric size Inserts & Tool Holders for Keyways & Slotting
- Eccentric Bushings
- Square Adapters
- Alignment Tools
- Sharpening Stems
- Insert Mounting Screws
- Torx Drivers
- Swivel Ball-Bearing Point Set Screws
- Square Tool Holders & Inserts
- Spline & External Spline Tool Holders
- Hexagon Tool Holders & Inserts
- Mini Tool Holders

ASK YOUR KAR DISTRIBUTOR FOR MORE DETAILS

Arbor Presses



- Easy to operate manual broaching machines
- Model 2R Arbor Press - Suitable for use with all standard broaches up to and including C series (3/8" or 10 mm)
- Model 3R Arbor Press - Suitable for use with all standard broaches up to and including D series (1/2" or 12 mm)

Model	Diameter Maximum (Inch)	Height Over Plate (Inch)	Leverage	Overall Height (Inch)	Pressure (Ton)	Weight (lbs)	Code
2R	12	17-1/4	45:1	32	3	220	218000
3R	21	20-1/2	55:1	35	5	517	218001



Broach Sets



- All Minute Man® Broach Sets are supplied in storage boxes, and come complete with precision broaches, slotted bushings, and necessary shims
- Collared bushings are recommended are supplied unless plain bushings are specified on your order

TiN coated sets available on request

No. 00 Precision Set

The most common keyway combinations for small keyways and bores.
3 broaches and 5 bushings = 15 keyway combinations
Collared bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
1/16 3/32 1/8	A	1/4, 5/16, 3/8, 7/16, 1/2	605500

No. 10 Standard Set

Our best selling broach set.
4 broaches and 9 bushings = 18 keyway combinations
Collared bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
1/8 3/16	B	1/2, 5/8, 3/4, 7/8	605501
1/4 3/8	C	1, 1-1/8, 1-1/4, 1-3/8, 1-1/2	

No. 10A Standard Set

Same as No. 10 Set, but for sixteenth-sized bores.
4 broaches and 9 bushings = 18 keyway combinations
Collared bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
1/8 3/16	B	9/16, 11/16, 13/16	605502
1/4 3/8	C	15/16, 1-1/16, 1-3/16, 1-5/16, 1-7/16, 1-9/16	

No. 10-10A Combination Set

Combines 10 and 10A sets features all bore sizes in 1/16 inch increments for keyways 1/8 to 3/8 inches.
4 broaches and 18 bushings = 36 keyway combinations
Collared bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
1/8 3/16	B	1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8	605503
1/4 3/8	C	15/16, 1, 1-1/16, 1-1/8, 1-3/16, 1-1/4, 1-5/16, 1-3/8, 1-7/16, 1-1/2, 1-9/16	

No. 20 Combination Set

Same as No. 10-10A combination set plus a 5/16" keyway for 11 extra combinations
5 broaches and 18 bushings = 47 keyway combinations
Collared bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
1/8 3/16	B	1/2, 9/16, 5/8, 11/16, 3/4, 13/16, 7/8	605504
1/4 5/16 3/8	C	15/16, 1, 1-1/16, 1-1/8, 1-3/16, 1-1/4, 1-5/16, 1-3/8, 1-7/16, 1-1/2, 1-9/16	

No. 40A Set

The most common keyway combinations for medium sized keyways and bores.
4 broaches and 8 bushings = 32 keyway combinations
Plain bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
5/16 3/8 7/16 1/2	D	1-1/2, 1-5/8, 1-3/4, 1-7/8, 2, 2-1/8, 2-1/4, 2-1/2	605505

No. 40 Set

Same as No. 40A, but for sixteenth sized bores.
4 broaches and 8 bushings = 32 keyway combinations
Plain bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
5/16 3/8 7/16 1/2	D	1-7/16, 1-9/16, 1-11/16, 1-13/16, 1-15/16, 2-3/16, 2-7/16, 2-15/16	605506

No. 40-1/2A Heavy Duty Set

The most common keyway combinations for large keyways and bores.
2 broaches and 6 bushings = 12 keyway combinations
Plain bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
5/8 3/4	E	2-3/8, 2-1/2, 2-5/8, 2-3/4, 2-7/8, 3	605507

Broach Sets (continued)



No. 40-1/2 Heavy Duty Set

Same as No. 40-1/2A
but for sixteenth sized bores.
2 broaches and 6 bushings = 12 keyway combinations

Plain bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
5/8 3/4	E	2-5/16, 2-7/16, 2-9/16, 2-11/16, 2-13/16, 2-15/16	605508

No. 50 Heavy Duty Set

Includes the most common keyway combinations for medium and large keyways.
3 broaches and 17 bushings = 29 keyway combinations

Plain bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
1/2	D	2, 2-1/16, 2-1/8, 2-3/16, 2-1/4	605509
5/8 3/4	E	2-5/16, 2-3/8, 2-7/16, 2-1/2, 2-9/16, 2-5/8, 2-11/16, 2-3/4, 2-13/16, 2-7/8, 2-15/16, 3	

No. 60 Metric Set

The most common metric keyway combination for small keyways and bores.
2 broaches and 3 bushings = 6 keyway combinations

Collared bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
2 mm 3 mm	A	6, 8, 10 mm	605510

No. 70 Metric Set

Our most popular metric broach set.
4 broaches and 13 bushings = 26 keyway combinations

Collared bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
4 mm 5 mm	B-1	12, 14, 15, 16 mm	605511
6 mm 8 mm	C	18, 19, 20, 22, 24, 25, 26, 28, 30 mm	

No. 80 Metric Set

The most common metric keyway combination for medium-sized keyways and bores.
3 broaches and 12 bushings = 36 keyway combinations

Plain bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
10 mm 12 mm 14 mm	D	32, 34, 35, 36, 38, 40, 42, 44, 45, 46, 48, 50 mm	605512

No. 90 Metric Set

The most common metric keyway combination for large keyways and bores.
2 broaches and 8 bushings = 16 keyway combinations

Plain bushings only

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
16 mm 18 mm	E	52, 54, 55, 56, 58, 60, 62, 65	605513

No. 100 Heavy Duty Combination Set

The most complete Minute Man® Broach Set available including all popular combinations without duplication. This set is supplied in three wood boxes for convenient handling and storage, and comes with broaches, slotted bushings, and necessary shims.
9 broaches and 44 bushings = 102 keyway combinations

*Collared bushings B & C
Plain bushings D & E*

Keyway Sizes	Broach Style	Bushing Diameters (Bore Sizes)	Code
1/8 3/16	B	1/2, 9/16 5/8, 11/16, 3/4, 13/16, 7/8	605514
1/4 5/16	C	15/16, 1, 1-1/16, 1-1/8, 1-3/16, 1-1/4 1-5/16, 1-3/8, 1-7/16, 1-1/2, 1-9/16 1-7/16, 1-1/2, 1-9/16, 1-5/8	
3/8 7/16 1/2	D	1-11/16, 1-3/4 1-13/16, 1-7/8, 1-15/16, 2, 2-1/16, 2-1/8, 2-3/16, 2-1/4	605514
5/8 3/4	E	2-5/16, 2-3/8, 2-7/16, 2-1/2, 2-9/16, 2-5/8, 2-11/16, 2-3/4 2-13/16, 2-7/8, 2-15/16, 3	