



### *Doppler Gear TechBit: Broaching*

Attached you will find some information regarding stocked broach tooling.

If you don't see a tool that matches your requirement, contact us. We have hundreds of additional broaches including most standard keyways.

#### Typical One Pass Internal Broach

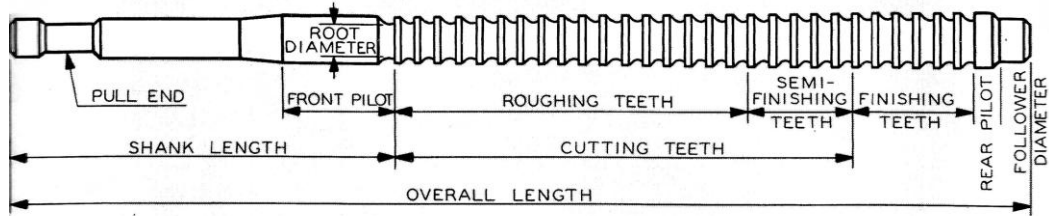


FIG. 44—Typical internal round broach.

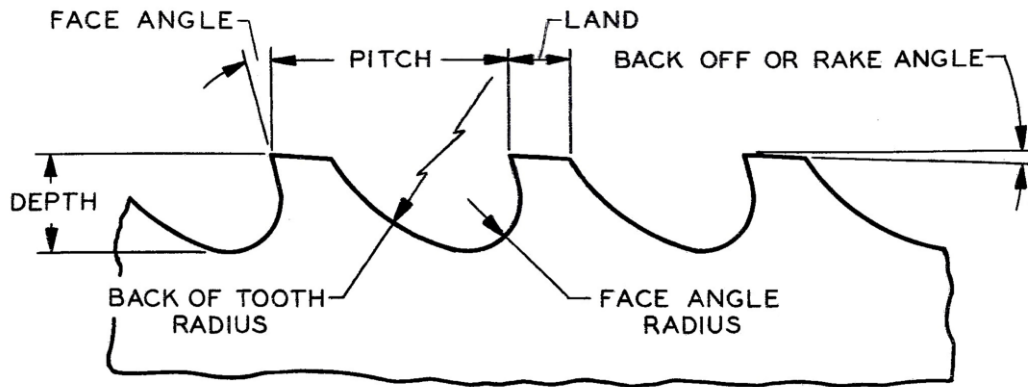
Broaching is one of the most highly productive machining processes. It removes a significant amount of material in a precise and repeatable way. Generally a long tool called a broach is pulled through a hole in the part removing material with each successive row of “teeth” on the broach.

Please visit the **TECHNICAL RESOURCES** page on our website [www.dopplergear.com](http://www.dopplergear.com) for listings of standard stocked tools.



Some things to consider when broaching:

**Material**  
**Hardness**  
**Length of cut**  
**Clearances and a "through" hole**



Typical broach tooth form

If your part does not have a through hole or the volume does not justify broaching, contact us to see if gear, form, or keyway shaping is the right process for you.



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