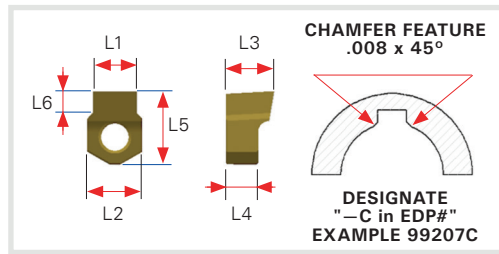


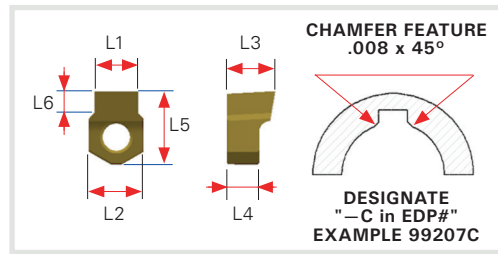
Broaching and Slotting Inserts - Imperial



Inserts (inch) - Tolerances															To order a different tolerance - EDP# + (TOLERANCE) = 99202P9	
EDP No.	L1 (Inch)	H-7 (Standard)		P-9		D-10		C-11		L2 (Inch)	L3 (Inch)	L4 (Inch)	L5 (Inch)	L6 (Inch)	Tool Holder Size	Sharpen Stem
		L1 (High)	L1 (Low)	L1 (High)	L1 (Low)	L1 (High)	L1 (Low)	L1 (High)	L1 (Low)							
99202		0.09410	0.09370											0.0551		
99202()	3/32			0.09360	0.09260	0.09610	0.09570	0.09850	0.09810	0.1968	0.2362	0.1968	0.2559	0.0551	2	SS-0
99202C*		0.09410	0.09370											0.0520		
99203		0.12550	0.12551											0.0905		
99203()	1/8			0.12460	0.12340	0.12810	0.12770	0.13070	0.13030	0.2362	0.2755	0.1968	0.3149	0.0905	3	SS-1
99203C*		0.12550	0.12551											0.0740		
99206		0.15670	0.15652											0.1141		
99206()	5/32			0.15590	0.15470	0.15930	0.15892	0.16200	0.16160	0.2362	0.2755	0.1968	0.3149	0.1141	4	SS-1
99206C*		0.15670	0.15652											0.0790		
99207		0.18800	0.18778											0.1299		
99207()	3/16			0.18710	0.18590	0.19060	0.19020	0.19320	0.19280	0.2362	0.2755	0.1968	0.3149	0.1299	5	SS-1
99207C*		0.18800	0.18778											0.1050		
99209		0.25080	0.25040											0.1587		
99209()	1/4			0.24940	0.24800	0.25390	0.25350	0.25670	0.25630	0.3968	0.3543	0.2362	0.5314	0.1587	6	SS-2
99209C*		0.25080	0.25040											0.1360		
99210		0.28180	0.28160											0.1692		
99210()	9/32			0.28060	0.27920	0.28510	0.28470	0.28790	0.28750	0.3968	0.3543	0.2362	0.5314	0.1692	8	SS-2
99210C*		0.28180	0.28160											0.1520		
99212		0.31310	0.31270											0.1875		
99212()	5/16			0.31190	0.31050	0.31640	0.31600	0.31920	0.31880	0.3968	0.3543	0.2362	0.5314	0.1875	8	SS-2
99212C*		0.31310	0.31270											0.1670		
99213		0.37560	0.37520											0.2500		
99213()	3/8			0.37440	0.37300	0.37890	0.37850	0.38170	0.38130	0.5157	0.5511	0.3937	0.7283	0.2500	10	SS-3
99213C*		0.37560	0.37520											0.1990		
99214		0.43820	0.43780											0.2500		
99214()	7/16			0.43680	0.43510	0.44220	0.44180	0.44560	0.44520	0.5157	0.5511	0.3937	0.7283	0.2500	12	SS-4
99214C*		0.43820	0.43780											0.2300		
99215		0.50070	0.50030											0.3000		
99215()	1/2			0.49930	0.49760	0.50470	0.50430	0.50810	0.50760	0.5157	0.5511	0.3937	0.7283	0.3000	12	SS-4
99215C*		0.50070	0.50030											0.2610		
99242		0.56320	0.56280											0.2750		
99242()	9/16			0.56180	0.56010	0.56720	0.56680	0.57060	0.57020	0.7086	0.5511	0.3937	0.8661	0.2750	14/16	SS-4
99242C*		0.56320	0.56280											0.2670		
99216		0.62570	0.62530											0.3120		
99216()	5/8			0.62430	0.62240	0.62970	0.62930	0.63310	0.63270	0.7086	0.5511	0.3937	0.8661	0.3120	14/16	SS-4
99216C*		0.62570	0.62530											0.3024		
99217		0.75080	0.75040											0.3930		
99217()	3/4			0.74910	0.74710	0.75590	0.75550	0.75940	0.75900	1.0236	0.7086	0.3937	1.1811	0.3930	18/26	SS-5
99217C*		0.75080	0.75040											0.3860		
99218		0.87579	0.87559											0.4330		
99218()	7/8			0.8743	0.8738	0.88090	0.88050	0.88450	0.88410	1.0236	0.7086	0.3937	1.1811	0.4330	18/26	SS-5
99218C*		0.87579	0.87559											0.4030		
99219		1.00150	1.00250											0.5410		
99219()	1			0.9993	0.9988	1.00590	1.00550	1.00960	1.00910	1.0236	0.7086	0.3937	1.1811	0.5410	18/26	SS-5
99219C*		1.00150	1.00250													

*Chamfer feature providing a 45° Chamfer at the intersection of the bore and the walls of the broached section when cut to full depth is available by specifying a "C" in the EDP No. for example --- 99408-C.

Broaching and Slotting Inserts - Metric



Inserts (mm) - Tolerances															To order a different tolerance - EDP# + (TOLERANCE) = 99202P9	
EDP No.	L1 (mm)	H-7 (Standard)		P-9		D-10		C-11		L2 (mm)	L3 (mm)	L4 (mm)	L5 (mm)	L6 (mm)	Tool Holder Size	Sharpen Stem
		L1 (High)	L1 (Low)	L1 (High)	L1 (Low)	L1 (High)	L1 (Low)	L1 (High)	L1 (Low)							
99401	2	0.07910	0.07810							5.00	6.50	5.00	6.00	1.30	2	SS-0
99401()				0.07850	0.07750	0.08540	0.08110	0.08350	0.08300					1.30		
99401C*		0.07910	0.07810											1.09		
99402	3	0.11860	0.11830							6.08	6.50	5.00	7.50	2.00	3	SS-1
99402()				0.11790	0.11690	0.12090	0.12047	0.12280	0.12244					2.00		
99402C*		0.11860	0.11830											1.42		
99403	4	0.15800	0.15767							6.08	7.00	5.00	8.00	2.60	4	SS-1
99403()				0.15710	0.15590	0.16020	0.15984	0.16220	0.16180					2.60		
99403C*		0.15800	0.15767											2.07		
99404	5	0.19730	0.19705							6.08	7.00	5.00	8.00	3.00	5	SS-1
99404()				0.19650	0.19530	0.19960	0.19920	0.20160	0.20118					3.00		
99404C*		0.19730	0.19705											2.74		
99406	6	0.23680	0.23650							10.08	9.00	6.00	13.50	4.00	6	SS-2
99406()				0.23560	0.23420	0.23940	0.23897	0.24090	0.24055					4.00		
99406C*		0.23680	0.23650											3.00		
99407	8	0.31560	0.31527							10.08	9.00	6.00	13.50	4.50	8	SS-2
99407()				0.31440	0.31300	0.31810	0.31770	0.32050	0.32010					4.50		
99407C*		0.31560	0.31527											3.78		
99408	10	0.39430	0.39410							13.10	14.00	10.00	18.50	6.00	10	SS-3
99408()				0.39300	0.39130	0.39720	0.39680	0.40000	0.39960					6.00		
99408C*		0.39430	0.39410											3.88		
99409	12	0.47310	0.47280							13.10	14.00	10.00	18.50	6.50	12	SS-3
99409()				0.47170	0.47000	0.47600	0.47560	0.47950	0.47910					6.50		
99409C*		0.47310	0.47280											3.89		
99410	14	0.55190	0.55157							18.00	14.00	10.00	22.00	7.00	14/16	SS-4
99410()				0.55050	0.54880	0.55510	0.55472	0.55910	0.55860					7.00		
99410C*		0.55190	0.55157											4.71		
99411	16	0.63060	0.63030							18.00	14.00	10.00	22.00	8.00	14/16	SS-4
99411()				0.62920	0.62750	0.63390	0.63346	0.63780	0.63740					8.00		
99411C*		0.63060	0.63030											5.53		
99412	18	0.70950	0.70905							26.00	18.00	10.00	30.00	9.00	18/26	SS-5
99412()				0.70780	0.70580	0.71450	0.71413	0.71810	0.71770					9.00		
99412C*		0.70950	0.70905											5.67		
99413	20	0.78820	0.78780							26.00	18.00	10.00	30.00	10.00	18/26	SS-5
99413()				0.78650	0.78450	0.79330	0.79287	0.79690	0.79645					10.00		
99413C*		0.78820	0.78780											6.29		
99414	22	0.86700	0.86650							26.00	18.00	10.00	30.00	11.00	18/26	SS-5
99414()				0.86520	0.86320	0.87200	0.87160	0.87560	0.87519					11.00		
99414C*		0.86700	0.86650											6.79		
99494	25	0.98510	0.98464							26.00	18.00	10.00	30.00	12.00	18/26	SS-5
99494()				0.98340	0.98140	0.99010	0.98970	0.99370	0.99330					12.00		
99494C*		0.98510	0.98464											7.02		

*Chamfer feature providing a 45° Chamfer at the intersection of the bore and the walls of the broached section when cut to full depth is available by specifying a "C" in the EDP No. for example --- 99402-C.

The Inserts designed to work exclusively with duMONT Tool Holders are a sintered steel alloy with a 13% cobalt content, heat treated to a 72 HRC hardness providing toughness and impact resistance. A TiN coating is applied to improve wear resistance and lubricity. All Inserts are designed to allow several re-sharpenings. Stock Insert specifications and mild steel application data are provided. A Chamfer Feature is available (see footnote*). See the Engineering Section for process and Special Insert information and available applications — Keyways in Tapered Bore, Square, Hexagon and Involute Internal Gears. We can add custom corner radius per your requirement, allow up to 2 weeks for modification and recoating.