

Program for CNC Keyway Broaching

For HAAS CNC MILL

**Try using this format to reduce programming time.
Just enter your broach information in the fields shown.**

%
O1234 (USE A WORK OFFSET FOR BROACH TOOL BY IT SELF)
(YOU CAN ADJUST THE LOCATION IN X OR Y DEPENDING ON KEYWAY
LOCATION)
(ALSO THE CODE IS WRITTEN FROM CENTER OF HOLE)
(THIS SAMPLE IS WRITTEN TO CUT KEY WAY AT 12 O ' CLOCK)
G91 G28 Z0

T__ M06 (ENTER YOUR BROACH TOOL # HERE)

G00 G90 G59 X0 Y0
M05
M19
G43 H__ Z1.0 (ENTER HEIGHT OFF-SET NUMBER HERE)
Z0.5
M08

(** L # MUST BE THE TOTAL DEPTH OF KEY WAY DIVIDED BY THE D.O.C.)
(IE... IF KEYWAY IS .130 DEEP AND D.O.C. IS .001 THEN L IS = L130)
(.130 / .001 = 130)
(L= TOTAL DEPTH / D.O.C.)

M97 P100 L130 (** ENTER NUMBER OF PASS HERE NO DECIMAL)

G00 G90 Z1.0 M09
G91 G28 Z0
G28 Y0
M30€

N100 (LOCAL BROACH SUB)

G00 G91 Y.001 (** YOU CAN CHANGE TO X IF KEYWAY IS IN THAT DIRECTION)

G01 G90 Z_____ F_____ (END POINT -Z OF BROACH & FEED RATE IPM)

G00 G91 Y -.300 (** THIS MUST BE SAME LETTER AS PREVIOUS MOVE X OR Y)
(** MUST BE OPPOSITE SIGN TOO + OR -)
(VALUE MUST BE LARGER THAN TOTAL DEPTH OF KEY WAY)

G90 Z.5

G91 Y.300 (** THIS VALUE MUST MATCH PREVIOUS LETTER AND #)
(BUT IT WILL BE OPPOSITE SIGN + OR -)

M99
%

