

*The Design of CNC Broach
Tools and Inserts are
Proprietary and Protected
by USA Patent #8,622,669,B2*



*The Only Inserted CNC
Broaching System
Manufactured in the USA™*



CNC Keyway Broaching Template

- for OKUMA CNC Mill -

For customers who need a complete and reliable solution, we recommend using our Keyway Broach Program Generator, which automatically builds CNC code for keyways.

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%  
BROACH MAIN.MIN  
(USE A WORK OFFSET FOR BROACH TOOL BY ITSELF)  
(ADJUST THE LOCATION IN X OR Y DEPENDING ON KEYWAY LOCATION)  
(CODE IS WRITTEN FROM CENTER OF HOLE)  
(EXAMPLE IS WRITTEN TO CUT KEY WAY AT 12 O' CLOCK)  
(THERE ARE 2 FILES- ONE IS MAIN PROGRAM, ONE IS SUB PROGRAM)  
  
G00 Z20.  
T__ M06 (ENTER YOUR BROACH TOOL # HERE)  
G15 H59  
G00 G90 X0 Y0  
M05  
M19  
G56 H_ Z1.0 (ENTER HEIGHT OFF-SET NUMBER HERE)  
Z0.5 M08  
(THE Q # EQUALS THE TOTAL DEPTH OF KEY WAY DIVIDED BY D.O.C.)  
(IF KEYWAY IS .130 DEEP AND D.O.C. IS .001 THEN Q = 130 )  
N001 PSUB.MIN Q130 ( *** ENTER Q DIGITS HERE NO SPACE, NO DECIMAL)  
G00 G90 Z20. M09  
G28 Y20.  
M30  
%  
  
%  
SUB.MIN  
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 -)  
G90 Z.5 (Z VALUE MUST BE LARGER THAN TOTAL DEPTH OF KEY WAY BY .125" MIN)  
G91 Y.300 (** THIS VALUE MUST MATCH PREVIOUS LETTER AND # )  
(BUT IT WILL BE OPPOSITE SIGN + OR - )  
GOTO N001  
%
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