

*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 LATHE -**

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

```
%  
(CNC SAMPLE OKUMA LATHE BROACH PROGRAM) ;  
(ENTER THE VALUES BELOW FOR YOUR TOOL AND PART) ;  
G00 X20. Z20.  
T____ (ENTER TOOL # HERE EXAMPLE IF TOOL # IS 5 THEN T0505) ;  
M05;  
M19;  
G00 X_____ Z_____ (X & Z STARTING POSITION) ;  
M08 ;  
G94 ;
```

```
(ENTER VALUES IN G71 LINE BELOW) ;  
( X=FINAL POSITION Z=FINAL POSITION ) ;  
(D=DEPTH OF CUT, H=DEPTH OF KEY WAY, U=FINISH PASS) ;  
(F=FEED RATE IPM);
```

```
M22 ;  
G71 M32 X_____ Z_____ D_____ H_____ U_____ F_____ ;  
G00 Z1.0 M09 ;  
G95;  
X20. Z20.  
M30 ;  
%
```