

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™



Program for CNC Keyway Broaching

FOR FADEL CNC MILL

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%  
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 )  
( THIS IS 2 FILES ONE IS MAIN PROGRAM ONE IS SUB PROGRAM )  
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. )  
  
M98 P100 L130 ( *** ENTER NUMBER OF PASS HERE NO DECIMAL )  
  
G00 G90 Z1.0 M09  
G91 G28 Z0  
G28 Y0  
M30  
%  
  
%  
O100 ( SEPARATE FILE SUB PROGRAM )  
  
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 )  
( CHECK CLEARANCE BETWEEN THE BORE AND BACKSIDE OF THE TOOL TO AVOID CRASH )  
  
G90 Z.5  
  
G91 Y.300 ( *** THIS VALUE MUST MATCH PREVIOUS LETTER AND # )  
( BUT IT WILL BE OPPOSITE SIGN + OR - )  
  
M99  
%
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