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Checking for Sharpness of a Broach

There are a number of objective signs that may be observed by the operator which indicate the need for resharpening/reconditioning a broach. The following is a n*on-exhaustive* list of signs for the operator to look for. If any of the signs are present, the broach should be taken out of production and resharpened/reconditioned.

1. POOR PART FINISH
    a. *I.e.*, tearing, rough finish, excessive burrs, or out-of-tolerance dimensions.

2. INCREASE IN HYDRAULIC PRESSURE REGISTERED ON MACHINE'S PRESSURE GAGE
    a. Note: Operator should regularly check the pressure gage for any inconsistencies. Consistent broaching at increased pressures is a clear signal that the broach has become dull.

3. SOUND MADE BY TOOL WHEN CUTTING
    a. Note: Operator should be alert to any change in the normal cutting sound, as this is often an early sign of tool wear.

4. VISUAL INSPECTION OF TOOL (*SEE ATTACHED DRAWING*)
    a. Operator should frequently inspect the tool, as the presence of any of the following conditions indicates the need for resharpening/reconditioning:
        i. "build-up" of material on cutting faces;
        ii. "packing of chips" in the chip pockets;
        iii. excessive wear on lands of teeth (*i.e.*, .005" wear on ANY tooth)
        iv. nicks and/or burning of the cutting edges;
        v. "rollover" of the cutting edges.

In addition to the above objective signals, the operator/tool department may wish to establish production "norms" (*i.e.*, the establishment of the number of parts produced per sharpening to govern the tool maintenance interval.).

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Being conscientious of the above factors and the establishment of production norms is the best way to ensure maximum tool life and tool performance.