

Guidelines for Contract Broaching

- ❖ The strength of the material to be broached must be between 400 and 1000 N/mm².
- ❖ Only clean and deburred workpieces can be broached.
- ❖ The pre-drilled hole dimension must fall within the tolerances we specify.
- ❖ The length of the hole to be broached must fall within the specified broaching length of the tool.
- ❖ The contact surface and the pilot hole must be perpendicular to each other. If multiple stacked parts are broached at once, both sides must be plane-parallel.
- ❖ With thin-walled workpieces, deformation of the workpiece may occur during the broaching process.
- ❖ For all internal broaching operations, it must be anticipated that tools that are not guided will result in a lateral deviation of the broached profile. Further machining may only be performed based on the broached profile.
- ❖ The delivery and return of workpieces for broaching are at the customer's expense and risk. Risk passes to the customer upon shipment. This applies even if the workpieces are delivered freight prepaid.
- ❖ If broaching work involves small quantities, our minimum order value will be charged.
- ❖ If broached parts are delivered with dimensional errors in the mounting dimensions, we reserve the right to either return the parts for rework or, upon request, to rework them for a fee, provided this is possible at our facility.
- ❖ The risk for manufacturing scrap must be borne by the customer.
- ❖ If, during broaching operations—due to material that is difficult to machine or inadequate preparation of the parts to be broached—additional sharpening of the broaching tools is required, these costs will be billed separately.
- ❖ If the tool breaks as a result of poor preparatory work or material defects in the parts to be broached, these costs shall also be borne by the customer.
- ❖ In all other respects, the terms of delivery of the German Precision Tool Association shall apply.

Effective March 1, 2026

The delivered goods remain our property until full payment has been made (goods subject to retention of title). The buyer is not authorized to dispose of the goods subject to retention of title. Complaints can only be considered within 8 days of receipt of the goods.
Information on the processing of your personal data in accordance with Articles 13 and 14 of the EU GDPR can be found at the following link:
<https://www.lochergmbh.de/datenschutz.html>

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