1. Mechanize bushing (Picture 1)

2. Take the measurement of the tooth bottom of the brush. In this case the 18mm broach. (Picture 2)

3. Next step: to reduce the bushing in the milling center. Milling height “d” will be obtained from summing up the constant “h” and “b” (Picture 3)

4. The milling cutter to use in this case is the constant “a”, that is to say, 19,5 mm (Picture 2)

Height “h” will be obtained from applying the following formula

\[ h = r - \frac{1}{2} \sqrt{4r^2 - c^2} \]

\[ h = 30 - \frac{1}{2} \sqrt{4 \times 30^2 - 18^2} \]

\[ h = 30 - \frac{1}{2} \sqrt{3600 - 324} \]

\[ h = 30 - 0,5 \sqrt{3276} = 57,236 \]

\[ h = 0,5 \times 57,236 = 28,618 \]

\[ h = 30 - 28,618 = 1,381 \]

\[ h = 1,38 \]