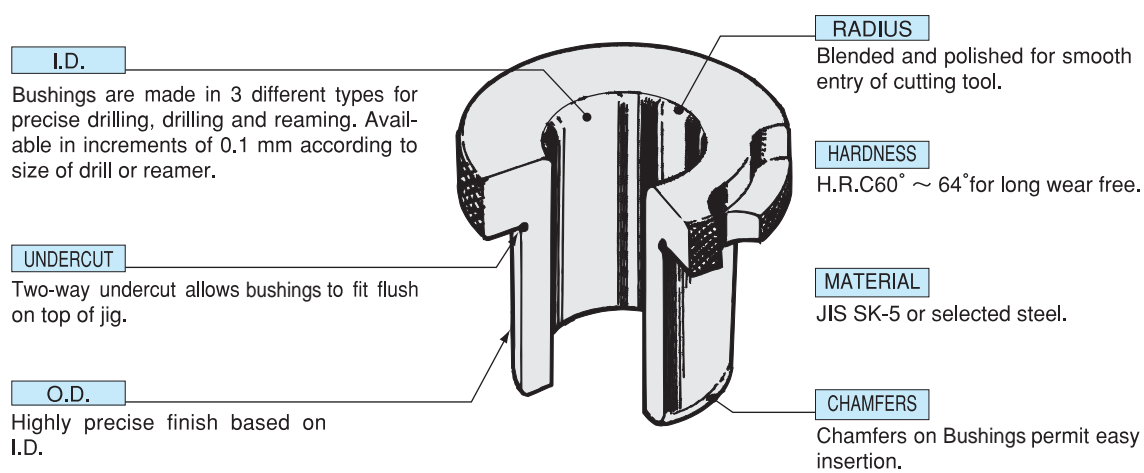


Drill Jig Bushing



Type	PRESS FIT BUSHING		RENEWABLE BUSHING
Designation	HEADLESS Type A	HEADED Type B	ROUND Type C
Tool applied			
Shape and sequence of fitting-in			
Sectional view			

HOW TO INSTALL A JIG BUSHING	
PRESS FIT BUSHING Type A, B, G	RENEWABLE BUSHING Type C, D, E, F
<p>How to press-fit</p> <p>Press the bushing correctly into the bush plate.</p>	<p>Renewable bushing can be inserted by hand.</p>

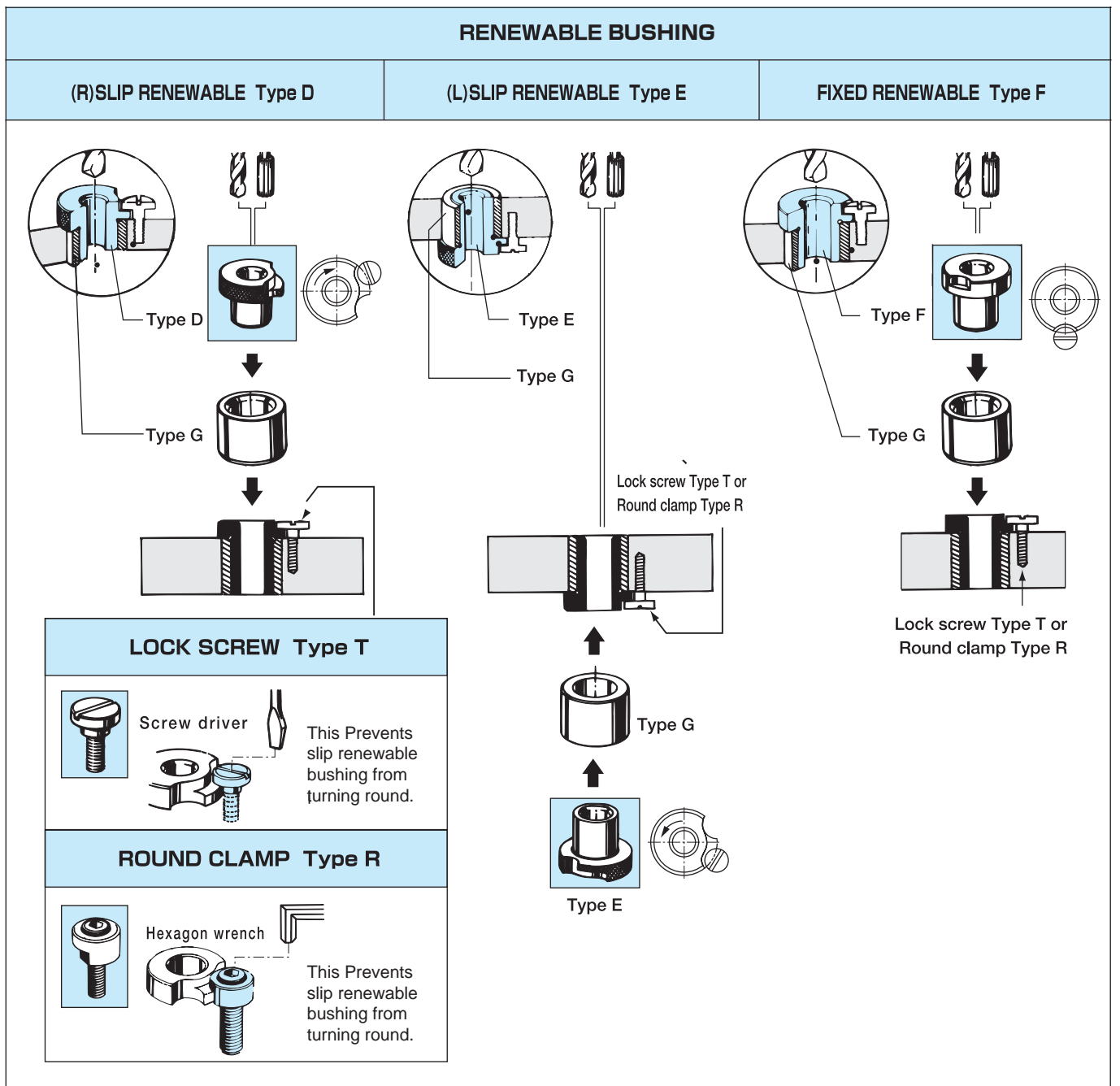
Bushings that have the same O.D. are interchangeable with each other.

LINER BUSHING Type G

This Guides the renewable bushing for smoother insertion or replacement.

Name	Press fit bushing		Renewable bushing				Headless liner bushing	Lock screw	Round clamp
	Headless	Headed	Round	Right slip	Left slip	Fixed			
Shape									
Higher accuracy	SA	SB	SC	SD	SE	SF	G	T	R
Standard accuracy	A	B	C	D	E	F			
Reaming	—	BR	CR	DR	ER	FR			

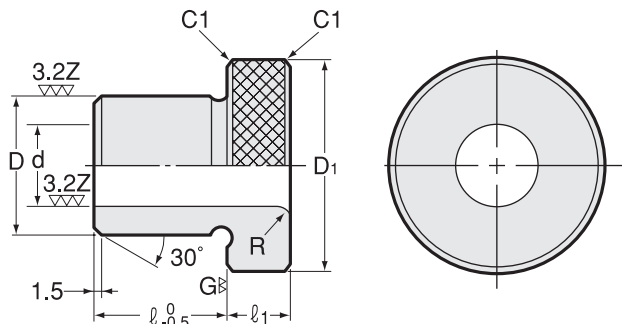
S...for higher accuracy R...for reaming



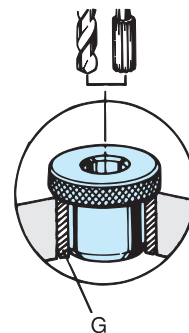
Type C

Round Renewable Bushing Type C

BT
CAT
AHO
HSK-A/E/F/C
HSK-T
UTS
Specialized Machine
Related Equipment
Bushing & Chamfering Drill



Example



※ 1. Bushing with I.D. size smaller than 3.0mm uses 30 degree chamfered radius (R).

Drill Jig Bushing

Application

Round renewable bushing can be frequently used in following cases.

1. Hole size differs from one workpiece to another.
2. Drilling requires two or more different drills, or reaming is necessary after being drilled.

Chamfering Cutter Series

Tolerance of I.D.

d	1.6 ~ 3.0	3.1 ~ 6.0	6.1 ~ 10.0	10.1 ~ 18.0	18.1 ~ 30.0	30.1 ~ 42.0
SC (G6)	+0.008 +0.002	+0.012 +0.004	+0.014 +0.005	+0.017 +0.006	+0.020 +0.007	+0.025 +0.009
C	+0.025 +0.002	+0.030 +0.004	+0.036 +0.005	+0.043 +0.006	+0.052 +0.007	+0.062 +0.009
CR	+0.014 +0.008	+0.020 +0.012	+0.024 +0.015	+0.029 +0.018	+0.034 +0.021	+0.041 +0.025

Chamfering Series

Concentric runout (T.I.R.) of O.D.to I.D.

d	1.6 ~ 18.0	18.1 ~ 42.0
SC/CR	0.005 or less	0.008 or less
C	0.012 or less	0.020 or less

1. Round renewable bushing can be used in combination with headless liner bushing (Type G).
2. O.D.(D) of round renewable bushing must coincide with I.D.(d) of headless liner bushing.

SC..... For higher accuracy
 C..... For standard accuracy
 CR..... For reaming

d	D (m5)	D1	ℓ 1	R	Grade	ℓ							
						12	16	20	25	30	35	45	
1.6 ~ 2.0	8	+0.012 +0.006	16	8	※ 1	SC	○						
						C	○						
2.1 ~ 3.0	8	+0.012 +0.006	16	8	※ 1	SC	○						
						C	○						
3.1 ~ 4.0	8	+0.012 +0.006	16	8	1	SC	○	○					
						C	○	○					
4.1 ~ 6.0	10	+0.012 +0.006	19	8	1	SC	○	○					
						C	○	○					
6.1 ~ 8.0	12	+0.015 +0.007	22	8	2	SC		○	○				
						C		○	○				
8.1 ~ 10.0	15	+0.015 +0.007	26	9	2	SC		○	○				
						C		○	○				
10.1 ~ 12.0	18	+0.015 +0.007	30	9	2	SC			○	○			
						C			○	○			
12.1 ~ 15.0	22	+0.017 +0.008	35	12	2	SC			○	○			
						C			○	○			
15.1 ~ 18.0	26	+0.017 +0.008	40	12	2	SC				○	○		
						C				○	○		
18.1 ~ 22.0	30	+0.017 +0.008	47	12	3	SC				○	○		
						C				○	○		
22.1 ~ 26.0	35	+0.020 +0.009	55	15	3	SC					○	○	
						C					○	○	
26.1 ~ 30.0	42	+0.020 +0.009	62	15	3	SC					○	○	
						C					○	○	
30.1 ~ 35.0	48	+0.020 +0.009	69	15	4	SC						○	○
						C						○	○
35.1 ~ 42.0	55	+0.024 +0.011	77	15	4	SC						○	○
						C						○	○

List prices of type CR are identical to those of type SC.

Ordering Example

SC - 6.0 × 12
 d ℓ

Code

0000 032 060 12
 Code
 C:031
 SC:032
 CR:033
 d ℓ

BT

CAT

AHO

HSK-A/EF/C

HSK-T

UTS

Specialized Machine

Related Equipment

Bushing & Chamfering Drill

Drill Jig Bushing

Chamfering Cutter Series

Chamfering Series