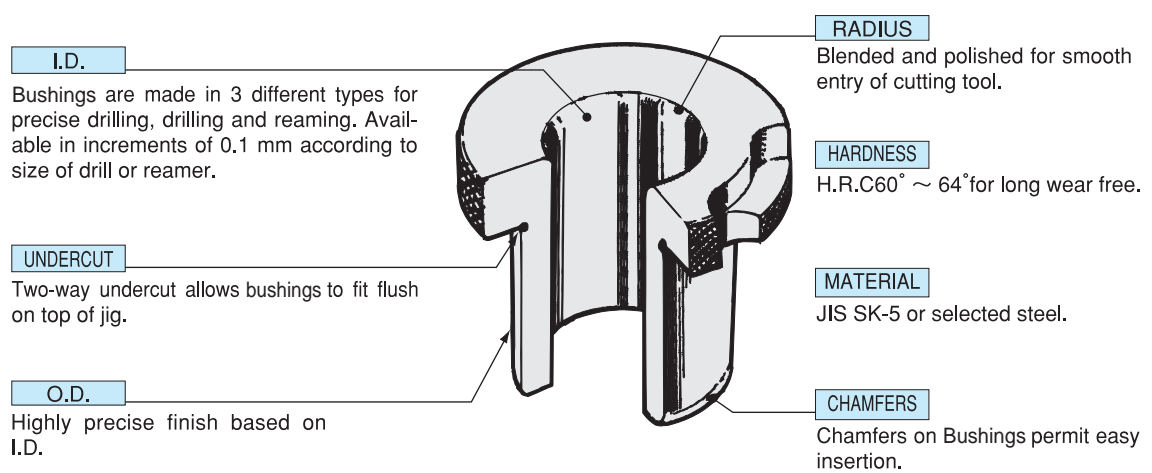


## Drill Jig Bushing



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><b>How to press-fit</b></p> <p>Press the bushing correctly into the bush plate.</p>	<p>Renewable bushing can be inserted by hand.</p>

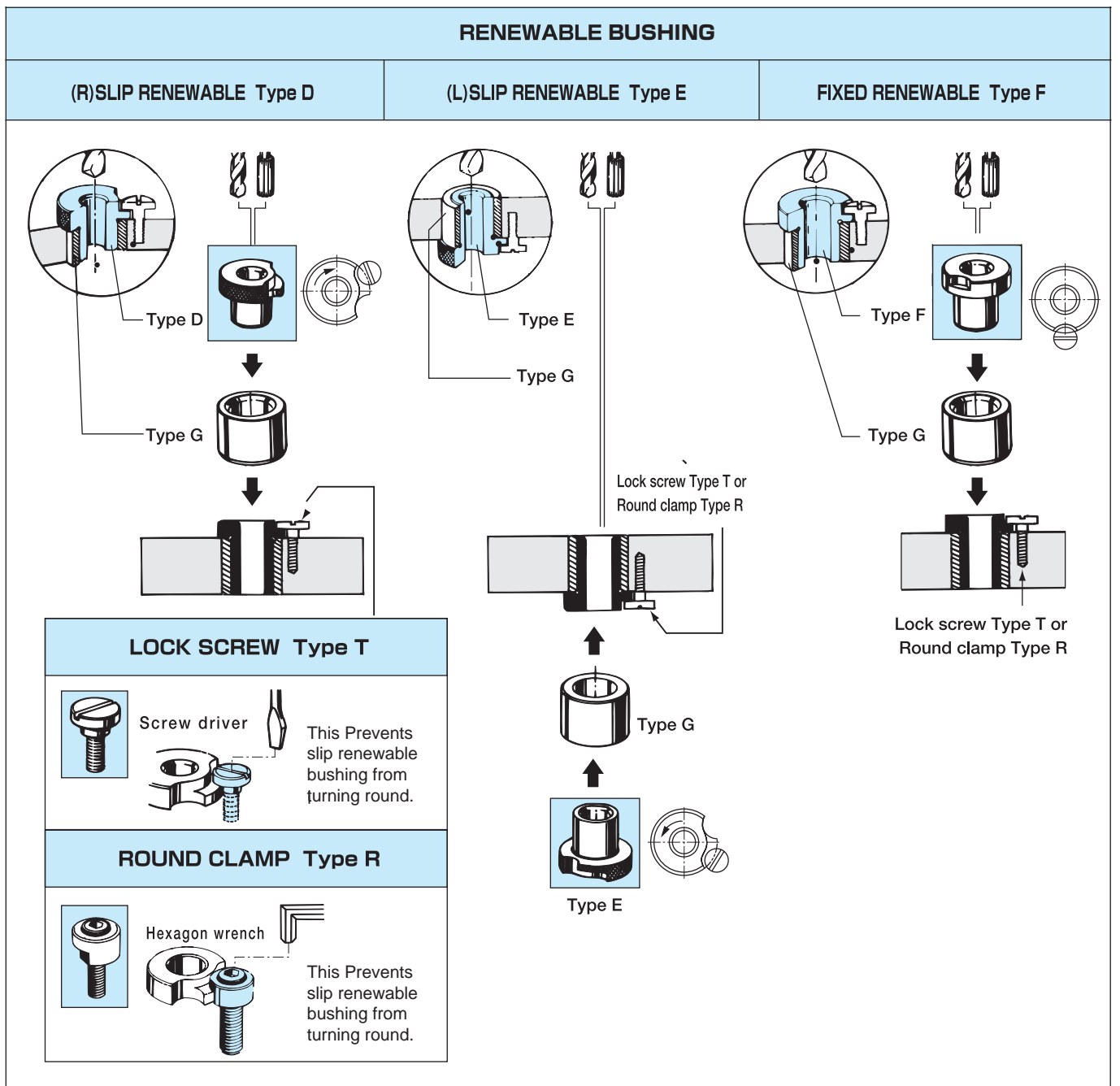
Bushings that have the same O.D. are interchangeable with each other.

**LINER BUSHING Type G**

This Guides the renewable bushing for smoother insertion or replacement.

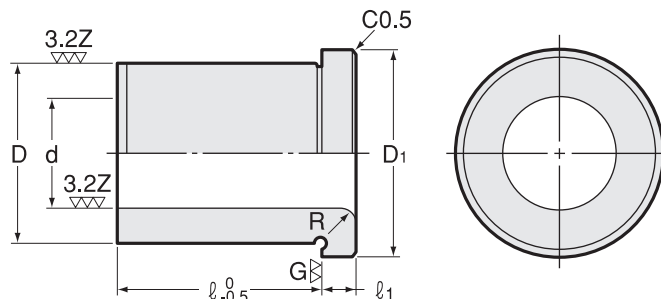
Name	Press fit bushing		Renewable bushing				Headless liner bushing	Lock screw	Round clamp
	Headless	Headed	Round	Right slip	Left slip	Fixed			
Shape									
Higher accuracy	<b>SA</b>	<b>SB</b>	<b>SC</b>	<b>SD</b>	<b>SE</b>	<b>SF</b>	<b>G</b>	<b>T</b>	<b>R</b>
Standard accuracy	<b>A</b>	<b>B</b>	<b>C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

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



# Type B

## Headed Press Fit Bushing Type B



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

### 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 ~ 50.0	50.1 ~ 55.0
<b>SB (G6)</b>	+0.008 +0.002	+0.012 +0.004	+0.014 +0.005	+0.017 +0.006	+0.020 +0.007	+0.025 +0.009	+0.029 +0.010
<b>B</b>	+0.025 +0.002	+0.030 +0.004	+0.036 +0.005	+0.043 +0.006	+0.052 +0.007	+0.062 +0.009	+0.074 +0.010
<b>BR</b>	+0.014 +0.008	+0.020 +0.012	+0.024 +0.015	+0.029 +0.018	+0.034 +0.021	+0.041 +0.025	+0.049 +0.030

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

d	1.6 ~ 18.0	18.1 ~ 50.0	50.1 ~ 55.0
<b>SB/BR</b>	0.005 or less	0.008 or less	0.010 or less
<b>B</b>	0.012 or less	0.020 or less	0.025 or less

1. Headed press fit bushing cannot be used together with renewable bushing, which can be used only with headless liner bushing (Type G).
2. Bore a hole in bushing plate at H7 for bushing with O.D. (D) p6. Tolerance of hole bored by reamer with O.D. m5 is H7.

I.D.(d) of hole in bushing plate	0.8 ~ 3.0	3.1 ~ 6.0	6.1 ~ 10.0	10.1 ~ 18.0	18.1 ~ 30.0	30.1 ~ 50.0	50.1 ~ 55.0
<b>Tolerance H7</b>	+0.010 0	+0.012 0	+0.015 0	+0.018 0	+0.021 0	+0.025 0	+0.030 0

SB ..... For higher accuracy  
 B ..... For standard accuracy  
 BR ..... For reaming

d	D (p6)	D1	ℓ 1	R	Grade	ℓ										
						8	10	12	16	20	25	30	35	45	55	
1.6 ~ 2.0	5 +0.020 +0.012	9	2.5	※ 1	SB	○	○	○								
					B	○	○	○								
2.1 ~ 3.0	7 +0.024 +0.015	11	2.5	※ 1	SB	○	○	○								
					B	○	○	○								
3.1 ~ 4.0	8 +0.024 +0.015	12	3	1	SB		○	○	○							
					B		○	○	○							
4.1 ~ 6.0	10 +0.024 +0.015	14	3	1	SB		○	○	○							
					B		○	○	○							
6.1 ~ 8.0	12 +0.029 +0.018	16	4	2	SB			○	○	○						
					B			○	○	○						
8.1 ~ 10.0	15 +0.029 +0.018	19	4	2	SB			○	○	○						
					B			○	○	○						
10.1 ~ 12.0	18 +0.029 +0.018	22	4	2	SB				○	○	○					
					B				○	○	○					
12.1 ~ 15.0	22 +0.035 +0.022	26	5	2	SB				○	○	○					
					B				○	○	○					
15.1 ~ 18.0	26 +0.035 +0.022	30	5	2	SB					○	○	○				
					B					○	○	○				
18.1 ~ 22.0	30 +0.035 +0.022	35	6	3	SB					○	○	○				
					B					○	○	○				
22.1 ~ 26.0	35 +0.042 +0.026	40	6	3	SB						○	○	○			
					B						○	○	○			
26.1 ~ 30.0	42 +0.042 +0.026	47	6	3	SB						○	○	○			
					B						○	○	○			
30.1 ~ 35.0	48 +0.042 +0.026	55	8	4	SB							○	○	○		
					B							○	○	○		
35.1 ~ 42.0	55 +0.051 +0.032	62	8	4	SB							○	○	○		
					B							○	○	○		
42.1 ~ 48.0	62 +0.051 +0.032	69	8	4	SB								○	○	○	
					B								○	○	○	
48.1 ~ 55.0	70 +0.051 +0.032	77	8	4	SB								○	○	○	
					B								○	○	○	

List prices of type BR are identical to those of type SB.

Ordering Example

**SB - 6.0 × 10**  
d ℓ

Code

**0000 022 060 12**  
Code d ℓ  
 Code  
 B:021  
 SB:022  
 BR:023

BT

CAT

AHO

HSK-A/E/F/C

HSK-T

UTS

Specialized Machine

Related Equipment

Bushing & Chamfering Drill

Drill Jig Bushing

Chamfering Cutter Series

Chamfering Series