

PINS & BUSHINGS-METRIC



PINS & BUSHINGS – METRIC

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General Information

For replacement parts and for those customers wanting to assemble their own sets, an extensive line of catalog guide posts and bushings in both plain bearing and ball bearing styles is available for immediate delivery.

Our guide posts are available in press fit and demountable styles. Both the -82 and -83 posts can be used in a plain bearing or a ball bearing system. The NP line of guide posts fully meet NAAMS standards.

Our plain bearing bushings are available in press fit and demountable styles and are equipped with figure 8 oil grooves and lubrication fittings. They are available in three profiles: standard, short and extra long shoulder to give optimum flexibility in die set design. The bushings are also available in steel, bronze-plated and self-lubricating materials and are ideally suited for running with metric posts.

Demountable posts and bushings are tap fit into location and seat flush with the ground face of the punch holder or die shoe. They are held in place with toe clamps and screws which provide perfect alignment of the post and bushing with the bore perpendicular to the ground surface of the punch holder or shoe. The clamp and screws provide four times the holding power compared to pressed-in components, yet they can be easily removed and assembled thus simplifying die building and maintenance.

The ball bearing system includes press fit and demountable guide posts, press fit sleeves and demountable bushings as well as ball cages. The ball bearing guide posts are manufactured from hardened steel to assure free rolling of balls and high wear resistance. Each post is drilled and tapped at the bottom for mounting of the ball cage washer assembly. This unique mounting method permits the ball cage, except when under pre-load, to freely rotate 360° around the guide post thus eliminating scoring or tracking of the guide post surface. The ball bearings are arranged in the cage in a spiral pattern which also minimizes tracking or grooving and assures uniform wear. Our demountable bushings and guide posts provide ease of assembly.



Demountable bushings are secured to the punch holder with clamps and screws, proving four times the holding power of pressed-in bushings.



Specially-designed spiral patterns are drilled into our ball cages to control tracking and grooving.



Special equipment spins ball bearings in place, then our ball cages move on to rigid quality inspection.



Plain & Ball Bearing Press Fit Guide Posts



Product Features

These press fit guide posts are designed to run in both a plain and ball bearing systems. They are manufactured from high quality hardened steel and finish ground for a high precision finish. The diameters that are used in ball bearing applications are drilled and tapped on the working end for the mounting of the ball cage washer assembly. This unique mounting method permits the ball cage, except when under preload, to freely rotate 360 degrees around the guide post, thus eliminating scoring or tracking of the guide post surface.



NOTES:

- Press fit length should be equal to or greater than the diameter of the guide post.
- See pages 32–33 for die set boring specifications.
- Ball Cage washer assembly sold separately and dependent on Type I, II or III assembly methods. Refer to page 24 for washer assembly part numbers.
- The diameters that are used in ball bearing applications are drilled and tapped on the working end for the mounting of the ball cage washer assembly.

D mm	L mm	U mm	Part Number
	100		5-1810-82
	110		5-1811-82
	120		5-1812-82
	130		5-1813-82
	140		5-1814-82
18	150	_	5-1815-82
	160		5-1816-82
	170		5-1817-82
	180		5-1818-82
	190		5-1819-82
	200		5-1820-82
	100		5-1910-82
	110		5-1911-82
	120		5-1912-82
	130		5-1913-82
	140		5-1914-82
19	150	_	5-1915-82
	160		5-1916-82
	170		5-1917-82
	180		5-1918-82
	190		5-1919-82
	200		5-1920-82
	100		5-2410-82
	110		5-2411-82
	120		5-2412-82
	130		5-2413-82
	140		5-2414-82
	150		5-2415-82
24	160		5-2416-82
24	170	_	5-2417-82
	180		5-2418-82
	190		5-2419-82
	200		5-2420-82
	220		5-2422-82
	240		5-2424-82
	260		5-2426-82

Plain & Ball Bearing Press Fit Guide Posts

D	L	U	Part	D	L	U	Part	D	L	U	Part
			Number				Number	mm	mm	mm	Number
	100		5-2510-82		110		5-3811-82		280		5-4828-82
	110		5-2511-82		120		5-3812-82		300		5-4830-82
	120		5-2512-82		130		5-3813-82	48	320	_	5-4832-82
	130		5-2513-82		140		5-3814-82		360		5-4836-82
	140		5-2514-82		150		5-3815-82		400		5-4840-82
	150		5-2515-62		170		5-3010-02		450		5-4845-82
25	100	M6	5 2517 92		190		5 2010 02		130		5-5013-82
	180		5 2519 92	30	100		5 3910 92		140		5-5014-82
	100		5-2510-82	30	200	_	5-3820-82		150		5-5015-82
	200		5-2520-82		200		5-3822-82		170		5-5010-62
	200		5-2522-82		220		5-3824-82		170		5-5017-62
	240		5-2524-82		240		5-3826-82		100		5-5010-62
	240		5-2526-82		280		5-3828-82		200		5 5020 82
	100		5-3010-82		300		5-3830-82	50	200	M10	5-5020-82
	110		5-3011-82		320		5-3832-82	50	240	INITO	5-5022-02
	120		5-3012-82		360		5-3836-82		240		5-5024-02
	130		5-3013-82		110		5-4011-82		280		5-5028-82
	140		5-3014-82		120		5-4012-82		300		5-5030-82
	150		5-3015-82		130		5-4013-82		320		5-5032-82
	160		5-3016-82		140		5-4014-82		360		5-5036-82
	170		5-3017-82		150		5-4015-82		400		5-5040-82
30	180	_	5-3018-82		160		5-4016-82		450		5-5045-82
	190		5-3019-82		170		5-4017-82		200		5-6320-82
	200		5-3020-82		180		5-4018-82		220		5-6322-82
	220		5-3022-82	40	190	M10	5-4019-82		240		5-6324-82
	240		5-3024-82		200		5-4020-82		260	ĺ	5-6326-82
	260		5-3026-82		220		5-4022-82		280		5-6328-82
	280		5-3028-82		240		5-4024-82	63	300	M10	5-6330-82
	300		5-3030-82		260	1	5-4026-82		320		5-6332-82
	320		5-3032-82		280]	5-4028-82		360		5-6336-82
	100		5-3210-82		300		5-4030-82		400		5-6340-82
	110		5-3211-82		320		5-4032-82		450	1	5-6345-82
	120		5-3212-82		360		5-4036-82		500		5-6350-82
	130		5-3213-82		130		5-4813-82		200		5-8020-82
	140		5-3214-82		140		5-4814-82		220		5-8022-82
	150		5-3215-82		150		5-4815-82		240		5-8024-82
	160		5-3216-82		160		5-4816-82		260		5-8026-82
	170		5-3217-82		170		5-4817-82		280		5-8028-82
32	180	M6	5-3218-82	48	180	—	5-4818-82	80	300	M10	5-8030-82
	190		5-3219-82		190		5-4819-82		320		5-8032-82
	200		5-3220-82		200		5-4820-82		360		5-8036-82
	220		5-3222-82		220		5-4822-82		400		5-8040-82
	240		5-3224-82		240		5-4824-82		450		5-8045-82
	260		5-3226-82		260		5-4826-82		500		5-8050-82
	280		5-3228-82								
	300		5-3230-82								
	190 200 220 240 260 280 300 320		5-3219-82 5-3220-82 5-3222-82 5-3224-82 5-3226-82 5-3228-82 5-3230-82 5-3230-82 5-3232-82		190 200 220 240 260		5-4819-82 5-4820-82 5-4822-82 5-4824-82 5-4826-82		320 360 400 450 500		5-8032-82 5-8036-82 5-8040-82 5-8045-82 5-8050-82

Plain & Ball Bearing Demountable Guide Posts





Product Features

These demountable guide posts are designed to run in both plain and ball bearing systems. They are manufactured from high quality hardened steel and finish ground for a high precision finish. The diameters that are used in ball bearing applications are drilled and tapped on the working end for the mounting of the ball cage washer assembly. This unique mounting method permits the ball cage, except when under preload, to freely rotate 360 degrees around the guide post, thus eliminating scoring or tracking of the guide post surface.

There are two ways of mounting the demountable posts into the die set: they can be either held in place with toe clamps and screws or they can be mounted using a retainer plug. Either mounting option offers the benefit of easy removal, even multiple times without damaging or distorting the mounting holes in the die set, thus simplifying die building and maintenance. Demountable posts are also used to replace press fit posts when the press fit hole has been damaged and the straight pin no longer fits securely in the hole.

CLAMPING APPLICATION:



M = Flange OD to Clamp Bolt Center Bolt Radius = (Flange OD ÷ 2) + M

NOTES:

- Designed to be used with bushings on pages 16-19 (not with NAAMS style bushings on pages 10-11).
- All demountable guide posts are supplied with mounting clamps and screws. See pages 34–35 for clamping dimensions or to order additional toe clamps or mounting screws.
- Ball Cage washer assembly sold separately and dependent on Type 1, 2 or 3 assembly methods. Refer to page 24 for washer assembly part numbers.
- Retainer plugs must be ordered separately. Refer to page 34 for part numbers and dimensional information.
- The diameters that are used in ball bearing applications are drilled and tapped on the working end for the mounting of the ball cage washer assembly.

D mm	D5 mm	E1 mm	Tap Size L	Tap Size U	Clamp Part Number	Clamps & Screws Req. per Bushing	М	Bolt Radius (REF)	
18	25.6	20	M5					16.5	
19	25.6	20	M5	_	0-95-1	5	5.7	10.5	
24	32.6	24	M6	—	6 00 1	2	4	20.2	
25	32.6	24	M6	M6	0-90-1	3	4	20.3	
30	40.6	30	M6	—	6 02 1	2	E 0	05 F	
32	40.6	30	M6	M6	0-93-1	5	5.2	20.0	
38	50.8	37	M10	_	6 02 1	4	4.6	20	
40	50.8	37	M10	M10	0-93-1	4	4.0		
48	63.8	45	M12	_	0.00.4	4	10	20 F	
50	63.8	45	M12	M10	0-93-1	4	4.0	30.5	
63	76.0	49	M16	M10	6-93-1	4	4.5	42.5	
80	93.0	60	M16	M10	6-93-1	4	4.5	51	

Plain & Ball Bearing Demountable Guide Posts

D mm	F1 mm	Part Number						
	80	5-1808-83						
	90	5-1809-83						
	100	5-1810-83						
18	110	5-1811-83						
	120	5-1812-83						
	140	5-1814-83						
	160	5-1816-83						
	80	5-1908-83						
	90	5-1909-83						
	100	5-1910-83						
19	110	5-1911-83						
	120	5-1912-83						
	140	5-1914-83						
	160	5-1916-83						
	80	5-2408-83						
	90	5-2409-83						
	100	5-2410-83						
	110	5-2411-83						
	120	5-2412-83						
	130	5-2413-83						
24	140	5-2414-83						
	150	5-2415-83						
	160	5-2416-83						
	170	5-2417-83						
	180	5-2418-83						
	190	5-2419-83						
	200	5-2420-83						
	80	5-2508-83						
	90	5-2509-83						
	100	5-2509-83						
	110	5-2511-83						
	120	5-2512-83						
	120	5-2513-83						
25	140	5-2514-83						
20	150	5-2515-83						
	160	5-2516-83						
	170	5-2517-83						
	180	5-2518-83						
	190	5-2519-83						
	200	5-2520-83						
	100	5-3010-83						
	110	5-3011-83						
	120	5-3012-83						
	130	5-3013-83						
	140	5-3014-83						
30	150	5-3015-83						
	160	5-3016-83						
	170	5-3017-83						
	180	5-3018-92						
	100	5 3010 02						
	190	5-2018-02						

D	F1	Part					
mm							
	200	5-3020-83					
30	220	5-3022-83					
	240	5-3024-83					
	280	5-3028-83					
	100	5-3210-83					
	110	5-3211-83					
	120	5-3212-83					
	130	5-3213-83					
	140	5-3214-83					
	150	5-3215-83					
32	160	5-3216-83					
	170	5-3217-83					
	180	5-3218-83					
	190	5-3219-83					
	200	5-3220-83					
	220	5-3222-83					
	240	5-3224-83					
	280	5-3228-83					
	110	5-3811-83					
	120	5 2012 02					
	140	5 2014 02					
	140	5-3815-83					
	100	5 2016 02					
20	100	5 2017 02					
30	170	5 2010 02					
	100	5 3910 93					
	200	5-3820-83					
	200	5-3820-83					
	220	5-3822-83					
	240	5-3828-83					
	110	5-4011-83					
	120	5-4012-83					
	120	5-4012-00					
	140	5-4014-83					
	150	5-4015-83					
	160	5-4016-83					
40	170	5-4017-83					
40	180	5-4018-83					
	190	5-4019-83					
	200	5-4020-83					
	220	5-4022-83					
	240	5-4024-83					
	280	5-4028-83					
	110	5-4811-83					
	120	5-4812-83					
	130	5-4813-83					
48	140	5-4814-83					
	150	5-4815-83					
	160	5-4816-83					
	2 30 32 32 40 48	D mmF1 mm200220240280280100110120130140150160170180190200240280110120130140150160200220240280110120130140150160200220240280110120130140150160200220240280110120130140150160170180190200220240130140150160160170180190200210220240280100100100100130140150160160160160160160160160160160160160160160160					

D	F1	Part					
mm	mm	Number					
	170	5-4817-83					
	180	5-4818-83					
	190	5-4819-83					
	200	5-4820-83					
40	220	5-4822-83					
48	240	5-4824-83					
	280	5-4828-83					
	320	5-4832-83					
	360	5-4836-83					
	400	5-4840-83					
	110	5-5011-83					
	120	5-5012-83					
	130	5-5013-83					
	140	5-5014-83					
	150	5-5015-83					
	160	5-5016-83					
	170	5-5017-83					
-0	180	5-5018-83					
50	190	5-5019-83					
	200	5-5020-83					
	220	5-5022-83					
	240	5-5024-83					
	280	5-5028-83					
	320	5-5032-83					
	360	5-5036-83					
	400	5-5040-83					
	120	5-6312-83					
	140	5-6314-83					
	160	5-6316-83					
	180	5-6318-83					
	200	5-6320-83					
63	220	5-6322-83					
	240	5-6324-83					
	280	5-6328-83					
	320	5-6332-83					
	360	5-6336-83					
	400	5-6340-83					
	120	5-8012-83					
	140	5-8014-83					
	160	5-8016-83					
	180	5-8018-83					
	200	5-8020-83					
80	220	5-8022-83					
	240	5-8024-83					
	280	5-8028-83					
	320	5-8032-83					
	360	5-8036-83					
	400	5-8040-83					

Automotive Straight Guide Posts



Product Features

NAAMS guide posts are manufactured in accordance with the North American Automotive Metric Standards. They are manufactured from high quality hardened steel and finish ground for a high precision finish. Hardness is RC 58-62 with a minimum depth of 1.5mm. These posts are ideally suited for the self-lubricating NAAMS bushings.

To reduce tooling weight, the 100mm and 125mm diameter posts, NPH series, are manufactured with a through hole.





For NP Series (Solid Posts)

For NPH Series (Hollow Posts)

Part Number	NAAMS Code	GM Part Number	Chrysler Part Number	Ford Part Number	D1 & D2 mm	D2 Tol r6	D3 mm	L mm	L2 mm	L3 mm	R mm	Pressed Fit Bore
NP25-80	G512508	_	19-245-6401	—								
NP25-100	G512510	_	19-245-6402	—				100				
NP25-120	—	_	19-245-6403	—		+ 041		120				25 025
NP25-125	G512512	90.20.50-25125	19-245-6404		25	+ 028	—	125	40	8	2	<u>25.025</u> 25.000
NP25-140	G512514	90.20.50-25140	19-245-6405	WDX13-60-07025140		1.020		140				20.000
NP25-160	G512516	90.20.50-25160	19-245-6406	WDX13-60-07025160				160				
NP25-180	G512518	90.20.50-25180	19-245-6407	WDX13-60-07025180				180				
NP32-100	G513210		19-245-6502	—				100				
NP32-120	—		19-245-6503	—				120				
NP32-125	G513212		19-245-6504	—		+ 050		125				32 025
NP32-140	G513214	90.20.50-32140	19-245-6505	WDX13-60-07032140	32	+0.030	—	140	45	8	2	32.000
NP32-160	G513216	90.20.50-32160	19-245-6506	WDX13-60-07032160		1.001		160				
NP32-180	G513218	90.20.50-32180	19-245-6507	WDX13-60-07032180				180				
NP32-200	G513220	90.20.50-32200	19-245-6508	WDX13-60-07032200				200				
NP40-140	—	90.20.50-40140						140				
NP40-160	G514016	90.20.50-40160	19-245-6606	WDX13-60-07040160				160				
NP40-180	G514018	90.20.50-40180	19-245-6607	WDX13-60-07040180		+ 050		180				40.025
NP40-200	G514020	90.20.50-40200	19-245-6608	WDX13-60-07040200	40	+ 0.030	—	200	56	8	2	40.000
NP40-225	G514022	90.20.50-40225	19-245-6609	WDX13-60-07040225		1.001		225				
NP40-250	G514025	90.20.50-40250	19-245-6610	WDX13-60-07040250				250				
NP40-280	—	90-20.50-40280		_				280				
NP50-160	G515016	90.20.50-50160	19-245-6806	WDX13-60-06050160				160				
NP50-180	G515018	90.20.50-50180	19-245-6807	WDX13-60-06050180				180				
NP50-200	G515020	90.20.50-50200	19-245-6808	WDX13-60-06050200				200				
NP50-225	G515022	90.20.50-50225	19-245-6809	WDX13-60-06050225	50	+.050	_	225	70	10	25	<u>50.025</u>
NP50-250	G515025	90.20.50-50250	19-245-6810	WDX13-60-06050250	00	+.034		250	10		2.5	50.000
NP50-280	G515028	90.20.50-50280	19-245-6811	WDX13-60-06050280				280				
NP50-315	G515031	90.20.50-50315	19-245-6812	WDX13-60-06050315				315				
NP50-355	_	90.20.50-50355	_	_				355				

Automotive Straight Guide Posts

Part	NAAMS	GM	Chrysler	Ford	D1 &	D2 Tol	D3	L	L2	L3	R	Pressed
Number	Code	Part Number	Part Number	Part Number	mm	r6	mm	mm	mm	mm	mm	Fit Bore
NP63-180		90.20.50-63180	_	_				180				
NP63-200	G516320	90.20.50-63200	19-245-7008	WDX13-60-06063200	1			200				
NP63-225	G516322	90.20.50-63225	19-245-7009	WDX13-60-06063225	1			225				
NP63-250	G516325	90.20.50-63250	19-245-7010	WDX13-60-06063250	1			250				
NP63-280	G516328	90.20.50-63280	19-245-7011	WDX13-60-06063280		+.060		280		10		63.030
NP63-315	G516331	90.20.50-63315	19-245-7012	WDX13-60-06063315	63	+.041	_	315	80	10	2.5	63.000
NP63-355	G516335	90.20.50-63355	19-245-7014	WDX13-60-06063355	1			355				
NP63-400	G516340	90.20.50-63400	19-245-7016	WDX13-60-06063400	1			400				
NP63-450	_	90.20.50-63450	-	_	1			450				
NP63-500	G516350	90.20.50-63500	19-245-7020	_	1			500				
NP80-225	_	90.20.50-80225	19-245-7209	—				225				
NP80-250	G518025	90.20.50-80250	19-245-7210	WDX13-60-06080250	1			250				
NP80-280	G518028	90.20.50-80280	19-245-7211	WDX13-60-06080280	1			280				
NP80-315	G518031	90.20.50-80315	19-245-7212	WDX13-60-06080315		+.062		315	100	10		80.030
NP80-355	G518035	90.20.50-80355	19-245-7214	WDX13-60-06080355	80	+.043	—	355	100	10	3	80.000
NP80-400	G518040	90.20.50-80400	19-245-7216	WDX13-60-06080400				400				
NP80-450	_	90.20.50-80450	_	WDX13-60-07080450				450				
NP80-500	G518050	90.20.50-80500	19-245-7220	WDX13-60-07080500	1			500				
NP100-250	_	90.20.50-100250A	_	_				250				
NP100-280	_	90.20.50-100280A	_	_	1			280				
NP100-315	G511031	—	19-245-7412	WDX13-60-06100315				315				
NP100-355	G511035	—	19-245-7414	WDX13-60-06100355				355				
NP100-400	G511040	—	19-245-7416	WDX13-60-06100400	100	+.073		400	405	10		100.035
NP100-450	_	90.20.50-100450A	19-245-7418	—	100	+.051	_	450	125	10	3	100.000
NP100-500	G511050	90.20.50-100500A	19-245-7420	WDX13-60-07100500	1			500				
NP100-550	_	90.20.50-100550A	—	WDX13-60-07100550	1			550				
NP100-600		90.20.50-100600A	_	WDX13-60-07100600				600				
NP100-650		90.20.50-100650A		—				650				
NPH100315		90.20.50-100315B		—				315				
NPH100355		90.20.50-100355B		—				355				
NPH100400		90.20.50-100400B		—		1 072		400				100.025
NPH100450	_	90.20.50-100450B*		—	100	+.073	50	450	125	10	3	100.035
NPH100500	—	90.20.50-100500B		—		1.001		500				100.000
NPH100550	_	90.20.50-100550B*		—				550				
NPH100600	_	90.20.50-100600B*		—				600				
NP115400	G511140	90.20.50-115400	19-245-7616	—	115	+.076		400	140	10	2	<u>115.035</u>
NP115500	G511150	90.20.50-115500	19-245-7620	—	115	+.054		500	140	10	3	115.000
NP125-315	—	90.20.50-125315A		_				315				
NP125-355	—	90.20.50-125355A		_				355				
NP125-400	G511240	90.20.50-125400A		_				400				
NP125-450	G511245	90.20.50-125450A				+ 088		450				125 040
NP125-500	G511250	90.20.50-125500A		_	125	+ 063	—	500	140	10	3	125.000
NP125-550	G511255	90.20.50-125550A		_				550				
NP125-600	G511260	90.20.50-125600A						600				
NP125-650	G511265	90.20.50-125650A						650				
NP125-700	G511270	90.20.50-125700A		_				700				
NPH125315	—	90.20.50-125315B	—	—				315				
NPH125355	—	90.20.50-125355B*	—	WDX13-60-05125355**				355				
NPH125400		90.20.50-125400B		WDX13-60-05125400**				400				
NPH125450		90.20.50-125450B		WDX13-60-05125450**	125	+.088	65	450	140	12	3	<u>125.040</u>
NPH125500		90.20.50-125500B		WDX13-60-05125500**	125	+.063	55	500	0	12		125.000
NPH125550		90.20.50-125550B		WDX13-60-05125550**				550				
NPH125600	_	90.20.50-125600B		WDX13-60-05125600**				600				
NPH125650	_	90.20.50-125650B		WDX13-60-05125650**				650				

* Not for North American Operations use.

Guide Pins – Tap Fit



32, 40, 50 & 63 Dia. guide posts have M8 x 1.25 -12 thread; 80, 100, 115 & 125 Dia. guide posts have M12 x 1.75 -18 thread to facilitate handling from deep freeze.

Product Features

A wide variety of pins meets most tool room requirements.

Applications:

Transfer Presses

Repairs

AUTOMOTIVE METRIC NAAMS STANDARD



Must be held in place with toe clamps. Three 6-99-1 (NAAMS #G720000C) toe clamps & screws are included.



M = Flange OD to Clamp Bolt Center Bolt Radius = (Flange OD \div 2) + M

Part Number	D1 mm	D1 TOL g6 mm	D2 mm	D2 TOL r6 mm	D3 mm	М	Bolt Radius (REF)	L1 mm	L3 mm	L5 mm													
G503214								140		95													
G503216	32	009	32	+ .050	40	۵	20	160	45	115													
G503218	52	025	52	+ .034	-0	3	25	180		135													
G503220								200		155													
G504016								160		104													
G504018		009 025		+ 050				180		124													
G504020	40		009	40	+ .030	50	9	34	200	56	144												
G504022								225		169													
G504025								250		194													
G505016								160		90													
G505018						9		180		110													
G505020		- 009		+ 050	63			200		130													
G505022	50	025	50	+ .034			40.5	225	70	155													
G505025								250		180													
G505028								280		210													
G505031								315		245													
G506320													200		120								
G506322				+ .060	+ .060	+ .060	+ .060	+ .060	+ .060	+ .060	+ .060	+ .060	+ .060				225		145				
G506325		010												+ .060	+ .060	+ .060	+ .060	+ .060	+ 060	+ 060	+ .060	+ .060	+ .060
G506328	63	029	63	+ .041	80	9	49	280	80	200													
G506331								315		235													
G506335								355		275													
G506340								400		320													
G508025								250		150													
G508028		010		+ .062	100		50	280	100	180													
G508031	80	029	80	+ .043	100	9	59	315	100	215													
G508035								355		255													
G508040								400		100													
G501031	100	012	100	+ .073	105		9 71.5	315	105	190													
G501035	100	034	100	+ .051	125	Э		305	125	230													
G501040								400		275													

Guide Pins – with Shoulders

NOTES

Automotive Demountable Self-Lubricating Guide Post Bushings





Product Features

Demountable NAAMS bushings are self-lubricating and are available in guide post and pad styles. These bushings fully conform to the NAAMS, GM, Chrysler and Ford standards.

Self-lubricating bushings contain graphite plugs which are impregnated with oil. When the bushings reach 80-90°F as a result of friction between the bushing and guide post, oil is drawn from the plug, thus lubricating the wear surface. A dark smear pattern is created on the wear surface as the oil and graphite are imbedded into the bronze or steel grain. This provides the lubrication necessary for continuous performance of the tool.

Demountable bushings are tap fit into location and seat flush with the ground face of the punch holder. The bushings are held in place with toe clamps and screws which provide perfect alignment of the bushing with the bore perpendicular to the ground surface of the punch holder. Multipe standard clamps are available.

D1 mm	D1 Tol H6	D2 mm	D2 Tol g6	D3 mm	D4 mm	L1 mm	L2 mm	L3 mm	R mm	Part Number	NAAMS Bushing Number	GM Part Number	Chrysler Part Number	Ford Part Number
25	+.013/+.000	32	009/025	40	32	40	30	4	3	NM25	G612540	90.20.55-25	19-029-1010	WDX13-60-08025
32	+.016/+.000	40	009/025	50	40	50	40	4	3	NM32	G613250	90.20.55-32	19-029-1011	WDX13-60-08032
40	+.016/+.000	50	009/025	63	50	63	50	5	3	NM40	G614063	90.20.55-40	19-029-1012	WDX13-60-08040
50	+.016/+.000	63	010/029	71	63	71	56	6	5	NM50	G615071	90.20.55-50	19-029-1013	WDX13-60-08050
63	+.019/+.000	80	010/029	90	80	80	63	8	6	NM63	G616380	90.20.55-63	19-029-1014	WDX13-60-08063
80	+.019/+.000	100	012/034	112	100	100	80	10	8	NM80	G618010	90.20.55-80	19-029-1015	WDX13-60-08080
100	+.022/+.000	125	014/039	140	125	125	106	12	10	NM100	G611012	90.20.55-100	19-029-1016	WDX13-60-08100
100	+.022/+.000	125	014/039	140	125	77	58	12	12	NM100S	_	90.20.55-100S	—	—
115	+.022/+.000	140	014/039	155	140	140	120	12	10	NM115	G611114	—	19-029-1017	—
125	+.025/+.000	160	014/039	180	160	160	132	12	12	NM125	G611216	90.20.55-125	19-029-1018	WDX13-60-08125

CLAMP NOTES:

- See pages 12–14 for clamp part numbers and dimensional information.
- OUR bushings will be supplied with (3) M8 toe clamps and screws (#6-99-1).
- NAAMS bushings will be supplied with (3) M8 toe clamps and screws (#6-99-1).
- GM bushings are supplied with NO clamps and screws. Order separately: for 25-50mm, order (1) 90.20.60A clamp per bushing; for 63-125mm, order (2) 90.20.60B clamps per bushing.
- CHRYSLER guide post bushings are supplied with NO clamps or screws. Order STOP/BUSHING CLAMP COMBINATION BLOCK separately. See Table 1 for sizes and part numbers.
- Ford bushings: 32-50mm are supplied with (1) toe clamp (#MMC0219);
 63mm-100mm are supplied with (2) toe clamps (#MMC0219).

TABLE 1 STOP BLOCK/BUSHING CLAMPS

Chrysler Part Number	Bushing ID
Number	
19-010-1105	50mm
19-010-1106	63mm
19-010-1108	80mm
19-010-1110	100mm

Automotive Demountable Self-Lubricating PAD Bushings





D1	D1 Tol C9	D2	D2 Tol g6	D3	L1	L2	Part Number	NAAMS Code Number	GM Part Number	Chrysler Part Number	Ford Part Number
25	+.162/+.110	32	009/025	40	40	4	NM25PAD	G712540	90.30.10-25	19-029-0102	WDX13-80-09025
32	+.182/+.120	40	009/025	50	50	4	NM32PAD	G713250	90.30.10-32	19-029-0103	WDX13-80-09032
40	+.182/+.120	50	009/025	63	55	5	NM40PAD	G714055	90.30.10-40	19-029-0104	WDX13-80-09040
50	+.192/+.130	63	010/029	71	63	6	NM50PAD	G715063	90.30.10-50	19-029-0105*	WDX13-80-09050
63	+.214/+.140	80	010/029	90	75	8	NM63PAD	G716375	90.30.10-63	19-029-0106*	WDX13-80-09063
63	+.214/+.140	80	010/029	90	125	8	NM63-125PAD	—	—	19-028-0107*	—
80	+.224/+.150	100	012/034	112	90	10	NM80PAD	G718090	90.30.10-80	19-029-0108*	WDX13-80-09080
80	+.224/+.150	100	012/034	112	140	10	NM80-140PAD	—	—	19-029-0109*	—
100	+.257/+.170	125	014/039	140	115	12	NM100PAD	G711011	90.30.10-100	19-029-0110	WDX13-80-09100
100	+.257/+.170	125	014/039	140	165	12	NM100-165PAD	_	—	19-029-0111	_
125	+.300/+.200	160	014/039	180	138	12	NM125PAD	G711213	90.30.10-125	19-029-0112	—

CLAMP NOTES:

- See pages 12–14 for clamp part numbers and dimensional information.
- OUR PAD bushings will be supplied with
 (3) M8 toe clamps and screws (#6-99-1).
- NAAMS PAD bushings will be supplied with
 (3) M8 toe clamps and screws (#6-99-1).
- GM PAD bushings are supplied with NO clamps and screws. Order separately; for 25-50mm, order (1) 90.20.60A clamp per bushing; for 63-125mm, order (2) 90.20.60B clamps per bushing.
- CHRYSLER PAD bushings are supplied with (3) M10 toe clamps and screws (6-990-1). Chrysler PAD bushings with "*" DO NOT come with M10 clamps and screws (10/15/07 Die Standards). They use the PAD Bushing Retainer Block shown in Table 2 and must be ordered separately.
- Ford PAD bushings: 32-50mm are supplied with (1) toe clamp (#MMC0219); 63mm-100mm are supplied with (2) toe clamps (#MMC0219).

TABLE 2 PAD BUSHING RETAINER BLOCK CLAMPS

Chrysler Part Number	Pad Bushing ID mm
19-010-1185	50mm
19-010-1195 ¹	50mm
19-010-1186	63mm
19-010-1196 ¹	63mm
19-010-1188	80mm
19-010-1198 ¹	80mm

RECOMENDED BORE SIZES FOR NAAMS GUIDE POST BUSHINGS AND PAD BUSHINGS

D1 mm	Wring Fit Bore
25	32.025 / 32.000
32	40.025 / 40.000
40	50.025 / 50.000
50	63.030 / 63.000
63	80.030 / 80.000
80	100.035 / 100.000
100	125.040 / 125.000
115	140.040 / 140.000
125	160.040 / 160.000

Automotive Demountable Self-Lubricating Bushing Clamps

CLAMP SPECIFICATIONS - DANLY / IEM / NAAMS / CHRYSLER

BC	Part Number	NAAMS Number	Chrysler Number	/ m	n n	B nm	C mm	D mm
	6-99-1	G720000C	N/A	24	.6 1	8.9	13	M8 x 1.25
	6-990-1	G730000C	19-010-010 ⁻	1 27	.9 2	3.5	15.5	M10 x 1.5
	(51.6	PART #6		PART #6-990-1 (NAAMS #G730000C)				
	(NA	AMS #G	20000C)		(N	AAMS	#G7300	00C)
	(NA D1	D3	BC 1	I	(N) D1	D3	#G7300 ВС	000C)
	D1 mm	D3 mm	BC M mm m	l m	D1 mm	AAMS 7 D3 mm	#G7300 вс mm	000C)
"D" TAP HOLES (3) EQUALLY SPACED	(NA D1 mm 32	AMS #G D3 mm 50	BC M mm m 68 45	l m .1	(N D1 mm 32	AAMS 7 D3 mm 50	#G7300 BC mm 71	00C) N mm 48.4
"D" TAP HOLES (3) EQUALLY SPACED NOTE: D1 = ID of bushing	(NA D1 mm 32 40	AMS #G D3 mm 50 63	BC M mm m 68 45 81 51	l m .1 .6	(N D1 mm 32 40	AAMS 7 D3 mm 50 63	#G7300 BC mm 71 84	N Mmm 48.4 54.9





D1 mm	D3 mm	BC mm	N mm
32	50	71	48.4
40	63	84	54.9
50	71	92	58.9
63	90	111	68.4
80	112	133	79.4
100	140	161	93.4
115	155	176	100.9
125	180	201	113.4

CLAMP SPECIFICATIONS – GM

GM Number	Bushing I.D.	C mm	D mm	E mm	F mm	G mm	H mm	J mm	K mm	Clamps Required
	25									
00 20 60 4	32	25	15	15	0	10	9.5	5	20	1
90.20.60A	40	25	15	15	9	12	0.5	5	20	I I
	50									
	63									
00 20 600	80	20	21	10	11 5	16	11.5	10	25	2
90.20.00B	100	32	21	10	11.5					
	125									



NOTE: Clamps are to be ordered with each bushing.



Automotive Demountable Self-Lubricating Bushing Clamps

CLAMP SPECIFICATIONS – CHRYSLER – STOP/BUSHING CLAMP COMBINATION BLOCK



D1 mm	D2 mm	Chrysler Code	Bushing I.D.
65	73	19-010-1105	50
82	92	19-010-1106	63
102	114	19-010-1108	80
127	142	19-010-1110	100

CLAMP SPECIFICATIONS – CHRYSLER – PAD BUSHING RETAINER BLOCK



Chrysler Number	Bushing I.D.	A mm	B mm	C mm	D mm	E mm
19-010-1185	50	127	73	57	48	20
19-010-1195*	50	127	73	57	48	25
19-010-1186	63	140	92	70	57	20
19-010-1196*	63	140	92	70	57	25
19-010-1188	80	165	114	87	67	20
19-010-1198*	80	165	114	87	67	25

* For bottoming of pads/lower rings.

Automotive Demountable Self-Lubricating Bushing Clamps

CLAMP SPECIFICATIONS – FORD – TOE CLAMPS – 25mm





PART NUMBER MMC-0217

Ford Part	Bushing	L1	L2	L3	L4	L5	L6	L7	L8	D1	D2
Number	Size	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
WDX13-60-0901	25	20	20	10	6.3	5	7	12.5	16	11	7

NOTE: For FORD 25mm bushing only

CLAMP SPECIFICATIONS - FORD - TOE CLAMPS - 32mm - 100mm





PART NUMBER MMC-0219

Ford Part	Bushing	L1	L2	L3	L4	L5	L6	L7	L8	D1	D2
Number	Size	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm
WDX13-60-1001	63–100	32	32	16	10	10	11.5	21	27	17.5	11.5

NOTE: For FORD 63–100mm bushings only

NOTES

Demountable Plain Bearing Bushings



F = D3 = 0

Product Features

Demountable bushings are available in three profiles: extra long, long, and short shoulder to give optimum flexibility in die set design. The bushings are manufactured from hardened steel and are ideally suited for running with press fit or demountable posts. The bronzeplated bushings offer superior resistance to seizure, the major cause of bushing wear. They are recommended in high speed applications and where high side thrust loads are present.

Demountable bushings are tap fit into location and seat flush with the ground face of the punch holder. The bushings are held in place with toe clamps and screws which provide perfect alignment of the bushing with the bore perpendicular to the ground surface of the punch holder. The clamp and screws provide four times the holding power compared to pressed-in bushings, yet they can be easily removed and assembled thus simplifying die building and maintenance.

All bushings are equipped with figure 8 oil grooves and lubrication fittings.

NOTES:

- All demountable bushings are supplied with mounting clamps and screws. See page 34–35 for clamping dimensions or to order additional toe clamps or mounting screws.
- Bronze-plated bushings should not be pressed-in or honed.
- See pages 32–33 for die set boring specifications.





M = Flange OD to Clamp Bolt Center Bolt Radius = (Flange OD ÷ 2) + M

DER	D1 mm	D2 mm	D3 mm	D4 mm	E mm	F	L mm	Clamp Part Number	Clamps & Screws Req. per Bushing	М	Bolt Radius (REF)	Steel Part Number	Bronze Plated Part Number
INC	24	30	44	47	22	75	08	6 00 1	2	Λ	27.5	6-2438-65	6-2438-28
HC	25	30	44	47	23	15	90	0-90-1	2	4	27.5	6-2538-65	6-2538-28
0 0	30	45	51	54	25	75	100	6 01 1	0	5 5	22.5	6-3045-65	6-3045-28
Ň	32	40	51	54	25	15	100	0-91-1	3	5.5	52.5	6-3245-65	6-3245-28
T C	38	E A	60	62	20	05	115	6 01 1	2	E	27	6-3854-65	6-3854-28
RA	40	34	60	03	30	00	115	0-91-1	3	5.5	57	6-4054-65	6-4054-28
ХТ	48	65	72	75	25	100	125	6 01 1	4	7	44.5	6-4865-65	6-4865-28
ш	50	05	13	15	- 55	100	135	0-91-1	4	7	44.5	6-5065-65	6-5065-28

Demountable Plain Bearing Bushings



6-1828-63 & 6-1828-23



	D1 mm	D2 mm	D3 mm	D4 mm	E mm	F mm	L mm	Clamp Part Number	Clamps & Screws Req. per Bushing	М	Bolt Radius (REF)	Steel Part Number	Bronze Plated Part Number
	18	29	29.5	32.5	10	30	50	6 05 1	2	3 75	20	6-1828-64	6-1828-24
2	19	20	20.5	52.5	10	52	50	0-95-1	2	5.75	20	6-1928-64	6-1928-24
В	24	20	44	47	22	47	70	6 00 1	2	4	27.5	6-2438-64	6-2438-24
Ы	25	50	44	47	23	47	10	0-90-1	2	4	27.5	6-2538-64	6-2538-24
P	30	45	51	54	25	50	75	6 01 1	2	5.5	22.5	6-3045-64	6-3045-24
S	32	40	51	54	25	50	15	0-91-1	5	5.5	52.5	6-3245-64	6-3245-24
NG N	38	54	60	62	20	50	00	6 01 1	2	5.5	27	6-3854-64	6-3854-24
2	40	54	00	03	30	50	00	0-91-1	5	5.5	57	6-4054-64	6-4054-24
	48	6E	70	75	25	50	0.5	6.01.1	4	7	44.5	6-4865-64	6-4865-24
	50	05	13	75	35	50	60	0-91-1	4		44.5	6-5065-64	6-5065-24
	63	81	90	93	48	52	100	6-91-1	4	5.5	52	6-6381-64	6-6381-24
	80	100	110	115	48	52	100	6-91-1	4	4.5	62	6-8010-64	6-8010-24

D4 D2

←D1-

D3

E⊥

CLAMPING APPLICATION:



M = Flange OD to Clamp Bolt Center Bolt Radius = (Flange OD ÷ 2) + M

	D1 mm	D2 mm	D3 mm	D4 mm	E mm	F mm	L mm	Clamp Part Number	Clamps & Screws Req. per Bushing	М	Bolt Radius (REF)	Steel Part Number	Bronze Plated Part Number		
	18	29	29.5	22	10	16	34	6.05.1	2	3 75	20	6-1828-63	6-1828-23		
Ř	19	20 20.3	20.5	32			34	0-95-1	2	3.75	20	6-1928-63	6-1928-23		
DE	24	- 38 44	44	47	22	21	44	6 00 1	2	4	27.5	6-2438-63	6-2438-23		
I	25		44	47	23	21	44	0-90-1		4	27.5	6-2538-63	6-2538-23		
H	30	- 45 5 ⁻	51	54	25	21	46	6 01 1	2	5.5	22.5	6-3045-63	6-3045-23		
ΓS	32		51	54	25	21	40	0-91-1	5	5.5	52.5	6-3245-63	6-3245-23		
.NC	38	54	60	62	20	21	51	6 01 1	0	5.5	27	6-3854-63	6-3854-23		
ЭНС	40	34	60	60	60	03	30	21	51	0-91-1	5	5.5	51	6-4054-63	6-4054-23
	48	6E	70	75	25	25	60	6 01 1	4	7	44.5	6-4865-63	6-4865-23		
	50	65	13	75	35	25	60	0-91-1	4	1	44.5	6-5065-63	6-5065-23		
	63	81	90	93	48	27	75	6-91-1	4	5.5	52	6-6381-63	6-6381-23		
	80	100	110	115	48	27	75	6-91-1	4	4.5	62	6-8010-63	6-8010-23		

Demountable Plain Bearing Low Profile Bushings



Product Features

Low profile demountable bushings are designed so that the main body of the bushing is contained within the punch holder while only a minimum of the bushing projects below the punch holder and into the die area. With minimal bushing projection, this model is ideal for dies running in presses with automatic transfer devices. Since the bushings do not need to be removed during grinding, it is well suited for applications that require often die sharpening. The bronze-plated bushings offer superior resistance to seizure, the major cause of bushing wear. They are recommended in high speed applications and where high side thrust loads are present.

Demountable bushings are tap fit into location and seat flush with the ground face of the punch holder. The bushings are held in place with toe clamps and screws which provide perfect alignment of the bushing with the bore perpendicular to the ground surface of the punch holder. The clamp and screws provide four times the holding power compared to pressed-in bushings, yet they can be easily removed and assembled, thus simplifying die building and maintenance.



D2

D1

NOTES:

- All demountable bushings are supplied with mounting clamps and screws. See pages 34–35 for clamping dimensions or to order additional toe clamps or mounting screws.
- Bronze-plated bushings should not be pressed-in or honed.
- See pages 32–33 for die set boring specifications.

CLAMPING APPLICATION:



M = Flange OD to Clamp Bolt Center Bolt Radius = (Flange OD ÷ 2) + M

D1 mm	D2 mm	D3 mm	D4 mm	E mm	F mm	L mm	Hole Location G	Clamp Part Number	Clamps & Screws Req. per Bushing	Μ	Bolt Radius (REF)	Steel Part Number	Bronze- Plated Part Number
18	28	28	32.5	18	10	28	6	6-95-1	2	3.75	20	6-1828-68	6-1828-27
19	28	28	32.5	18	10	28	6	6-95-1	2	3.75	20	6-1928-68	6-1928-27
24	38	36	47	23	10	33	6	6-96-1	3	7	30.5	6-2438-68	6-2438-27
25	38	36	47	23	10	33	6	6-96-1	3	7	30.5	6-2538-68	6-2538-27
30	45	43	54	30	10	40	10	6-96-1	3	7	34	6-3045-68	6-3045-27
32	45	43	54	30	10	40	10	6-96-1	3	7	34	6-3245-68	6-3245-27
38	54	48	63	38	14	52	10	6-97-1	4	8.5	40	6-3854-68	6-3854-27
40	54	48	63	38	14	52	10	6-97-1	4	8.5	40	6-4054-68	6-4054-27
48	65	64	75	48	14	62	20	6-97-1	4	8.5	46	6-4865-68	6-4865-27
50	65	64	75	48	14	62	20	6-97-1	4	8.5	46	6-5065-68	6-5065-27
63	81	79	93	61	14	75	20	6-97-1	4	8.5	55	6-6381-68	6-6381-27
80	100	99	115	78	14	92	32	6-97-1	4	8.5	66	6-8010-68	6-8010-27

Self-Lubricating Ejector Bushings

Product Features

These self-lubricating bushings contain graphite plugs which are impregnated with oil. When the bushing reach 80-90°F as a result of friction between the bushing and guide post, oil is drawn from the plug, thus lubricating the wear surface. A dark smear pattern is created on the wear surface as the oil and graphite are imbedded into the bronze or steel grain. This provides the lubrication necessary for continuous performance of the tool.



NOTES:

 See pages 32–33 for die set boring specifications.



D	Α	В	С	L1	L	Part
mm	mm	mm	mm	mm	mm	Number
20	26	26	28	25	37	MME20
25	32	32	35	29	45	MME25
30	38	38	41	29	45	MME30

Ball Bearing Cages



Product Features

Ball cages are manufactured from a heat treated aluminum alloy which provides tough, wear resistant qualities. The ball bearings are vacuum degassed quality, fatigue resistant steel and are inspected to ensure roundness, smoothness and dimensional conformance. The ball bearings are arranged in the cage in a spiral pattern to minimize tracking or grooving and assure uniform wear. Ball cages are mounted to drilled and tapped guide posts by a special washer assembly which permits the cage to rotate freely around the guide post when not under preload.



TYPE I For Type I Ball Bearing Bushing Assembly



TYPE II For Type II and Type III Ball Bearing Bushing Assemblies

п	С	s	x	Type I	Type II
mm	mm	mm	mm	Part	Part
				Number	Number
	36	11.5		6-2503-81	—
	48	17.5		6-2504-81	—
	55	31		_	6-2505-82
25	70	40	4.2	_	6-2507-82
	90	47		_	6-2509-82
	100	55		_	6-2510-82
	110	65		_	6-2511-82
	36	11.5		6-3203-81	—
	48	17.5		6-3204-81	—
	70	40		—	6-3207-82
22	90	47	12	—	6-3209-82
52	105	55	4.2	—	6-3210-82
	115	65		—	6-3211-82
	125	75		—	6-3212-82
	135	85		_	6-3213-82
	48	17.5		6-4004-81	—
	60	23.5		6-4006-81	—
	70	40		—	6-4007-82
	85	48		—	6-4008-82
40	105	56	5.9	—	6-4010-82
40	115	66	5.0	_	6-4011-82
	125	76			6-4012-82
	135	86		—	6-4013-82
	145	96			6-4014-82
	155	107		—	6-4015-82

D	С	S	X	Type I Part	Type II Part
mm	mm	mm	mm	Number	Number
	70	28.5		6-5007-81	_
	84	35.5		6-5008-81	
	105	56		_	6-5010-82
	120	65			6-5012-82
50	140	76	7.0		6-5014-82
50	150	86	7.0	_	6-5015-82
	160	96		_	6-5016-82
	170	108		_	6-5017-82
	185	121		—	6-5018-82
	195	133			6-5019-82
	98	42.4		6-6309-81	
	145	76		_	6-6314-82
	165	86		_	6-6316-82
63	180	96	7.0	_	6-6318-82
	190	107			6-6319-82
	205	121			6-6320-82
	215	132			6-6321-82
	98	42.5		6-8009-81	
	145	76		—	6-8014-82
	165	86		-	6-8016-82
80	180	96	8.5	_	6-8018-82
	190	107			6-8019-82
	205	121		_	6-8020-82
	215	132			6-8021-82

Ball Bearing Demountable Bushings

Product Features

Demountable bushings are tap fit into location and seat flush with the ground face of the die holder. The bushings are held in place with toe clamps and screws which provide perfect alignment of the bushing with the bore perpendicular to the ground surface of the punch holder. The clamp and screws provide four times the holding power compared to pressed-in bushings, yet they can be easily removed and assembled thus simplifying die building and maintenance.





NOTES:

- All demountable bushings are supplied with mounting clamps and screws. See pages 34–35 for clamping dimensions or to order additional toe clamps or mounting screws.
- See pages 32–33 for die set boring specifications.





M = Flange OD to Clamp Bolt Center Bolt Radius = (Flange OD ÷ 2) + M

D mm	D1 mm	D2 mm	D3 mm	D4 mm	E mm	F mm	L1 mm	Clamp Part Number	Clamps & Screws Required per Bushing	М	Bolt Radius (REF)	Part Number
						35	65					6-2503-85
25	33	45	50.8	55	30	50	80	6-90-1	2	3.5	31	6-2505-85
						65	95					6-2506-85
						50	80					6-3205-85
32	40	54	55.88	64	30	65	95	6-91-1	3	5	37	6-3206-85
						80	110					6-3208-85
						50	80					6-4005-85
40	10	65	73.03	77	30	65	95	6-91-1	3	15	43	6-4006-85
40	40	05				80	110		5	4.5		6-4008-85
						100	130					6-4010-85
						60	110					6-5006-85
50	62	Q1	85.73	05	50	80	130	6-91-1	4	4.5	52	6-5008-85
50	02	01	05.75	95	50	100	150		4	4.5	52	6-5010-85
						120	170					6-5012-85
						100	150					6-6310-85
63	75	95	103.99	109	50	120	170	6-91-1	4	5.5	60	6-6312-85
						140	190					6-6314-85
						100	161					6-8010-85
80	92	108	114.30	125	61	117	178	6-91-1	4	5.5	68	6-8011-85
						140	200					6-8014-85

Ball Bearing Straight Sleeve Bushings



Product Features

Press fit bushings are manufactured from high quality hardened steel, the bushings are finish ground for a press fit. Like all ball bearing components, these straight sleeve bushings are completely interchangeable.



INSTALLATION INSTRUCTIONS

In order to avoid the bushing close-in which occurs as a result of pressfit, these bushings should be retained with a Bushing Mount. When so installed, it is not necessary to hone the bushing bore after installation, and the bushing fit will be correct.

APPLICATION OF THE BUSHING MOUNT

- 1. Degrease bushing OD and die shoe bore with alcohol, acetone or other volatile solvent and wipe dry.
- 2. Apply Bushing Mount sparingly and wring bushing into die shoe.
- 3. Allow a 4-hour cure at 72° F (23° C). Do not disturb bushing until cure is complete.

Bushing Mount Part number: 9-60-82

Post Diameter mm	D1 mm	D2 mm	L2 mm	Part Number
			65	6-2506-86
			80	6-2508-86
25	33	45	95	6-2509-86
			110	6-2511-86
			130	6-2513-86
			80	6-3208-86
	40		95	6-3209-86
22		54	110	6-3211-86
52	40	- 34	130	6-3213-86
			150	6-3215-86
			170	6-3217-86
			80	6-4008-86
			95	6-4009-86
			110	6-4011-86
40	10	65	130	6-4013-86
40	40	05	150	6-4015-86
			170	6-4017-86
			190	6-4019-86
			215	6-4021-86

Post Diameter mm	D1 mm	D2 mm	L2 mm	Part Number
			110	6-5011-86
			130	6-5013-86
			150	6-5015-86
50	62	81	170	6-5017-86
50	02	01	190	6-5019-86
			215	6-5021-86
			240	6-5024-86
			265	6-5026-86
			150	6-6315-86
			170	6-6317-86
63	75	05	190	6-6319-86
03		95	215	6-6321-86
			240	6-6324-86
			265	6-6326-86
			150	6-8015-86
			170	6-8017-86
80	02	112	190	6-8019-86
00	92	112	215	6-8021-86
			240	6-8024-86
			265	6-8026-86

Demountable Ball Bearing Stripper Bushings and Cages

Product Features

Type III cages are made using the same material and control standards as our Type I & II cages. Type III cages use an external snap ring to act as a cage carrier and stop. This allows the cage to rotate freely around the guide post when not under preload and prevents the cage from pushing through the guide bushing at full stroke. Ball bearings are arranged in a spiral pattern in the cage to minimize tracking or grooving and assure uniform wear.

Low profile demountable bushings give maximum flexibility in die set design. The low profile bushing, coupled with low mount clamping, provide maximum available die set use. The bushings are manufactured from hardened steel and are designed for use with Type III cage components. These demountable bushings are a tap fit into location and seat flush with the ground face of the die holder. The bushings are held in place with low mount clamps and screws which provide perfect alignment of the bushing with the bore perpendicular to the ground surface of the die holder.

NOTES:

- All demountable bushings are supplied with mounting clamps and screws. See pages 34–35 for clamping dimensions or to order additional toe clamps or mounting screws.
- See pages 32–33 for die set boring specifications.

Cage Data

D mm	L mm	G mm	D2 mm	Part Number
25	40	16	22.2	6-2504-83
25	52	1.0	32.3	6-2505-83
22	40	10	20.2	6-3204-83
32	52	1.9	39.3	6-3205-83
40	52	10	17.2	6-4005-83
40	64	1.9	47.5	6-4006-83
50	74	2.2	61.2	6-5007-83
50	88	2.2	01.2	6-5008-83

Bushing Data





M = Flange OD to Clamp Bolt Center Bolt Radius = (Flange OD ÷ 2) + M







Post Diameter mm	D1 mm	D2 mm	D4 mm	E mm	L mm	Clamp Part Number	Clamps & Screws Req. per Bushing	М	Bolt Radius (REF)	Part Number
25	33	45	51	20	30	6-96-1	3	8	33.5	6-2520-87
				25	30					6-2525-87
32	40	54	60	25	35	6-96-1	3	8	38	6-3225-87
				32	42					6-3232-87
				29	39					6-4029-87
40	48	65	75	36	46	6-97-1	4	8.5	46	6-4036-87
				44	54					6-4044-87
50	62	01	01	36	46	6 07 1	4	0 5	54	6-5036-87
50	02		91	44	54	0-97-1	4	0.0	54	6-5044-87

Mounting Accessories

BALL CAGE	WASHER ASSE	MBLY			15-16		C
Nominal Post	Washer Assembly Part Number		Stop Wash	Stop Washer-Retainer		Hex Head Screw	Snap Ring- Ball Bearing Cages
Diameter	Type I	Type I Type II		Туре	Туре	Туре	Туре
A mm	Assembly	Assembly	l I	II and III	II and III	I, II and III	II and III
25	6-0025-81	6-0025-82	6-2500-85	6-2500-83		6-0620-933	6-2500-86
32	6-0032-81	6-0032-82	6-3200-85	6-3200-83	6-2500-84	M6 x 20 DIN933 8G or 10K	6-3200-86
40	6-0040-81	6-0040-82	6-4000-85	6-4000-83			6-4000-86
50	6-0050-81	6-0050-82	6-5000-85	6-5000-83		6-1025-933	6-5000-86
63	6-0063-81	6-0063-82	6-6300-85	6-6300-83	6-4000-84	8G or 10K	6-6300-86
80	6-0080-81	6-0080-82	6-8000-85	6-8000-83	-		6-8000-86

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NOTES:

- **TYPE I** Assembly includes stopwasher ٠ retainer and head hex screw.
- TYPE II Assembly includes stopwasher retainer, bushing stopwasher, hex head screw and snap ring.

BUSHING MOUNT/RETAINING COMPOUND

Part Number	Volume
9-60-82	118 mL

A bushing mount/retaining compound is used when installing straight sleeve ball bearing bushings to avoid bushing close-in as a result of press-fit.

BALL CAGE WASHE	RASSEMBLY		
Guide Pos	t Tap Sizes	Required Sea	ating Torque
Diameter O mm	Tap Size	N-m	In-Ibs
25 – 32	M6 x 1.0	36	320
40 – 50	M10 x 1.5	98	867
63 – 80	M10 x 1.5	236	2088

NOTES:

BALL BEARING BUSHING LUBRICATION RECOMMENDATION

During the operation of the Ball Bearing Bushing Assembly, add lubricant once each 8-hour shift by spray or brush application. Use a refined mineral oil of viscosity 290/340 SSU @ 100° F (38° C) containing "EP" additives and rust inhibitors.

Ball Bearing Components Selection Guide

Product Features

For proper post, bushing and cage selection, the operating conditions of the die must be taken into consideration. Factors such as press speed, shut height, stroke length and operating environment all play a role in selecting the appropriate operating condition to give the best performance possible of your components. The operating conditions include full preload, relieved and total disengagement.



<u>Type III</u> <u>Total Disengagement</u> of Cage from Bushing

Type III component assemblies are designed so the ball cage totally disengages from the bushing. This assembly is utilized on long stroke applications.

NOTES:

• See ball bearing lubrication recommendation on page 24.

Type I Component Selection Guide



PRESS FIT POSTS

- Calculate L, the desired guide post length, using one of the following 2 formulas: Assembly with Straight Sleeve Bushings: L=T-U₁-Z Assembly with Demountable Bushings: L=T-U₁-Z-J+E
- Select a post length from the catalog that is equal to L calculated above. If the calculated L value is not a standard catalog length, you have two options. Choose the next longest length and cut off to the calculated L dimension or select a shorter length and recess the post in the punch holder to obtain correct L dimension. *Note:* Press fit length should be equal to or greater than the diameter of the guide post.

DEMOUNTABLE POSTS

- 1. Calculate F_1 , the desired guide post length, using one of the following 2 formulas:
 - Assembly with Straight Sleeve Bushings: $F_1=T-U_1-Z-K$ (Note F+J+K+Y<T) Assembly with Demountable Bushing: $F_1=T-U_1-Z-J+E-K$ (Note L₂+K+Y<T)
- Select a post length from the catalog that is equal to F₁ calculated above. If the calculated F₁ value is not a standard catalog length, choose a catalog length that is close to but less than the calculated F₁.
 Note: Demountable posts cannot be cut off. See page 4 for standard post lengths (F₁).

BUSHING & CAGE SELECTION

Selection of a Type 1 Ball bearing bushing and cage assembly is based on the required stroke and the guide post diameter.

- 1. Determine the guide post diameter required and the stroke required.
- 2. Using the selection chart on page 27, find the desired stroke. Move down this column to the colored square on the horizontal line opposite the required post diameter.
- Select the required bushing length which is listed to the left of the selected square in the columns labeled demountable shoulder and straight sleeve.
 Note: For applications with no off-center loading, select the bushing with the shortest overall length from the

selection chart. However for longer stroke applications or where side-loading may be present select the bushing with the longest possible length to provide optimal guidance.

4. Select the required cage length which is also listed to the left of the selected square in the column labeled "Ball Cage."

Note: Shut height permitting, select the longest cage length possible for optimal performance.

NOTES:

- If die grind is not required, stroke may be increased by the amount of die grind allowance, dimension X, found in the right most column of the selection chart.
- A die set designed for a particular stroke may be used in any press of lesser stroke but never in any press where the stroke is greater than originally chosen.
- Die shoe thickness must be greater than "E" dimension when shoulder bushings are selected.

Type I Component Selection Guide

NOM. POST DIA.	BA	LL BUS	SHING SI FEVF	BALL CAGE		STROKE "S" INCLUDING DIE GRIND ALLOWANCE											*MAXIMUM DIE WEAR ALLOWANCE						
D	F	L ₁	L ₂	С		2	20	4	0	6	0	8	0	1(00	1:	20	14	40	16	60		X
mm	25	mm 65	mm 65	mm			-			-		-				-	_		_	-	-		mm
	50	80	80																				
25	65	00	05																				10
25	- 05	- 35	110	48	-																		10
	_	_	130		<u> </u>																		
	50	80	80																				
	65	95	95	26																			
	80	110	110																				
32	-	-	130																				10
	-	-	150	48																			
	-	-	170	\																			
	50	80	80	Ń																			
	65	95	95																				
	80	110	110	48																			
40	100	130	130																				10
40	-	-	150																				10
	-	-	170	60																			
	-	-	190																				
	-	-	215	\																			
	60	110	110	Λ																			
	80	130	130	70																			
	100	150	150																				
50	120	170	170																				10
	-	-	190		<u> </u>																		
	-	-	215	84																			
	-	-	240																				
	-	-	265	<u> </u>																			
	100	150	150																				
	120	1/0	170																				
63	140	190	190	98	<u> </u>																		15
	-	-	215		<u> </u>																		
	-	-	240		<u> </u>																		
	-	-	200						_		_								-		-		
	-	-	170		-												<u> </u>						
	<u> </u>	-	100		-																	-	
80			215	98	-																		15
			240		-																		
	_	_	265																		<u> </u>		
			200																	1			

If your selection falls in a white square, use Type II or Type III.

Type II & III Component Selection Guide





D mm	Z mm	E mm	U1 mm	U2 mm	Y mm
25	10.5	30		3.5	14.7
32	10.5	30		3.5	18.9
40	13	30	1.5	4	18.9
50	13	50		4	18.9
63	13	50		4	18.9
80	13	50		4	18.9

Type II & III Component Selection Guide

PRESS FIT POSTS

- Calculate L, the desired guide post length, using one of the following 2 formulas: Assembly with Straight Sleeve Bushings: L=T-U₂-Z Assembly with Demountable Bushings: L=T-U₂-Z-J+E
- 2. Select a post length from the catalog that is equal to L calculated above. If the calculated L value is not a standard catalog length, you have two options. Choose the next longest length and cut off to the calculated L dimension or select a shorter length and recess the post in the punch holder to obtain correct L dimension.

Note: Press fit length should be equal to or greater than the diameter of the guide post.

DEMOUNTABLE POSTS

- Calculate F₁, the desired guide post length, using one of the following 2 formulas: Assembly with Straight Sleeve Bushings: F₁=T-U₂-Z-K (Note F+J+K+Y<T) Assembly with Demountable Bushings: F₁=T-U₁-Z-J+E-K (Note L₂+K+Y<T)
- Select a post length from the catalog that is equal to F₁ calculated above. If the calculated F₁ value is not a standard catalog length, choose a catalog length that is close to but less than the calculated F₁.

Note: Demountable posts cannot be cut off. See page 4 for standard post lengths (*F*_.).

BUSHING & CAGE SELECTION

Selection of a Type II and Type III Ball bearing bushing and cage assembly is based on the required stroke and the guide post diameter.

- 1. Determine the guide post diameter required and the stroke required.
- 2. Determine the desired operating condition or the extent to which the cage leaves the bushing.
- 3. Determine if a demountable or straight sleeve bushing is to be used.
- 4. Using the selection chart on pages 30 & 31, find the desired stroke (S). Move down this column to the colored square on the horizontal line opposite the required post diameter. Find the colored square in the desired operating condition.
- 5. Select the required bushing length which is listed to the left of the selected square in the columns labeled demountable shoulder or straight sleeve.

Note: For applications with no off-center loading, select the bushing with the shortest overall length from the selection chart. However for longer stroke applications or where side-loading may be present select the bushing with the longest possible length to provide optimal guidance.

6. Select the required cage length which is also listed to the left of the selected square in the column labeled "Ball Cage."

Note: Shut height permitting, select the longest cage length possible for optimal performance.

NOTES:

- If stroking rate is under 150 rpm, Figure B (on page 28) is recommended, which allows the ball cage to reposition at each stroke.
- A die set designed for a particular stroke may be used in any press of lesser stroke but never in any press where the stroke is greater than originally chosen.
- Die shoe thickness must be greater than "E" dimension when shoulder bushings are selected.

Type II & III Bushing & Ball Cage Selection Guide

CAUTION

Be sure bushing does not strike punch holder at minimum shut height. If this condition exists, use shorter bushing and corresponding ball cage.

> Type II and III components provide Type I operating conditions





Figure A Partial Preload

Figure B Preload Relieved



Figure C Unlimited stroke cage leaves bushing

NOTES:

- Sleeve Bushing: L₂ + K must be less than T
- Shoulder Bushing: J + F + K must be less than T
- Demountable Bushing: Maximum F = T J K
- Sleeve Bushing: Maximum L₂ = T K

Nominal		Ball Bushi	ng	Ball Cage	
Diameter D mm	F mm	L1 mm	L2 mm	C mm	
	35	65	65	55	
	50	80	80	70	
25	65	95	95	90	
	_	-	110	100	
	-	-	130	110	
	50	80	80	70	
	65	95	95	90	
32	80	110	110	105	
	_	-	130	115	
	_	-	150	125	
	-	_	170	135	
	50	۶N	80	70	
	65	00 05	00 05	85	
	80	110	110	105	
	100	130	130	115	
40		-	150	125	
	_	_	170	135	
	_	_	190	145	
	_	_	215	155	
	60	110	110	105	
	80	130	130	120	
	100	150	150	140	
50	120	170	170	150	
50	_	_	190	160	
	-	-	215	170	
	-	-	240	185	
	-	-	265	195	
	100	150	150	145	
	120	170	170	165	
63	140	190	190	180	
	_	_	215	190	
	-	_	240	205	
<u> </u>	-	-	265	215	
	-	_	150	145	
	-	-	170	165	
80	_	_	190	180	
	_	_	215	190	
	_	_	240	205	
	-	-	265	215	

Type II & III Bushing & Ball Cage Selection Guide

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Bore Size Data for Bushings

BORE SIZES FOR DEMOUNTABLE PLAIN BEARING BUSHINGS

Bushing Diameter	Bus Locating N	hing Diameter 16	Punch Bc H	Holder ore 16	Assembly Fit			
mm	mm	mm	mm	mm	mm			
19 10	20	+0.021	20	+0.013	0.005	LOOSE		
10 - 19	20	+0.008	20	-0.000	0.021	TIGHT		
24 25	20	+0.025	20	+0.016	0.007	LOOSE		
24 - 25	30	+0.009	30	-0.000	0.025	TIGHT		
20 22	45	+0.025	45	+0.016	0.007	LOOSE		
30 - 32	45	+0.009	45	-0.000	0.025	TIGHT		
20 40	EA	+0.030	E A	+0.019	0.008	LOOSE		
36 - 40	54	+0.011	54	-0.000	0.030	TIGHT		
49 50	6F	+0.030	65	+0.019	0.008	LOOSE		
46 - 50	60	+0.011	65	-0.000	0.030	TIGHT		
62	01	+0.035	01	+0.022	0.009	LOOSE		
03	01	+0.013		-0.000	0.035	TIGHT		
00	100	+0.035	100	+0.022	0.009	LOOSE		
00	100	+0.013	100	-0.000	0.035	TIGHT		



BORE SIZES FOR STRAIGHT SLEEVE BALL BEARING BUSHINGS

Post Diameter	Bus Dian C	hing neter 02	Die S Bo H	Shoe pre 16	Asse F	embly it
mm	mm	mm	mm	mm	mm	
25	45	-0.017	15	+0.016	0.017	
25	45	-0.024	45	-0.000	0.040	LOOSE
22	54	-0.020	E4	+0.019	0.020	
32	54	-0.028	54	-0.000	0.047	LUUSE
40	6F	-0.020	65	+0.019	0.020	
40	60	-0.028	65	-0.000	0.047	LUUSE
50	01	-0.024	01	+0.022	0.024	
50	01	-0.034	01	-0.000	0.056	LUUSE
62	05	-0.024	05	+0.022	0.024	
03	95	-0.034	95	-0.000	0.056	
00	110	-0.024	110	+0.022	0.024	
00	112	-0.034		-0.000	0.056	



BORE SIZES FOR DEMOUNTABLE BALL BEARING BUSHINGS

	Bus	hing	Die	Shoe				
Bushing	Locating	Diameter	Bo	ore	Assembly			
Diameter	D)2	H	6	Fit			
mm	mm	mm	mm	mm	mm			
25	45	+0.020	45	+0.016	0.007	LOOSE		
25	45	+0.009	45	-0.000	0.020	TIGHT		
22	ΕA	+0.024	E 4	+0.019	0.008	LOOSE		
32	54	+0.011	54	-0.000	0.024	TIGHT		
40	65	+0.024	65	+0.019	0.008	LOOSE		
40	05	+0.011	05	-0.000	0.024	TIGHT		
50	01	+0.028	01	+0.022	0.009	LOOSE		
50	01	+0.013	01	-0.000	0.028	TIGHT		
63	05	+0.028	05	+0.022	0.009	LOOSE		
03	95	+0.013	95	-0.000	0.028	TIGHT		
00	100	+0.032	109	+0.025	0.010	LOOSE		
00	100	+0.015	100	-0.000	0.032	TIGHT		



BORE SIZES FOR DEMOUNTABLE GUIDE POSTS

Guide	e Post	Bore		
Dian	neter	Diameter	Asse	mbly
		S6	F	it
mm	mm	mm	mm	
18	-0.016	-0.025	0.002	LOOSE
10	-0.027	-0.036	0.020	TIGHT
10	-0.020	-0.031	0.002	LOOSE
19	-0.033	-0.044	0.024	TIGHT
24	-0.020	-0.031	0.002	LOOSE
24	-0.033	-0.044	0.024	TIGHT
25	-0.020	-0.031	0.002	LOOSE
25	-0.033	-0.044	0.024	TIGHT
20	-0.020	-0.031	0.002	LOOSE
30	-0.033	-0.044	0.024	TIGHT
22	-0.025	-0.038	0.003	LOOSE
32	-0.041	-0.054	0.029	TIGHT
20	-0.025	-0.038	0.003	LOOSE
38	-0.041	-0.054	0.029	TIGHT
40	-0.025	-0.038	0.003	LOOSE
40	-0.041	-0.054	0.029	TIGHT
40	-0.025	-0.038	0.003	LOOSE
48	-0.041	-0.054	0.029	TIGHT
50	-0.025	-0.038	0.003	LOOSE
50	-0.041	-0.054	0.029	TIGHT
62	-0.030	-0.047	0.002	LOOSE
63	-0.049	-0.066	0.036	TIGHT
	-0.030	-0.053	0.004	TIGHT
80	-0.049	-0.072	0.042	TIGHT



BORE SIZES FOR PRESS FIT GUIDE POSTS

Guide	Bore
Post	Diameter
Diameter	S6
mm	mm
18	-0.025
10	-0.036
10	-0.031
19	-0.044
24	-0.031
24	-0.044
25	-0.031
20	-0.044
30	-0.031
30	-0.044
22	-0.038
52	-0.054
20	-0.038
50	-0.054
40	-0.038
40	-0.054
19	-0.038
40	-0.054
50	-0.038
50	-0.054
62	-0.047
63	-0.066
00	-0.053
60	-0.072



CLAMP ARRANGEMENTS

Clamp Part Number	Screw Part Number	Screw Type	А	В	С	D	E (REF)
6-90-1	F010610	M6	14.3	15.9	4.9	8.7	7.2
6-91-1	F010810	M8 x 20	19.8	15.9	4.9	9.5	11
6-93-1	F010810	M8 x 20	19.6	15.9	6.3	10.9	11
6-95-1	F010610	M6	12.3	12.7	3.2	5.6	5.6
6-96-1	F010610	M6	17.5	14.5	5	10	4
6-97-1	F010810	M8 x 20	24.6	18.9	7.9	13	11.1

CLAMP

PART NUMBERS

> 6-90-1 6-91-1 6-93-1 6-95-1



Bushing 3 Clamp Arrangement





V

D



Bushing 2 & 4 Clamp Arrangement





Clamping Specifications

RETAINER PLUG DIMENSIONAL DATA

NOTES:

 All tapped holes for retainer plugs are tapped to two (2) times the diameter of the screw.



We offer two ways of mounting the pins into the die plate: clamps or a retainer plug.

Part Number	D2	D3	Α	В	D4	L4	H3
	mm	mm	mm	mm	mm	mm	mm
5-1800-88	18	25	3.3	4.0	26	3.5	25
5-2400-88	24	32	5.0	4.2	33	5.5	30
5-3000-88	30	40	5.0	7.0	41	5.5	40
5-3800-88	38	50	5.0	10.0	51	5.5	51
5-4800-88	48	63	5.0	13.0	64	5.5	59
5-6300-88	63	76	5.0	19.0	77	5.5	70
5-8000-88	80	93	5.0	25.0	95	5.5	87

BALL BEARING COMPONENTS

Recommended Lubrication:

- Ball-Lube
- Pint BALL-LUBE spray # ARL016
- Gallon BALL-LUBE # ARL128

Notes*:

- · Lubricates assemblies providing protection against wear, oxidation and rust
- MSDS available upon request
- Alternate / refined mineral oil of viscosity 220 cSt (@40°C), and 28.5 cSt (@100°C) containing "EP" additives and rust inhibitors.

SELF-LUBRICATING STYLE BUSHINGS OR WEAR PLATES WITH OIL IMPREGNATED GRAPHITE PLUGS

Recommended Lubrication:

• Light 20 wt. oil should be applied to pre-lube the wear surface of the bushing

Notes*:

 When bushing reaches 80-90 degrees F° because of friction between the components, oil is drawn from the plug thus lubricating the wear surface



NEVER USE GREASE with the Self-Lubricating oil impregnated graphite plug products. Grease on the oil impregnated graphite plugs will prevent the self-lubricating process

PLAIN BEARING FRICTION

Recommended Lubrication:

- Quart # 9-01-52
- Gallon # 9-02-52
- (5) Gallons # 9-02-520
- (55) Gallons # 9-02-521

Notes*:

- Above die lubricant is specially prepared to provide efficient lubrication for guide post in plain bearing applications
- · Alternative, lithium complex white grease or multi-purpose grease

*Note:

MSDS available upon request

Recommendations are based on applications in typical ambient temperatures. For high / low temperature applications, a reputable Lubricant Company or lubrication specialist should be consulted.

Lifter Pins

Product Features

Lifter pins are manufactured from 1144 steel and are commonly used to handle large die sets. They conform to NAAMS standards. The internal spring provides added assurance that the fall ring will function properly during the course of the pin's use.





Part Number	NAAMS Code	A ⁺⁰ 03 mm	B mm	C mm	D mm	E mm	F mm	Total Die Wt. in Metric Tons (t)
LP35-125	L013512	35	125	165	45	10	21.5	0 – 2.72
LP50-190	L015019	50	190	230	63	10	31	2.72 – 9.07
LP63-280	L016328	63	280	320	76	10	37.5	9.07 – 36.28
LP80-320	L018032	80	320	370	89	15	46	36.28 - 72.57

Cage Stopper End Cap – Metric



Product Features

The Cage Stopper End Cap is an alternative method to attach the ball bearing cage to a Danly ball bearing guide post. The Cage Stopper attaches to the guide post, allowing the ball bearing cage to rotate when not in preload position. The Cage Stopper is a good option when cage travel required is more than what is available with our traditional Danly ball bearing cages. A socket head cap screw is also included.



Guide Pin Diameter (mm)	B (mm)	D (mm)	SHCS Used	Part Number
25	31.75	22.23	Me	CS-2512
32	38.10	28.58		CS-3212
40	44.45	34.93		CS-4012
50	60.33	47.63	M10	CS-5012
63	73.03	60.33	INI TO	CS-6312
80	85.73	73.03		CS-8012



Socket Head Cap Screw included

Pad Retainers – Standard Mount – Metric

Product Features

These pad retainers are manufactured from 1144 steel and hardened to 28-34 Rockwell C-scale. They are machined to precise tolerances in order to retain the pad and assure parallelism during use.



PART NUMBER	D1	D2	L2	L3	S1	S2	LOAD RATING
NR50	50	40	35	15	M27 x 2	M16 x 2.0	192kN
NR70	70	60	40	15	M36 x 3	M20 x 2.5	299kN

PART	Diam.	Lenath	Diam.	Lenath
NUMBER	D2 (mm)	L1 (mm)	D1 (mm)	L4 (mm)
NR50-30		30		40
NR50-40		40		45
NR50-45		45		50
NR50-50		50		55
NR50-60		60		65
NR50-65		65		70
NR50-70	40	70	50	75
NR50-75		75	50	75
NR50-90		90		100
NR50-100		100		110
NR50-115		115		120
NR50-130		130		140
NR50-140		140		150
NR50-160		160		170
NR70-40		40		45
NR70-45		45		50
NR70-50		50		55
NR70-60		60		65
NR70-65		65		70
NR70-70		70	70	75
NR70-75	60	75		75
NR70-90		90		100
NR70-100		100		110
NR70-115		115		120
NR70-130		130		140
NR70-140		140		150
NR70-160		160		170



Pad Retainers – Reverse Mount – Metric



Product Features

These pad retainers are manufactured from 1144 steel and hardened to 28-34 Rockwell C-scale. They are machined to precise tolerances in order to retain the pad and assure parallelism during use.



	PART NUMBER	D1	D2	F	L3	LOAD RATING
ss	NR50	50	40	33.65	15	192kN
s	NR70	70	60	53.70	15	299kN

PART	Diam	Length	Diam	T1
NUMBER	D2 (mm)	L1 (mm)	D1 (mm)	(mm)
NP50 30P		30		
NR50-30R		40		
NR50-45R		45		
NR50-50R		50		
NR50-60R		60		
NR50-65R		65		
NR50-70R	10	70	50	
NR50-75R	40	75	50	M16 x 2.0
NR50-90R		90		
NR50-100R		100	- - -	
NR50-115R		115		
NR50-130R		130		
NR50-140R		140		
NR50-160R		160		
NR70-40R		40		
NR70-45R		45		
NR70-50R		50		
NR70-60R		60		
NR70-65R		65		
NR70-70R		70		
NR70-75R	60	75	70	M20 x 2.5
NR70-90R		90		
NR70-100R		100		
NR70-115R		115		
NR70-130R		130		
NR70-140R		140		
NR70-160R		160		

The Danly IEM Value Proposition

- I. DANLY IEM is recognized as the leader in manufacturing quality die components to the global parts forming industry. Our reputation has been built by satisfying customer needs, and we are very strong in the automotive and appliance industries.
- **II. DANLY IEM** offers outstanding delivery on a consistent basis. Choosing us as a supplier means that our customers have a competitive advantage in delivering their products to the market.
- **III. DANLY IEM** has complex machining capabilities on die components at several facilities. With extensive machining capabilities in the USA and China, we have taken the lead role in creating and bringing new products to customers and helping them find solutions that improve their operations.
- **IV. DANLY IEM's** vast breadth of products assures innovative solutions. We strive to address customer problems by utilizing our research and development department as well as other technical professionals.
- V. DANLY IEM has a technically trained sales force and distributor channels with Engineering support. Sales, Marketing and Engineering professionals are available to support our product lines.
- Competitive Prices
 Reliability and Performance





...A LEADING MANUFACTURER AND INNOVATOR OF DIE COMPONENTS SUPPLIED GLOBALLY TO THE METAL FORMING INDUSTRY...





High Quality Design & Construction
 Outstanding Service & Support

Commitment to Quality & Customer Satisfaction

Dayton Lamina is a leading manufacturer of tool, die and mold components for the metal-working and plastics industries. As a customer-focused, world-class supplier of choice, we provide the brands, product breadth, distribution network and technical support for all your metal forming needs.

Our goal is to give our customers the most innovative and valueadded products and services.

DAYTON Lamina



*Dayton Lamina's line of Danly products is available only to North America.

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