

# G.引導用固定襯套

## G.HEADLESS LINER BUSH

### 內徑

分精密級、一般級和鉸刀用3種

#### I.D.

Made in 3 different tolerances for precise drilling, normal drilling and reaming.

### 外徑

以內徑為基準，經精密研磨加工而成，分固定式襯套及插入式襯套

#### O.D.

Highly precise finish based on I.D.

(Press Fit Bush...P6) (Renewable Bush...m5)

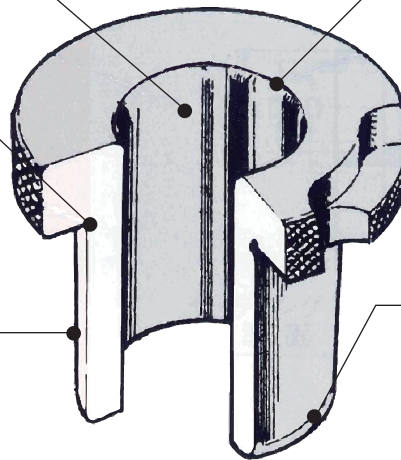
### 硬度

HRC60° 以上耐磨度極高

#### HARDNESS

HRC 60° up for long-er life.

### 襯套 BUSH



#### R圓

提供容易滑入之引導作用

#### RADIUS

For smooth entry of tool.

#### 倒角

為了襯套之容易裝配故施以倒角加工

#### CHAMFER

Permit easy entry and removal.

### ■ 治具用襯套 TYPE

### 形狀及種類 TYPE AND APPLICATION

S...精密鉗頭用

R...鉸刀用

S...Precise drilling R...Reaming

名稱 Designation	固定襯套 Press Fit		插入式襯套 Renewable Bush				引導用 固定式襯套 Headless Liner bush	止動螺絲 Lock Screw	止動環 Round Clamp	
	無帽緣 Headless	付帽緣 Headed	圓形 Round	右向迴轉切口形 Right Slip	左向迴轉切口形 Left Slip	切口形 Fixed				
形狀 Shape										
內徑的 使用 Sort of I.D.	精密級鉗頭 Precise Drilling	SA	SB	SC	SD	SE	SF	G形	T形	R形
	一般級鉗頭 Normal Drilling	A	B	C	D	E	F			
	鉸刀 Reaming	-	BR	CR	DR	ER	FR			
使用方法 Illustration of use	無帽緣(A) Headless		無帽緣(B) Headed		插入式(C)	插入式(D)	插入式(E)	插入式(F)		
	AB型襯套均以緊密配合平均壓入 Press the bush into the plate				先將固定襯套G以緊密配合壓入治具板後再用手裝取插入式襯套並配以T形螺絲固定 First press the liner bush into the plate, the insert the bush and set the lock screw.					

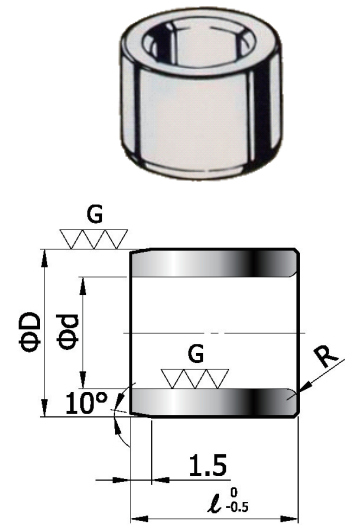
### ■ 內徑與外徑的同心度 Concentricity of ID and OD

內徑 (d) 寸法 ID(d)	1.6~18.0	18.1~50.0	50.1~55.0
精密級 / 鉗孔 Precise drilling/ reaming	0.005	0.008	0.010
一般級 Normal Drilling	0.012	0.020	0.025

### ■ 與治具板之裝配公差 Assembly tolerance with bush plate

襯套承板的內徑尺寸 I.D.(d) of hole in bush plate	0.3~3.0	3.1~6.0	6.1~10.0	10.1~18.0	18.1~30.0	30.1~50.0	50.1~55.0
H7公差 Tolerance H7	+0.010 0	+0.012 0	+0.015 0	+0.018 0	+0.021 0	+0.025 0	+0.030 0

- 引導用固定襯套，請於插入式襯套的引導下使用。
- 引導用固定襯套請勿用於鉗孔和鉸刀的加工。
- 就引導用固定襯套和襯套承板的固定而言。
  - 普通精度的場合(一般的)因無帽緣固定式襯套，其外徑係以p6 公差製造，固襯套承板的孔請用H7 公差，以利壓入配合。(用外徑m5 的鉸刀加工，即可得H7 的公差。)只能向反時針方向迴轉，取出時，其反轉即是。
  - 高精度的場合:
- 襯套外徑由實測而得，而襯套承板孔徑比襯套外徑小0.004~0.006mm，裝配時，以油壓壓床作90度垂直壓入。



- Headless liner bush is used for guide of renewable bush.
- Headless liner bush cannot be used for guide of drill or reamer.
- Information on pressing headless liner bush in the bush plate.
  - In case of normal precision (general):  
Bore a hole in bush plate at H7 in which the headless liner bush with O.D. (D) p6 can be fitted.  
(The tolerance of a hole bored by reamer with O.D. m5 is H7.)
  - In case of requiring high precision:
- Bore in the bush plate the hole with diameter less some 0.004 ~ 0.006 than O.D. of headless liner bush actually measured. in which the bush is straight by oil pressure press.

### ■ 標準稱呼尺寸(標準尺寸以外亦可製作)

Standard dimensions ( Special dimensions be ordered)

Ø d (內徑) (ID)		Ø D (外徑) (OD) p6		R	l
8	+0.032 +0.023	12	+0.029 +0.018	2	12 • 16
10	+0.036 +0.025	15			
12	+0.037 +0.026	18			
15	+0.040 +0.027	22	+0.035 +0.022		20 • 25
18	+0.041 +0.023	26			
22	+0.045 +0.027	30			
26	+0.041 +0.023	35	+0.042 +0.026	3	25 • 30
30	+0.045 +0.027	42			
35	+0.045 +0.027	48			
42	+0.051 +0.032	55	+0.051 +0.032	4	30 • 35
48	+0.055 +0.034	62			
55	+0.055 +0.034	70			

訂購例: Order

G - 10.0 x 12

全長 l Length  
內徑 ID  
型式 Type

