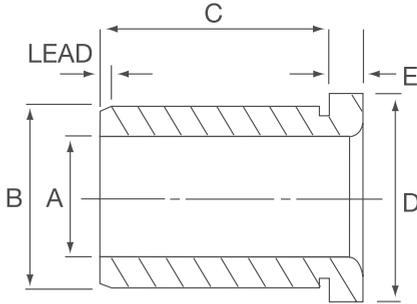


# Headed Drill Jig Bushes – Imperial

BS 1098 PT.1 1967



### ORDERING INSTRUCTIONS

- / Imperial bushes including metric bores.
- / Nitrided bushes for longer life can be supplied.
- / State: Qty, Type, Bore Size and Length
- / Example: 5, S6 3/8" x 3/4" lg

**Note:** All bores of the 32nd and 64th sizes over 1/2" diameter are now considered special. Standard bore sizes see chart page.

**Upsize bushes:** +.010"/+.015" on 'B' diameter can be supplied for finish grinding. State O/S if required after ref. Price on application. **Ream limits:** If required state R after ref. Price on application. Special bushes price on application.

### FITTING INSTRUCTIONS

Bore or Ream hole to dimension 'B' use H6 Limit when the Bush will be a suitable press fit.



A Dia. Range		B	Length C and Reference															Head	
mm	Imp.	Q.D.	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	1"	1 1/4"	1 3/8"	1 1/2"	1 3/4"	2"	2 1/4"	2 1/2"	D	E	
1.2 to 2.35	3/64 to 3/32	.2035 .2038	SB1	SB1	SB1	SB1											5/16	3/32	
2.4 to 3.5	7/64 to 9/64	.2505 .2508	S2	S2	S2	S2											5/16	1/8	
3.6 to 4.75	5/32 to 3/16	.3131 .3135		S3	S3	S3	S3	S3									3/8	1/8	
4.8 to 6.3	13/64 to 1/4	.4068 .4072		SB4	SB4	SB4	SB4	SB4									9/16	3/16	
6.4 to 7.9	17/64 to 5/16	.5006 .5010		S5	S5	S5	S5	S5	S5								5/8	3/16	
8.0 to 10.3	21/64 to 13/32	.6257 .6262				S6	S6	S6	S6	S6							3/4	3/16	
10.4 to 12.6	27/64 to 1/2	.7507 .7512				S7	S7	S7	S7	S7							15/16	1/4	
12.75 to 15.75	9/16 to 5/8	.8757 .8762						S8	S8	S8	S8	S8					1 1/8	1/4	
16 to 19	11/16 to 3/4	1.0009 1.0015				S9		S9	S9	S9	S9	S9	S9				1 1/4	5/16	
19.25 to 22	13/16 to 7/8	1.1884 1.1890						SB9	SB9	SB9	SB9	SB9	SB9	SB9			1 7/16	5/16	
22.25 to 25.25	15/16 to 1	1.3759 1.3765						S10	S10	S10	S10	S10	S10	S10			1 5/8	5/16	
25.5 to 30	1 1/16 to 1 3/16	1.5635 1.5642							SB10	SB10	SB10	SB10	SB10	SB10	SB10	SB10	1 13/16	3/8	
30.25 to 34.5	1 1/4 to 1 3/8	1.7510 1.7517							S11	S11	S11	S11	S11	S11	S11		2	3/8	
35 to 39.5	1 7/16 to 1 9/16	2.0010 2.0017							SB11	SB11	SB11	SB11	SB11	SB11		SB11	2 1/4	3/8	
40 to 44	1 5/8 to 1 3/4	2.2512 2.2520							S12	S12	S12	S12	S12	S12	S12	S12	2 1/2	3/8	

References shaded price on application