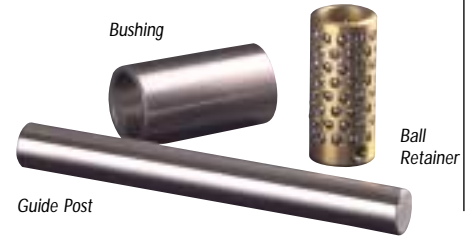


DIE SET COMPONENTS

Die set components are packaged as a set to assure tolerance compatibility.

Standard Bushings and Guide Posts JT&M's standard bushings are made of hardened steel and are ground and honed to exact tolerance. Guide posts are precision ground and made of case hardened steel. Optional post lengths are available upon request. (except 5/16 dia.)



Post Dia.	Post Lgth.	Post Hole Dia.	Bush O.D.	Bush Lgth.	Bush Hole Dia.*	Assy #
5/16	3	.3115 / .3120	1/2	3/4	.5014 / .5017	PB1
3/8	3 1/2	.3740 / .3745	5/8	1	.6264 / .6267	PB2
3/8	5	.3740 / .3745	5/8	1	.6264 / .6267	PB3
3/8	3 1/2	.3740 / .3745	3/4	1 3/4	.7515 / .7518	PB4
3/8	5	.3740 / .3745	3/4	1 3/4	.7515 / .7518	PB5
1/2	5	.4990 / .4995	3/4	1 3/8	.7515 / .7518	PB6
1/2	6	.4990 / .4995	3/4	1 3/8	.7515 / .7518	PB7
1/2	6	.4990 / .4995	1	2 1/8	1.0015 / 1.0018	PB8
1/2	5	.4990 / .4995	1	2 1/8	1.0015 / 1.0018	PB9
5/8	5	.6240 / .6245	7/8	1 1/4	.8765 / .8768	PB10
3/4	6 3/4	.7490 / .7495	1 3/8	2 1/2	1.3768 / 1.3772	PB11
1	9 7/8	.9990 / .9995	1 3/4	2 1/2	1.7519 / 1.7523	PB12
1 1/4	9 7/8	1.2490 / 1.2495	2 1/4	2 1/2	2.2525 / 2.2521	PB13

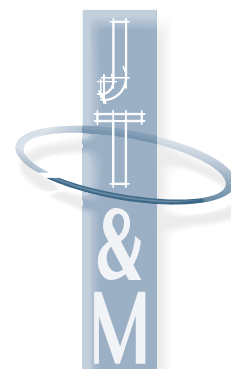
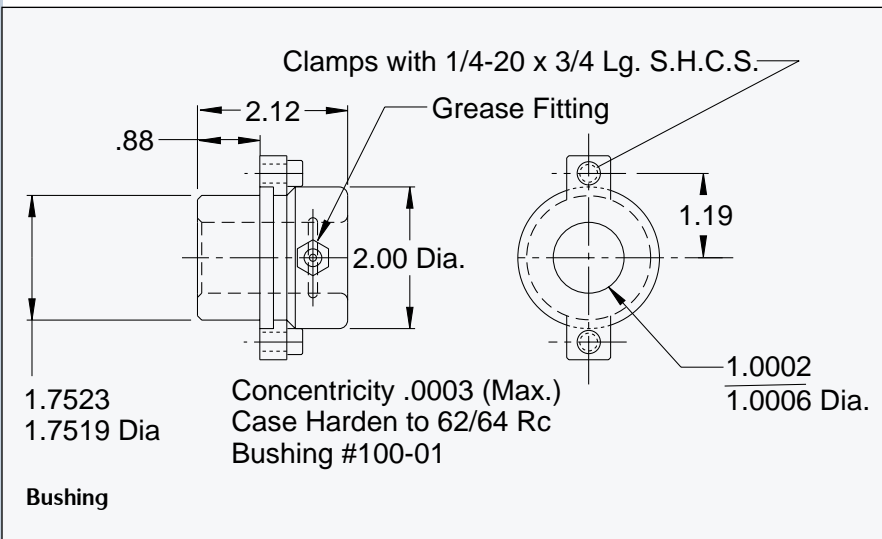
Ball Bearing Sleeve, Retainers, and Guide Posts JT&M's ball bearing components are precisely matched for full contact pre-load operation. Guide pins are made of case hardened steel and are precision ground. Ball retainers are made from gold anodized aluminum and hold a 25 millionth tolerance class chrome alloy ball. Each ball is held captive with four stakes. Ball bearing bushings are made of hardened steel and are ground and honed to exact tolerance. Longer post lengths are available upon request. Maximum stroke length is three inches.

Post Dia.	Post Lgth.	Post Hole Dia.	Bush O.D.	Bush Lgth.	Bush Hole Dia.*	Ball Retainer Lgth.	Assy #
3/8	3 1/2	.3740 / .3745	3/4	2 1/2	.7515 / .7518	2 1/2	PR1
3/8	5	.3740 / .3745	3/4	2 1/2	.7515 / .7518	2 1/2	PR2
1/2	5	.4990 / .4995	1	2 1/2	1.0015 / 1.0018	2	PR3
1/2	6	.4990 / .4995	1	2 1/2	1.0015 / 1.0018	2	PR4
3/4	6 3/4	.7490 / .7495	1 3/8	2 1/2	1.3768 / 1.3772	2 1/2	PR5
1	9 7/8	.9990 / .9995	1 3/4	2 1/2	1.7519 / 1.7523	2 1/2	PR6
1 1/4	9 7/8	1.2490 / 1.2495	2 1/4	2 1/2	2.2525 / 2.2521	2 1/2	PR7

*To minimize bushing close in, which is a result of press fit, use JT&M's bushing mount kit to eliminate additional honing or grinding. Order #566

1. Degrease bushing O.D. and die set hole with alcohol or acetone.
2. Apply bushing mount to die set hole.
3. Insert bushing into die set and allow 24-hour cure time.

Demountable Shoulder Bushings JT&M Demountable Shoulder Bushings are made of hardened steel and precision ground to within .0003 concentricity. They are designed for slip fit installation and assembled to the die set plate with two clamps and screws. Lubrication fitting at intersection of Bushing provides simple effective lubrication. Model #100-01



Janesville Tool & Manufacturing, Inc.