

All Danly solid guiding elements are made from high quality steels, hardened to a depth of 1.3mm with a hardness figure in excess of Rc60/62. Pillars are ground and bushes are honed to very close tolerances, with a surface finish of 0.2 μ CLA. Accuracy is preserved during their operating life by the fitting of oil reservoirs or grease nipples which allow continuous lubrication.
For boring sizes see pages 4/10 and 4/11


DEMOUNTABLE PILLARS

- Quickly and easily removed for die regrinds
- No distortion of guide pillar hole or centre distances
- Assured perpendicularity of guide pillar axis to die surface
- Interchangeable. Can be used with any Danly guide bush


DEMOUNTABLE SINTERLUBE BUSHES

- Superior resistance to seizure under high sides thrust and high press speeds
- Easily removed for punch or die regrind
- Completely interchangeable with steel bushes
- Assured perpendicularity of bush axis to die surface


SINTERED BRONZE DEMOUNTABLE BUSHES

- Superior resistance to seizure under high side thrust and high press speeds
- Easily removed for punch or die regrinds
- Assured perpendicularity of bush axis to die surface
- Completely interchangeable with demountable steel bushes
- Can be used with any Danly guide pillar


PRECISION GUIDE PILLARS

- Parallel throughout length
- Interchangeable
- Can be used with any Danly guide bush


STEEL DEMOUNTABLE BUSHES

- Easily removed for punch or die regrinds
- Accurate repositioning
- Assured perpendicularity of bush axis
- Interchangeable
- Can be used with any Danly guide pillar


S TYPE PILLARS

- Second, press fit, diameter at base provides interference fit to secure in plate.
Can be fitted from rear of plate
- Interchangeable
- Can be used with any Danly guide bushes


B TYPE PILLARS

- Simple, low cost, maximises die space
- Oil reservoir supplied for continuous lubrication
- Slide fit when used by customer, retain with bonding compound
- Can be used with any Danly guide pillar


BOSS BUSHES & PILLAR SUPPORTS

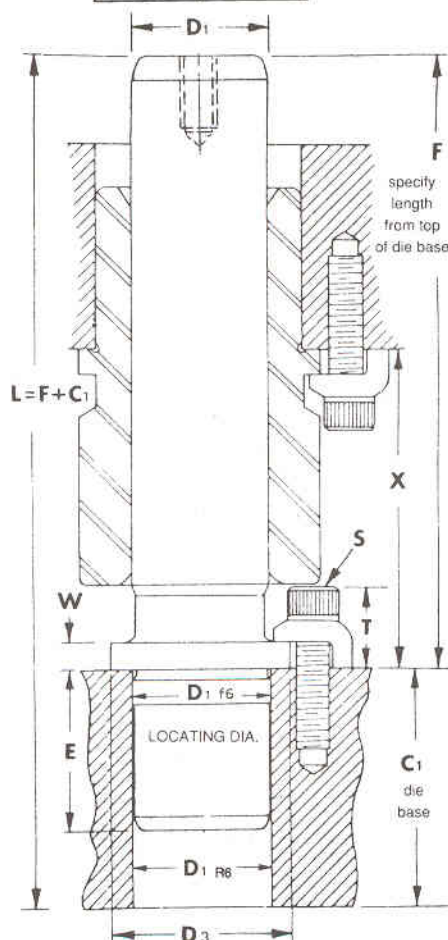
- Manufactured in high grade cast iron
- Available in two types
- Spigot location for accurate positioning


DH DEMOUNTABLE HOUSINGS

- Available in two thicknesses of high grade cast iron
- Can be fitted with solid guiding B type bush, or linear bearing guiding BAC only.
S type pillar only
- Supplied with four holes for bolting to plate

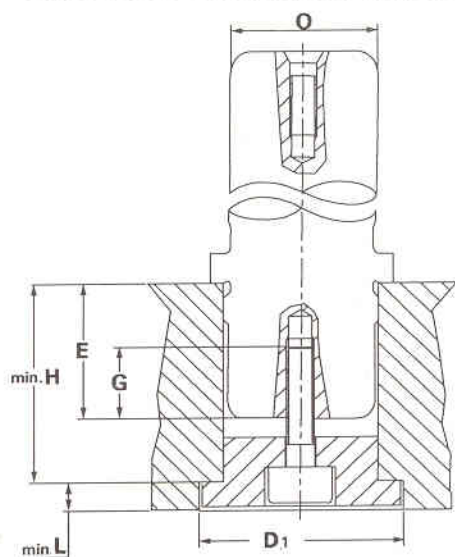
DEMOUNTABLE GUIDE PILLARS

GUIDE PILLAR THREAD SIZES	
NOM DIA "D"	THREAD SIZE
24-32	M6
40-80	M10



NOTE: ENSURE THAT DIMENSION 'X' LEAVES CLEARANCE FOR BUSH AT BOTTOM OF STROKE.

DEMOUNTABLE PIN ASSEMBLY WITH STOP WASHER



D1	18	19	24	25	30	32
D3	25.6	25.6	32.6	32.6	40.6	40.6
W	5	5	5	5	6.5	6.5
E	20	20	24	24	30	30
F	Cat. No.	Cat. No.	Cat. No.	Cat. No.	Cat. No.	Cat. No.
70	5-1807-83	5-1907-83	5-2407-83	5-2507-83		
80	5-1808-83	5-1908-83	5-2408-83	5-2508-83		
90	5-1809-83	5-1909-83	5-2409-83	5-2509-83	5-3009-83	5-3209-83
100	5-1810-83	5-1910-83	5-2410-83	5-2510-83	5-3010-83	5-3210-83
110	5-1811-83	5-1911-83	5-2411-83	5-2511-83	5-3011-83	5-3211-83
120	5-1812-83	5-1912-83	5-2412-83	5-2512-83	5-3012-83	5-3212-83
130	5-1813-83	5-1913-83	5-2413-83	5-2513-83	5-3013-83	5-3213-83
140	5-1814-83	5-1914-83	5-2414-83	5-2514-83	5-3014-83	5-3214-83
150	5-1815-83	5-1915-83	5-2415-83	5-2515-83	5-3015-83	5-3215-83
160	5-1816-83	5-1916-83	5-2416-83	5-2516-83	5-3016-83	5-3216-83
170			5-2417-83	5-2517-83	5-3017-83	5-3217-83
180			5-2418-83	5-2518-83	5-3018-83	5-3218-83
200			5-2420-83	5-2520-83	5-3020-83	5-3220-83
220					5-3022-83	5-3222-83
240					5-3024-83	5-3224-83
280					5-3028-83	5-3228-83

D1	40	42	50	52	63	80
D3	50.8	50.8	63.8	63.8	76	93
W	6.5	6.5	6.5	6.5	6.5	6.5
E	37	37	45	45	49	60
F	Cat. No.	Cat. No.	Cat. No.	Cat. No.	Cat. No.	Cat. No.
100	5-4010-83	5-4210-83				
110	5-4011-83	5-4211-83	5-5011-83	5-5211-83		
120	5-4012-83	5-4212-83	5-5012-83	5-5212-83	5-6312-83	
130	5-4013-83	5-4213-83	5-5013-83	5-5213-83		
140	5-4014-83	5-4214-83	5-5014-83	5-5214-83	5-6314-83	
150	5-4015-83	5-4215-83	5-5015-83	5-5215-83		
160	5-4016-83	5-4216-83	5-5016-83	5-5216-83	5-6316-83	
170	5-4017-83	5-4217-83	5-5017-83	5-5217-83		
180	5-4018-83	5-4218-83	5-5018-83	5-5218-83	5-6318-83	5-8018-83
200	5-4020-83	5-4220-83	5-5020-83	5-5220-83	5-6320-83	5-8020-83
220	5-4022-83	5-4222-83	5-5022-83	5-5222-83	5-6322-83	5-8022-83
240	5-4024-83	5-4224-83	5-5024-83	5-5224-83	5-6324-83	5-8024-83
260			5-5026-83	5-5226-83		
280	5-4028-83	5-4228-83	5-5028-83	5-5228-83	5-6328-83	5-8028-83
320			5-5032-83	5-5232-83	5-6332-83	5-8032-83
360			5-5036-83	5-5236-83	5-6336-83	5-8036-83
400			5-5040-83	5-5240-83	5-6340-83	5-8040-83

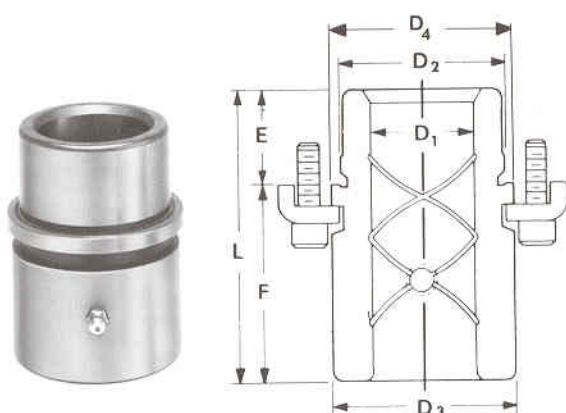
pin dia O	D1	E	G	H min	L min	stop washer part nr	screw
18-19	26	20	15	24.5	3.5	6-0018-3	M5x15
24-25	33	24	20	30.5	5.5	6-0024-3	M6x20
30-32	41	30	25	36.5	5.5	6-0030-3	M8x25
40-42	51	37	30	43.5	5.5	6-0040-3	M10x30
50-52	54	45	35	51.5	5.5	6-0050-3	M12x40
63	77	49	40	55.5	5.5	6-0063-3	M16x40
80	94	60	40	66.5	5.5	6-0080-3	M20x50

Refer to page 4/12 for clamp data
Quickly and easily removed for die regrind.
Assured perpendicularity of guide pillar axis to die surface.
Clamps and screws supplied with each pillar.
Other diameters and lengths can be supplied on special order.

ORDERING
State catalogue number
from chart above

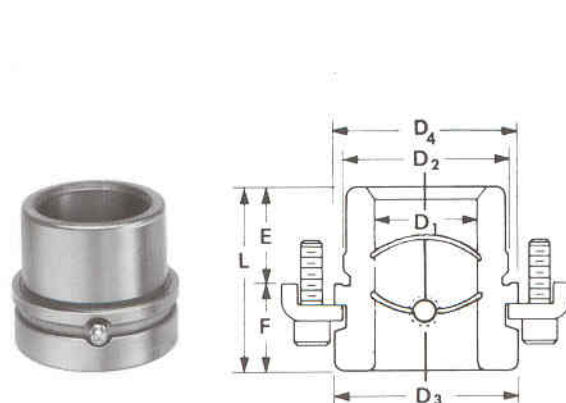
DEMOUNTABLE SINTERED BRONZE BUSHES

LONG SHOULDER



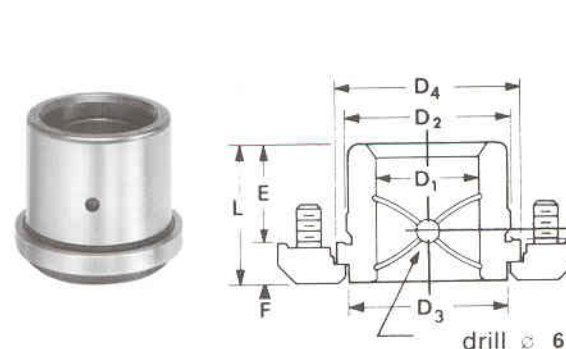
D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	CATALOGUE NUMBER
18	28	28,5	32,5	18	32	50	6-1828-44
19	28	28,5	32,5	18	32	50	6-1928-44
24	38	44	47	23	47	70	6-2438-44
25	38	44	47	23	47	70	6-2538-44
30	45	51	54	25	50	75	6-3045-44
32	45	51	54	25	50	75	6-3245-44
40	54	60	63	30	50	80	6-4054-44
42	54	60	63	30	50	80	6-4254-44
50	65	73	75	35	50	85	6-5065-44
52	65	73	75	35	50	85	6-5265-44
63	81	90	93	48	52	100	6-6381-44
80	100	110	115	48	52	100	6-8010-44

SHORT SHOULDER



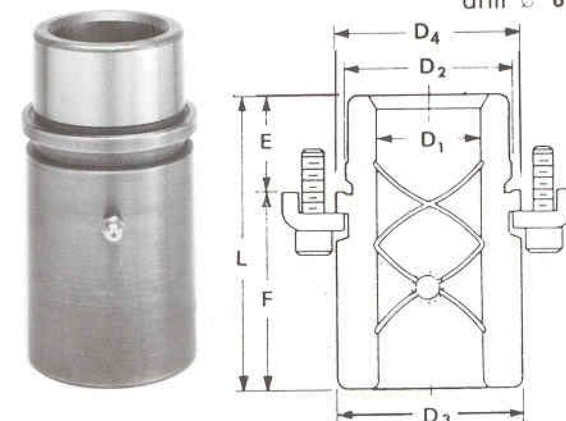
D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	CATALOGUE NUMBER
18	28	28,5	32,5	18	16	34	6-1828-43
19	28	28,5	32,5	18	16	34	6-1928-43
24	38	44	47	23	21	44	6-2438-43
25	38	44	47	23	21	44	6-2538-43
30	45	51	54	25	21	46	6-3045-43
32	45	51	54	25	21	46	6-3245-43
40	54	60	63	30	21	51	6-4054-43
42	54	60	63	30	21	51	6-4254-43
50	65	73	75	35	25	60	6-5065-43
52	65	73	75	35	25	60	6-5265-43
63	81	90	93	48	27	75	6-6381-43
80	100	110	115	48	27	75	6-8010-43

LOW PROFILE



D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	X mm	CATALOGUE NUMBER
18	28	28	32,5	18	10	28	6	6-1828-48
19	28	28	32,5	18	10	28	6	6-1928-48
24	38	36	47	23	10	33	6	6-2438-48
25	38	36	47	23	10	33	6	6-2538-48
30	45	43	54	30	10	40	10	6-3045-48
32	45	43	54	30	10	40	10	6-3245-48
40	54	48	63	38	14	52	10	6-4054-48
42	54	48	63	38	14	52	10	6-4254-48
50	65	64	75	48	14	62	20	6-5065-48
52	65	64	75	48	14	62	20	6-5265-48
63	81	79	93	61	14	75	20	6-6381-48
80	100	99	115	78	14	92	32	6-8010-48

EXTRA LONG SHOULDER BRONZE PLATED

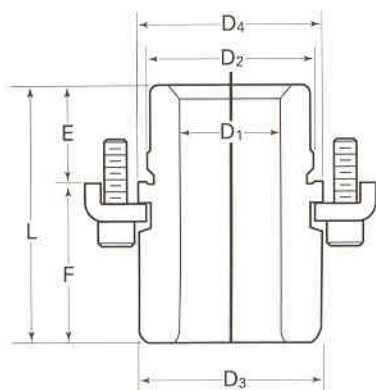


D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	CATALOGUE NUMBER
24	38	44	47	23	75	98	6-2438-45
25	38	44	47	23	75	98	6-2538-45
30	45	51	54	25	75	100	6-3045-45
32	45	51	54	25	75	100	6-3245-45
40	54	60	63	30	85	115	6-4054-45
42	54	60	63	30	85	115	6-4254-45
50	65	73	75	35	100	135	6-5065-45
52	65	73	75	35	100	135	6-5265-45
63	81	90	93	48	100	148	6-6381-45

Superior resistance to seizure under high sides thrust and high press speeds.
 Easily removed for punch or die regrind.
 Completely interchangeable with steel bushes.
 Assured perpendicularity of bush axis to die surface.
 Clamps and screws supplied with each bush.
 Demountable Sintered Bronze Bushes should not be pressed in or honed.
 Refer to page 4/12 for clamp data.

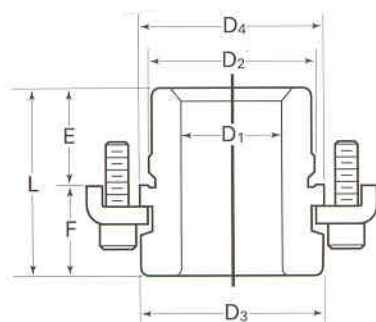
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DEMOUNTABLE **SinterLube**® BUSHES



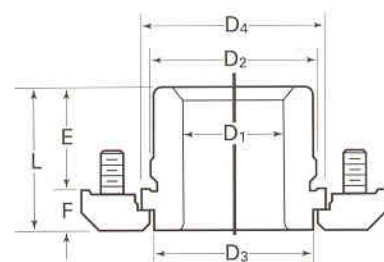
LONG SHOULDER

D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	CATALOGUE NUMBER
18	28	28,5	32,5	18	32	50	6-1828-34
19	28	28,5	32,5	18	32	50	6-1928-34
24	38	44	47	23	47	70	6-2438-34
25	38	44	47	23	47	70	6-2538-34
30	45	51	54	25	50	75	6-3045-34
32	45	51	54	25	50	75	6-3245-34
40	54	60	63	30	50	80	6-4054-34
42	54	60	63	30	50	80	6-4254-34
50	65	73	75	35	50	85	6-5065-34
52	65	73	75	35	50	85	6-5265-34
63	81	90	93	48	52	100	6-6381-34
80	100	110	115	48	52	100	6-8010-34



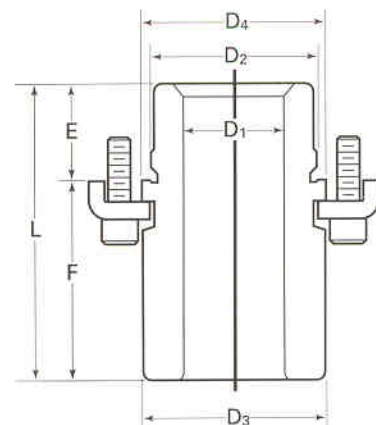
SHORT SHOULDER

D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	CATALOGUE NUMBER
18	28	28,5	32,5	18	16	34	6-1828-33
19	28	28,5	32,5	18	16	34	6-1928-33
24	38	44	47	23	21	44	6-2438-33
25	38	44	47	23	21	44	6-2538-33
30	45	51	54	25	21	46	6-3045-33
32	45	51	54	25	21	46	6-3245-33
40	54	60	63	30	21	51	6-4054-33
42	54	60	63	30	21	51	6-4254-33
50	65	73	75	35	25	60	6-5065-33
52	65	73	75	35	25	60	6-5265-33
63	81	90	93	48	27	75	6-6381-33
80	100	110	115	48	27	75	6-8010-33



LOW PROFILE

D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	CATALOGUE NUMBER
18	28	28	32,5	18	10	28	6-1828-38
19	28	28	32,5	18	10	28	6-1928-38
24	38	36	47	23	10	33	6-2438-38
25	38	36	47	23	10	33	6-2538-38
30	45	43	54	30	10	40	6-3045-38
32	45	43	54	30	10	40	6-3245-38
40	54	48	63	38	14	52	6-4054-38
42	54	48	63	38	14	52	6-4254-38
50	65	64	75	48	14	62	6-5065-38
52	65	64	75	48	14	62	6-5265-38
63	81	79	93	61	14	75	6-6381-38
80	100	99	115	78	14	92	6-8010-38

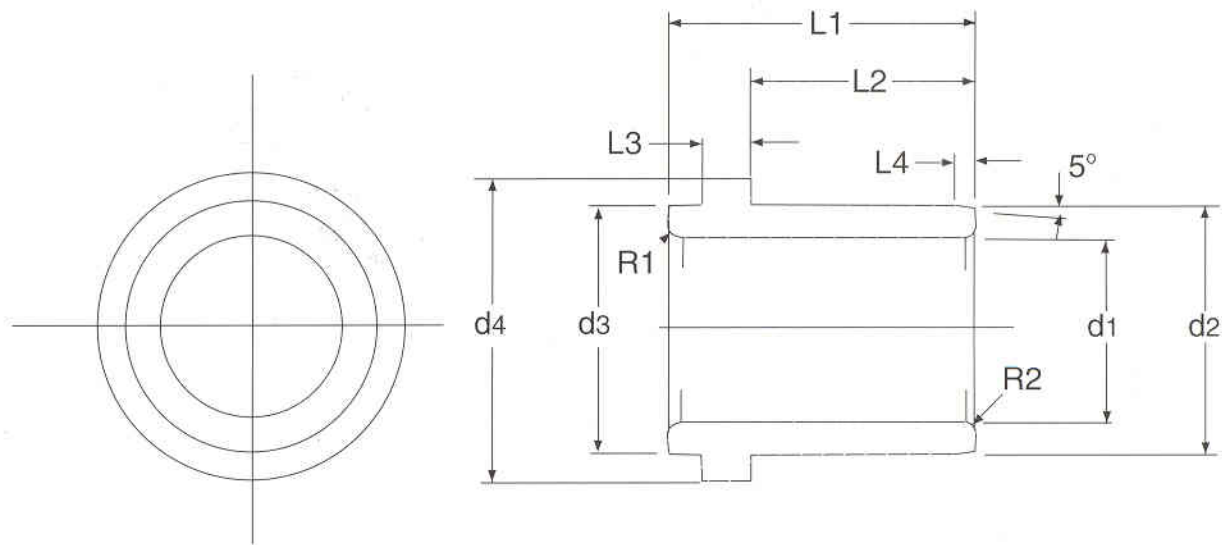


EXTRA LONG SHOULDER

D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	CATALOGUE NUMBER
24	38	44	47	23	75	98	6-2438-35
25	38	44	47	23	75	98	6-2538-35
30	45	51	54	25	75	100	6-3045-35
32	45	51	54	25	75	100	6-3245-35
40	54	60	63	30	85	115	6-4054-35
42	54	60	63	30	85	115	6-4254-35
50	65	73	75	35	100	135	6-5065-35
52	65	73	75	35	100	135	6-5265-35
63	81	90	93	48	100	148	6-6381-35

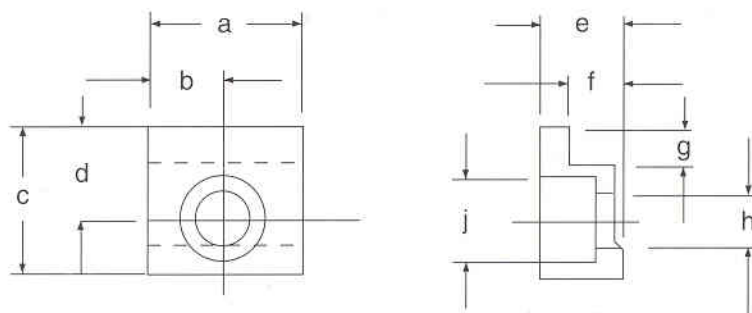
Superior resistance to seizure under high sides thrust and high press speeds.
 Easily removed for punch or die regrind.
 Completely interchangeable with steel bushes.
 Assured perpendicularity of bush axis to die surface.
 Clamps and screws supplied with each bush.
 Demountable **SinterLube**® Bushes should not be pressed in or honed,
 Refer to page 4/12 for clamp data.

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 State catalogue
 number from
 chart above



Catalogue No.	d1	d2	d3	d4	L1	L2	L3	L4	R1	R2	CLAMP
	H7	h6	0 -0.25	0 -0.8	-1 -1.6	-2 -2.5	±0.1	±1			
6-2532-78	25	32	32	40	40	32	6.3	3	3	1	6-78-1
6-3240-78	32	40	40	50	50	40	6.3	4	3	1	6-78-1
6-4050-78	40	50	50	63	63	50	6.3	5	3	1	6-78-1
6-5063-78	50	63	63	71	71	56	6.3	6.3	5	1	6-78-1
6-6380-78	63	80	80	90	80	63	10	8	6	1	6-78-2
6-8010-78	80	100	100	112	100	80	10	10	8	1	6-78-2

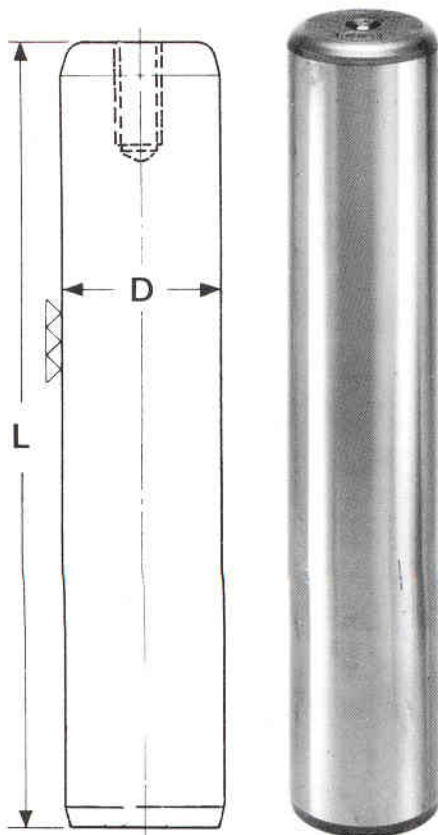
Clamps (Two per Bush)



Catalogue No.	a	b	c	d	e	f	g	h	i	Cap Screw
6-78-1	20	10	20	12.5	10	6.3	5	7	11	6mm
6-78-2	32	16	32	21	16	10	10	11.5	17.5	10mm

PRECISION GUIDE PILLARS

GUIDE PILLAR THREAD SIZES		RECOMMENDED SEATING TORQUE
NOM. DIA. "D"	THREAD SIZE	Kg-M
24-32	M6	0,90
40-50-63-80	M10	4,40



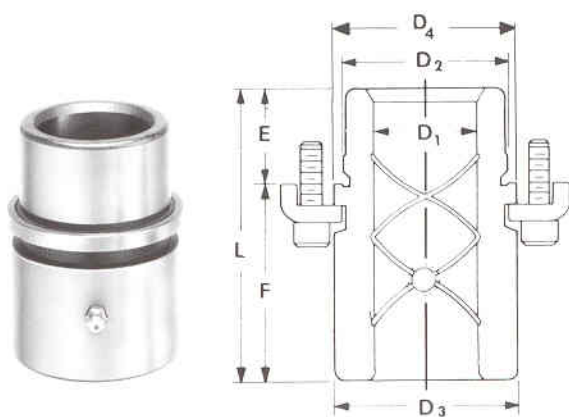
D	18	19	24	25
L	Cat. No.	Cat. No.	Cat. No.	Cat. No.
100	5-1810-82	5-1910-82	5-2410-82	5-2510-82
110	5-1811-82	5-1911-82	5-2411-82	5-2511-82
120	5-1812-82	5-1912-82	5-2412-82	5-2512-82
130	5-1813-82	5-1913-82	5-2413-82	5-2513-82
140	5-1814-82	5-1914-82	5-2414-82	5-2514-82
150	5-1815-82	5-1915-82	5-2415-82	5-2515-82
160	5-1816-82	5-1916-82	5-2416-82	5-2516-82
170	5-1817-82	5-1917-82	5-2417-82	5-2517-82
180	5-1818-82	5-1918-82	5-2418-82	5-2518-82
190	5-1819-82	5-1919-82	5-2419-82	5-2519-82
200	5-1820-82	5-1920-82	5-2420-82	5-2520-82
220			5-2422-82	5-2522-82
240			5-2424-82	5-2524-82
260			5-2426-82	5-2526-82
280			5-2428-82	5-2528-82
D	30	32	40	42
L	Cat. No.	Cat. No.	Cat. No.	Cat. No.
130	5-3013-82	5-3213-82	5-4013-82	5-4213-82
140	5-3014-82	5-3214-82	5-4014-82	5-4214-82
150	5-3015-82	5-3215-82	5-4015-82	5-4215-82
160	5-3016-82	5-3216-82	5-4016-82	5-4216-82
170	5-3017-82	5-3217-82	5-4017-82	5-4217-82
180	5-3018-82	5-3218-82	5-4018-82	5-4218-82
190	5-3019-82	5-3219-82	5-4019-82	5-4219-82
200	5-3020-82	5-3220-82	5-4020-82	5-4220-82
220	5-3022-82	5-3222-82	5-4022-82	5-4222-82
240	5-3024-82	5-3224-82	5-4024-82	5-4224-82
260	5-3026-82	5-3226-82	5-4026-82	5-4226-82
280	5-3028-82	5-3228-82	5-4028-82	5-4228-82
320	5-3032-82	5-3232-82	5-4032-82	5-4232-82
360			5-4036-82	5-4236-82
D	50	52	63	80
L	Cat. No.	Cat. No.	Cat. No.	Cat. No.
160	5-5016-82	5-5216-82		
180	5-5018-82	5-5218-82		
200	5-5020-82	5-5220-82	5-6320-82	
220	5-5022-82	5-5222-82	5-6322-82	
240	5-5024-82	5-5224-82	5-6324-82	5-8024-82
260	5-5026-82	5-5226-82	5-6326-82	5-8026-82
280	5-5028-82	5-5228-82	5-6328-82	5-8028-82
320	5-5032-82	5-5232-82	5-6332-82	5-8032-82
330	5-5033-82	5-5233-82		
360	5-5036-82	5-5236-82	5-6336-82	5-8036-82
400	5-5040-82	5-5240-82	5-6340-82	5-8040-82
450	5-5045-82	5-5245-82	5-6345-82	5-8045-82
500			5-6350-82	5-8050-82

In accordance with DIN 9825
Induction hardened to 60-64 Rc.
Suitable for use with all brushes.

ORDERING
State catalogue number
from chart above

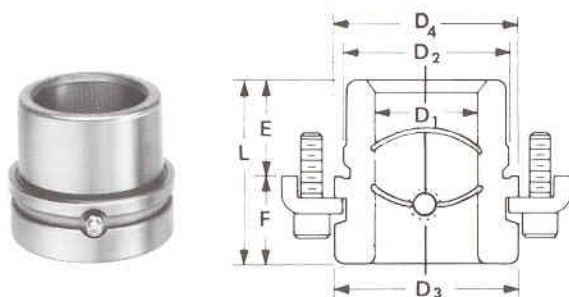
DEMOUNTABLE STEEL BUSHES

LONG SHOULDER



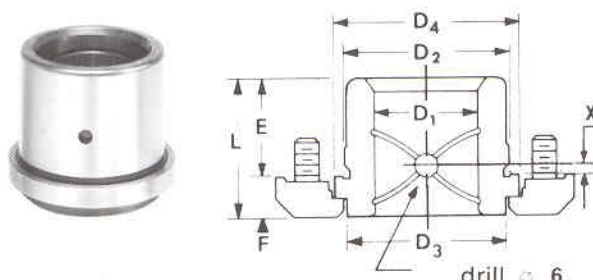
D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	CATALOGUE NUMBER
18	28	28,5	32,5	18	32	50	6-1828-64
19	28	28,5	32,5	18	32	50	6-1928-64
24	38	44	47	23	47	70	6-2438-64
25	38	44	47	23	47	70	6-2538-64
30	45	51	54	25	50	75	6-3045-64
32	45	51	54	25	50	75	6-3245-64
40	54	60	63	30	50	80	6-4054-64
42	54	60	63	30	50	80	6-4254-64
50	65	73	75	35	50	85	6-5065-64
52	65	73	75	35	50	85	6-5265-64
63	81	90	93	48	52	100	6-6381-64
80	100	110	115	48	52	100	6-8010-64

SHORT SHOULDER



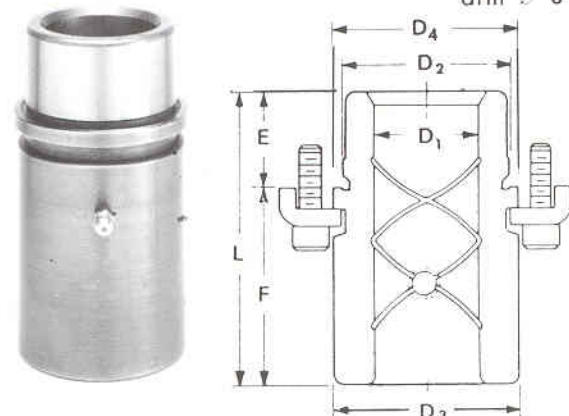
D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	CATALOGUE NUMBER
18	28	28,5	32,5	18	16	34	6-1828-63
19	28	28,5	32,5	18	16	34	6-1928-63
24	38	44	47	23	21	44	6-2438-63
25	38	44	47	23	21	44	6-2538-63
30	45	51	54	25	21	46	6-3045-63
32	45	51	54	25	21	46	6-3245-63
40	54	60	63	30	21	51	6-4054-63
42	54	60	63	30	21	51	6-4254-63
50	65	73	75	35	25	60	6-5065-63
52	65	73	75	35	25	60	6-5265-63
63	81	90	93	48	27	75	6-6381-63
80	100	110	115	48	27	75	6-8010-63

LOW PROFILE



D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	X mm	CATALOGUE NUMBER
18	28	28	32,5	18	10	28	6	6-1828-68
19	28	28	32,5	18	10	28	6	6-1928-68
24	38	36	47	23	10	33	6	6-2438-68
25	38	36	47	23	10	33	6	6-2538-68
30	45	43	54	30	10	40	10	6-3045-68
32	45	43	54	30	10	40	10	6-3245-68
40	54	48	63	38	14	52	10	6-4054-68
42	54	48	63	38	14	52	10	6-4254-68
50	65	64	75	48	14	62	20	6-5065-68
52	65	64	75	48	14	62	20	6-5265-68
63	81	79	93	61	14	75	20	6-6381-68
80	100	99	115	78	14	92	32	6-8010-68

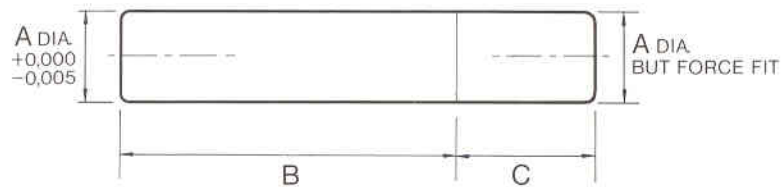
EXTRA LONG SHOULDER



D ₁ mm	D ₂ mm	D ₃ mm	D ₄ mm	E mm	F mm	L mm	CATALOGUE NUMBER
24	38	44	47	23	75	98	6-2438-65
25	38	44	47	23	75	98	6-2538-65
30	45	51	54	25	75	100	6-3045-65
32	45	51	54	25	75	100	6-3245-65
40	54	60	63	30	85	115	6-4054-65
42	54	60	63	30	85	115	6-4254-65
50	65	73	75	35	100	135	6-5065-65
52	65	73	75	35	100	135	6-5265-65
63	81	90	93	48	100	148	6-6381-65

Refer to page 4/12 for clamp data
 Easily removed for punch or die regrind
 Assured perpendicularity of bush axis to die surface
 Clamps and screws supplied with each bush
 Demountable Steel Bushes should not be pressed in or honed

ORDERING
 State catalogue
 number from
 chart above



These components are made from good quality induction-hardening steel. They are hardened and ground to close tolerances and a high finish.

These components are designed for use with all Danly solid bushes and Danly linear bearings.

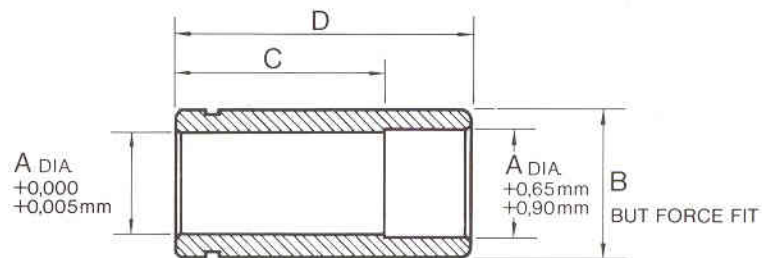
A	C mm	B																							
PART No.		65	70	75	90	95	100	110	115	120	125	130	140	150	160	170	180	190	200	230	255	300			
S 16	20	x	x	x	x	x	x	x	x	x	x	x	x	x	x		x								
S 18	22	x	x	x	x	x	x	x	x	x	x	x	x	x	x		x								
S 19	22	x	x	x	x	x	x	x	x	x	x	x	x	x	x		x								
S 24	27	x	x	x	x	x	x	x	x	x	x	x	x	x	x		x	x	x						
S 25	27	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x		x	x			
S 30	34	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x				
S 32	34	x		x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x	x			
S 40	42					x	x		x	x	x	x	x	x	x	x	x	x	x	x	x	x			
S 42	42						x	x	x	x		x	x	x	x	x	x	x	x	x	x	x			
S 50	52						x			x		x	x	x	x	x			x	x	x	x			
S 52	52						x			x		x	x	x	x	x			x	x	x	x			

ORDERING:

Guide Pillars should be ordered by the part number and projecting length 'B', e.g. S16 x 65B.

ATTENTION

These sizes are no longer fitted to our Shaped Die Set Assemblies.



These components are made from good quality case-hardening steel. They are hardened, ground and the bores honed to close tolerances and a high finish.

PART No. 'A'	B	C	D						
			50	65	75	90	100	115	130
B 16	25	32	X	X	X		X		
B 18	30	40	X	X	X		X		
B 19	30	40	X	X	X	X	X		X
B 24	38	50	X	X	X	X	X		X
B 25	38	50	X	X	X	X	X	X	X
B 30	45	65		X	X	X	X	X	X
B 32	45	65		X	X	X	X	X	X
B 40	57	75			X	X	X	X	X
B 42	57	75			X	X	X	X	X
B 50	73	100					X		X
B 52	73	100					X		X

ORDERING:

Guide Bushes should be ordered by the part number 'A' dia and overall length 'D',
e.g. B16 x 75D

ATTENTION

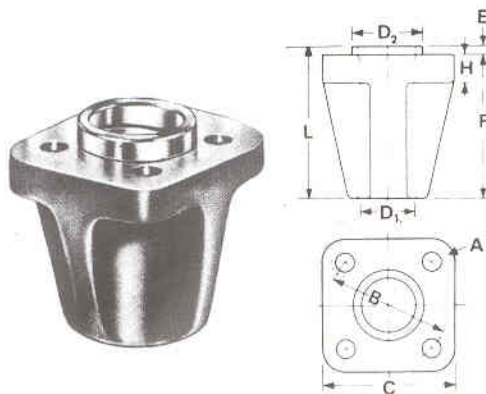
These sizes are no longer fitted to our Shaped Die Set Assemblies.

BOSS BUSHES AND PILLAR SUPPORTS

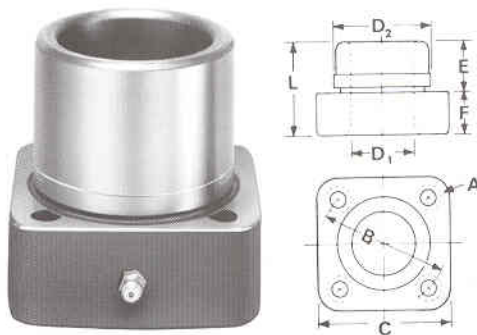


Danly Demountable Boss Bushes are made of cast iron and are available in two bush types. Type 1 is a flange mounted bush with the major part of the bush projecting above the die set. It can also be used as a guide pillar support for extra guide pillar stability. (When ordering, specify if it is to be used as support.)

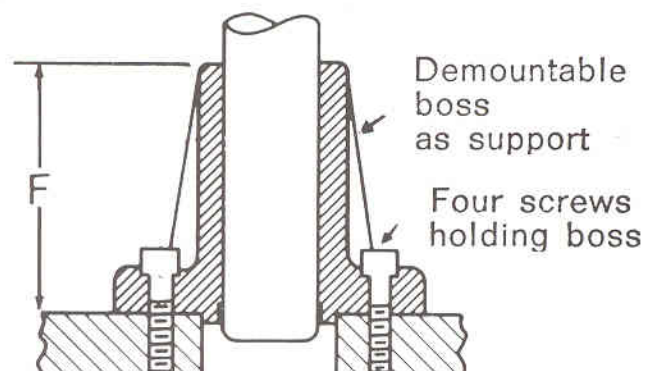
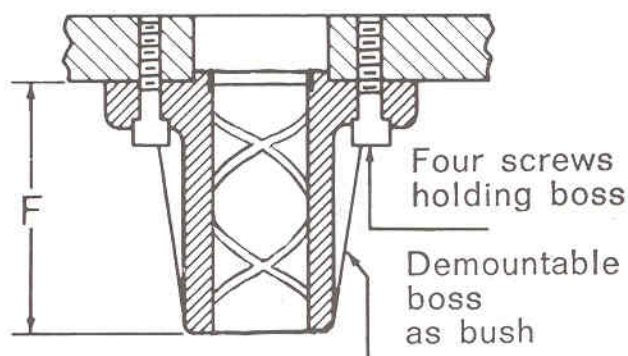
Type II is a flange-mounted bush with the main part of the bush within the bore of the die set. Both bushes are furnished with necessary mounting screws.



D ₁ mm	C mm	E mm	F mm	L mm	H mm	B mm	SCREW A	D ₂	BUSH Catalogue number	SUPPORT Catalogue number
50	124	8	89	97	25	114	M-16	65	6-5065-12	
			139	147					6-5065-13	6-5065-14
63	152	8	89	97	25	152	M-16	81	6-6381-12	
			139	147					6-6381-13	6-6381-14
80	178	8	89	97	25	180	M-20	100	6-8010-12	
			139	147					6-8010-13	6-8010-14

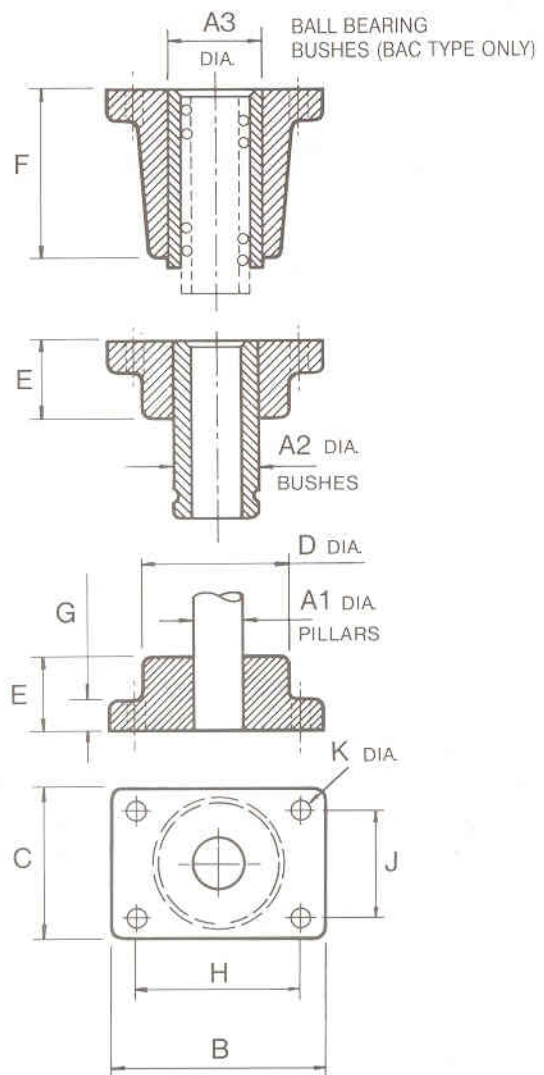


D ₁ mm	C mm	E mm	F mm	L mm	B mm	SCREW A	D ₂	CATALOGUE NUMBER
25	54	23	18	41	52	M-6	38	6-2538-18
32	59	30	20	50	58	M-6	45	6-3245-18
40	72	38	25	63	68.5	M-8	54	6-4054-18
50	79	48	30	78	77.5	M-8	65	6-5065-18
63	97	61	30	91	94.5	M-10	81	6-6381-18
80	111	78	48	126	114.5	M-10	100	6-8010-18



For correct fitment to die sets, boss bushes and pillar supports must be provided with an accurately bored location to suit locating diameter D₂.
For suitable screws, see page 10/1.

ORDERING
State catalogue
number from
chart above



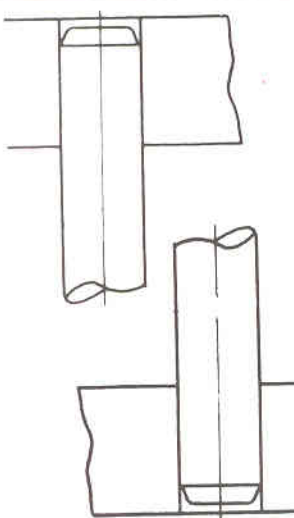
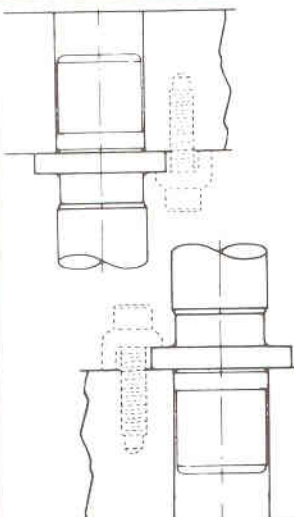
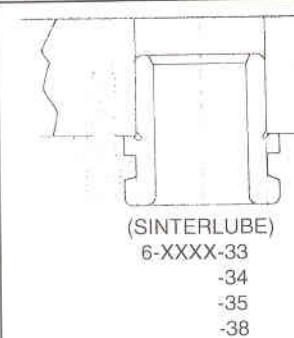
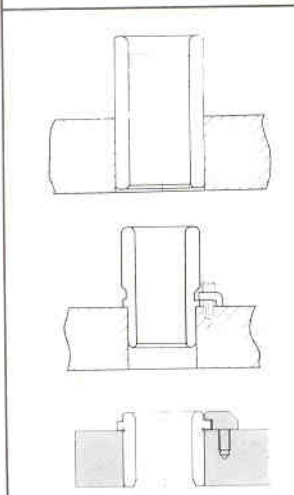
TYPE No.	A1	A2	A3	B	C	D	E	F	G	H	J	K
DH 19	19	30	36	95	70	60	32	75	15	72	47	9.5
DH 25	25	38	42									
DH 32	32	45	52	120	85	70	42	80	20	90	55	11.5
DH 40	40	57	63	145	100	85	60	90	25	110	65	14
DH 50	50	73	73	170	120	108	65	90	32	130	80	18

Material: Cast iron.

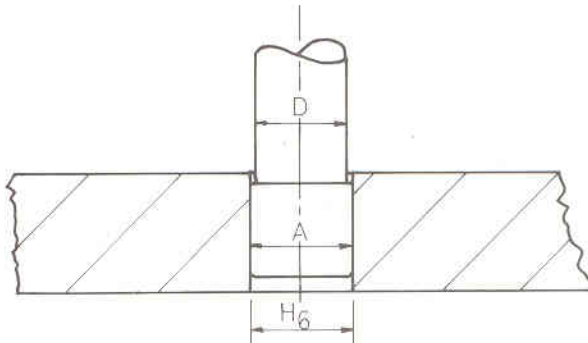
ORDERING: e.g.

Housing with 'S' type pillar 25mm dia x 125mm 'B' length = 1-DH25E/S120B.
Housing with standard bush 25mm i/dia x 75mm 'D' length = 1-DH25E/B75D.
Housing with ball bearing assembly BAC25/L4 = 1-DH25F/BAC/L4.

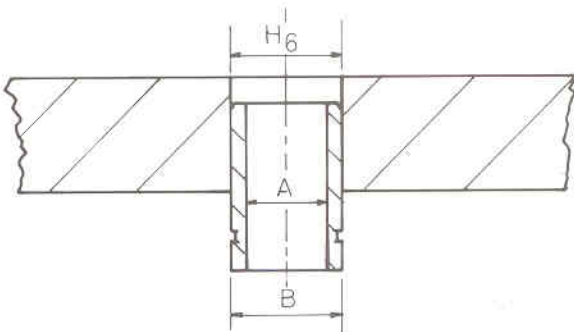
BORING CHART

 <p>STRAIGHT PILLARS</p> <p>BALL BUSH TYPE * SERIES REF 5-XXXX-82</p> <p>SOLID GUIDE TYPE SERIES REF 5-XXXX-82</p>		NOMINAL PILLAR DIA.	BORE PLATE R6
		18	17.969/17.980
		19	18.963/18.976
		24	23.963/23.976
		25	24.963/24.976
		30	29.963/29.976
		32	31.955/31.971
 <p>DEMOUNTABLE PILLARS</p> <p>BALL BUSH TYPE SERIES REF 5-XXXX-83</p> <p>SOLID GUIDE TYPE SERIES REF 5-XXXX-83</p>		40	39.955/39.971
		42	41.955/41.971
		50	49.955/49.971
		52	51.946/51.965
		63	62.946/62.965
		80	79.944/79.963
 <p>DEMOUNTABLE BUSHES SOLID GUIDE TYPE</p> <p>SERIES REF (STEEL) 6-XXXX-63 -64 -65 -68</p> <p>(SINTERLUBE) 6-XXXX-33 -34 -35 -38</p> <p>(SINTERED BRONZE) 6-XXXX-43 -44 -45 -48</p>		NOMINAL BUSH DIA.	BORE PLATE H6
		18 AND 19	28.000/28.016
		24 AND 25	38.000/38.016
		30 AND 32	45.000/45.016
		40 AND 42	54.000/54.019
		50 AND 52	65.000/65.019
		63	81.000/81.022
		80	100.000/100.022
 <p>BALL BUSHES</p> <p>STRAIGHT SLEEVE SERIES REF 6-XXXX-86</p> <p>DEMOUNTABLE SERIES REF 6-XXXX-85</p> <p>STRIPPER BUSH SERIES REF 6-XXXX-87</p>		NOMINAL PILLAR DIA.	BORE PLATE H6
		25	45.000/45.016
		32	54.000/54.019
		40	65.000/65.019
		50	81.000/81.022
		A 63	95.000/95.022
		B 80	112.000/112.022
		<p>A — ONLY AVAILABLE AS STRAIGHT AND DEMOUNTABLE TYPES</p> <p>B — ONLY AVAILABLE AS STRAIGHT TYPE</p>	

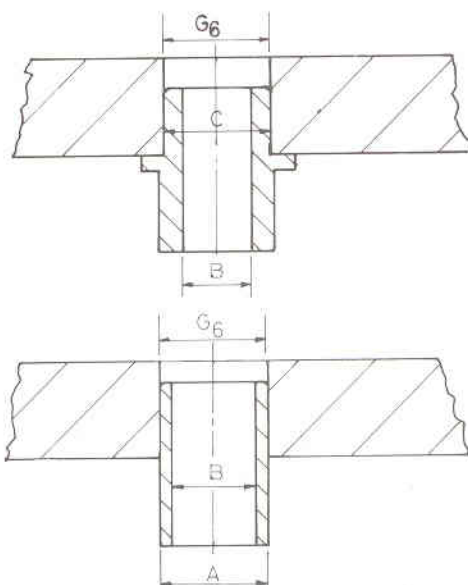
The following table shows recommended sizes for boring holes to fit "double diameter" guide pillars, standard 'B' type bushes and ball bearing bushes type BA, HBA & BAC. With the exception of the latter, these sizes will give an interference fit, which in the case of a standard bush, may result in the collapse of the bore, necessitating rehonng after assembly. The alternative is to bore the holes to make the bushes a sliding fit (approximately 0,05 mm larger than sizes stated below) and retain the bushes with a bonding compound. Ball Bearing bushes type BA and HBA are retained with three screws, type BAC with a bonding compound.

STANDARD 'S' PILLARS

NOMINAL PILLAR DIA.
BORE PLATE

16mm	16.000/16.013
* 18mm	18.000/18.013
19mm	19.000/19.013
* 24mm	24.000/24.013
25mm	25.000/25.013
* 30mm	30.000/30.013
32mm	32.000/32.016
* 35mm	35.000/35.016
* 38mm	38.000/38.016
40mm	40.000/40.016
* 42mm	42.000/42.016
50mm	50.000/50.016
* 52mm	52.000/52.016

STANDARD 'B' BUSHES

NOMINAL PILLAR DIA.
BORE PLATE

16mm	25.000/25.013
* 18mm	30.000/30.013
19mm	30.000/30.013
* 24mm	38.000/38.016
25mm	38.000/38.016
* 30mm	45.000/45.016
32mm	45.000/45.016
* 35mm	52.000/52.019
* 38mm	52.000/52.019
40mm	57.000/57.019
* 42mm	57.000/57.019
50mm	73.000/73.019
52mm	73.000/73.019

TYPE BA, HBA & BAC

NOMINAL PILLAR DIA.
BORE PLATE

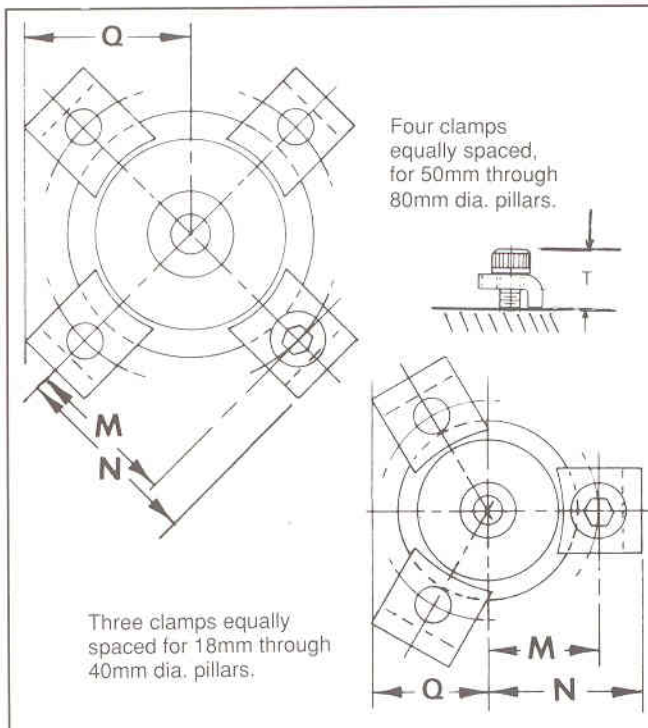
16mm	+ 32.015/32.023
* 18mm	36.015/36.023
19mm	+ 36.015/36.023
* 24mm	42.015/42.023
25mm	+ 42.015/42.023
* 30mm	52.015/52.023
32mm	+ 52.015/52.023
* 35mm	55.015/55.023
* 38mm	58.015/58.023
40mm	+ 63.015/63.023
* 42mm	63.015/63.023
50mm	+ 73.015/73.023
52mm	+ 73.015/73.023

† Retained cages type 'HBA' available only in these sizes.

* These sizes no longer fitted to shaped die set assemblies.

If replacing bushes in a standard die set, bores should be opened out or bushes reduced to nominal size and then retained with a bonding compound (see note above).

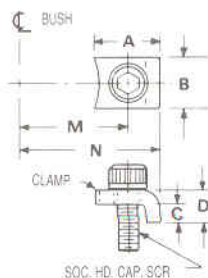
CLAMP DATA



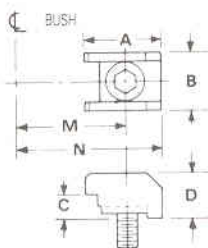
PILLAR CLAMP DATA

Dia. D ₁	Radius		Q	Qty per pillar	Calalogue number	Socket Head Cap Screws	
	M	N				S	T
18-19	16	23,5	19	3	6-90-1	M 6 x 16	15
24-25	20,3	27,8	20,8	3			
30-32	25,5	35,5	24,6	3	6-93-1	M 8 x 22	19,4
40-42	30	40	26,9	3-4	6-93-1		
50-52	36,5	46,5	38,5	4	6-93-1	M 8 x 22	19,4
63	42,5	52,5	42,7	4	6-93-1		
80	51	61	48,8	4	6-93-1		

Catalogue Numbers 6-90-1, 6-93-1, & 6-95-1



Catalogue Numbers 6-96-1 & 6-97-1



BUSH CLAMP DATA

Extra Long, Long and Short Shoulder Bushes

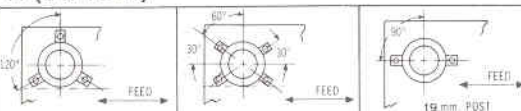
Nom pillar Dia.	Clamp per Bush	Screw	Clamp	A mm	B mm	C mm	D mm	M mm	N mm
18-19	2	M6	6-95-1	12,3	12,7	3,2	5,6	19,5	25,5
24-25	2-3	M6	6-90-1	14,3	15,9	4,9	8,7	27,5	35
30-32	3	M8	6-93-1	19,8	15,9	6,5	11,4	32,5	42,5
40-42	3-4	M8	6-93-1	19,8	15,9	6,5	11,4	37	47
50-52	4	M8	6-93-1	19,8	15,9	6,5	11,4	44,5	54,5
63	4	M8	6-93-1	19,8	15,9	6,5	11,4	52	62
80	4	M8	6-93-1	19,8	15,9	6,5	11,4	62	72

Low Profile Bushes

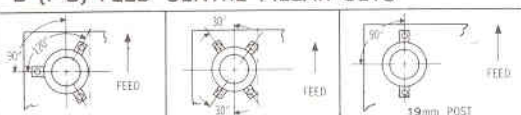
Nom pillar Dia.	Clamp per Bush	Screw	Clamp	A mm	B mm	C mm	D mm	M mm	N mm
18-19	2	M6	6-95-1	12,3	12,7	3,2	5,6	19,5	25,5
24-25	2-3	M6	6-96-1	17,5	14,5	5	10	30	37
30-32	3	M6	6-96-1	17,5	14,5	5	10	34	41
40-42	3-4	M8	6-97-1	24,6	18,9	7,9	13	39,5	50,5
50-52	4	M8	6-97-1	24,6	18,9	7,9	13	46	57
63	4	M8	6-97-1	24,6	18,9	7,9	13	56	67,5
80	4	M8	6-97-1	24,6	18,9	7,9	13	66	77

CLAMP ARRANGEMENT SELECTION DATA

A (L-R FEED)



B (F-B) FEED CENTRE PILLAR SETS



Note :

if not specified, clamp arrangement A will be furnished. Clamp arrangement B is furnished on centre pillar sets.

NOTE: necessary clamps and screws are included in the price of pillars & bushings.