

Guide Bushing

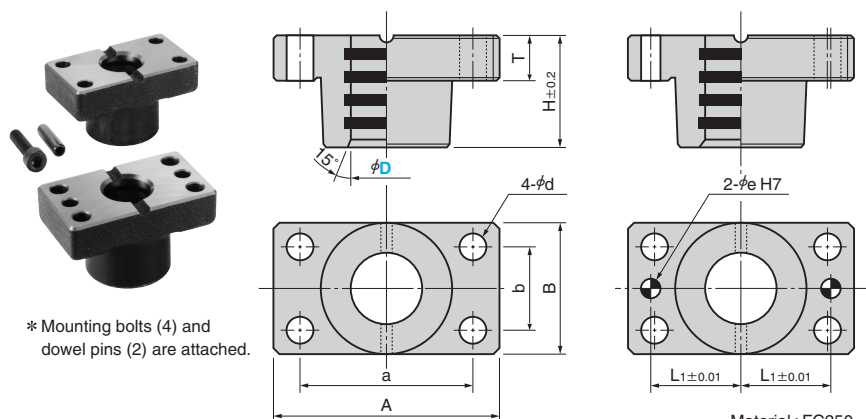
FOR HOLDER TYPE GUIDE POST SET

CAD
FILE

Plain Type

SGRB

SGRBN(With dowel pin hole)



* Mounting bolts (4) and
dowel pins (2) are attached.

Material : FC250
with Graphite

A	a	B	b	H	T	d	L1	e H7	Accessories		Catalog No.	D Tolerance
									Bolt	Dowel pin		
84	66	48	30	45	20	9	33	8	M 8×35	φ 8×30	SGRB SGRBN	25 +0.041 -0.031
100	76	58	36	50		11	38	8	M10×40			32 +0.047 -0.037
130	100	75	44	60	25		50	10	M10×45	φ10×40		38 +0.049 -0.037
155	125	90	60	85		14	62.5		M12×50			50 +0.052 -0.037
190	150	120	80	100	30	18	75	13	M16×60	φ13×50		60 +0.061 -0.043
230	180	150	110	130	35	22	95	16	M20×75	φ16×60		80 +0.063 -0.043



Order

Catalog No.	D
SGRB	38



Option

Option Code	Specification
W	Tapped hole for the height block is drilled on the guide bushing.
BM	Tapped hole for lifting bolt is drilled on the guide bushing. (D=25~50only)



Order SGRB 38 - W

See page 83~ for option details.

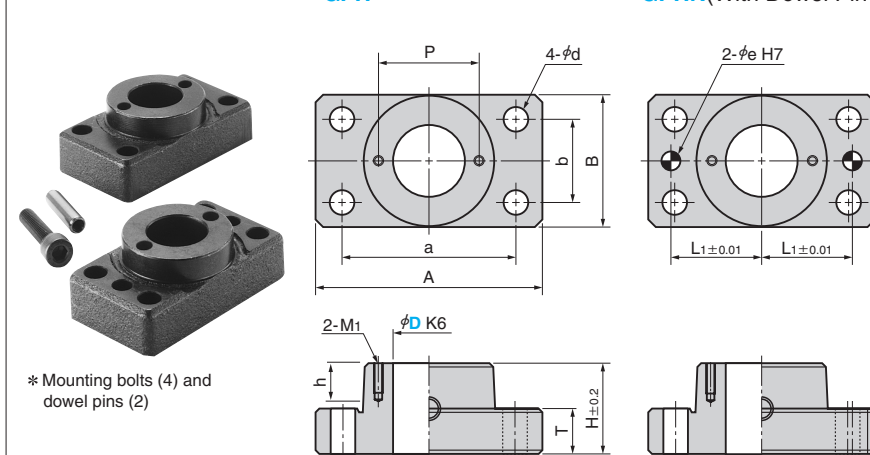
Guide Holder

FOR HOLDER TYPE GUIDE POST SET

CAD
FILE

GPH

GPHN(With Dowel Pin Hole)



* Mounting bolts (4) and
dowel pins (2)



The size of 2-M1 tapped hole is φ38 or more.

Material : FC250

D	K6	A	a	B	b	T	H	P	M1	h	d	L1	e H7	Accessories	
														Bolt	Dowel pin
25	+0.002 -0.011	84	66	48	30	20	30				9	33	8	M8×35	φ8×30
32		100	76	58	36		40				11	38		M10×40	
38	+0.003 -0.013	130	100	75	44	25	50	60	M5	15		50	10	M10×45	φ10×40
50		155	125	90	60		65	72	M6		14	62.5		M12×50	
60	+0.004 -0.015	190	150	120	80	30	75	92	M8	20	18	75	13	M16×60	φ13×50
80		230	180	150	110	35	100	116			22	95	16	M20×75	φ16×60

Catalog No.	D
	25
	32
GPH	38
GPHN	50
	60
	80



Option

Option Code	Specification
M	Tapped hole for the height block is drilled on the guide holder. (φ25, 32 only)



Order GPH 25 - M



Order

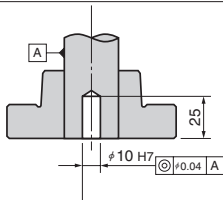
Catalog No.	D
GPH	50

Option

FOR HOLDER TYPE GUIDE POST SET

■Drilling of Center Dowel Pin Hole

-C



-C

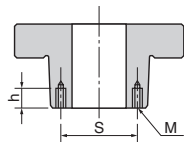
Dowel pin hole for location is drilled at the center of the guide post.



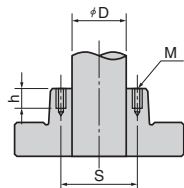
Order **SGR 32 - 140 - C**

■Drilling of Height Block Mounting Tapped Hole

-W



-M



-W

Tapped hole for height block mounting is drilled on the guide bushing.
* Does not apply to Ball Guide Type.

-M

Tapped hole for height block mounting is drilled on the guide holder.
Only $\phi 25$ and $\phi 32$.

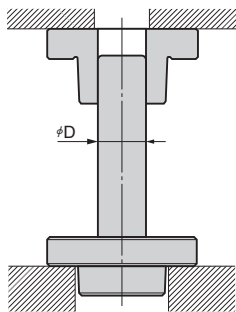


Order **SGR 60 - 250 - W**

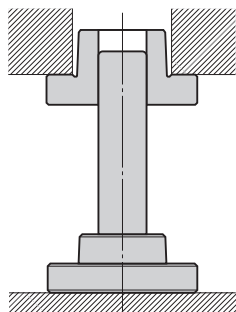
D	M	h	S
25	4	12	37
32			45
38	5	15	60
50	6		72
60			92
80	8	20	116

■Machining of Reverse Holder and Bushing Type

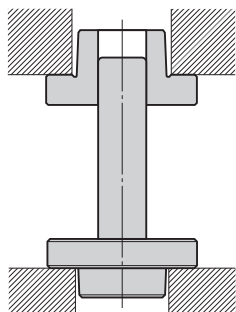
-RH



-RB



-RHB



-RH

The flange surface of the guide holder is machined flat for inverted mounting type.

-RB

The flange surface of the guide bushing is machined flat for inverted mounting type.

-RHB

Both the guide holder and the guide bushing are inverted mounting type.



Order **SGR 60 - 250 - RH**

●Dimension that can reduce die height

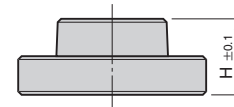
D	RH	RB
		Plain oilless
25	10	25
32	20	30
38	25	35
50	40	60
60	45	70
80	65	95

Option

FOR HOLDER TYPE GUIDE POST SET

■Precision Machining of Holder and Bushing Height

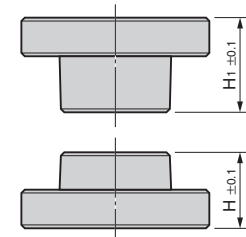
-HK



-BK



-HBK



-HK

The guide holder height is precision machined to ± 0.1

-BK

The guide bushing height is precision machined to ± 0.1

-HBK

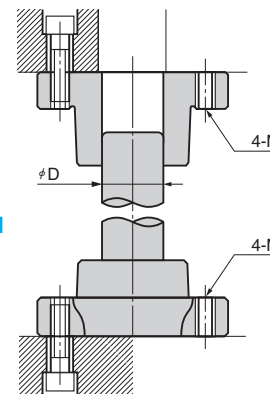
Both the guide holder and the guide bushing height are precision machined to ± 0.1



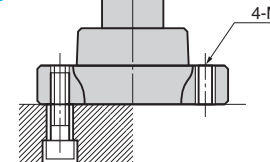
Order **SGR 50 - 200 - HBK**

■Drilling of Mounting Bolt Tapped Hole (D= 25 to 50 only)

-BM



-HM



-BM

Tapped hole for lifting bolt is drilled on the guide bushing.

-HM

Tapped hole for pulling bolt is drilled on the guide holder.

D	M
25	8
32 - 38	10
50	12



Order **SGR 38 - 160 - BM - HM**



For ordering option parts

Multiple option codes may be specified as necessary.



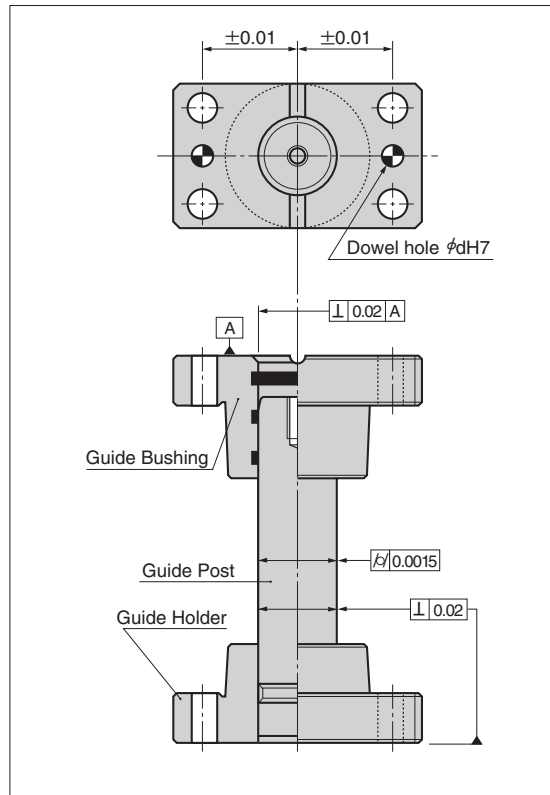
SGR38-250-W-HK-BM-HM

Outline of Guide Post Set

ACCURACY

■Product Accuracy of Guide Post Set

Product accuracy of the guide post set greatly affects the die life and the stamped parts produced from the die. Sankyo's guide post set is manufactured to precision under strict control system as shown below:



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■Product Accuracy

	Guide Bushing	Guide Post	Guide Holder
Roundness	Within 1 μ	Within 1 μ	—
Concentricity	Within 2 μ	Within 1.5 μ	—
Surface roughness	0.4a	0.2a	0.4a
Assembly squareness	0.02 / 100mm		—
	Squareness between guide bushing bottom surface and guide post center		
	—	0.02 / 100mm	
	Squareness between guide holder bottom surface and guide post center		