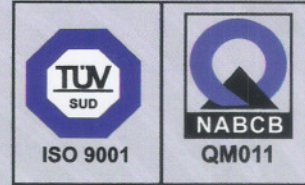
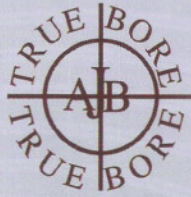


ACCURATE JIG BUSHING

Plot No.3, Shed No.5, Tass Industrial Estate, Ambattur, Chennai - 600 098.

Ph. : 044 - 4207 7551, Fax : 044 - 4208 0123

e-mail : accuratejig@yahoo.com



Super Fine, High Quality DRILL JIG BUSHINGS

OUR OTHER PRODUCT TO I.S / CUSTOMER SPECIFICATION

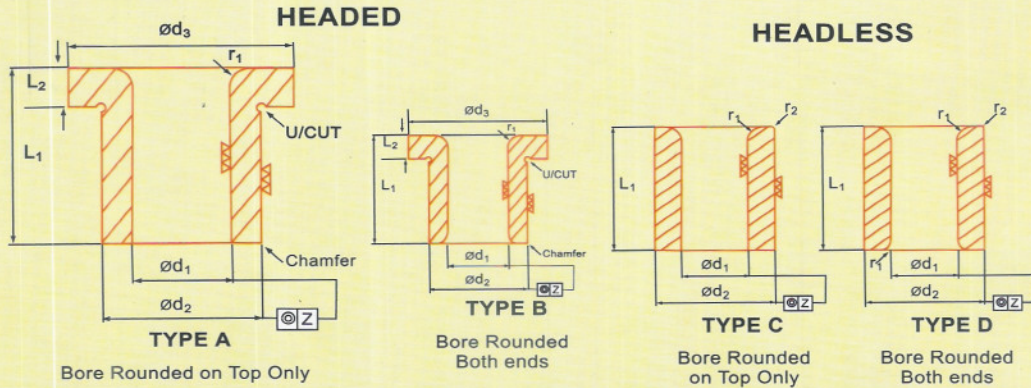
- PLUG, RING and RECEIVER GAUGES
- JIG PLATES
- WEAR PARTS FOR SPM
- TEST MANDRELS
- TAPPER LOCATING PINS
- ECCENTRIC BUSHES
- SPECIAL BUSHES WITH INTERRUPTED BORES SUCH AS THOSE WITH CROSS HOLES, CHIP BREAKERS ETC.

SPECIAL SERVICES OFFERED BY US

- HONING OF SMALL BORE COMPONENTS 3.0 mm to 65.0 mm. DIA



DRILL JIG BUSHES As per IS : 666 (Part I) - 1972



d1 (F7)		L1		L2	d2 (n6)	d3	r1	r2	Z
Over	Up to	Short	Long						
1.2	1.8	6	9	2	4	7	1.2	0.3	0.01
1.8	2.6				5	8			
2.6	3.3	8	12	2.5	6	10	1.6	0.4	
3.3	4				7	11			
4	5	10	16	3	8	12	2	0.6	
5	6				10	14			
6	8	12	20	4	12	16	2.5	0.8	
8	10				15	19			
10	12	16	28	4	18	22	4	0.8	
12	15				22	26			
15	18	20	36	5	26	30	6	1.0	
18	22				30	35			
22	26	25	45	5	35	40	6	1.0	
26	30				42	47			
30	35	30	56	6	48	55	8	1.6	
35	42				55	62			
42	48	35	72	6	62	69	8	1.6	
48	55				70	77			
55	63				78	85			

All dimensions in millimeters

Material : EN 31

Heat Treatment: Hardened to 62/64 HRC.



A Headed jig bush of Type A with bore d1 = 12 F7 and Length L1 = 20 is designated as JIG BUSH A 12 x 20 IS : 666 (Part I)



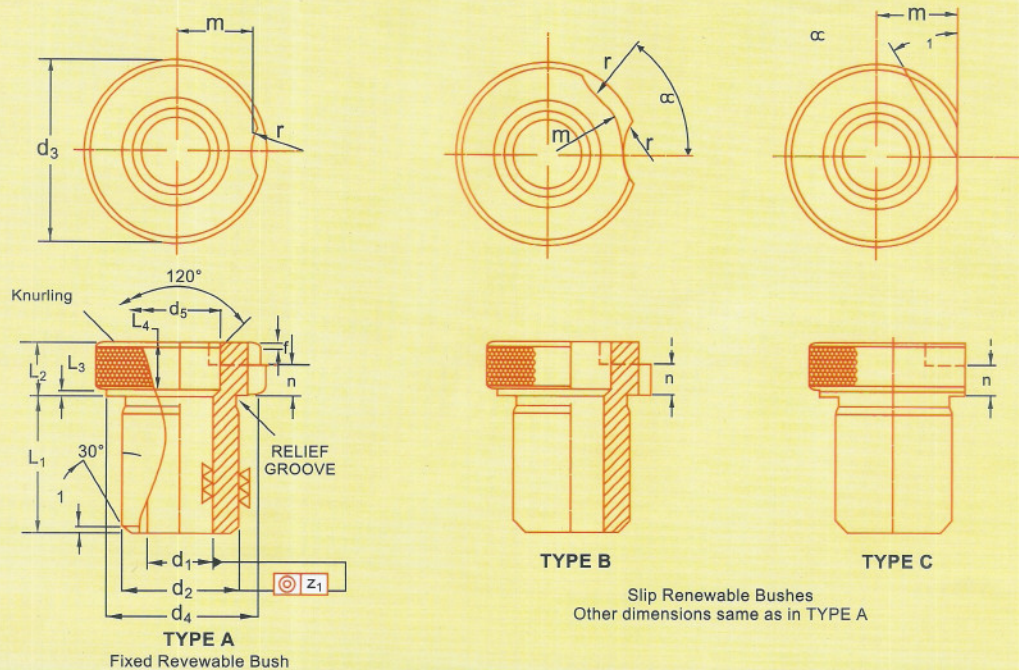
A Headless jig bush of Type D with bore d1 = 12 F7 and Length L1 = 20 is designated as JIG BUSH D 12 x 20 IS : 666 (Part I)

RENEWABLE DRILL JIG BUSHES

As per IS : 666 (Part II) - 1972

d1 (G7)		d2	d3	d4	d5	f	L1			L2	L3	L4		m	n	r	z	α	α^1
Over	Upto	(h6)					Short	Med	Long			Med	Long						
-	2.65	8	15	12	3	0.5	8	12.5	-	8	1	4.5	-	5	4.5	7	0.02	65°	40°
2.65	4.75	10	18	15	5		10	16	25			6	15						
4.75	8.5	15	24	20	9	0.8	12.5	20	32	10	1	8	20	9	5.5	9	0.03	50°	30°
8.5	14.0	22	32	28	14.5		16	25	40			9	24						
14.0	19.0	28	40	36	20	1.2	20	32	50	12	1.5	12	30	17	7	9	0.03	30°	30°
19.0	25.0	35	50	46	26		22												
25.0	33.5	46	60	56	35	1.6	25	40	63	16	2	15	38	26	9.5	11.5	0.04	25°	20°
33.5	45.0	58	74	70	47		33												

All dimensions in millimeters



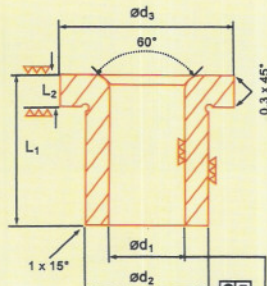
Material : EN 31

Heat Treatment: Hardened to 62/64 HRC.

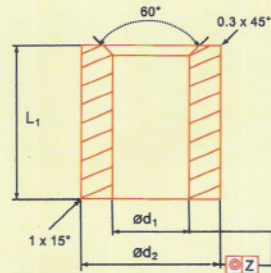
☞ Designation : A Renewable Drill Bush of Type B with bore $d_1 = 18$ mm $d_2 = 28$ mm and $L_1 = 32$ mm is designation as : RENEWABLE DRILL BUSH B 18 x 28 x 32 IS : 666 (Part II)

Slip Renewable Bushes of Type B, if required with entry groove to be indicated in the designation as : RENEWABLE DRILL BUSH (EG) 18 x 28 x 32 IS : 666 (Part II)

LINER BUSHES As per IS : 666 (Part II) - 1972



TYPE A Headed Liner Bush



TYPE B Headless Liner Bush
Other Dimensions and Details are same as for TYPE A

d1 (H7)	L1		L2	d2 (m6)	d3	Z
	Short	Long				
8	8	12.5	2	12	15	0.01
10	10	16		15	18	
15	12.5	20	2.5	20	24	
22	16	25		28	32	0.02
28	20	32	3	36	40	
35				46	50	
46	25	40	4	56	60	0.03
58				70	74	

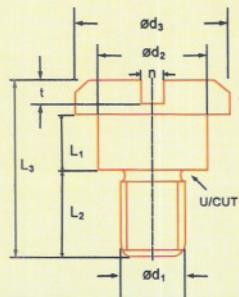
Material : EN 31

Heat Treatment : 62/64 HRC



Designation : A Headed liner bush having d1 = 22 and L1 = 25 mm is designated as : LINER BUSH A 22 x 25 IS : 666 (Part II)

LOCKING SCREWS As per IS : 666 (Part II) - 1972



d1	L1	d2	d3	L2	L3	n	t
M5	5	7.5	12	8	15.5	1.6	2
M6	6	10	16	10	19.5	2	2.5
	7.5				21		
M8	10	13	20	12	27	2.5	3

Material : EN 8 in Soft Condition, Chemically Blackened



Designation : A Locking screw with d1 = M6 and Shoulder length L1 = 7.5 mm is designated as : Locking screw M6 x 7.5 IS 666 (Part II)