

General Information

TECHNICAL DATA

I.D. Tolerances – ABC ANSI Standard

Standard Drill Sizes	I.D.	Tolerance
#80 to 1/4	Nominal	+ .0001 to + .0004
Over 1/4 to 3/4	Nominal	+ .0001 to + .0005
Over 3/4 to 1 1/2	Nominal	+ .0002 to + .0006
Over 1 1/2	Nominal	+ .0003 to + .0007

Standard Sizes

Standard sizes in a given I.D. range are sizes listed in the decimal equivalent chart either as a fraction, number or letter size. Any other decimal millimeter size within a given range is considered “special” and will be priced accordingly.

Special Bushings

When a special unlisted hole size is required, or a special outside diameter or length is required, the bushing becomes a “special” and will be priced accordingly.

When the bushing is not standard and has dimensions not according to the catalog, make sure that the length and O.D. are specified as well as the I.D. For Head-Type bushings, specify the head dimensions. Also, where tolerances are to be different from the catalog tolerances, be sure to include the tolerances required.

Materials

Drill bushings are manufactured from **C1144 stress-proof steel**, or other high carbon steels known for their long wear and stability. Specialty steels are available upon request.

Hardness

**62-64 Rockwell C**

Lead

All finish ground press-fit bushings have a concentric ground lead for exact alignment in press-fit starting.

Countersink

For drill entry end – a blended radius.

Counterbore

Certain bushings are relieved in the I.D., depending on the bore-to-length ratio. They can also be supplied without counterbore. This type of bushing will be priced as a “special”. To order with **counterbore**, add the prefix letter “C” to the symbol.

When using drill bushings with special tools, such as reamers, counterbores, taps, pilots, etc., it would be an advantage if the exact hole size is specified—instead of the tool size. This is important since the tolerance and the clearance of these tools vary according to application.

By processing these “special” from semi-finished blanks, prompt service is assured at reasonable prices. All “special” bushings will be priced from the factory.

Ordering Information

HOW TO ORDER – EXAMPLES

Add Inside Diameter Size to ANSI Symbol

Example:

- P-10-5-#77** 5/32” Nominal O.D.  
5/16” Length  
with #77 (.0180) Inside Diameter
- P-12-4-1/16** 3/16” Nominal O.D.  
1/4” Length  
with 1/16” (.0625) Inside Diameter
- P-10-5- .0191** 5/32” Nominal O.D.  
5/16” Length  
with .0191” Inside Diameter

Suggestions for Ordering

Complete tolerance and dimensional data on all **ANSI** and **ABC** standard bushings are given in this catalog. See **Fractional Decimal Drill Size Chart** on preceding page for list of standard drill sizes and decimal equivalents. In specifying a drill size, use the number, letter, fractional or decimal size. In specifying decimally, indicate the size in four places;

Example: use .1875, not .187. We would consider .187 as .1870, which would be special.

Terms

**Net 30 Days,**  
F.O.B. Garwood, New Jersey 07027 USA

Pricing - Prices subject to change without notice

For current price information, call or fax our Sales Department at:

Tel. **908.789.1121** Fax. **908.789.9429**  
[www.accuratebushing.com](http://www.accuratebushing.com)

Return of Bushings

Special bushings are non-returnable. Full credit will be given for standard bushings if they are returned **freight prepaid** to the factory within **two weeks** after the date of shipment.

For orders exceeding \$100 U.S., written authorization must be obtained from the factory prior to return shipment.