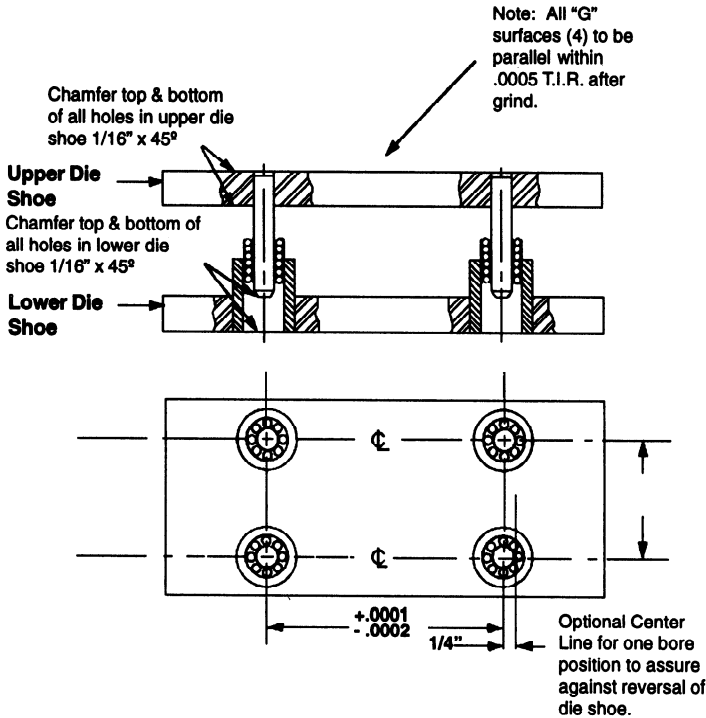




RECOMMENDED BORING PROCEDURES AND DIMENSIONS FOR BALL BEARING COMPONENTS



1. Grind die shoe plates parallel within .0005, then deburr and thoroughly clean plates.
2. Clamp upper and lower shoes together and mount in boring machine.
3. Sweep and strip top surface of plate in boring machine. Shim as required to achieve "0" indicator reading of $\pm .0001 / .0002$ T.I.R. All bores to the square to plate surfaces within $\pm .0001 / .0002$ T.I.R.
4. Step bore in line with hole patterns to dimensions shown on chart. Center to center distances shall be $\pm .0001 / .0002$ T.I.R. All bores to be square to plate surfaces within $\pm .0001 / .0002$ T.I.R.
5. Chamfer 1/16" x 45° on both ends of bore.

Complete interchangeability of Lamina ball bearing guide posts, bushings and retainers makes select fitting unnecessary. No modifications, such as grinding, honing or lapping will be required if mounting and boring instructions which are shown on this page are carefully followed. It is important to be aware of the dimensions shown in the table below.

Nom Guide Post Dia.	BORE SIZE for PRESS FIT of Press Fit Steel Sleeve Bushings and for WRING FIT of Demountable Steel Guide Pin Bushings	BORE SIZE for PRESS FIT of Straight Guide Pins and for REMOVABLE FIT of Demountable Flanged Guide Pins	GRIND SIZE over Bore Size for PRESS FIT of Shoulder Guide Pins	GRIND SIZE from Bore Size for WRING FIT of Steel Shoulder Guide Pin Bushings	GRIND SIZE over Bore Size for PRESS FIT of Steel Shoulder Guide Pin Bushings
3/4	1.3862 1.3864	.7515 .7510	N/A	N/A	N/A
1	1.7162 1.7164	1.0015 1.0010	.0012 .0005	Bore +.0003 -.0003	.0012 .0005
1-1/4	2.1062 2.1064	1.2515 1.2510	.0012 .0005	Bore +.0003 -.0003	.0012 .0005
1-1/2	2.4362 2.4364	1.5015 1.5010	.0012 .0005	Bore +.0003 -.0003	.0012 .0005
1-3/4	2.7462 2.7464	1.7515 1.7510	.0012 .0005	Bore +.0003 -.0004	.0012 .0005
2	3.1612 3.1614	2.0015 2.0010	.0012 .0005	Bore +.0003 -.0004	.0012 .0005
2-1/2	3.6812 3.6814	2.5015 2.5010	.0012 .0005	Bore +.0003 -.0004	.0012 .0005
3	4.1812 4.1814	3.0015 3.0010	.0012 .0005	Bore +.0003 -.0004	.0012 .0005