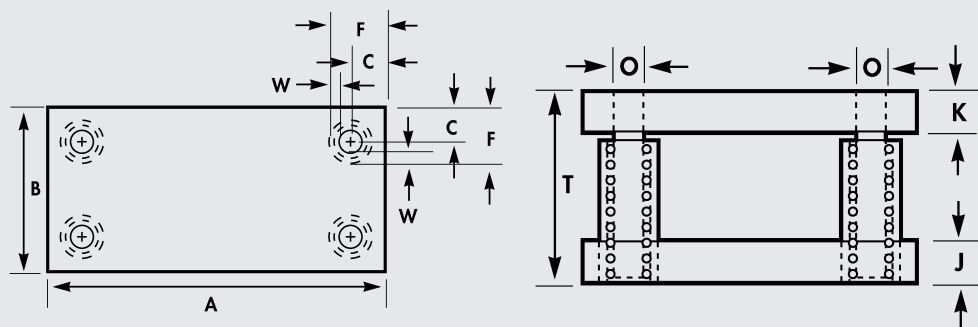


Custom, Four Post Ball Bearing Die Sets

Four Post - Type 4BB



Right front pin offset 1/4" to outside.

Ball Bearing Component Selection

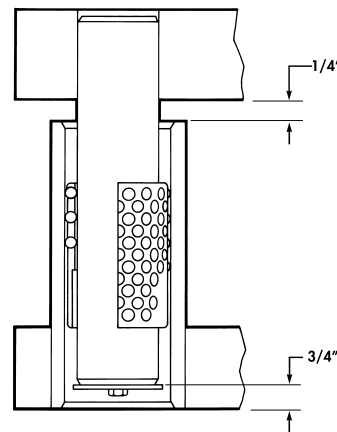
Refer to pages 18 and 19 of the Selective Fit Pin and Bushing Guiding catalog for the correct selection of operating condition and components. Please note that on long stroke applications, the pin and cage can be disengaged **only** if the press is operated at less than 150 spm and in a vertical position with accurate ram gib alignment.

Maximum Pin Length

= Minimum Shut Height - 3/4"

Maximum Straight Sleeve Length

= Minimum Shut Height - Punch Holder Thickness - 1/4"



Tool at Minimum Shut Height (die life depleted)

Four Post Die Sets

Dimensions furnished when customer specifies only A and B dimensions.

| Die Space L to R A | Post Diameter O | D.H. Thickness J | P.H. Thickness K |
|--------------------------|-----------------------|------------------------|------------------------|
| 8" to 10" | 1 | 1 1/4 | 1 1/4 |
| 11" to 16" | 1 1/4 | 1 1/2 | 1 1/2 |
| 17" to 22" | 1 1/2 | 1 3/4 | 1 3/4 |
| 23" to 28" | 1 3/4 | 2 | 2 |
| 29" to 40" | 2 | 2 1/2 | 2 1/2 |
| 41" to 65" | 2 1/2 | 3 | 3 |

These dimensions apply to both two post and four post sets.

| Nominal Guide Post Diameter | C | Sleeve Bushing | | Demountable Bushings | |
|-----------------------------------|-------|----------------|------|-------------------------|-------|
| | | F | W | F | W |
| 1" | 1 3/4 | 2 11/16 | 7/16 | 2 7/8 | 9/16 |
| 1 1/4" | 1 7/8 | 2 15/16 | 7/16 | 3 1/16 | 9/16 |
| 1 1/2" | 2 1/8 | 3 3/8 | 1/2 | 3 9/16 | 11/16 |
| 1 3/4" | 2 1/4 | 3 5/8 | 1/2 | 3 13/16 | 11/16 |
| 2" | 2 1/2 | 4 1/8 | 5/8 | 4 5/16 | 13/16 |
| 2 1/2" | 2 7/8 | 4 3/4 | 5/8 | 5 | 13/16 |
| 3" | 3 1/4 | -- | -- | 5 5/8 | 7/8 |