

**METRIC Plain Bearing Components**

*Precision Guide Pins*..... 22  
*Demountable Pins*..... 22  
*Demountable Sintered Bronze Bushings*..... 23  
*Demountable Steel Bushings*..... 23

**METRIC Ball Bearing Components**

*Precision Guide Pins*..... 24  
*Ball Bearing Cages*..... 24  
*Stripper Plate Cages* ..... 25  
*Straight Sleeve Bushings*..... 25  
*Demountable Bushings*..... 25  
*Demountable Pins*..... 26

**Selecting Components** ..... 28

**Type I Selection Chart** ..... 29

**Selecting Type II Components** ..... 30

**Type II Selection Chart**..... 31

# READY Metric Plain Bearing and Ball Bearing Components

The following 11 pages represent our extensive line of metric guide components, which have been used by European toolmakers and stamping plants for over 30 years.

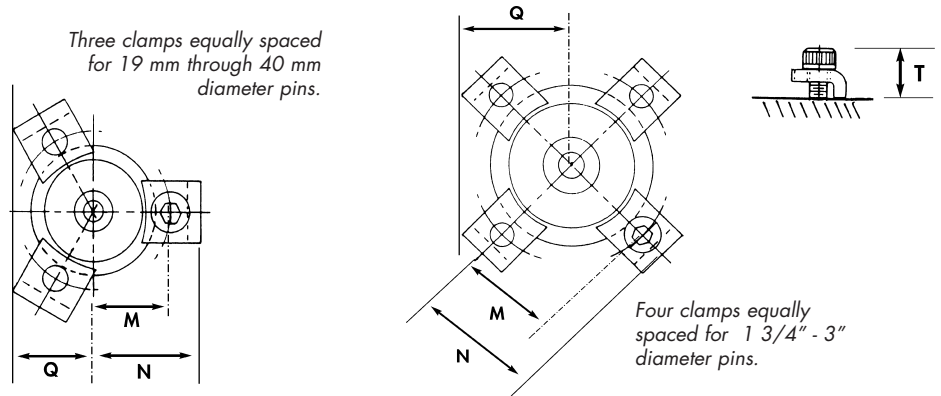
Our design is elegantly simple. All of our guide pillars, press fit and demountable, fit an R6 bored hole. All our bushings, ball bearing and plain bearing, straight and demountable, fit an H6 bored hole:

As with our line of inch components, each Ready metric pillar can be used either as a plain bearing or ball bearing pin. Every pin and bushing is color coded for Selective Fit™, providing you with the correct running clearance for your application.

**Metric Hole Boring Chart**

Pin Diameter O	Pin R6 Bore	Standard Bushing H6 Bore	Ball Bushing H6 Bore
19	18.976	28.016	-
	18.963	28.000	
25	24.976	38.016	45.016
	24.963	38.000	45.000
32	31.971	45.016	54.019
	31.955	45.000	54.000
40	39.971	54.019	65.019
	39.955	54.000	65.000
50	49.971	65.019	81.022
	49.955	65.000	81.000
63	62.965	81.022	95.022
	62.946	81.000	95.000
80	79.963	100.022	112.022
	79.944	100.000	112.000

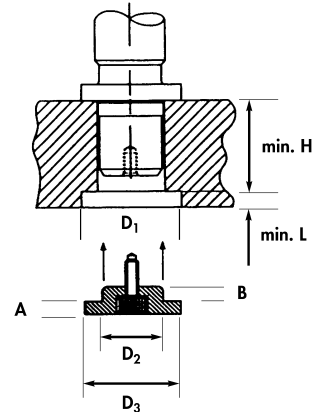
## Metric Clamp Data



Diameter O	DEMOUNTABLE PIN						
	Radius		Q	Qty per Pillar	Clamp	Socket Head Cap Screws	
	M	N				S	T
19	16	23.5	19	3	6-90-1	M 6 x 18	15
25	20.3	27.8	20.8				
32	25.5	35.5	24.6	3	6-93-1	M 8 x 22	19.4
40	30	40	26.9				
50	36.5	46.5	38.5	4	6-93-1	M 8 x 22	19.4
63	42.5	52.5	42.7				
80	51	61	48.8				

# Metric Clamp Data (cont.)

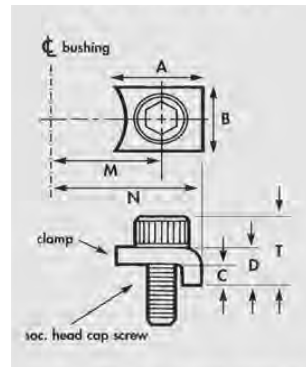
Pin Diameter O	Pillar Retaining Plug								Catalog Number	Screw
	D1	min. L	min. H	A	B	D2	D3			
19	26	3.5	26	3.3	4.2	18	25	6-18-3	M 5 x 16	
25	33	5.5	30	5	4.2	24	32	6-24-3	M 6 x 20	
32	41	5.5	39	5	7	30	40	6-30-3	M 8 x 25	
40	51	5.5	49	5	10	40	50	6-40-3	M 10 x 30	
50	64	5.5	60	5	13	50	63	6-50-3	M 12 x 40	
63	77	5.5	70	5	19	63	76	6-63-3	M 16 x 40	
80	94	5.5	87	5	25	80	93	6-80-3	M 20 x 50	



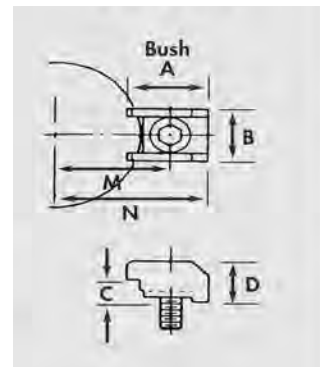
## Extra Long, Long and Short Shoulder Bushings

Pillar Dia.	Clamps per Bush	Screw	Clamp number	A mm	B mm	C mm	D mm	M mm	N mm
19	2	M6	6-95-1	12.3	12.7	3.2	5.6	19.5	25.5
25	3	M6	6-90-1	14.3	15.9	4.9	8.7	27.5	35
32	3	M8	6-93-1	19.8	15.9	6.5	11.4	32.5	42.5
40	3	M8	6-93-1	19.8	15.9	6.5	11.4	37	47
50	4	M8	6-93-1	19.8	15.9	6.5	11.4	44.5	54.5
63	4	M8	6-93-1	19.8	15.9	6.5	11.4	52	62
80	4	M8	6-93-1	19.8	15.9	6.5	11.4	62	72

Clamp Numbers:  
6-90-1, 6-93-1, 6-95-1



Clamp Numbers:  
6-96-1, 6-97-1



## Low Profile Bushings

Pillar Dia.	Clamps per Bush	Screw	Clamp number	A mm	B mm	C mm	D mm	M mm	N mm
19	2	M6	6-95-1	12.3	12.7	3.2	5.6	19.5	25.5
25	3	M6	6-96-1	17.5	14.5	5	10	30	37
32	3	M6	6-96-1	17.5	14.5	5	10	34	41
40	3	M8	6-97-1	24.6	18.9	7.9	13	39.5	50.5
50	4	M8	6-97-1	24.6	18.9	7.9	13	46	57
63	4	M8	6-97-1	24.6	18.9	7.9	13	56	67.5
80	4	M8	6-97-1	24.6	18.9	7.9	13	66	77

## Ball Bearing Stripper Plate Bushings

Pillar Dia.	Clamps per Bush	Screw	Clamp number	A mm	B mm	C mm	D mm	M mm	N mm
25	3	M6	6-96-1	17.5	14.5	5	10	32.5	39.5
32	3	M6	6-96-1	17.5	14.5	5	10	37	44
40	4	M6	6-96-1	17.5	14.5	5	10	44.5	51.5
50	4	M6	6-96-1	17.5	14.5	5	10	52.5	59.5

Nominal Diameter	DEMOUNTABLE BALL BEARING BUSHINGS									
	Radius		Size				Clamp No.	Per Unit	Screw size	T
	M	N	A	B	C	D				
25	32.5	43	19.8	15.9	6.5	11.4	6-93-1	3	M8 X 20	19.4
32	37	47								
40	43.5	54								
50	52.5	63								
63	59.5	70								