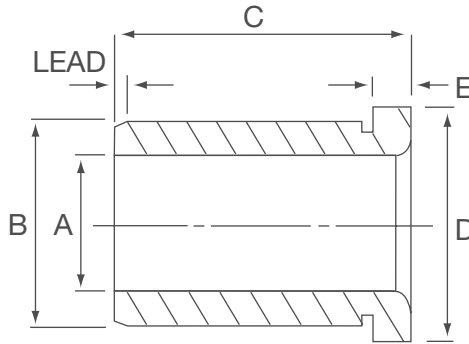


# Headed Drill Jig Bushes – Metric

BS 1098 PT.2 1977/ISO 4247/DIN 172A



## KEY FEATURES

- / Hardened from 58 to 62 RC
- / F7 ID drill limits
- / OD ground to suit H6 limits
- / Radius for easy drill entry
- / Lead for easy drill bush location

## ORDERING INSTRUCTIONS

- / Nitrided bushes for longer life can be supplied.
- / State: Qty, Type, Bore Size and Length
- / Example: 5, PH18E 10.1mm

## NOTES

- See page 33 for table showing ISO Limits for Jig Bushes and standard bore sizes. \*(Also Reamer Limits.)
- / Bushes with a bore size above 48mm may not be stock items.
- / Price and delivery on application
- / Some overlap sizes available from stock.



A Dia. F7 Limits (Drills) *Limits (Reamers)		B Dia. n6 Limits	Length C and Bush Reference						D Dia. h13 Limits	E Length
From	Up to		Short		Long		Extra Long			
			C	Ref.	C	Ref.	C	Ref.		
-	1	3	6	PH3A	9	PH3C	-	-	6	2
1.05	1.8	4	6	PH4A	9	PH4C	-	-	7	2
1.85	2.6	5	6	PH5A	9	PH5C	-	-	8	2
2.65	3.3	6	8	PH6B	12	PH6E	16	PH6F	9	2.5
3.4	4	7	8	PH7B	12	PH7E	16	PH7F	10	2.5
4.1	5	8	8	PH8B	12	PH8E	16	PH8F	11	2.5
5.1	6	10	10	PH10D	16	PH10F	20	PH10H	13	3
6.1	8	12	10	PH12D	16	PH12F	20	PH12H	15	3
8.1	10	15	12	PH15E	20	PH15H	25	PH15J	18	3
10.1	12	18	12	PH18E	20	PH18H	25	PH18J	22	4
12.1	15	22	16	PH22F	28	PH22K	36	PH22N	26	4
15.25	18	26	16	PH26F	28	PH26K	36	PH26N	30	4
18.25	22	30	20	PH30H	36	PH30N	45	PH30R	34	5
22.25	26	35	20	PH35H	36	PH35N	45	PH35R	39	5
26.25	30	42	25	PH42J	45	PH42R	56	PH42S	46	5
30.25	35	48	25	PH48J	45	PH48R	56	PH48S	52	5
35.50	42	55	30	PH55L	56	PH55S	67	PH55T	59	5
42.50	48	62	30	PH62L	56	PH62S	67	PH62T	66	6
48.50	55	70	30	PH70L	56	PH70S	67	PH70T	74	6
56	63	78	35	PH78M	67	PH78T	78	PH78W	82	6
64	70	85	35	PH85M	67	PH85T	78	PH85W	90	6
71	78	95	40	PH95P	78	PH95W	105	PH95Y	100	6
79	85	105	40	PH105P	78	PH105W	105	PH105Y	110	6
86	95	115	45	PH115R	89	PH115X	112	PH115Z	120	6
96	105	125	45	PH125R	89	PH125X	112	PH125Z	130	6

All dimensions in millimetres

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