



HEGDE

DRILL JIG BUSHES



Manufactured in India. By

HEGDE ACCESSORIES & COMPONENTS

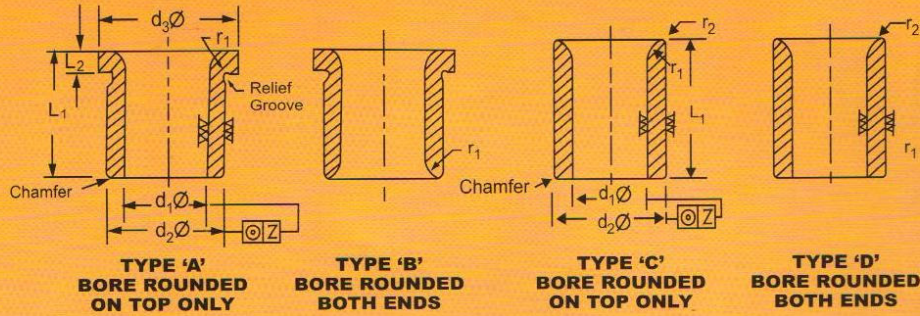
15 B/8, D-1 Block, MIDC, Chinchwad, Pune - 411 019.

☎ : 27470602, Mob. : 09766799988 Fax : +91 - 20 - 27487260

E-mail : hegdeaccessories@gmail.com / h.accessories@rediffmail.com

DRILL JIG BUSHES IS 666 : 1972

Part : 1 HEADED AND HEADLESS JIG BUSHES

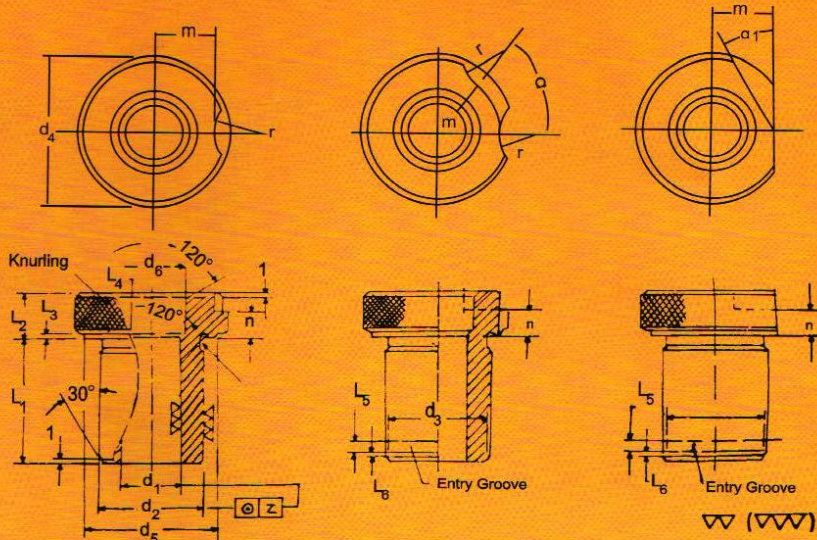


d ₁	F ₇	d ₂	d ₃	L ₁		L ₂	r ₁	r ₂	z
				short	long				
—	1	3	6					0.2	0.01
1	1.8	4	7	6	9	2	1.2	0.3	
1.8	2.6	5	8					0.4	
2.6	3.3	6	10	8	12	2.5	1.6		
3.3	4	7	11					0.6	
4	5	8	12					0.8	0.02
5	6	10	14	10	16	3	2		
6	8	12	16						
8	10	15	19	12	20	4	2.5		
10	12	18	22						
12	15	22	26	16	28	4	4		
15	18	26	30						0.04
18	22	30	35					1	
22	26	35	40	20	36	5	6		
26	30	42	47						
30	35	48	55	25	45	5	8		
35	42	55	62						
42	48	62	69	30	56	6			
48	55	70	77					1.6	
55	63	78	85	35	72	6			

All dimensions in mm

Designation : A Headed Jig Bush of Type A with bore D₁ = 15 F₇ and length L₁ = 28 mm shall be designated as : Jig Bush A 15 x 28 IS : 666 (Part I)
A Headless Jig Bush of Type C with bore dia d₁ = 15 F₇ and Length L₁ = 28 mm shall be designated as Jig. Bush C 15 x 28 IS : 666 (Part I)

Part : II RENEWABLE DRILL JIG BUSHES



TYPE A FIXED RENEWABLE BUSH

TYPE B SLIP REN. BUSH
Other dimensions and details are same as for type A

TYPE B SLIP RENEWABLE BUSH
Other dimensions and details are same as for type A

d ₁		d ₂	d ₃	d ₄	d ₅	d ₆	f ₁	L ₁			L ₂	L ₃	L ₄		L ₅	L ₆	m	n	r	Z ₁	oc	oc ₁
over	upto	h ₆						short	medium	long			For medium	For long								
—	2.65	8	7.8	15	12	3	0.5	8	12.5	—	8	1	4.5	—	0.8	0.2	5	4.5	7	0.02	65°	40°
2.65	4.75	10	9.7	18	15	5	0.5	10	16	25	8	1	6	15	1	0.25	6.5	4.5	7	0.02	65°	40°
4.75	8.5	15	14.5	24	20	9	0.8	12.5	20	32	10	1	8	20	1.6	0.3	9	5.5	7	0.03	50°	30°
8.5	14.0	22	21.4	32	28	14.5	0.8	16	25	40	10	1	9	24	2.2	0.5	13	7	9	0.03	50°	30°
14.0	19.0	28	27.2	40	36	20	1.2	20	32	50	12	1.5	12	30	2.8	0.6	17	7	9	0.03	50°	30°
19.0	25.0	35	34	50	46	26	1.2	20	32	50	12	1.5	12	30	3.5	0.8	22	7	9	0.03	50°	30°
25.0	33.5	46	44.6	60	56	35	1.6	25	40	63	16	2	15	38	4.5	1	26	9.5	11.5	0.04	25°	20°
33.5	45.0	58	56.2	74	70	47	1.6	25	40	63	16	2	15	38	5.6	1.2	33	9.5	11.5	0.04	25°	20°

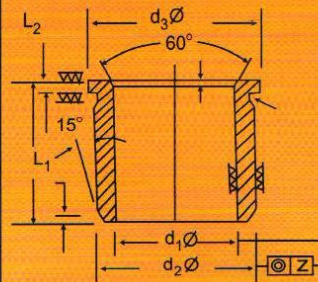
All dimensions in mm

Designation A Renewable Drill Bush of type B with $d_1 = 20$ mm $d_2 = 35$ mm and $L_1 = 32$ mm shall be designed as Renewable Drill Bush B 20 x 35 x 32 IS : 666 (Part II)
Slip renewable bushes of type B and Type C can also be provided with entry groove.
If entry groove is desired, the same shall be indicated in the designation as Renewable Drill Bush B (EG) 20 x 35 x 32 IS : 666 (Part II)

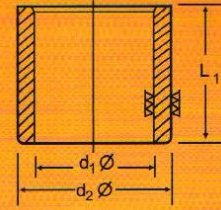
Part II. LINER BUSHES

d ₁ H ₇	d ₂ m6	d ₃	L ₁		L ₂	Z
			Short	Long		
8	12	15	8	12.5	2	0.01
10	15	18	10	16		
15	20	24	12.5	20		
22	28	32	16	25	2.5	0.02
28	36	40	20	32		
35	46	50	25	40	3	0.03
46	56	60				
58	70	74	4			

All dimensions in mm



TYPE 'A'
HEADED LINER BUSH



TYPE 'B'

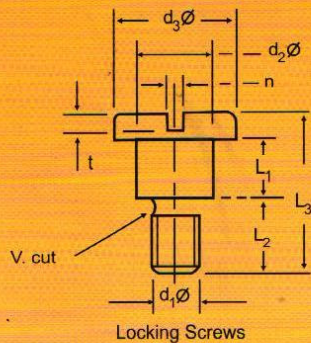
Other dimensions and details are same as for type A

Designation A Headed liner bush having d₁ = 28 mm & L₁ = 32 mm shall be designated as Liner Bush A 28 x 32 IS : 666 (Part II)

DIMENSIONAL DATA OF LOCKING SCREWS

d ₁ g6	L ₁	d ₂	d ₃	L ₂	L ₃	n	t
M5	5	7.5	12	8	15.5	1.6	2
M6	6	10	16	10	19.5	2	2.5
	7.5				21		
M8	10	13	20	12	27	2.5	3

Designation : A locking screw with d₁ = M₆ and shoulder Length L₁ = 7.5 mm shall be designated as Locking Screw M₆ x 7.5 IS : 666 (Part II)



Locking Screws

SPECIFICATIONS/MAIN FEATURES.

1. Material : En 31 or Equivalent steel.
2. Hardness : 62 to 65 H R C (740/820 HV)
3. Bore Finish : Ground or Honed.
4. O.D. : Ground.
5. Surface treatment : Blacodised.
6. Quality : Confirming to I S.
7. Two way under cut & lead for easy entry into drill jig.
8. Customer's specifications: All above items can be manufactured as per customers specifications also.
9. Delivery : Normally Ex stock/Early delivery. (2to4 weeks)

OTHER PRODUCTS MANUFACTURED BY US

1. Grinding Mandrels/Expanding Mandrels.
2. Locating pins.
3. Tooling items and Tool Room components
4. Precision Engineers Square
5. Comparator stand
6. Machine tool Accessories