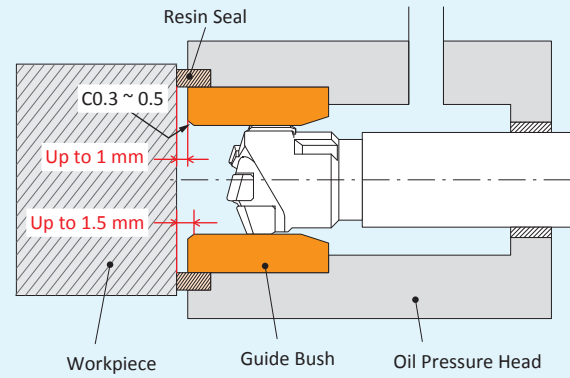


Notes for Guide Bush Installation

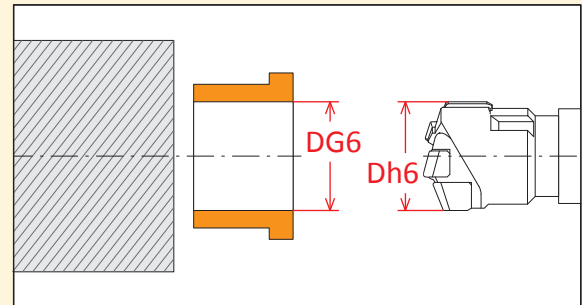
Many of the problems in BTA drilling are caused by incorrect use of the guide bush. The shape, type and tolerance greatly affect cutting accuracy and tool life. Please note the following when using one in your application.

1 Resin Seal Type



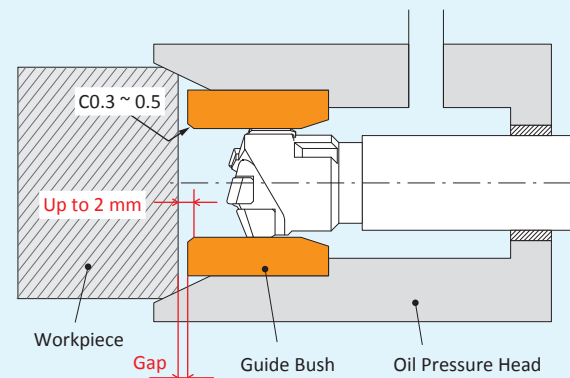
Guide Bush Tolerance

Guide bush tolerance should be G6 in order to keep good tool life and cutting accuracy as shown below.

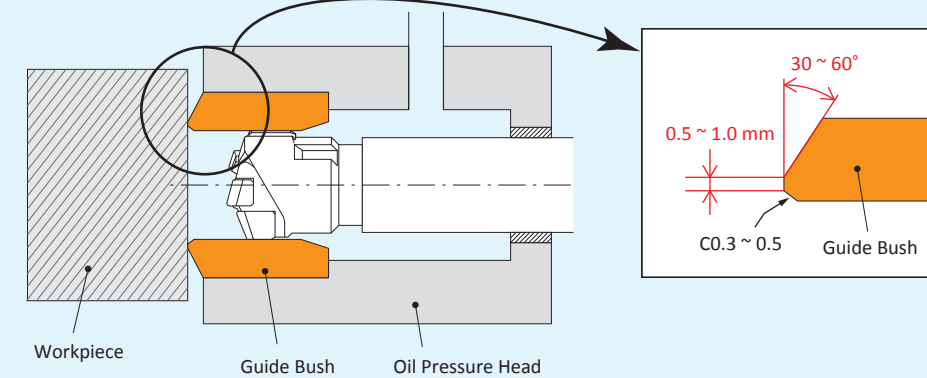


Tool Dia. D (mm)	G6 Tolerance (mm)
8.00 - 10.00	+0.005 ~ +0.014
10.01 - 18.00	+0.006 ~ +0.017
18.01 - 30.00	+0.007 ~ +0.020
30.01 - 50.00	+0.009 ~ +0.025
50.01 - 80.00	+0.010 ~ +0.029
80.01 - 120.00	+0.012 ~ +0.034
120.01 - 180.00	+0.014 ~ +0.039
180.01 - 245.99	+0.015 ~ +0.044

2 Taper Cone Type



3 Flat-edge Type



Recommended for $\Phi 65\text{mm}$ and less