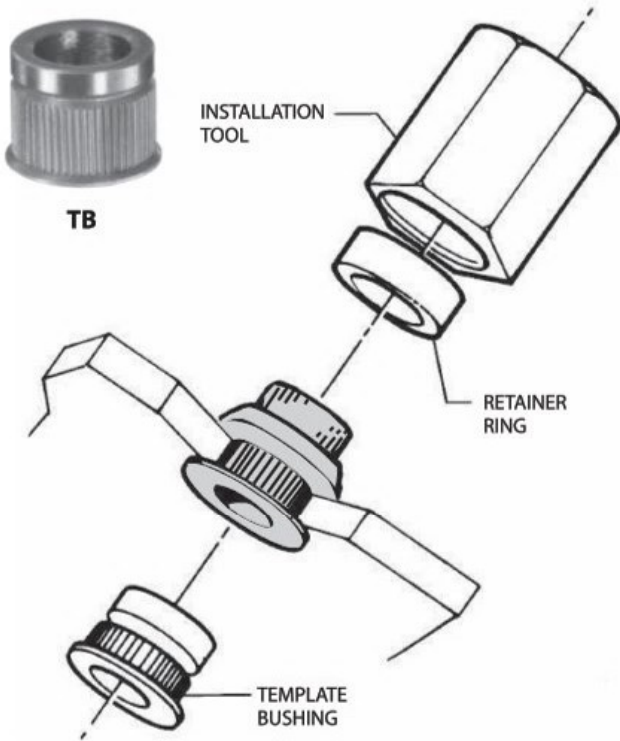
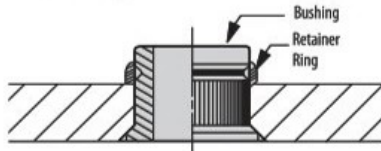


# TEMPLATE BUSHINGS



## APPLICATIONS:

An economical bushing designed for thin template jig plates from 1/16 to 3/8" thick. Bushings are held in place by a Retainer Ring (order Retainer Ring and Installation Tool separately). The OD serrations prevent the bushing from spinning. Bushings can be removed and reused by breaking the aluminum Retainer Ring (extra rings available separately).



## ORDERING EXAMPLES:

TB-24-6-4-.1250 Bushing with 1/8" ID  
 TR-10 Matching Retainer Ring for 1/16" thick template  
 TR-30 Matching Retainer Ring for 1/8" thick template

Standard prices apply only to bushings with a standard-drill-size ID within the stated ID range. See catalog back cover for standard drill sizes and their decimal equivalents. For prices on non-standard ID sizes, including reamer-tolerance and tap-guide bushings, please contact factory.

## STANDARD ID TOLERANCES:

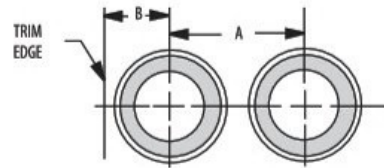
#55 to 1/2" +.0001/+0.011 | 1.30 to 12mm +.002/+0.030mm

## CONCENTRICITY:

ID concentric with OD to within .002 TIR

## INSTALLATION STEPS

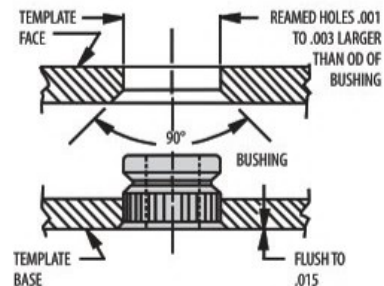
### 1. LAY OUT HOLES



When laying out holes, observe the minimum hole spacing and edge distance listed below:

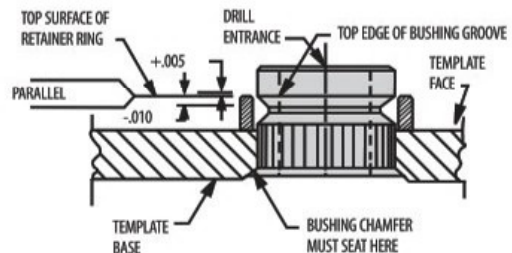
| BUSHING OD | A MINIMUM | B MINIMUM |
|------------|-----------|-----------|
| 3/8        | .60       | .250      |
| 1/2        | .73       | .312      |
| 3/4        | .98       | .438      |

### 2. REAM AND COUNTERSINK



Ream hole .001 to .003 larger than bushing OD. Countersink reamed hole to allow the bushing to seat .015 below flush with surface. For best results, use a piloted countersink tool so that the countersink is concentric and free of chatter marks.

### 3. INSTALL



Install Retainer Ring with an arbor press whenever possible. The Installation Tool is also tapped for mounting on a rivet gun or other impact tool. Check that Retainer Ring top surface is within +.005 / -.010 of the bushing groove's top edge before installing.