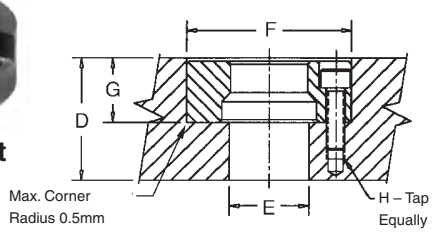
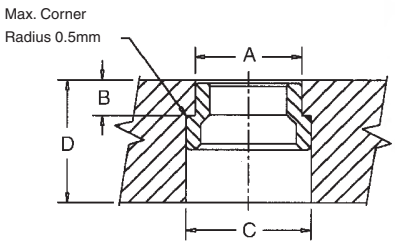
Receiver Bushings

Two styles of receiver bushings are available. Installed bushings should be approximately 0.3mm below subplate surface.

Face Mount



Face Mount Bushing
Installation Instructions



Back Mount Bushing
Installation Instructions

Back Mount

Generally, the face mount receiver bushing is utilized in blind hole applications (Slip Fit).

The back mount receiver bushing is used in through hole applications (Light Press Fit).

Installation Dimensions

Face Mount

Shank Dia. (mm)	Face Mount Part Number	Actual O.D. -0.01 -0.02	Clearance Drill Diameter E	Bore +0.010 +0.003 F	Depth +0.025 -0.025 G	Tap Size & Depth[1] H	Bolt Circle Diameter 3 PL Equally Spaced	Min. Subplate Thickness D
13	**49556**	35	13.5	35	11.91	M4x0.7 x 7	25	20
16	**49557**	37	21.0	37	11.91	M4x0.7 x 7	29	20
20	**49551**	45	21.0	45	16.21	M5x0.8 x 9	35	25
25	**49552**	55	25.5	55	20.32	M6x1.0 x 10	42	30
30	**49553**	60	30.5	60	22.15	M6x1.0 x 11	48	35
35	**49554**	70	40.0	70	22.99	M8x1.25 x 17	56	40
50	**49555**	92	55.0	92	31.50	M10x1.5 x 18	75	50

Back Mount

Shank Dia. (mm)	Back Mount Part Number	Actual O.D. +0.04 +0.03 A	Depth +0.025 -0.025 B	C-Bore ±0.15 C	Min. Subplate Thickness D
13	**49566**	20	6.92	26	20
16	**49567**	22	7.24	29	20
20	**49561**	28	8.74	33	25
25	**49562**	35	10.54	41	25
30	**49563**	42	10.95	49	30
35	**49564**	48	12.50	55	35
50	**49565**	67	15.75	76	45

[1]Cap Screws Supplied with Face Mount Bushings.

Liner Bushings for Fixture Plates

Locating repeatability will determine if one primary and one secondary or two primary liners are needed. With two primary liners, repeatability of ±0.013 mm can be maintained if the two holes for receiver bushings are held to a centerline distance of ±0.005 mm tolerance.

Note on Installation of Press Fit Liners & Back Mount Style Receiver Bushings: To alleviate the possibility of binding the shank in the bore, the maximum interference fit between bore and bushing O.D. should not exceed 0.013 mm.

Shank Diameter (mm)	Fixture Plate Thickness +0.13 -0.13	Primary Liner		Secondary Liner		Liner O.D. +0.00 - 0.01
		Part Number	I.D.	Part Number	I.D.	
13	13	**49755**	13.01	**49855**	13.04	19.040
—	20	**49756**	—	**49856**	—	19.040
16	20	**49757**	16.01	**49857**	16.04	25.042
—	25	**49758**	—	**49858**	—	25.042
20	20	**49751**	20.01	**49851**	20.04	35.042
—	25	**49752**	—	**49852**	—	35.042
25	20	**49761**	25.01	**49861**	25.04	35.042
—	25	**49762**	—	**49862**	—	35.042
30	20	**49771**	30.01	**49871**	30.04	45.042
—	25	**49772**	—	**49872**		45.042
35	20	**49781**	35.01	**49881**	35.04	45.042
—	25	**49782**	—	**49882**	—	45.042
—	40	**49783**	—	**49883**	—	45.042
—	50	**49784**	—	**49884**	—	45.042
50	20	**49791**	50.01	**49891**	50.04	63.546
—	25	**49792**	—	**49892**	—	63.546
—	40	**49793**	—	**49893**	—	63.546
—	50	**49794**	—	**49894**	—	63.546