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**Tools for pressing — Guide bushes —  
Part 8:  
Form G, gliding bushes, stepped, type  
1**

*Outillage de presse — Bagues de guidage —*

*Partie 8: Forme G, bagues lissés à gorge pour guidage lisse, type 1*

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2. [www.iso.org/directives](http://www.iso.org/directives)

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received. [www.iso.org/patents](http://www.iso.org/patents)

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT) see the following URL: Foreword - Supplementary information

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 8, *Tools for pressing and moulding*.

[ISO 9448-8:2013](http://www.iso.org/iso/9448-8:2013)

This second edition results from the reinstatement of ISO 9448-8:1991, which was withdrawn in 2006 and with which it is technically identical. [52c48#96420/iso-9448-8-2013](http://www.iso.org/iso/52c48#96420/iso-9448-8-2013)

ISO 9448 consists of the following parts, under the general title *Tools for pressing — Guide bushes*:

- Part 1: *Forms*
- Part 2: *Form A, gliding bushes, plain, type 1*
- Part 3: *Form B, ball cage bushes, plain, type 1*
- Part 4: *Form C, gliding bushes, headed, type 1*
- Part 5: *Form D, ball cage bushes, headed, type 1*
- Part 6: *Form E, gliding bushes, flanged, type 1*
- Part 7: *Form F, ball cage bushes, flanged, type 1*
- Part 8: *Form G, gliding bushes, stepped, type 1*
- Part 9: *Form B, ball cage bushes, plain, type 2*
- Part 10: *Form E, gliding bushes, flanged, type 2*
- Part 11: *Form F, ball cage bushes, flanged, type 2*

# Tools for pressing — Guide bushes —

## Part 8: Form G, gliding bushes, stepped, type 1

### 1 Scope

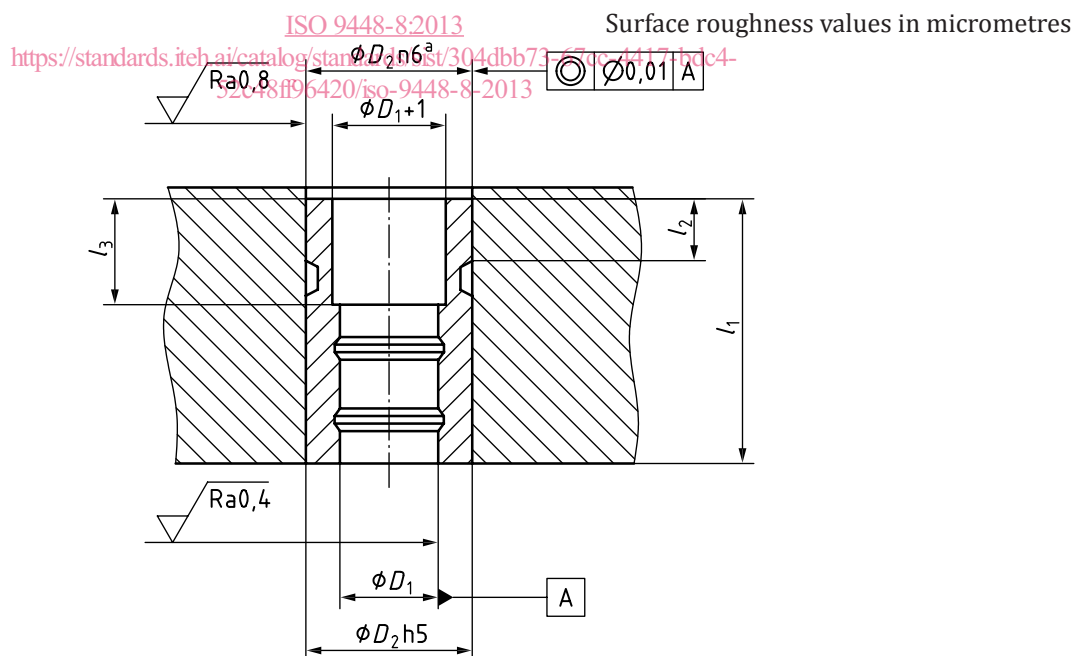
This part of ISO 9448 specifies the main dimensions and tolerances, in millimetres, of guide bushes of form G, stepped gliding bushes, type 1, intended for use in press tools and to be mounted in the clamp plate with interference fit over a certain length. The remaining portion of the length ensures the guiding. The bushes are provided with a clearance for lubrication.

It gives guidance on the materials, and specifies the hardness and the designation of bushes in accordance with this part of ISO 9448.

### 2 Dimensions

The dimensions of type 1 stepped gliding bushes (form G) shall conform to the indications of [Figure 1](#) and [Table 1](#).

Details not stated, such as chamfers, radii and lubrication grooves, are left to the manufacturer's discretion.



**Figure 1 — Form G, stepped gliding bushes, type 1**

Table 1

$D_1$	nom.	12		16		20		25		32		40		50		63		80		100	
	tol.	G6						G5													
$D_2$		22		28		32		40		48		58		70		85		105		125	
$l_1$	$\begin{matrix} 0 \\ -0,5 \end{matrix}$	$l_2$	$l_3$	$l_2$	$l_3$	$l_2$	$l_3$	$l_2$	$l_3$	$l_2$	$l_3$	$l_2$	$l_3$	$l_2$	$l_3$	$l_2$	$l_3$	$l_2$	$l_3$	$l_2$	$l_3$
20		6	8																		
25		6	8																		
32		6	8																		
36				9	13																
45						10	16														
50				9	13			13	20												
56										13	20										
63						10	16					14	21	14	21						
71								13	20							16	24				
80										13	20							18	26		
100												14	21	14	21					20	28
110																16	24				
125																		18	26		
140																				20	28

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To prevent incorrect assembly of the upper and lower plates of the die set in relation to each other, the following values of  $D_1$  are recommended: 11, 15, 19, 24, 30, 38, 48, 60, 76 and 95.

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### 3 Material

The material is left to the manufacturer’s discretion and the hardness shall be  $60^{+2}_0$  HRC.

### 4 Designation

A guide bush in accordance with this part of ISO 9448 shall be designated by:

- a) “Guide bush”;
- b) a reference to this part of ISO 9448, i.e ISO 9448-8;
- c) its form;
- d) its guiding diameter,  $D_1$ , in millimetres;
- e) its length,  $l_1$ , in millimetres.

EXAMPLE A guide bush of form G, stepped gliding bush, type 1 of guiding diameter  $D_1 = 12$  mm and of length  $l_1 = 20$  mm is designated as follows:

**Guide bush ISO 9448-8 G - 12 × 20**

## Bibliography

- [1] ISO 6508-1, *Metallic materials — Rockwell hardness test — Part 1: Test method*

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