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**Tools for pressing — Guide pillars —**  
**Part 4:**  
**Type C, pillars with taper lead and**  
**bush**

*Outils de presse — Colonnes de guidage —*

*Partie 4: Type C, colonnes à emmanchement conique et sa bague de guidage*

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Published in Switzerland

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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 document should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

ISO draws attention to the possibility that the implementation of this document may involve the use of (a) patent(s). ISO takes no position concerning the evidence, validity or applicability of any claimed patent rights in respect thereof. As of the date of publication of this document, ISO had not received notice of (a) patent(s) which may be required to implement this document. However, implementers are cautioned that this may not represent the latest information, which may be obtained from the patent database available at [www.iso.org/patents](http://www.iso.org/patents). ISO shall not be held responsible for identifying any or all such patent rights.

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This document was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 8, *Tools for pressing and moulding*.

This fourth edition cancels and replaces the third edition (ISO 9182-4:2020) which has been technically revised.

The main changes are as follows:

- deletion of pillar diameter 12 mm, 80 mm and 100 mm, of pillar lengths 400 mm and 450 mm and modification of the tolerance on  $d_1$ ;
- addition of an option with a thread;
- modification of the surface roughness value on  $d_1$ ;
- modification of the hardness of the pillar;
- deletion of the pillar end alternative with radius;
- modification of dimension  $T$  and of the tolerance on  $d_2$  on the bush;
- change in the designation of the lengths of the pillar and of the bush.

A list of all parts in the ISO 9182 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).

# Tools for pressing — Guide pillars —

## Part 4: Type C, pillars with taper lead and bush

### 1 Scope

This document specifies the dimensions and tolerances of guide pillars, type C, with taper lead and bush, intended for use in press tools.

This document gives guidance on the materials and specifies the hardness and the designation of guide pillars which meet the requirements of this document.

### 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 6753-1, *Tools for pressing and moulding — Machined plates — Part 1: Machined plates for press tools*

### 3 Terms and definitions

No terms and definition are listed in this document.

ISO and IEC maintain terminology databases for use in standardization at the following addresses:

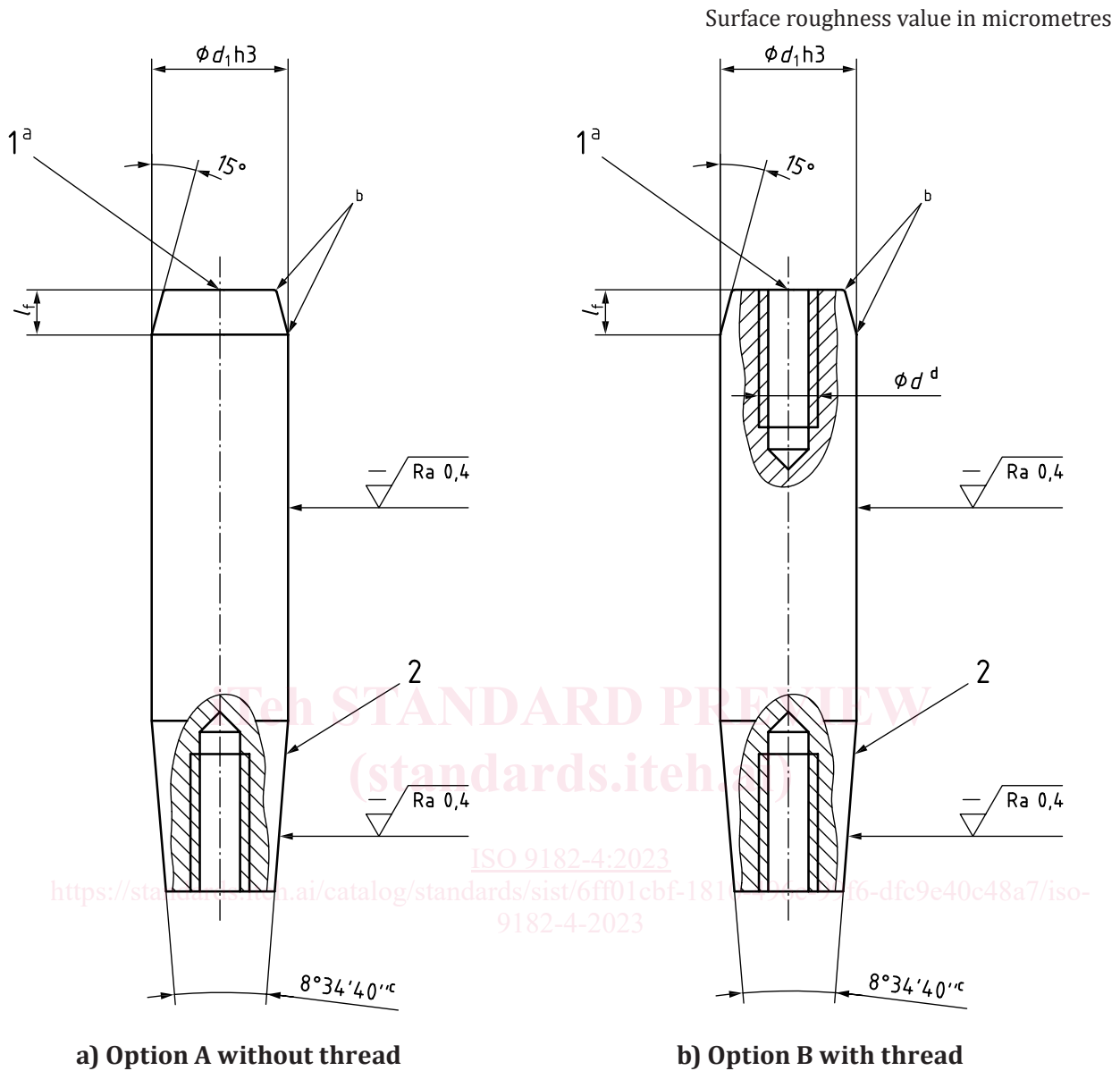
- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

### 4 Dimensions

The dimensions of guide pillar with taper lead (type C) shall conform to the indications of [Figure 1](#) and [Table 1](#).

The dimensions of the bush for guide pillar with taper lead shall conform to the indications of [Figure 2](#) and [Table 1](#).

The dimensions of the mounting of the bush on the pillar shall conform to the indications of [Figure 3](#) and [Table 1](#).



**Key**

- 1 centre
- 2 taper

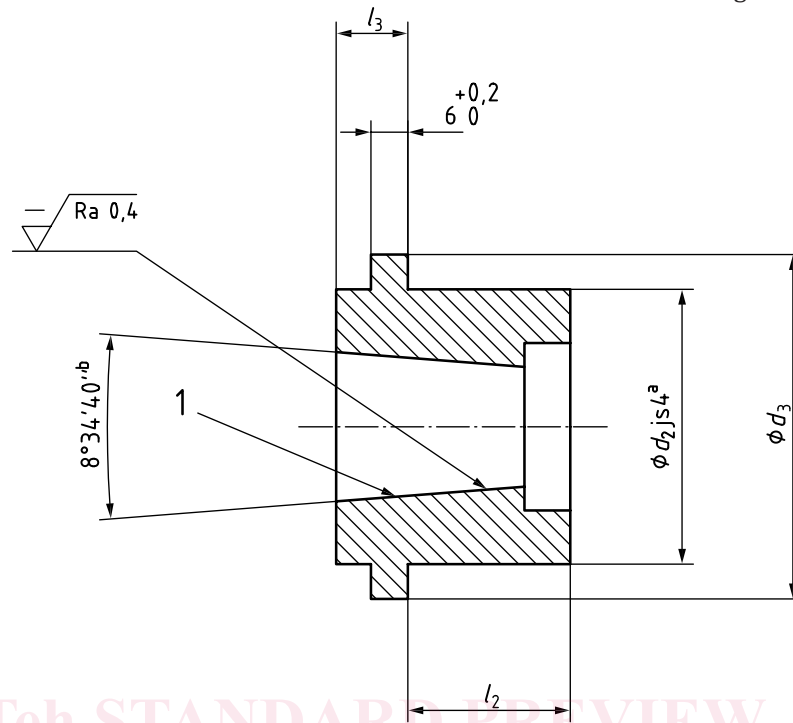
NOTE 1 Tolerance classes and limit deviations are defined in ISO 286-2.

NOTE 2 Centre holes are defined in ISO 6411.

- a Optional.
- b Slightly rounded. The values of the radii are left to the manufacturer's discretion.
- c The angle is left to the manufacturer's discretion and is the same for the pillar and the bush.  $8^{\circ}34'40''$  is a recommended value.
- d The diameter of the thread is left to the manufacturer's discretion.

**Figure 1 — Guide pillar with taper lead**

Dimensions in millimetres  
Surface roughness value in micrometres



**Key**

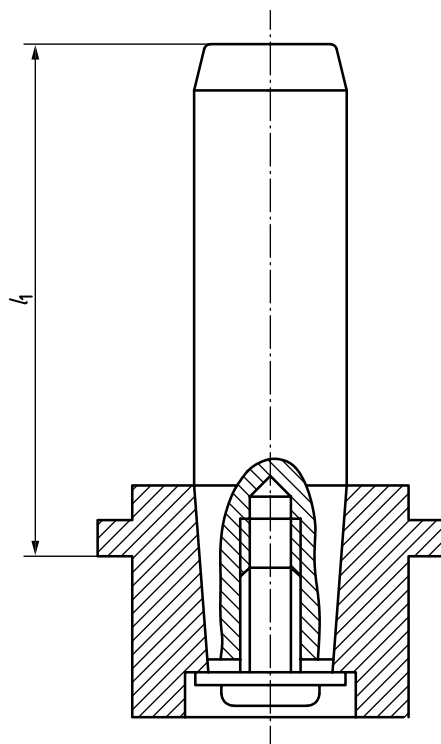
1 taper

NOTE Tolerance classes and limit deviations are defined in ISO 286-2.

<sup>a</sup> To be mounted in a hole tolerated H5.

<sup>b</sup> The angle is left to the manufacturer's discretion and is the same for the pillar and the bush. 8°34'40" is a recommended value.

**Figure 2 — Bush for guide pillar with taper lead**



**Figure 3 — Mounting of the bush on the pillar**  
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**Table 1 — Dimensions of guide pillar with taper lead (type C), its corresponding bush and their mounting dimension**

Dimensions in millimetres

$d_1^a$		16	20	25	32	40	50	63
$d_2$		28	32	40	48	58	70	85
$d_3$		36	40	48	56	66	80	95
$l_f$ min.		4	4	6	6	6	8	8
$l_2$ min. <sup>b</sup>		25	32	32	40	40	50	63
$l_3$		10	12	12	15	15	18	18
$l_1$ <sup>0</sup> <sub>-1</sub>	80							
	90	×						
	100	×	×					
	112	×	×	×				
	125	×	×	×	×			
	140	×	×	×	×	×		
	160	×	×	×	×	×	×	
	180	×	×	×	×	×	×	
	200		×	×	×	×	×	×
	224			×	×	×	×	×
	250			×	×	×	×	×
	280				×	×	×	×
	315					×	×	×
355						×	×	
<b>Key</b>		ISO 9182-4:2023						
×		standardized dimension						
<sup>a</sup>		To prevent an 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: 15, 19, 24, 30, 38, 48, and 60.						
<sup>b</sup>		Larger values of $l_2$ shall be chosen as a function of other dimensions such as plate thickness in accordance with ISO 6753-1.						

## 5 Material

The material and hardness are left to the manufacturer's discretion, but the hardness shall be  $(56^{+2}_0)$  HRC.

NOTE Rockwell C hardness (HRC) is defined in ISO 6508-1.

## 6 Designation

Guide pillars for press tools in accordance with this document shall be designated by:

- “Guide pillar”;
- a reference to this document, i.e. ISO 9182-4:2023;
- its type;
- its diameter,  $d_1$ , in millimetres;
- the bush length,  $l_2$ , in millimetres;
- the length,  $l_1$ , in millimetres;

g) option A (without thread) or option B (with thread).

EXAMPLE A guide pillar, type C, of diameter  $d_1 = 20$  mm with a bush length  $l_2 = 32$  mm a length  $l_1 = 200$  mm and with a thread is designated as follows:

**Guide pillar ISO 9182-4 - C - 20 × 32 × 200 - B (option with thread)**

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