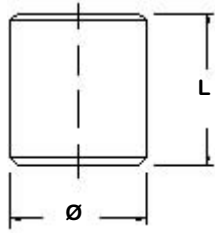


Metric Sintered Self-Lubricating Bars



Part No.	Material	Diameter Ø	Length L
BAR 20X52 B	Oil-Bronze	20	52
BAR 30X52 B		30	52
BAR 40X52 B		40	52
BAR 50X60 B		50	60
BAR 60X60 B		60	60
BAR 80X80 B		80	80
BAR 10X22 G	Graphite-Bronze	10	22
BAR 20X52 G		20	52
BAR 30X52 G		30	52
BAR 40X52 G		40	52
BAR 50X60 G		50	60
BAR 60X60 G		60	60
BAR 80X80 G		80	80

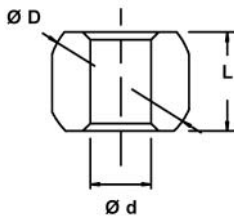
Machining

Machining of self-lubricated bearings should be avoided. Casting produces a far superior bearing. Oil-Bronze and Graphite-Bronze should be turned with diamond or carbide tips, quality ISO K 20, with a tip radius of max. 0.1-0.2 mm. Suitable cutting speeds are 100-200 m/min.

The bearing surface of self-lubricating bearings must not be ground as the oil transportation pores are then closed. The outer surface of bearing can be machined in any way required. The bearing can be heated on an electrical hot plate after machining to check that the pores are still open. Oil will then ooze out of the pores.

Bearings usually lose oil during the turning operation and the oil should be replaced before the bearing is used. A simple method of doing this is accomplished by immersing the bearing in oil SAE 20 heated to 80°C (176°F). The bearing should be immersed until the oil has cooled. The pores are filled with oil by this process and the bearing is then ready for use.

Metric Sintered Self-Lubricating Spherical Bearings



Inside Ø d H7	Outside Ø D h11	Length L h13	Inside Ø d H7	Outside Ø D h11	Length L h13
2	5	3	8	16	11
3	8	6	8	19	14
4	10	8	9	22	14
5	10	7	10	18	12
5	13	10	10	22	14
6	12	8	12	25	20
6	15	11	16	30	20
7	16	11	20	40	25
			25	50	30

Non-Stock, request price (quantity sensitive)