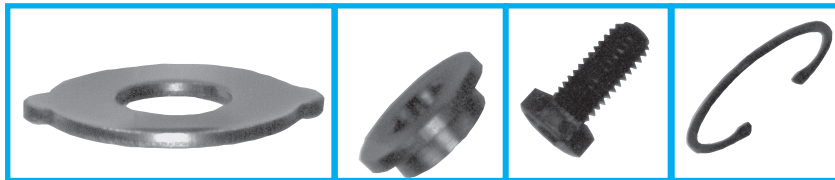


# Ball Bearing Components

## Technical Information

### BORING SPECIFICATIONS FOR BALL BEARING GUIDE POSTS AND BUSHINGS

Post Diameter A (in)	Bore Sizes (in)			
	Punch Holder for Posts		Die Shoe for Bushings	
	Minimum	Maximum	Minimum	Maximum
1	0.9980	0.9988	1.8748	1.8755
1 1/4	1.2480	1.2488	2.1248	2.1255
1 1/2	1.4975	1.4983	2.4998	2.5005
1 3/4	1.7475	1.7483	2.7498	2.7505
2	1.9975	1.9983	3.2498	3.2505
2 1/2	2.4970	2.4978	3.7498	3.7505
3	2.9970	2.9978	4.2498	4.2505



### BALL CAGE WASHER ASSEMBLY

Nominal Post Diameter A (in)	Washer Assembly Part Number		Stop Washer-Retainer		Bushing Stop Washer	Hex Head Screw	Snap Ring-Ball Bearing Cages
	Type I Assembly	Type II Assembly	Type I	Type II and III	Type II and III	Type I, II and III	Type II and III
1	6-0008-82-1	6-0008-82-2	5-0800-831	5-0800-832	5-0800-840	9-0506-730 5/16 -18 x 3/4	6-0800-832
1 1/4	6-0010-82-1	6-0010-82-2	5-1000-831	5-1000-832			6-1000-832
1 1/2	6-0012-82-1	6-0012-82-2	5-1200-831	5-1200-832	5-1200-840	9-0607-730 3/8 -16 x 7/8	6-1200-832
1 3/4	6-0014-82-1	6-0014-82-2	5-1400-831	5-1400-832			6-1400-832
2	6-0016-82-1	6-0016-82-2	5-1600-831	5-1600-832			6-1600-832
2 1/2	6-0020-82-1	6-0020-82-2	5-2000-831	5-2000-832	5-2400-840	9-0808-730 1/2 -13 x 1	6-2000-832
3	6-0024-82-1	6-0024-82-2	5-2400-831	5-2400-832			6-2400-832

### NOTES:

- ◆ **TYPE I** Assembly includes stopwasher retainer and head hex screw.
- ◆ **TYPE II** Assembly includes stopwasher retainer, bushing stopwasher, hex head screw and snap ring.

### BUSHING MOUNT/RETAINING COMPOUND

Part Number	Volume
9-60-82	4 oz.

### NOTES:

- ◆ A bushing mount/retaining compound is used when installing straight sleeve ball bearing bushings to avoid bushing close-in as a result of press-fit.

### BALL CAGE WASHER ASSEMBLY

Guide Post Tap Sizes		Required Seating Torque	
Diameter O (in)	Tap Size	in-lbs	ft-lbs
1 – 1 1/4	5/16" – 18UNC	320	26
1 1/2 – 2	3/8" – 16UNC	560	47
2 1/2 – 3	1/2" – 13UNC	1350	112

### Ball Bearing Bushing Lubrication Recommendation

During operation of Ball Bearing Bushing Assembly, add lubricant once each 8-hour shift by spray or brush application. Use a refined mineral oil of viscosity 290/340 SSU @ 100° F (39° C) containing "EP" additives and rust inhibitors.