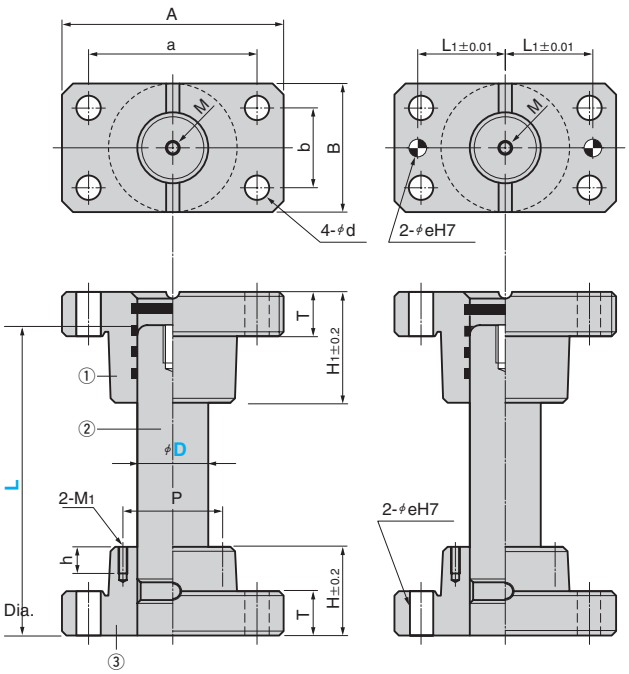
Guide Post Set

OILLESS PLAIN TYPE

CAD FILE

SGR
SGRL(Type for Dimension L)

With dowel pin hole
SGRN
SGRNL(Type for Dimension L)



⚠ Tapped holes (2-M1) on Dia. φ38 and over.

■Table of Components

No.	Description	Qty	Material and Remark	Catalog No.
①	Guide Bushing	1	FC250 with Graphite	SGRB, SGRBN
②	Guide Post	1	S45C induction hardened HRC55 or more	NGP
③	Guide Holder	1	FC250	GPH, GPHN
Accessories	Hexagon Socket Head Bolt	8	SCM435	
Accessories	Dowel Pin with Female Thread	4	SUJ2 Tolerance m6	

■Accessories

D	Hexagon Socket Head Bolt	Dowel Pin
25	M 8×35	φ8×30
32	M10×40	
38	M10×45	φ10×40
50	M12×50	
60	M16×60	φ13×50
80	M20×75	φ16×60

D 公差		A	a	B	b	T	H	P	M1	h	H1	d	M	L1	e	H7
25	+0.024 +0.015	84	66	48	30	20	30	–	–	–	45	9	–	33	8	+0.015 0
32		100	76	58	36		40				50	11		38		
38	+0.028 +0.017	130	100	75	44	25	50	60	M5	15	60			50	10	
50		155	125	90	60		65	72	M6		85	14		62.5		
60	+0.033 +0.020	190	150	120	80	30	75	92	M8	20	100	18	M12	75	13	+0.018 0
80		230	180	150	110	35	100	116			130	22		95	16	

Catalog No.	D	L
SGR SGRN	25	80 90 100 110 120 130 140 150 160 170 180 200
	32	90 100 110 120 130 140 150 160 170 180 200 220 250
	38	100 110 120 130 140 150 160 170 180 200 220 250 280 300
	50	160 170 180 200 220 250 280 300 350
	60	180 200 220 250 280 300 350 400
	80	250 280 300 350 400 450

Catalog No.	D	L
SGRL SGRNL	25	70～200
	32	80～250
	38	80～300
	50	120～350
	60	140～400
	80	200～450

Order

Catalog No.	D	–	L
SGRN	32	–	170
SGRL	60	–	320

Option

See page 83～ for option details.

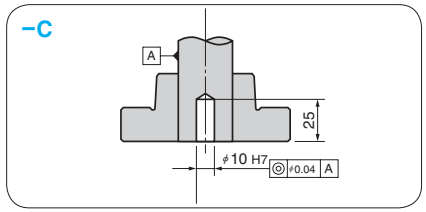
Option Code	Specification
C	Dowel pin hole for location is drilled at the center of the guide post.
M	Tapped hole for the height block is drilled on the guide holder. (D=25, 32 only)
W	Tapped hole for the height block is drilled on the guide bushing.
RH	Guide holder is changed to the inverted mounting type.
RB	Guide bushing is changed to the inverted mounting type.
RHB	Both guide bushing and holder are changed to the inverted mounting type.
HK	Guide holder height is machined to the tolerance of ±0.1.
BK	Guide bushing height is machined to the tolerance of ±0.1.
HBK	Both guide holder and bushing heights are machined to the tolerance of ±0.1.
BM	Tapped hole for lifting bolt is drilled on the guide bushing. (D=25～50only)
HM	Tapped hole for jack screw is drilled on the guide bushing. (D=25～50only)

Order SGRN 32 – 170 – RHB

Option

FOR HOLDER TYPE GUIDE POST SET

■Drilling of Center Dowel Pin Hole

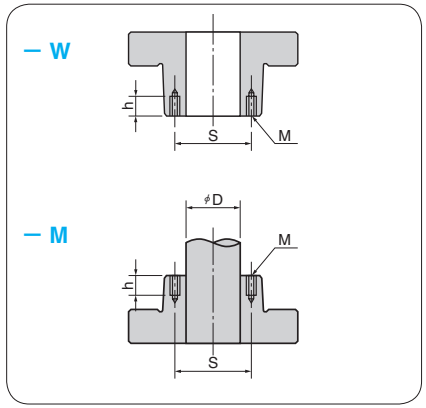


–C

Dowel pin hole for location is drilled at the center of the guide post.

Order **SGR 32 – 140 – C**

■Drilling of Height Block Mounting Tapped Hole



–W

Tapped hole for height block mounting is drilled on the guide bushing.
∗Does not apply to Ball Guide Type.

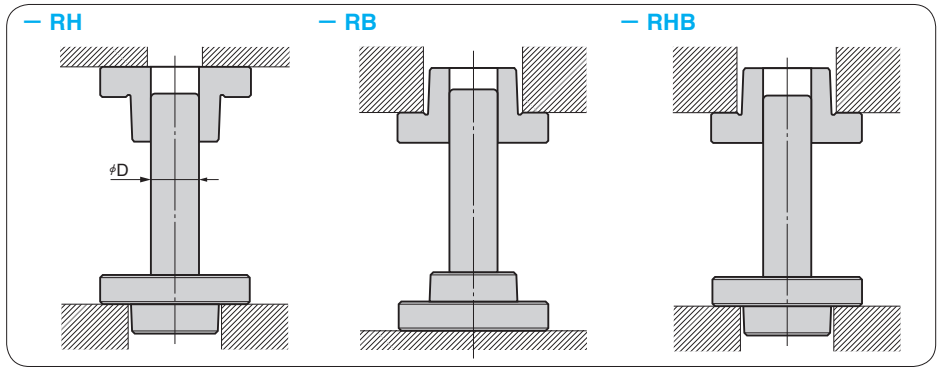
–M

Tapped hole for height block mounting is drilled on the guide holder.
Only ϕ25 and ϕ32.

Order **SGR 60 – 250 – W**

D	M	h	S
25	4	12	37
32			45
38	5	15	60
50	6		72
60	8	20	92
80			116

■Machining of Reverse Holder and Bushing Type



–RH

The flange surface of the guide holder is machined flat for inverted mounting type.

–RB

The flange surface of the guide bushing is machined flat for inverted mounting type.

–RHB

Both the guide holder and the guide bushing are inverted mounting type.

Order **SGR 60 – 250 – RH**

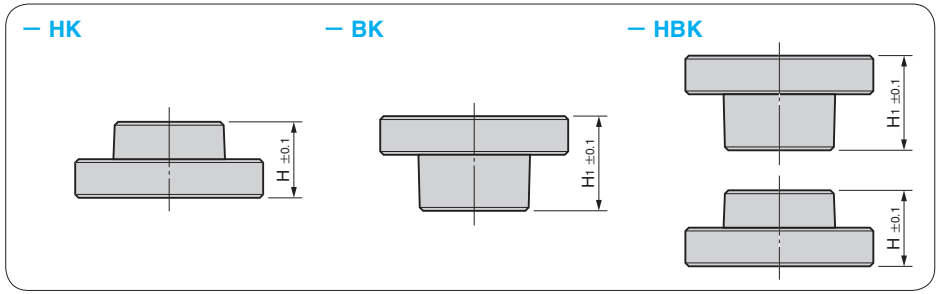
●Dimension that can reduce die height

D	RH	RB
		Plain oilless
25	10	25
32	20	30
38	25	35
50	40	60
60	45	70
80	65	95

Option

FOR HOLDER TYPE GUIDE POST SET

■Precision Machining of Holder and Bushing Height



–HK

The guide holder height is precision machined to ±0.1

–BK

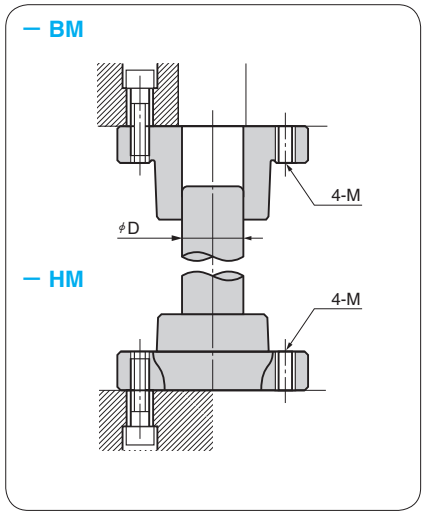
The guide bushing height is precision machined to ±0.1

–HBK

Both the guide holder and the guide bushing height are precision machined to ±0.1

Order **SGR 50 – 200 – HBK**

■Drilling of Mounting Bolt Tapped Hole (D= 25 to 50 only)



–BM

Tapped hole for lifting bolt is drilled on the guide bushing.

–HM

Tapped hole for pulling bolt is drilled on the guide holder.

D	M
25	8
32 · 38	10
50	12

Order **SGR 38 – 160 – BM – HM**

For ordering option parts
Multiple option codes may be specified as necessary.

EX SGR38-250-W-HK-BM-HM

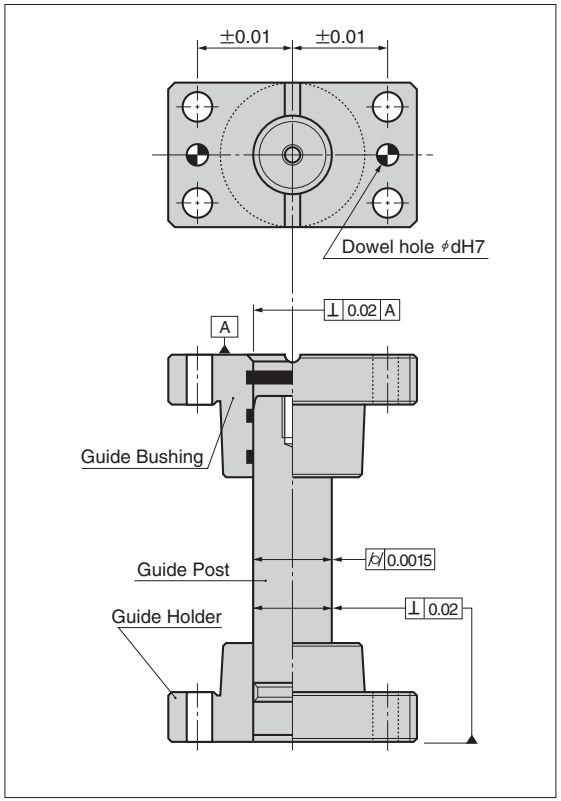
Die Guide Components

Outline of Guide Post Set

ACCURACY

■Product Accuracy of Guide Post Set

Product accuracy of the guide post set greatly affects the die life and the stamped parts produced from the die. Sankyo's guide post set is manufactured to precision under strict control system as shown below:



■Product Accuracy

	Guide Bushing	Guide Post	Guide Holder
Roundness	Within 1 μ	Within 1 μ	—
Concentricity	Within 2 μ	Within 1.5 μ	—
Surface roughness	0.4a	0.2a	0.4a
Assembly squareness	0.02 / 100mm Squareness between guide bushing bottom surface and guide post center		—
	—	0.02 / 100mm Squareness between guide holder bottom surface and guide post center	