



D ₁	25	32	40	50	63	80*
Lb	CATALOG NUMBER					
65	B30025065					
80	B30025080	B30032080	B30040080			
95	B30025095	B30032095	B30040095			
110	B30025110	B30032110	B30040110	B30050110		
130	B30025130	B30032130	B30040130	B30050130		
150		B30032150	B30040150	B30050150	B30063150	B30080150
170		B30032170	B30040170	B30050170	B30063170	B30080170
190			B30040190	B30050190	B30063190	B30080190
215			B30040215	B30050215	B30063215	B30080215
240				B30050240	B30063240	B30080240
265				B30050265	B30063265	B30080265
D ₂	45	54	65	81	95	112

MDL Straight Sleeve Ball Cage Bushings should not be press-fit since close-in may occur. If properly installed, no honing is necessary.

MDL recommends that Straight Sleeve Ball Cage Bushings should be installed using Loctite 603.

For selection of appropriate Sleeve Ball Cage Bushings length, see page 42/43.

Assembly Instructions:

1. Press Guide Posts into Punch Holder Plate. End of Guide Posts with drill and tapped hole should not be pressed in.
2. Be sure Guide Posts are perpendicular to the surface of the Punch Holder (0.025 in 150 mm).
3. Mount Ball Cages on the Guide Pillar using Retainer Assembly supplied.
4. Place Die Shoe on a flat surface. For Big Die Sets we recommend using two horses to keep the bores accessible on both ends.
5. Place on Die Shoe two parallels having height as close as possible Minimum Shut Height.
6. Degrease Sleeve and Die Shoe Bore using appropriate solvent and wipe carefully.
7. Apply a thin layer of Loctite 603 on the Bores and Sleeves.
8. Position the Sleeve into Bore.
9. Bring the Punch Holder into position until it rests on the two parallels.
10. Check that the Sleeves are in the right position.
11. Allow the required time to harden: 4 hours at 22°C. Do not use Die Set during hardening process.

* Dia. 80[mm], Special Item.