

 **GGB**
BY TIMKEN



GGB DX[®]

**METAL-POLYMER MAINTENANCE-FREE
BEARING SOLUTIONS**





PUSHING BOUNDARIES TO CO-CREATE A HIGHER QUALITY OF LIFE

GGB helps create a world of motion with minimal frictional loss through plain bearing and surface engineering technologies. With R&D, testing and production facilities in the United States, Germany, France, Brazil, Slovakia and China, GGB partners with customers worldwide on customized tribological design solutions that are efficient and environmentally sustainable. GGB's engineers bring their expertise and passion for tribology to a wide range of industries, including automotive, aerospace and industrial manufacturing. To learn more about tribology for surface engineering from GGB, visit www.ggbearings.com/en.

Our products are used in tens of thousands of critical applications every day on our planet. It is always our goal to provide superior, high-quality solutions for our customers' needs, no matter where those demands take our products. From space vehicles to golf carts and virtually everything in between; we offer the industry's most extensive range of high performance, maintenance-free bearing solutions for a multitude of applications:

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- [Agricultural](#)
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The GGB Advantage



LOWER SYSTEM COST

GGB bearings reduce shaft costs by eliminating the need for hardening and machining grease paths. Their compact, one-piece construction provides space and weight savings and simplifies assembly.



LOW-FRICTION, HIGH WEAR RESISTANCE

Low coefficients of friction eliminate the need for lubrication, while providing smooth operation, reducing wear and extending service life. Low-friction also eliminates the effects of stick-slip or "stiction" during start up.



MAINTENANCE-FREE

GGB bearings are self-lubricating, making them ideal for applications requiring long bearing life without continuous maintenance, as well as operating conditions with inadequate or no lubrication.



ENVIRONMENTAL

Greaseless, lead-free GGB bearings comply with increasingly stringent environmental regulations such as the EU RoHS directive restricting the use of hazardous substances in certain types of electrical and electronic equipment.



CUSTOMER SUPPORT

GGB's flexible production platform and extensive supply network assure quick turnaround and timely deliveries. In addition, we offer local applications engineering and technical support.

The Highest Standards in Quality



SAFETY

Our deep-rooted culture of safety places a relentless focus on creating a secure, healthy work environment for all. As one of our core values, safety is essential for us to achieve our goal of having the safest employees in the industry.



EXCELLENCE

Our world-class manufacturing plants in the United States, Brazil, China, Germany, France and Slovakia are certified in quality and excellence according to ISO 9001, IATF 16949, ISO 14001 and ISO 45001. This allows us to access the industry's best practices while aligning our management system with global standards.

For a complete listing of our certifications, please visit our website:

www.ggbearings.com/en/certificates



RESPECT

Our teams work together with mutual respect regardless of background, nationality, or function, embracing the diversity of people and learning from one another - after all, with respect comes both individual and group growth.

GGB Who We Are



GGB'S HISTORY AS THE GLOBAL LEADER IN PLAIN BEARING TECHNOLOGIES DATES BACK MORE THAN 120 YEARS.

Beginning with the founding of Glacier Antifriction Metal Company in 1899 and later introducing the industry-leading DU® bearing in 1965, GGB has continued to create innovative technologies and solutions that improve safety, performance, and profitability in a wide range of markets. Today, our products can be found everywhere - from scientific vessels at the bottom of the ocean to racecars speeding down the tarmac to jumbo jets slicing through the sky to the Curiosity rover exploring the surface of Mars.

Throughout our history, safety, excellence, and respect have formed the foundational values for the entire GGB family. They are of paramount importance as we seek to maximize personal possibility, achieve excellence, and establish open, creative work environments



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1 Introduction

The purpose of this handbook is to provide comprehensive technical information on the characteristics of DX® bearings. The information given permits designers to establish the correct size of bearing required and the expected life and performance. GGB Research and Development services are available to assist with unusual design problems.

Complete information on the range of DX® standard stock products is given together with details of other DX® products.

GGB is continually refining and extending its experimental and theoretical knowledge and, therefore, when using this brochure it is always worth-while to contact the Company should additional information be required.

As it is impossible to cover all conditions of operation which arise in practice, customers are advised to carry out prototype testing wherever possible.

1.1 CHARACTERISTICS AND ADVANTAGES

- DX® provides maintenance free operation
- DX® has a high pU capability
- DX® exhibits low wear rate
- Seizure resistant
- Suitable for temperatures from -40 °C to +120 °C
- High static and dynamic load capacity
- Good frictional properties
- No water absorption and therefore dimensionally stable
- Compact and light
- Suitable for rotating, oscillating, reciprocating and sliding movements
- DX® bearings are prefinished and require no machining after assembly

2 Structure

DX® is a composite bearing material developed specifically to operate with marginal lubrication and consists of three bonded layers: a steel backing strip and a sintered porous bronze matrix, impregnated and overlaid with a pigmented acetal copolymer bearing material.

The steel backing provides mechanical strength and the bronze interlayer provides a strong mechanical bond for the lining. This construction promotes dimensional stability and improves thermal conductivity, thus reducing the temperature at the bearing surface.

DX® is designed for use with grease lubrication and the bearing surface is normally provided with a uniform pattern of indents. These serve as a reservoir for the grease and are designed to provide the optimum distribution of the lubricant over the bearing surface.

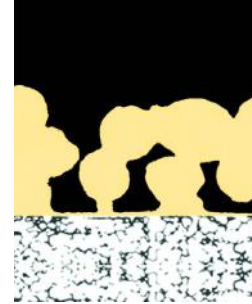


Fig. 1: DX Microsection

2.1 BASIC FORMS

Standard Components available from stock

These products are manufactured to International, National or GGB standard designs:

Metric and Imperial Sizes

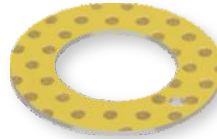
— Cylindrical Bushes

PM pre finished metric range, not machinable in situ, for use with standard journals finished to h6-h8 limits.

MB machinable metric range, with an allowance for machining in situ.

MB machinable inch range for use as supplied or after machining in situ.

— Thrust Washers



— Strip Material



Fig. 2: Standard Components

Non Standard Components not available from stock

These products are manufactured to customers' requirements with or without GGB recommendations, and include for example:

— Modified Standard Components

— Half Bearings

— Flat Components

— Pressings

— Stampings

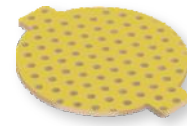
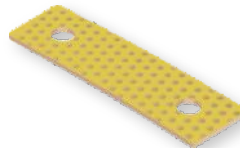
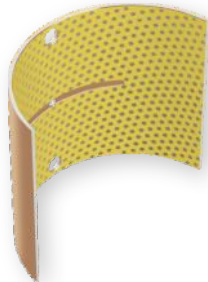
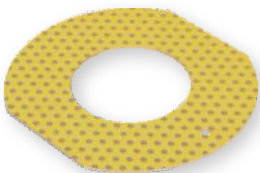


Fig. 3: Non Standard Components

3 Properties

3.1 PHYSICAL, MECHANICAL AND ELECTRICAL PROPERTIES

BEARING PROPERTIES		SYMBOL	UNIT	VALUE - DX®	COMMENTS
PHYSICAL PROPERTIES					
Thermal conductivity		λ	W/mK	52	
Coefficient of linear thermal expansion	parallel to surface	α_1	$10^{-6}/K$	11	
	normal to service	α_2		29	
Operating temperature		T_{max} T_{min}	°C	+120 - 40	
MECHANICAL PROPERTIES					
Compressive yield strength		σ_c	N/mm ²	380	measured on disc Ø 25 mm x 2,45 mm thick
Maximum load	static	$p_{sta.max}$	N/mm ²	140	
	dynamic	$p_{dyn.max}$		140	
ELECTRICAL PROPERTIES					
Volume resistivity of acetal lining		ρ_D	Ωcm	10^{15}	

Table 1: Physical, mechanical and electrical properties of DX

3.2 CHEMICAL PROPERTIES

The following table provides an indication of the chemical resistance of DX® to various chemical media. It is recommended that the chemical resistance is confirmed by testing if possible.

CHEMICAL	%	°C	DX®	CHEMICAL	°C	DX®
STRONG ACIDS				SOLVENTS		
Hydrochloric Acid	5	20	-	Acetone	20	+
Nitric Acid	5	20	-	Carbon Tetrachloride	20	+
Sulfuric Acid	5	20	-	LUBRICANTS AND FUELS		
WEAK ACIDS				Paraffin	20	+
Acetic Acid	5	20	-	Gasolene	20	+
Formic Acid	5	20	-	Kerosene	20	+
BASES				Diesel Fuel	20	+
Ammonia	10	20	o	Mineral Oil	70	o
Sodium Hydroxide	5	20	o	HFA-ISO46 High Water Fluid	70	o
				HFC-Water-Glycol	70	o
				HFD-Phosphate Ester	70	+
				Water	20	o
				Sea Water	20	-

Table 2: Chemical Resistance of HI-EX

- + Satisfactory: Corrosion damage is unlikely to occur
- o Acceptable: Some corrosion damage may occur but this will not be sufficient to impair either the structural integrity or the tribological performance of the material
- Unsatisfactory: Corrosion damage will occur and is likely to affect either the structural integrity and/or the tribological performance of the material

4 Lubrication and Friction

4.1 CHOICE OF LUBRICANT

DX[®] must be lubricated. The choice of lubricant depends upon pU and the sliding speed and the stability of the lubricant under the operating conditions.

Grease

Grease lubrication is the recommended method of lubrication. The performance ratings of different types of grease are indicated in Table 3. For environmental temperatures above 50 °C the grease should contain an anti-oxidant additive. Greases containing EP additives or significant additions of graphite or MoS₂ are not generally recommended for use with DX[®].

Oil

DX[®] is not generally suitable for use with hydrocarbon oils operating above 115 °C. At these temperatures oxidation of the oil may produce a low concentration of labile residues, acid or free radical, which will cause depolymerisation of the DX[®] acetal copolymer bearing lining. Such oxidation can also occur after prolonged periods at lower temperatures. In practice, this means that DX[®] is not recommended for use with recirculating oil systems or bath systems where sump temperatures of 70 °C or greater are possible.

Non lubricating fluids

Care must be taken when using DX[®] with non lubricating fluids as indicated below.

Water

DX[®] is only suitable for operation in water when the load and speed permit full hydrodynamic conditions to be established (see Fig. 7).

Water-oil emulsion

DX[®] is suitable for use with 95/5 water/oil emulsions, however initial operation with pure oil or grease is recommended before transferring to emulsion.

Shock-Absorber Oils

DX[®] is not compatible with shock-absorber oils at operating temperature.

Petrol

With petrol as a lubricant at a pU factor of 0,21 N/mm² x m/s the wear rate of DX[®] has been found to be about 4-5 times greater than that of an initially greased bearing under the same pU conditions.

Kerosene and Polybutene

The wear rate of DX[®] with these fluids has been found to be equivalent to that obtained with a light hydrocarbon oil.

Other Fluids

Polyester, polyethylene glycol and polyglycol lubricants give similar wear rates with DX[®] to light hydrocarbon oil. With the glycol fluids however the operating temperature must not exceed 80 °C because the acetal lining of DX[®] could then be attacked by these fluids.

4 Lubrication and Friction

In general, the fluid will be acceptable if it does not chemically attack the acetal lining or the porous bronze interlayer. Chemical resistance data are given in Table 2. Where there is doubt about the suitability of a fluid, a simple test is to submerge a sample of DX[®] material in the fluid for two to three weeks at 15-20 °C above the operating temperature. The following will usually indicate that the fluid is not suitable for use with DX[®].

- A significant change in the thickness of the DX[®] material,
- A visible change in the bearing surface from polished to matt,
- A visible change in the microstructure of the bronze interlayer.

MANUFACTURER	GRADE	TYPE		RATING
		OIL	THICKENER	
BP	Energrease LS2	Mineral	Lithium Soap	+
	Energrease LT2	Mineral	Lithium Soap	+
	Energrease FGL	Mineral	Non Soap	o
	Energrease GSF	Synthetic	NA	o
Century	Lacerta ASD	Mineral	Lithium/Polymer	o
	Lacerta CL2X	Mineral	Calcium	-
Dow Corning	Molykote 55M	Silicone	Lithium Soap	o
	Molykote PG65	PAO	Lithium Soap	+
	Molykote PG75	Synthetic/Mineral	Lithium Soap	+
	Molykote PG602	Mineral	Lithium Soap	o
Elf	Rolexa.1	Mineral	Lithium Soap	+
	Rolexa.2	Mineral	Lithium Soap	o
	Epexelf.2	Mineral	Lithium/Calcium Soap	o
Esso	Andok C	Mineral	Sodium Soap	o
	Andok 260	Mineral	Sodium Soap	o
	Cazar K	Mineral	Calcium Soap	-
Mobil	Mobilplex 47	Mineral	Calcium Soap	o
	Mobiltemp 1	Mineral	Non Soap	+
Rocol	BG622	White Mineral	Calcium Soap	o
	Sapphire	Mineral	Lithium Complex	o
	White Food Grease	White Oil	Clay	-
Shell	Albida R2	Mineral	Lithium Complex	+
	Axinus S2	Mineral	Lithium	o
	Darina R2	Mineral	Inorganic Non Soap	+
	Stamina U2	Mineral	Polyurea	o
	Tivela A	Synthetic	NA	+
Sovereign	Omega 77	Mineral	Lithium	o
	Omega 85	Mineral	Polyurea	-
Tom Pac	Tom Pac	NA	NA	o
Total	Aerogrease	Synthetic	NA	+
	Multis EP2	NA	Lithium	-

Table 3: Performance of greases

+ Recommended o Satisfactory - Not recommended NA Data not available

Area 1 of Figure 7

The bearing will operate with boundary lubrication. The pU factor will be the major determinant of bearing life.

DX[®] bearing performance can be estimated from the following equations.

The effective pU factor epU can be estimated from section 5.8.

If $epU/\eta \leq 0,2$ then

$$(4.5.1) \quad L_H = \frac{2250}{\left(\frac{epU}{\eta}\right)^{0,5}} \cdot a_Q \cdot a_T \cdot a_S \quad [h]$$

If $0,2 < epU/\eta \leq 1,0$ then

$$(4.5.2) \quad L_H = \frac{1000}{\left(\frac{epU}{\eta}\right)} \cdot a_Q \cdot a_T \cdot a_S \quad [h]$$

If $epU/\eta > 1,0$ then

$$(4.5.3) \quad L_H = \frac{1000}{\left(\frac{epU}{\eta}\right)^2} \cdot a_Q \cdot a_T \cdot a_S \quad [h]$$

epU see (5.8.), page 21

Area 2 of Figure 7

The bearing will operate with mixed film lubrication.

pU factor is no longer a significant parameter in determining the bearing life.

DX[®] bearing performance will depend upon the nature of the fluid and the actual service conditions.

Area 3 of Figure 7

The bearing will operate with hydrodynamic lubrication. Bearing wear will be determined only by the cleanliness of the lubricant and the frequency of start up and shut down.

Area 4 of Figure 7

These are the most demanding operating conditions.

- The bearing is operated under either high speed or high bearing load to viscosity ratio, or a combination of both.
- These conditions may cause
 - excessive operating temperature
 - and/or high wear rate.
- Bearing performance may be improved:
 - by use of unindented DX[®] lining
 - by the addition of one or more grooves to the bearing
 - by shaft surface finish $< 0,05$ [$\mu\text{m } R_a$].

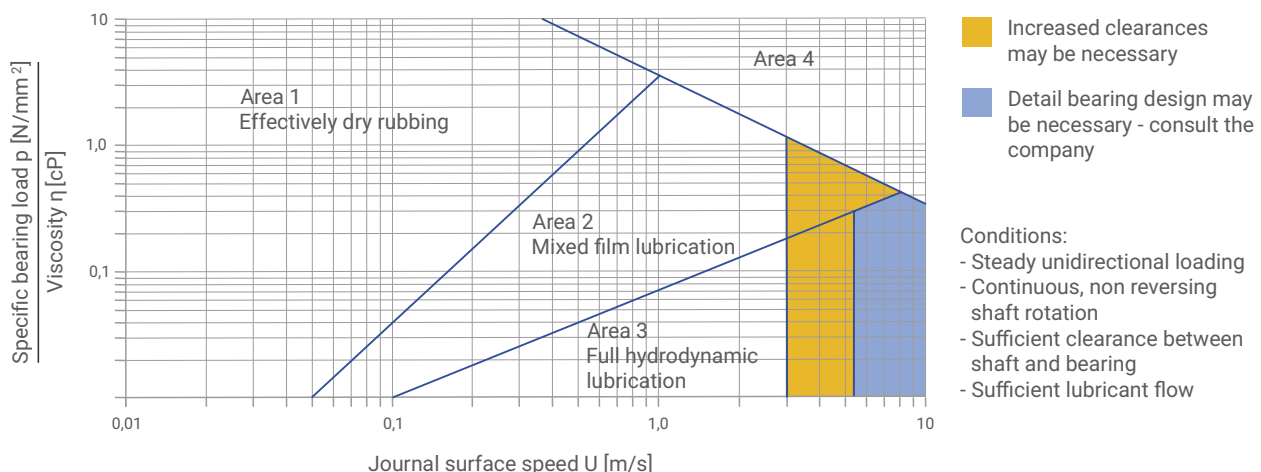


Fig. 7: Design guide for lubricated application

4 Lubrication and Friction

4.2 FRICTION

Lubricated DX[®] bearings show negligible 'stick-slip' and provide smooth sliding between adjacent surfaces. The coefficient of friction of lubricated DX[®] depends upon the actual operating conditions as indicated in section 4.3. Where frictional characteristics are critical to a design they should be established by prototype testing.

4.3 LUBRICATED ENVIRONMENTS

The following sections describe the basics of lubrication and provide guidance on the application of DX[®] in such environments.

Lubrication

There are three modes of lubricated bearing operation which relate to the thickness of the developed lubricant film between the bearing and the mating surface.

These three modes of operation depend upon:

- Bearing dimensions
- Clearance
- Load and speed
- Lubricant viscosity and flow

Hydrodynamic lubrication

Characterised by:

- Complete separation of the shaft from the bearing by the lubricant film
- Very low friction and no wear of the bearing or shaft since there is no contact.
- Coefficients of friction of 0,001 to 0,01

Hydrodynamic conditions occur when:

$$(4.3.1) \quad p \leq \frac{U \cdot \eta \cdot B}{7,5 \cdot D_i} \quad [\text{N/mm}^2]$$

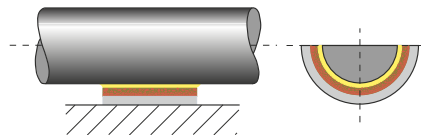


Figure 4: Hydrodynamic lubrication

Mixed Film Lubrication

Characterised by:

- Combination of hydrodynamic and boundary lubrication.
- Part of the load is carried by localised areas of self pressurised lubricant and the remainder supported by boundary lubrication.
- Coefficients of friction of 0,01 to 0,10.
- Friction and wear depend upon the degree of hydrodynamic support developed.

- DX[®] provides low friction and high wear resistance to support the boundary lubricated element of the load.

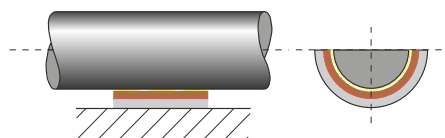


Figure 5: Mixed film lubrication

Boundary lubrication

Characterised by:

- Rubbing of the shaft against the bearing with virtually no lubricant separating the two surfaces.
- Bearing material selection is critical to performance.
- Shaft wear is likely due to contact between bearing and shaft.
- The excellent properties of DX[®] material minimises wear under these conditions.
- The dynamic coefficient of friction with DX[®] is typically 0,02 to 0,1 under boundary lubrication conditions.
- The static coefficient of friction with DX[®] is typically 0,03 to 0,15 under boundary lubrication conditions.

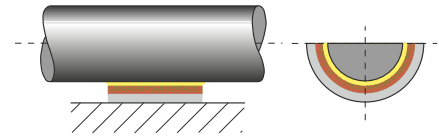


Figure 6: Hydrodynamic lubrication

4.4 CHARACTERISTICS OF FLUID LUBRICATED HI-EX[®] BEARINGS

DX[®] is particularly effective in the most demanding of lubricated applications where full hydrodynamic operation cannot be maintained, for example:

High load conditions

In highly loaded applications operating under boundary or mixed film conditions DX[®] shows excellent wear resistance.

Start up and shut down under load

With insufficient speed to generate a hydrodynamic film the bearing will operate under boundary or mixed film conditions.

- DX[®] minimises wear
- DX[®] requires less start up torque than conventional metallic bearings.

Sparse lubrication

Many applications require the bearing to operate with less than the ideal lubricant supply, typically with splash or mist lubrication only. DX[®] requires significantly less lubricant than conventional metallic bearings.

4.5 DESIGN GUIDANCE FOR FLUID LUBRICATED APPLICATIONS

Fig. 7, Page 11 shows the three lubrication regimes discussed above plotted on a graph of sliding speed vs the ratio of specific load to lubricant viscosity.

In order to use Fig. 7

Using the formulae in Section 5:

- Calculate the specific load p
- Calculate the shaft surface speed U

Using the viscosity temperature relationships presented in Table 4:

- Determine the viscosity in centipoise of the lubricant.

Note:

Viscosity is a function of operating temperature. If the operating temperature of the fluid is unknown, a provisional temperature of 25 °C above ambient can be used.

4 Lubrication and Friction

Temperature [°C]	VISCOSITY cP														
	0	10	20	30	40	50	60	70	80	90	100	110	120	130	140
Lubricant															
ISO VG 32	310	146	77	44	27	18	13	9,3	7,0	5,5	4,4	3,6	3,0	2,5	2,2
ISO VG 46	570	247	121	67	40	25	17	12	9,0	6,9	5,4	4,4	3,6	3,0	2,6
ISO VG 68	940	395	190	102	59	37	24	17	12	9,3	7,2	5,8	4,7	3,9	3,3
ISO VG 100	2110	780	335	164	89	52	33	22	15	11,3	8,6	6,7	5,3	4,3	3,6
ISO VG 150	3600	1290	540	255	134	77	48	31	21	15	11	8,8	7,0	5,6	4,6
Diesel oil	4,6	4,0	3,4	3,0	2,6	2,3	2,0	1,7	1,4	1,1	0,95				
Petrol	0,6	0,56	0,52	0,48	0,44	0,40	0,36	0,33	0,31						
Kerosene	2,0	1,7	1,5	1,3	1,1	0,95	0,85	0,75	0,65	0,60	0,55				
Water	1,79	1,30	1,0	0,84	0,69	0,55	0,48	0,41	0,34	0,32	0,28				

Table 4: Viscosity data

4.6 WEAR RATE AND RELUBRICATION INTERVALS WITH GREASE LUBRICATION

At specific bearing loads below 100 N/mm² a grease lubricated DX[®] bearing shows only small bedding-in wear of about 0,0025 mm. This is followed by little wear during the early part of the bearing life until the lubricant becomes exhausted and the wear rate increases. If the bearing is regreased before the rate of wear starts to increase rapidly the material will continue to function satisfactorily with little wear. Figure 8 shows the typical wear pattern. Under specific loads above 100 N/mm² the initial bedding-in wear is greater, typically about 0,025 mm, followed by a decreasing wear rate until the bearing exhibits a similar wear/life relationship to that shown in Figure 8.

The useful life of the bearing is limited by wear in the loaded area. If this wear exceeds 0,15 mm the grease capacity of the indents is reduced and more frequent regreasing of the bearing will be required.

Fretting wear

Oscillating movements of less than the dimensions of the indent pattern may cause localised wear of the mating surface after prolonged usage. This will result in the indent pattern becoming transferred onto the mating surface in contact with the DX[®] bearing and may also give rise to fretting corrosion damage. In this situation DS material should be considered as an alternative to DX[®].

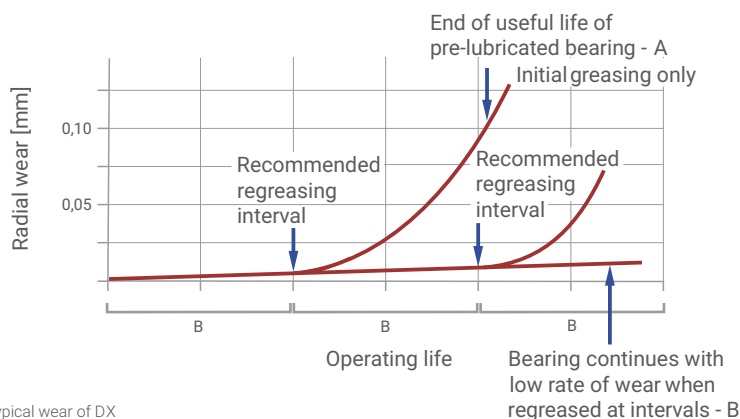


Fig. 8: Typical wear of DX

5 Design Factors

The main parameters when determining the size or calculating the service life for a DX® bearing are:

- Specific load limit p_{lim} [N/mm²]
- pU Factor [N/mm² x m/s]
- Mating surface roughness R_a [μm]
- Mating surface material
- Temperature T [°C]
- Other environmental factors eg. housing design, dirt, lubrication.

5.1 SPECIFIC LOAD

The specific load p is defined as the working load divided by the projected area of the bearing and is expressed in N/mm²

Cylindrical Bush

$$(5.1.1) \quad p = \frac{F}{D_i \cdot B} \quad [\text{N/mm}^2]$$

Thrust Washer

$$(5.1.2) \quad p = \frac{4F}{\pi \cdot (D_o^2 - D_i^2)} \quad [\text{N/mm}^2]$$

Slide Plate

$$(5.1.3) \quad p = \frac{F}{L \cdot W} \quad [\text{N/mm}^2]$$

Specific load limit

The maximum load which can be applied to a DX® bearing can be expressed in terms of the specific load limit, which depends on the type of the loading and lubrication. It is highest under steady loads. The values of specific load limit specified in table 5 assume good alignment between the bearing and mating surface.

The specific load limit for DX® reduces for bearing operating temperatures in excess of 40 °C, falling to about half the values given in table 5 for temperatures above 100 °C.

Conditions of dynamic load or oscillating movement which produce fatigue stress in the bearing result in a reduction in the permissible specific load limit (Fig. 9, page 16).

LOAD	OPERATING CONDITION	LUBRICATION	p_{lim}
Steady	Intermittent or very slow (below 0,01 m/s) continuous rotation or oscillating motion	Grease or oil	140
Steady	Continuous rotation or oscillating motion	Grease or oil (boundary lubrication)	70
Steady or dynamic	Continuous rotation or oscillating motion	Oil (hydrodynamic lubrication)	45

Table 5: Specific load limit p_{lim} for DX

5 Design Factors

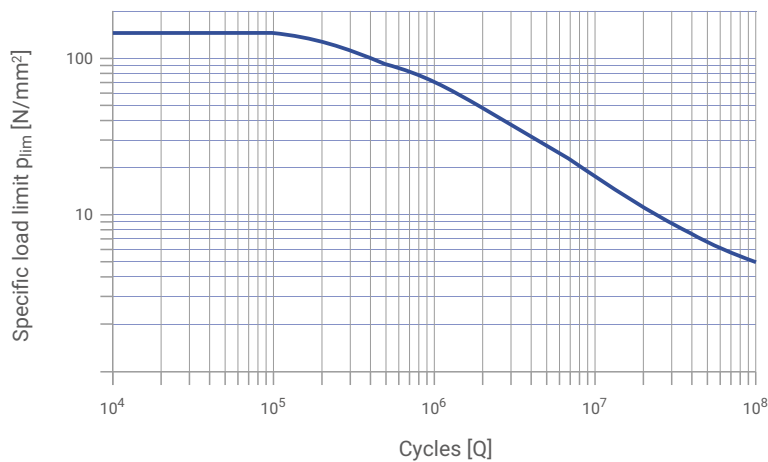


Fig. 9: DX specific load limits p_{lim} under dynamic loads or oscillating conditions

5.2 SLIDING SPEED U

The sliding speed U [m/s] is calculated as follows:

Continuous Rotation

Cylindrical Bush

$$(5.2.1) \quad U = \frac{D_i \cdot \pi \cdot N}{60 \cdot 10^3} \quad [\text{m/s}]$$

Thrust Washer

$$(5.2.2) \quad U = \frac{D_o + D_i}{2} \cdot \pi \cdot N \quad [\text{m/s}]$$

Oscillating Movement

Cylindrical Bush

$$(5.2.3) \quad U = \frac{D_i \cdot \pi}{60 \cdot 10^3} \cdot \frac{4\varphi \cdot N_{osz}}{360} \quad [\text{m/s}]$$

Thrust Washer

$$(5.2.4) \quad U = \frac{D_o + D_i}{2} \cdot \pi \cdot \frac{4\varphi \cdot N_{osz}}{360} \quad [\text{m/s}]$$

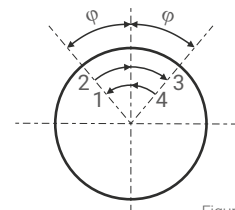


Figure 10: Oscillating cycle φ

The maximum permissible effective pU factor (epU factor) for grease lubricated DX® bearings is dependent upon the sliding speed as shown in Figure 11. For sliding speeds in excess of 2,5 m/s continuous oil lubrication is recommended.

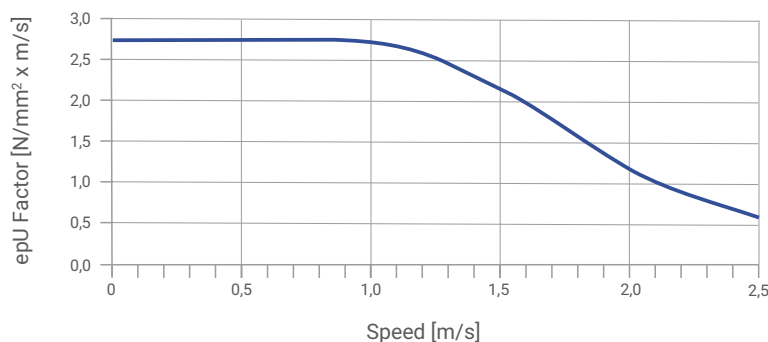


Fig. 11: Maximum epU factor for grease lubrication

5.3 pU FACTOR

The useful operating life of a DX[®] bearing is governed by the pU factor, which is calculated as follows:

$$(5.3.1) \quad [N/mm^2 \cdot m/s]$$

$$pU = p \cdot U$$

5.4 LOAD

In addition to its contribution to the pU factor the type and direction of the applied load also affects the performance of a DX[®] bearing. This is accommodated in the calculation of the bearing service life by the speed/load application factor a_Q shown in Figures 15 - 17.

Type of Load

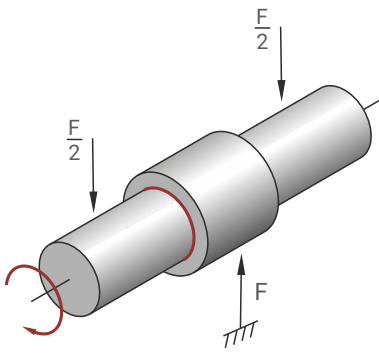


Fig. 12: Steady load, vertically downwards, bush stationary, shaft rotating. Lubricant drains to loaded area.

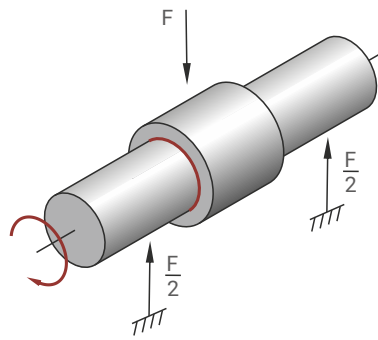


Fig. 13: Steady load, vertically upwards, bush stationary, shaft rotating. Lubricant drains away from loaded area

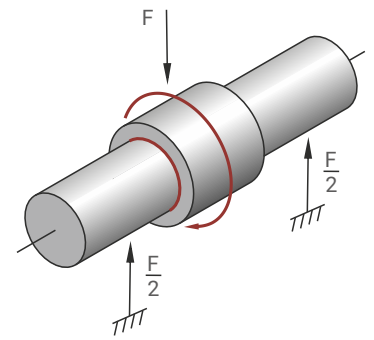
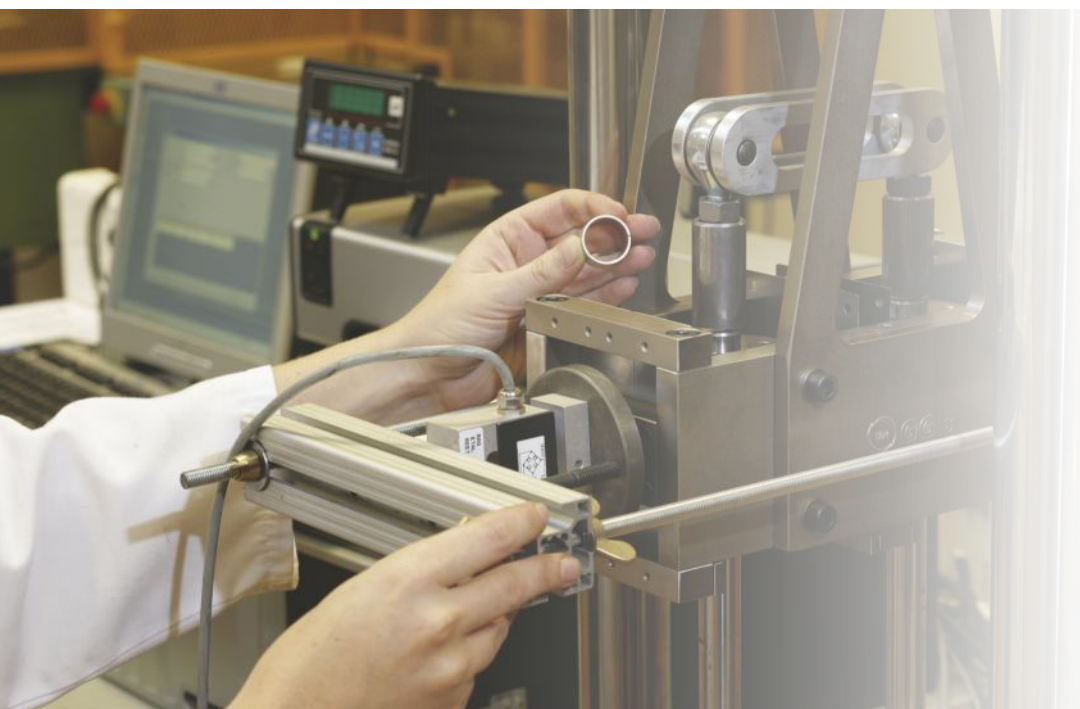


Fig. 14: Rotating load, shaft stationary, bush rotating



5 Design Factors

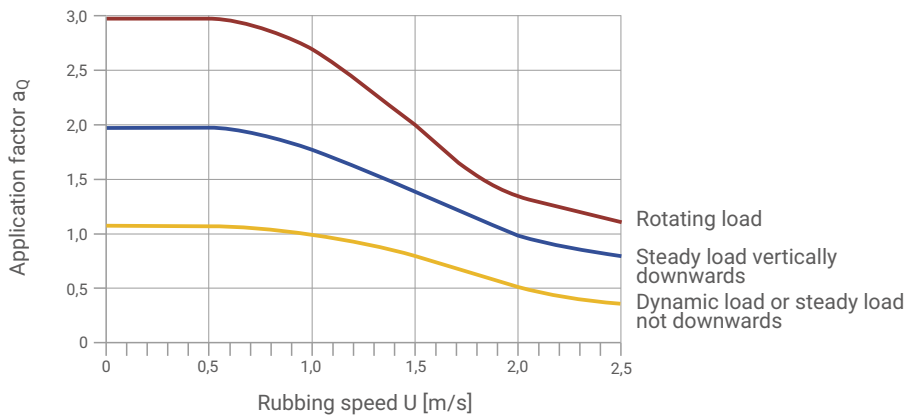


Fig. 15: Application factor a_Q for MB range bushes - unmachined

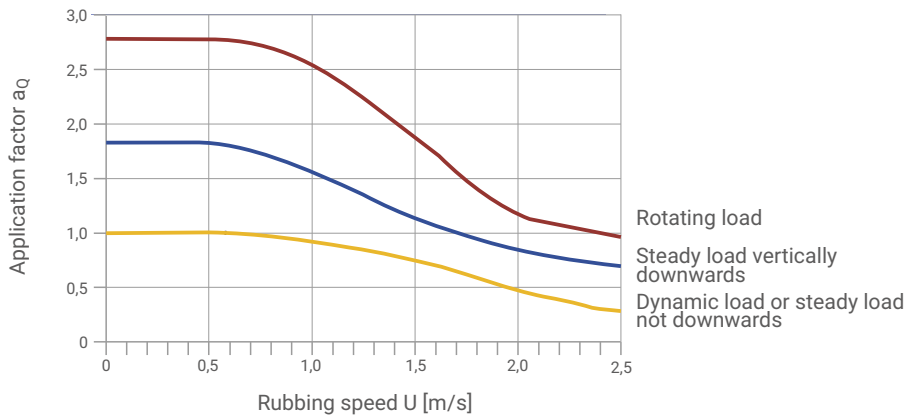


Fig. 16: Application factor a_Q for PM range and MB range bushes - machined

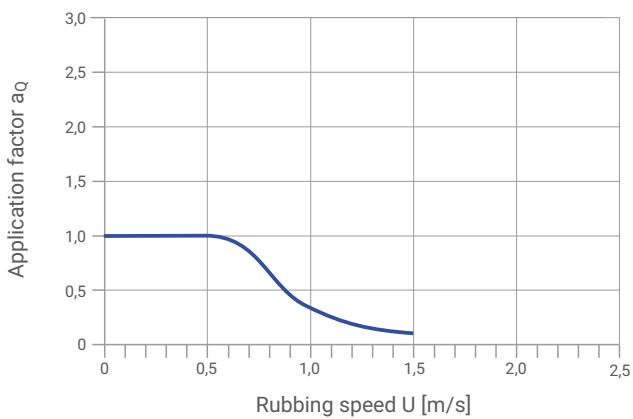


Fig. 17: Application factor a_Q for thrust washers

Note: $a_Q = 1$ for slideways

5.5 TEMPERATURE

The useful life of a DX[®] bearing depends upon the operating temperature. The performance of grease lubricated DX[®] decreases at bearing temperatures above 40 °C. This loss of performance is related to both material and lubricant effects.

For a given pU factor the operating temperature of the bearing depends upon the temperature of the surrounding environment and the heat dissipation properties of the housing.

In calculating the service life of DX[®] these effects are accommodated by the application factor a_T shown in Fig. 18

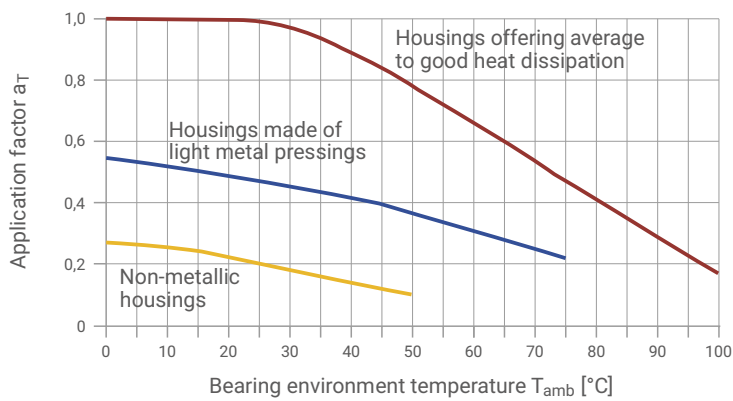


Fig. 18: DX application factor a_T

5.6 MATING SURFACE

The wear rate of DX[®] is strongly dependent upon the roughness of the mating counterface. For optimum bearing performance the mating surface should be ground to better than 0,4 $\mu\text{m } R_a$. This effect is accommodated by the mating surface finish application factor a_S shown in Fig. 19.

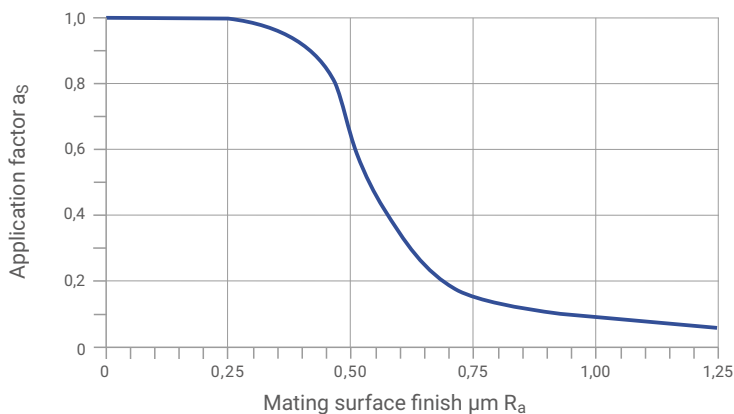


Fig. 19: DX application factor a_S

5 Design Factors

5.7 BEARING SIZE

Frictional heat generated at the bearing surface and dissipated through the shaft and housing depends both on the operating conditions (i.e. pU factor) and the bearing size.

For a given pU condition a large bearing will run hotter than a smaller bearing. The bearing size factor a_B shown in Figure 20 takes account of this effect.

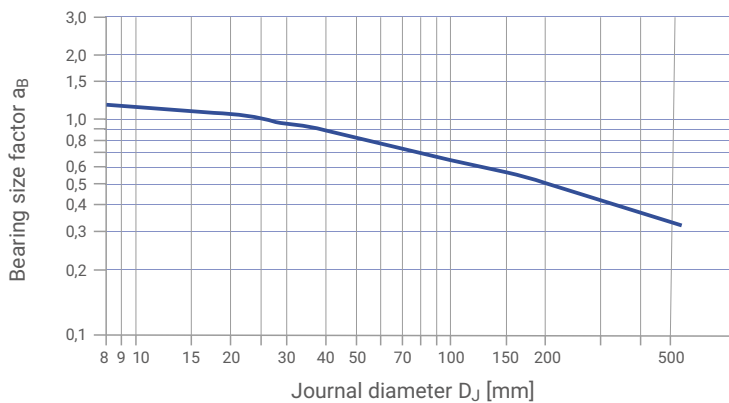


Fig. 20: Bearing size factor a_B

Note: $a_B = 1$ for slideways

5.8 ESTIMATION OF BEARING SERVICE LIFE WITH GREASE LUBRICATION

Calculation Parameters

BUSHES	THRUST WASHERS	SLIDE PLATES	UNIT
Bearing diameter D_i	Bearing outside diameter D_o	Bearing length L	[mm]
Bearing width B	Bearing inside diameter D_i	Bearing width W	[mm]

Operating Conditions

Load	F	[N]
Rotational speed (continuous)	N	[1/min]
Oscillating frequency	N_{osc}	[1/min]
Angular movement about mean position	φ	[°]
Specific load limit	see table 5, page 15	[N/mm ²]
Application factor a_Q	see figure 15 - 17, page 18	[-]
Application factor a_T	see figure 18, page 19	[-]
Application factor a_S	see figure 19, page 19	[-]
Bearing size factor a_B	see figure 20, page 20	[-]

Calculate p from the equations in 5.1 on Page 15.

Calculate U from the equations in 5.2 on Page 16.

Calculate pU from the equation in 5.3 on Page 17.

Calculate high load factor a_E

$$(5.8.1) \quad a_E = \frac{p_{lim} - p}{p_{lim}} \quad [-]$$

p_{lim} see Table 5, Page 15

Note:

If $a_E > 10000$, or $a_E < 0$, the bearing is overloaded.

Calculate effective pU factor epU

$$(5.8.2) \quad epU = \frac{a_E \cdot pU}{a_B} \quad [-]$$

Note:

Check that epU is less than limit set in Fig. 11 for the sliding speed U . If NOT, increase the bearing length or use continuous lubrication.

Estimate bearing life

If $epU < 1,0$ then

$$(5.8.3) \quad L_H = \frac{3000}{epU} \cdot a_Q \cdot a_T \cdot a_S \quad [h]$$

If $epU > 1,0$ then

$$(5.8.4) \quad L_H = \frac{3000}{(epU)^{2,4}} \cdot a_Q \cdot a_T \cdot a_S \quad [h]$$

Estimate regreasing interval

$$(5.8.5) \quad L_{RG} = \frac{L_H}{2} \quad [h]$$

Oscillating motion and dynamic loads

Calculate number of cycles

$$(5.8.6) \quad Z_T = L_{RG} \cdot n_{osc} \cdot 60 \cdot (R + 2) \quad [h]$$

Calculate number of cycles

$$(5.8.7) \quad C_T = L_{RG} \cdot C \cdot 60 \cdot (R + 2) \quad [h]$$

where R = Number of times bearing is regreased during total life required.

Check that Z_T (or C_T) is less than the total number of cycles Q given in Figure 9 for actual bearing specific load p .

If Z_T (or C_T) $> Q$ then life will be limited by fatigue after Q cycles.

If Z_T (or C_T) $< Q$ then life will be limited by wear after Z_T cycles.

If the estimated life or total cycles are insufficient or the regreasing intervals are too frequent, increase the bearing length or diameter, or consider drip feed or continuous oil lubrication, the quantity to be established by test.

5 Design Factors

5.9 WORKED EXAMPLES

PM cylindrical bush

Given:		
Load Details	Steady Load Direction: down	Inside Diameter D_i 40 mm Length B 30 mm
Shaft	Steel ambient temperature	Bearing Load F 15.000 N Rotational Speed N 30 · 1/min
	good heat conditions	R_a 0,3 μ m

Calculation Constants and Application Factors	
Specific Load Limit p_{lim}	70 N/mm ² (Table 5, Page 15)
Application Factor a_T	1,0 (Fig. 18, Page 19)
Mating Surface Applic. Factor a_S	0,98 (Fig. 19, Page 19)
Bearing Size Factor a_B for \varnothing 40	0,98 (Fig. 20, Page 20)
Application Factor for PM bush a_Q	1,8 (Fig. 16, Page 18)

Calculation	Ref	Value
Specific Load p [N/mm ²]	(5.1.1) Page 15	$p = \frac{F}{D_i \cdot B} = \frac{15.000}{40 \cdot 30} = 12,5$
Sliding Speed U [m/s]	(5.2.1) Page 16	$U = \frac{D_i \cdot \pi \cdot N}{60 \cdot 10^3} = \frac{40 \cdot 3,14 \cdot 30}{60 \cdot 10^3} = 0,063$
High Load Factor a_E [-] must be > 0	(5.8.1) Page 21	$a_E = \frac{p_{lim}}{p_{lim} - p} = \frac{70}{70 - 12,5} = 1,22$
epU Factor [-]	(5.8.2) Page 21	$epU = \frac{a_E \cdot pU}{a_B} = \frac{1,22 \cdot 12,5 \cdot 0,063}{0,98} = 0,98$
Life L_H [h] for $epU < 1$	(5.8.3) Page 21	$L_H = \frac{3000}{epU} \cdot a_Q \cdot a_T \cdot a_S$ $= \frac{3000}{0,98} \cdot 1,8 \cdot 1,0 \cdot 0,98 = 5400$
L_{RG} [h]	(5.8.5) Page 21	$L_{RG} = \frac{L_H}{2} = \frac{5400}{2} = 2700$

PM cylindrical bush

Given:		
Load Details	Steady Load Direction: up	Inside Diameter D_i 90 mm Length B 60 mm
Shaft	Steel Temperature 80 °C	Bearing Load F 45.000 N Rotational Speed N 20 · 1/min
	good heat conditions	R_a 0,3 μ m

Calculation Constants and Application Factors	
Specific Load Limit p_{lim} at 80 °C	46,7 N/mm ² (Table 5, Page 15)
Application Factor a_T	0,4 (Fig. 18, Page 19)
Mating Surface Applic. Factor a_S	0,98 (Fig. 19, Page 19)
Bearing Size Factor a_B for \varnothing 40	0,70 (Fig. 20, Page 20)
Application Factor for PM bush a_Q	1,0 (Fig. 16, Page 18)

Calculation	Ref	Value
Specific Load p [N/mm ²]	(5.1.1) Page 15	$p = \frac{F}{D_i \cdot B} = \frac{45.000}{90 \cdot 60} = 8,33$
Sliding Speed U [m/s]	(5.2.1) Page 16	$U = \frac{D_i \cdot \pi \cdot N}{60 \cdot 10^3} = \frac{90 \cdot 3,14 \cdot 20}{60 \cdot 10^3} = 0,094$
High Load Factor a_E [-] must be > 0	(5.8.1) Page 21	$a_E = \frac{p_{lim}}{p_{lim} - p} = \frac{46,7}{46,7 - 8,33} = 1,22$
epU Factor [-]	(5.8.2) Page 21	$epU = \frac{a_E \cdot pU}{a_B} = \frac{1,22 \cdot 8,33 \cdot 0,094}{0,70} = 1,36$
Life L_H [h] for $epU > 1$	(5.8.4) Page 21	$L_H = \frac{3000}{epU^{2,4}} \cdot a_Q \cdot a_T \cdot a_S$ $= \frac{3000}{1,36^{2,4}} \cdot 1,0 \cdot 0,4 \cdot 0,98 = 562$
L_{RG} [h]	(5.8.5) Page 21	$L_{RG} = \frac{L_H}{2} = \frac{562}{2} = 281$



Thrust washer

Given:		
Load Details	Steady Load Direction: down	Inside Diameter D_i 26 mm Outside Diameter D_o 44 mm
Shaft	Steel ambient temperature	Bearing Load F 10.000 N Rotational Speed N 10 · 1/min
	good heat conditions	R_a 0,3 μm

Calculation Constants and Application Factors	
Specific Load Limit p_{lim}	70 N/mm ² (Table 5, Page 15)
Application Factor a_T for 50 °C	1,0 (Fig. 18, Page 19)
Mating Surface Applic. Factor a_S	0,98 (Fig. 19, Page 19)
Bearing Size Factor a_B for \varnothing 35	0,90 (Fig. 20, Page 20)
Applic. Factor for Thrust Washer a_Q	1,0 (Fig. 16, Page 18)

Calculation	Ref	Value
Specific Load p [N/mm ²]	(5.1.1) Page 15	$p = \frac{4 \cdot F}{\pi \cdot (D_o^2 - D_i^2)} = \frac{4 \cdot 10.000}{\pi \cdot (44^2 - 26^2)} = 10,11$
Sliding Speed U [m/s]	(5.2.2) Page 16	$U = \frac{D_o + D_i}{2} \cdot \pi \cdot N$ $= \frac{44 + 26}{2} \cdot \pi \cdot 10$ $= \frac{70}{60 \cdot 10^3} = 0,018$
High Load Factor a_E [-] must be > 0	(5.8.1) Page 21	$a_E = \frac{p_{lim}}{p_{lim} - p} = \frac{70}{70 - 10,11} = 1,169$
epU Factor [-]	(5.8.2) Page 21	$epU = \frac{a_E \cdot pU}{a_B} = \frac{1,169 \cdot 10,11 \cdot 0,018}{0,90} = 0,236$
Life L_H [h] for $epU < 1$	(5.8.3) Page 21	$L_H = \frac{3000}{epU} \cdot a_Q \cdot a_T \cdot a_S$ $= \frac{3000}{0,236} \cdot 1,0 \cdot 1,0 \cdot 0,98 = 12.460$
L_{RG} [h]	(5.8.5) Page 21	$L_{RG} = \frac{L_H}{2} = \frac{12.460}{2} = 6.230$

Slideways

Given:			
Load Details	Steady Load Direction: down	Length B 50 mm Width W 20 mm	
Shaft	Steel ($R_a = 0,3 \mu\text{m}$) Temperature 80 °C	Bearing Load F 15.000 N Stroke 15 mm	
	good heat conditions	Frequency 10 · 1/min	

Calculation Constants and Application Factors	
Specific Load Limit p_{lim} at 80 °C	93 N/mm ² (Table 5, Page 15)
Application Factor a_T	0,4 (Fig. 18, Page 19)
Mating Surface Applic. Factor a_S	0,98 (Fig. 19, Page 19)
Bearing Size Factor a_B	1,0 (Fig. 20, Page 20)
Application Factor for PM bush a_Q	1,0 (Fig. 16, Page 18)

Calculation	Ref	Value
Specific Load p [N/mm ²]	(5.1.3) Page 15	$p = \frac{F}{L \cdot W} = \frac{20.000}{50 \cdot 20} = 20$
Sliding Speed U [m/s]		$U = \frac{15 \cdot 2 \cdot 10}{60 \cdot 10^3} = 0,005$
High Load Factor a_E [-] must be > 0	(5.8.1) Page 21	$a_E = \frac{p_{lim}}{p_{lim} - p} = \frac{93}{93 - 20} = 1,27$
epU Factor [-]	(5.8.2) Page 21	$epU = \frac{a_E \cdot pU}{a_B} = \frac{1,27 \cdot 20 \cdot 0,005}{1,0} = 0,127$
Life L_H [h] for $epU < 1$	(5.8.3) Page 21	$L_H = \frac{3000}{epU} \cdot a_Q \cdot a_T \cdot a_S$ $= \frac{3000}{0,127} \cdot 1,0 \cdot 0,4 \cdot 0,98 = 9.260$
L_{RG} [h]	(5.8.5) Page 21	$L_{RG} = \frac{L_H}{2} = \frac{9.260}{2} = 4.630$

6 Bearing Assembly

6.1 DIMENSIONS AND TOLERANCES

For optimum performance it is essential that the correct running clearance is used and that both the diameter of the shaft and the bore of the housing are finished to the limits given in the tables.

If the bearing housing is unusually flexible the bush will not close in by the calculated amount and the running clearance will be more than the optimum. In these circumstances the housing should be bored slightly undersize or the journal diameter increased, the correct size being determined by experiment.

6.2 TOLERANCES FOR MINIMUM CLEARANCE

Grease lubrication

The minimum clearance required for satisfactory performance of DX[®] depends upon the pU factor, the sliding speed and the environmental temperature, any one or combination of which may reduce the diametral clearance in operation due to inward thermal expansion of the DX[®] acetal lining. It is therefore necessary to compensate for this.

Figure 21 shows the minimum diametral clearance plotted stepped against journal diameter at an ambient 20 °C. Where the stepped lines show a change of clearance for a given journal diameter, the lower value is used.

The superimposed straight lines indicate the minimum permissible diametral clearance for various values of pUu (Figure 21), where pU is calculated as in 5.3 on page 17, and u is a sliding speed factor for speeds in excess of 0,5 m/s given in Figure 22.

If the clearance indicated for a pUu factor lies below the stepped lines the recommended standard shaft may be used. If above, the shaft size must be reduced to obtain the clearance indicated on the vertical axis of the relevant figure.

Under slow speed and high load conditions it may be possible to achieve satisfactory performance with diametral clearances less than those indicated. But adequate prototype testing is recommended in such cases.

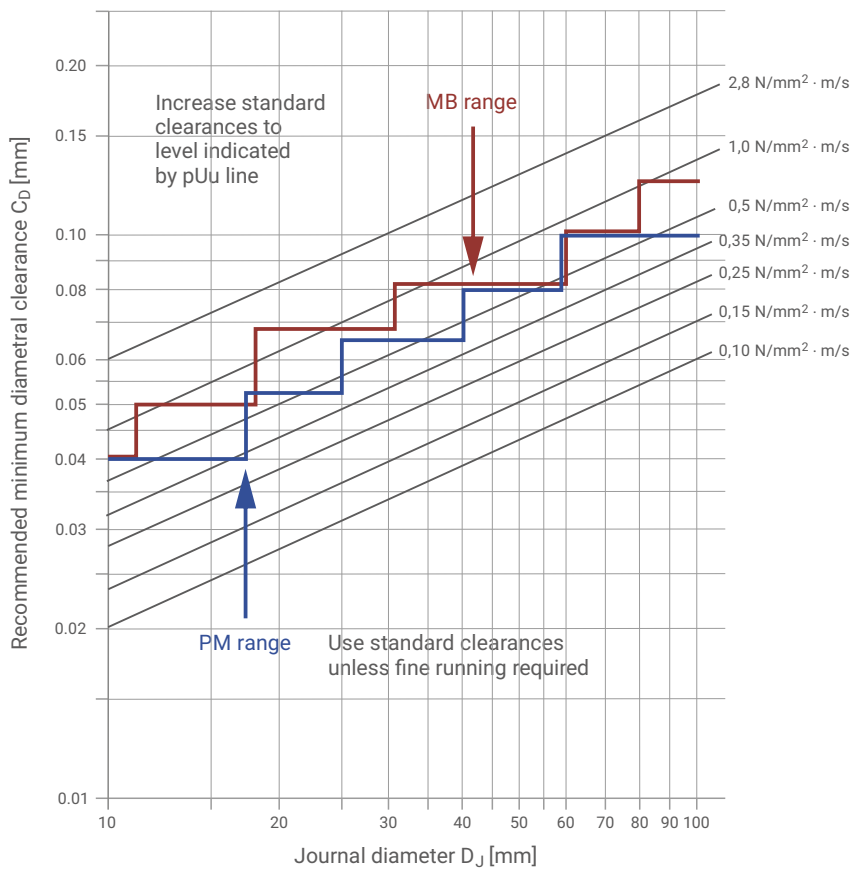


Fig. 21: Minimum clearance for PM prefinished and MB machinable range machined to H7 bore

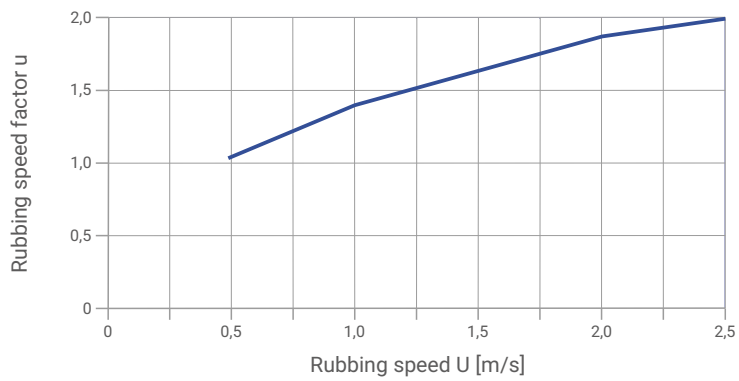


Fig. 22: Rubbing speed factor u

6 Bearing Assembly

Fluid lubrication

The minimum clearance required for journal bearings operating under hydrodynamic or mixed film conditions for a range of shaft rotational speeds and diameters is shown in Figure 23. It is recommended that the bearing performance under minimum clearance conditions be confirmed by testing if possible.

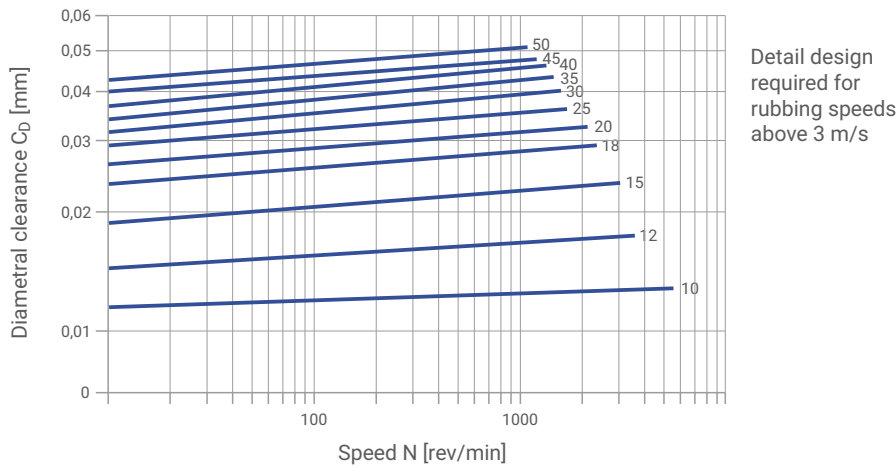


Fig. 23: DX minimum clearances - bush diameters D_i 10 - 50 mm

Allowance for thermal expansion

For operation in high temperature environments the clearance should be increased by the amounts indicated by Figure 24 to compensate for the inward thermal expansion of the bearing lining.

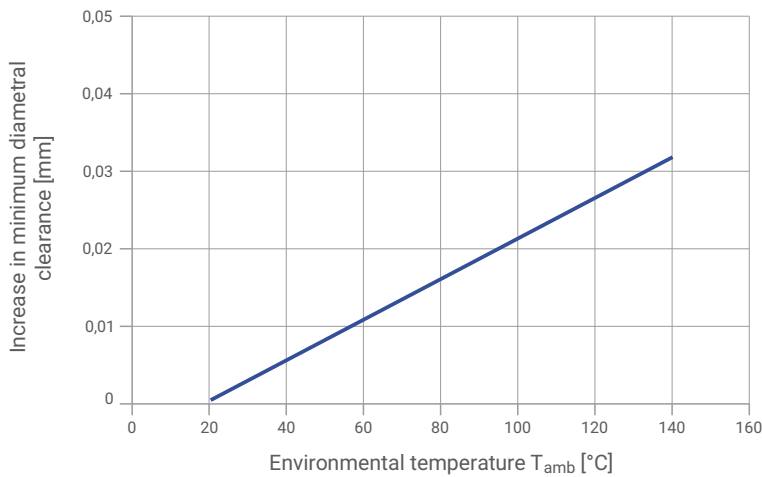


Fig. 24: Recommended increase in diametral clearance

If the housing is non-ferrous then the bore should be reduced by the amounts given in Table 5, in order to give an increased interference fit to the bush, with a similar reduction in the journal diameter additional to that indicated by Figure 24.

HOUSING MATERIAL	REDUCTION IN HOUSING DIAMETER PER 100°C RISE	REDUCTION IN SHAFT DIAMETER PER 100°C RISE
Aluminium alloys	0,1 %	0,1 % + values from Fig. 24
Copper base alloys	0,05 %	0,05 % + values from Fig. 24
Steel and cast iron	Nil	values from Fig. 24
Zinc base alloys	0,15 %	0,15 % + values from Fig. 24

Table 6: Allowance for high temperature

6.3 COUNTERFACE DESIGN

DX® bearings may be used with all conventional mating surface materials. Hardening of steel journals is not required unless abrasive dirt is present or if the projected bearing life is in excess of 2000 hours, in which cases a minimum shaft hardness of 350HB is recommended.

A ground surface finish of better than 0,4 µm R_a is recommended. The final direction of machining of the mating surface should preferably be the same as the direction of motion relative to the bearing in service.

DX® is normally used in conjunction with ferrous journals and thrust faces, but in damp or corrosive surroundings stainless steel, hard chromium plated mild steel, or alternatively WH shaft sleeves (Standard programm available) are recommended. When plated mating surfaces are specified the plating should possess adequate strength and adhesion, particularly if the bearing is to operate with high fluctuating loads.

The shaft or thrust collar used in conjunction with the DX® bush or thrust washer must extend beyond the bearing surface in order to avoid cutting into it. The mating surface must also be free from grooves or flats, the end of the shaft should be given a lead-in chamfer and all sharp edges or projections which may damage the soft acetal lining of the DX® must be removed.

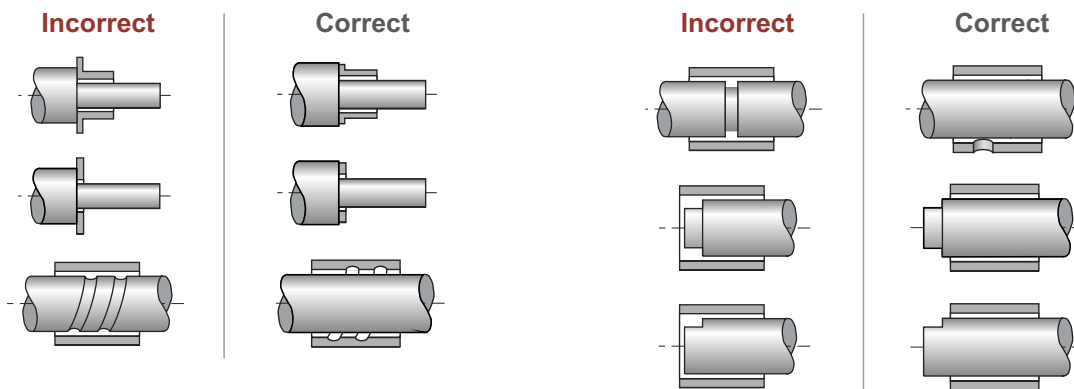


Fig. 25: Counterface Design

6 Bearing Assembly

6.4 INSTALLATION

Important note:

Care must be taken to ensure that the DX® lining material is not damaged during the installation.

Fitting of bushes

The bush is inserted into its housing with the aid of a stepped mandrel, preferably made from case hardened mild steel, as shown in Figure 26. The following should be noted to avoid damage to the bearing:

- Housing diameter is as recommended
- 15-30° lead-in chamfer on housing
- Edges of lead-in chamfer are deburred
- The bush must be square to the housing
- Light smear of oil on bush OD

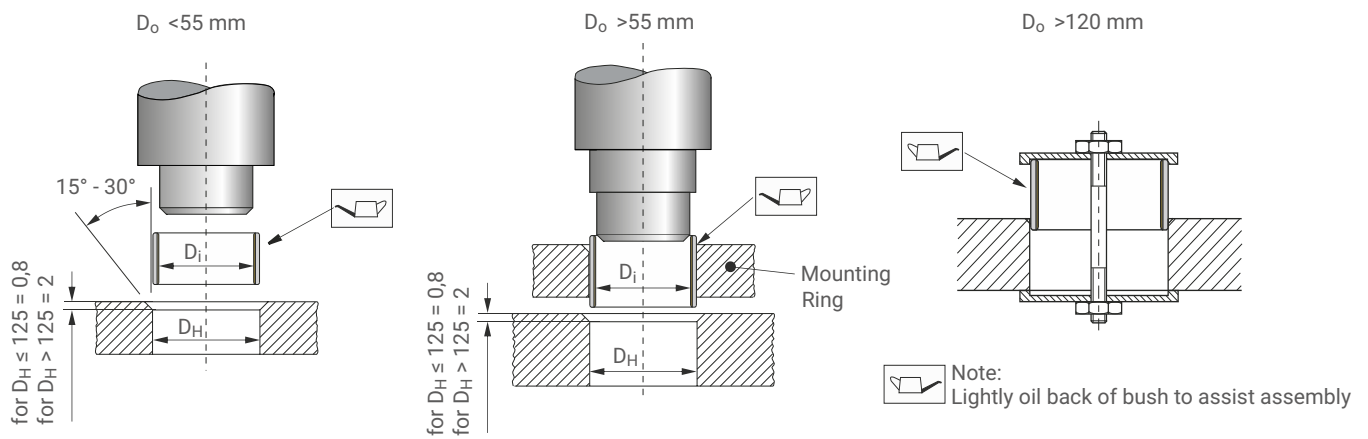


Fig. 26: Fitting of cylindrical bushes

Insertion forces

Figure 27 gives an indication of the maximum insertion force required to correctly install standard DX® bushes.

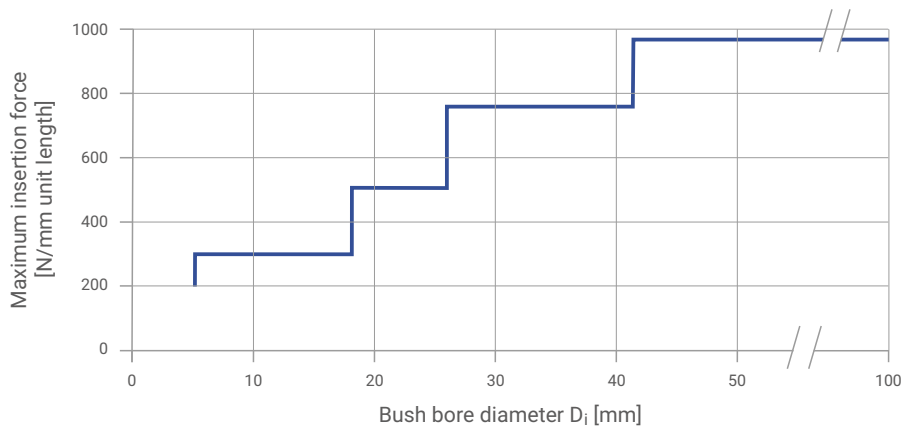


Fig. 27: Maximum Insertion Force

Alignment

Accurate alignment is an important consideration for all bearing assemblies. With DX® bearings misalignment over the length of a bush (or pair of bushes), or over the diameter of a thrust washer should not exceed 0,020 mm as illustrated in Figure 28.

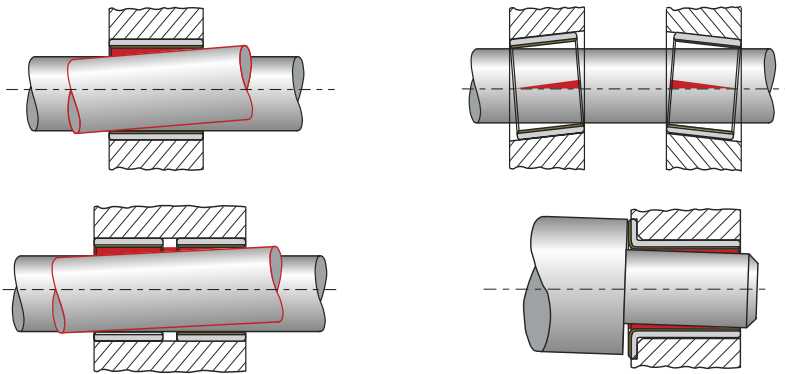


Fig. 28: Alignment

Sealing

While DX® can tolerate the ingress of some contaminant materials into the bearing without loss of performance, where there is the possibility of highly abrasive material entering the bearing, a suitable sealing arrangement, as illustrated in Figure 29 should be provided.

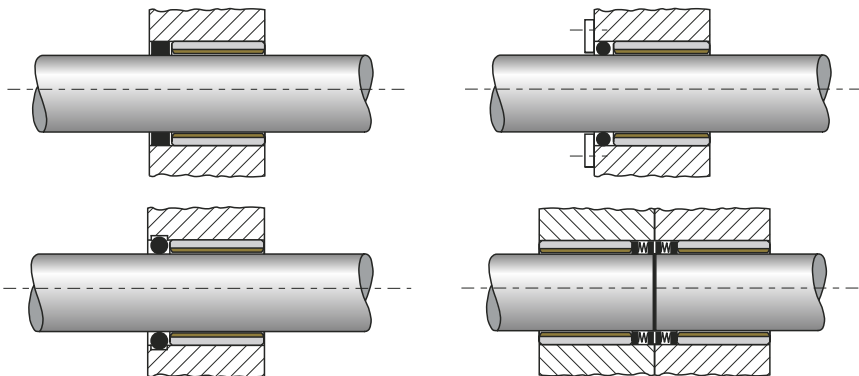


Fig. 29: Recommended sealing arrangements

Axial location

Where axial location is necessary, it is generally advisable to fit DX® thrust washers in conjunction with DX® bushes, even when the axial loads are low. Experience has shown that fretting debris from unsatisfactory locating surfaces can enter an adjacent DX® bush and adversely affect the bearing life and performance.

6 Bearing Assembly

Fitting of thrust washers

DX® thrust washers should be located on the outside diameter in a recess as shown in Fig. 30. The inside diameter must be clear of the shaft in order to prevent contact with the steel backing of the DX® material. The recess diameter should be 0,125 mm larger than the washer diameter and the depth as given in the product tables.

If there is no recess for the thrust washer one of the following methods of fixing may be used:

- Two dowel pins
- Two screws
- Adhesive

Important Note

- Dowel pins should be recessed 0,25 mm below the bearing surface
- Screws should be countersunk 0,25 mm below the bearing surface
- DX® must not be heated above 130 °C
- Contact adhesive manufacturers for guidance on the selection of suitable adhesives
- Protect the bearing surface to prevent contact with adhesive
- Ensure the washer ID does not touch the shaft after assembly
- Ensure that the washer is mounted with the steel backing to the housing

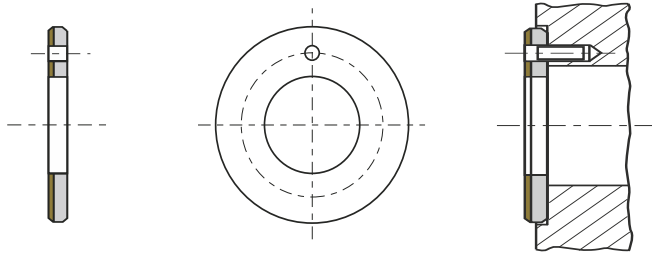


Fig. 30: Installation of thrust-washer

Slideways

DX® strip material for use as slideway bearings should be installed using one of the following methods:

- Countersunk screws
- Adhesives
- Mechanical location

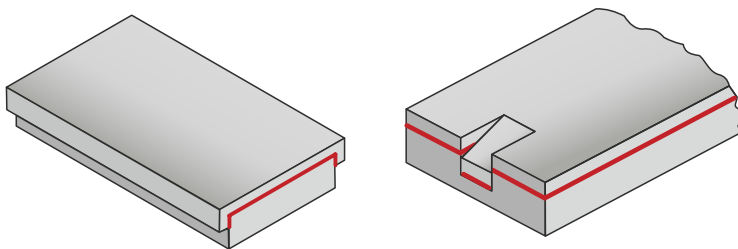


Fig. 31: Mechanical location of DX slideplates

7 Machining

7.1 MACHINING PRACTICE

The acetal copolymer lining of DX® has good machining characteristics and can be treated as a free cutting brass in most respects. The indents in the bearing surface may lead to the formation of burrs or whiskers due to the resilience of the lining material, but this can be avoided by using machining methods which remove the lining as a ribbon, rather than a narrow thread.

When machining DX® it is recommended that not more than 0,125 mm is removed from the lining thickness in order to ensure that the lubricant capacity of the indents remaining after machining is not significantly reduced.

Boring, reaming and broaching are all suitable machining methods for use with DX®. The recommended tool material is high speed steel or tungsten carbide.

7.2 BORING

Figure 32 illustrates a recommended boring tool which should be mounted with its axis at right angles to the direction of feed.

The essential characteristic required in the boring tool is a tip radius greater than 1,5 mm, which combined with a side rake of 30° will produce the ribbon effect required.

Cutting speeds should be high, the optimum between 2,0 and 4,5 m/s. The feed should be low, in the range 0,05/0,025 mm for cuts of 0,125 mm, the lower feeds being used with the higher cutting speeds.

Satisfactory finishes can usually be obtained machining dry and an air blast may facilitate swarf removal. The use of coolant is not detrimental.

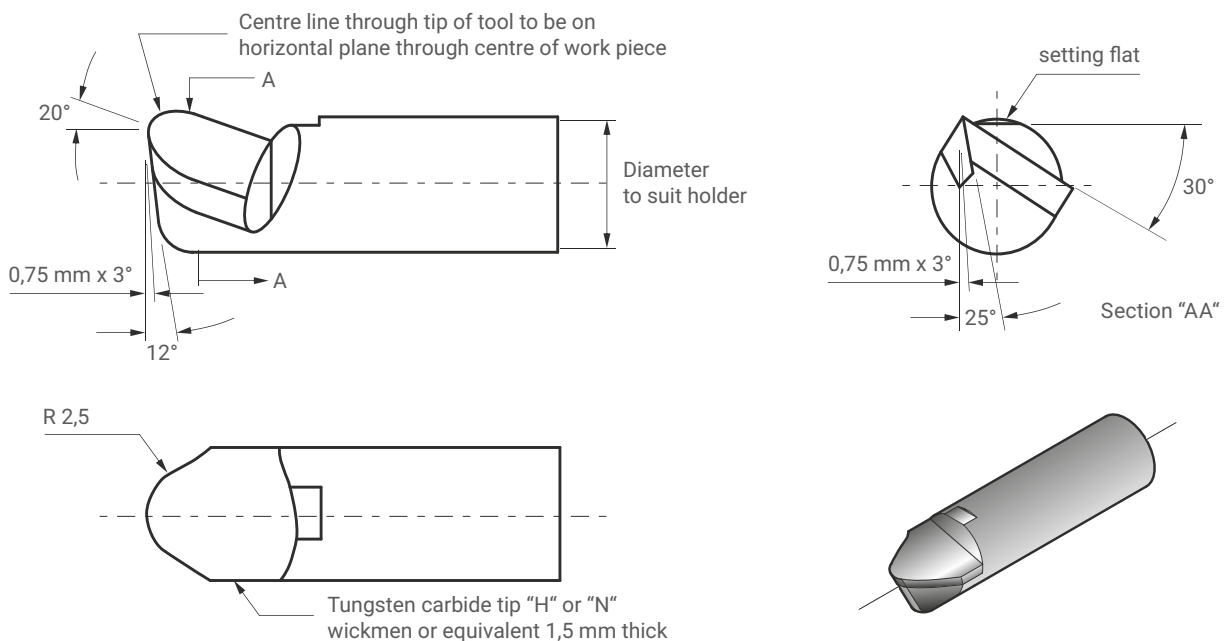


Fig. 32: Boring tool for DX

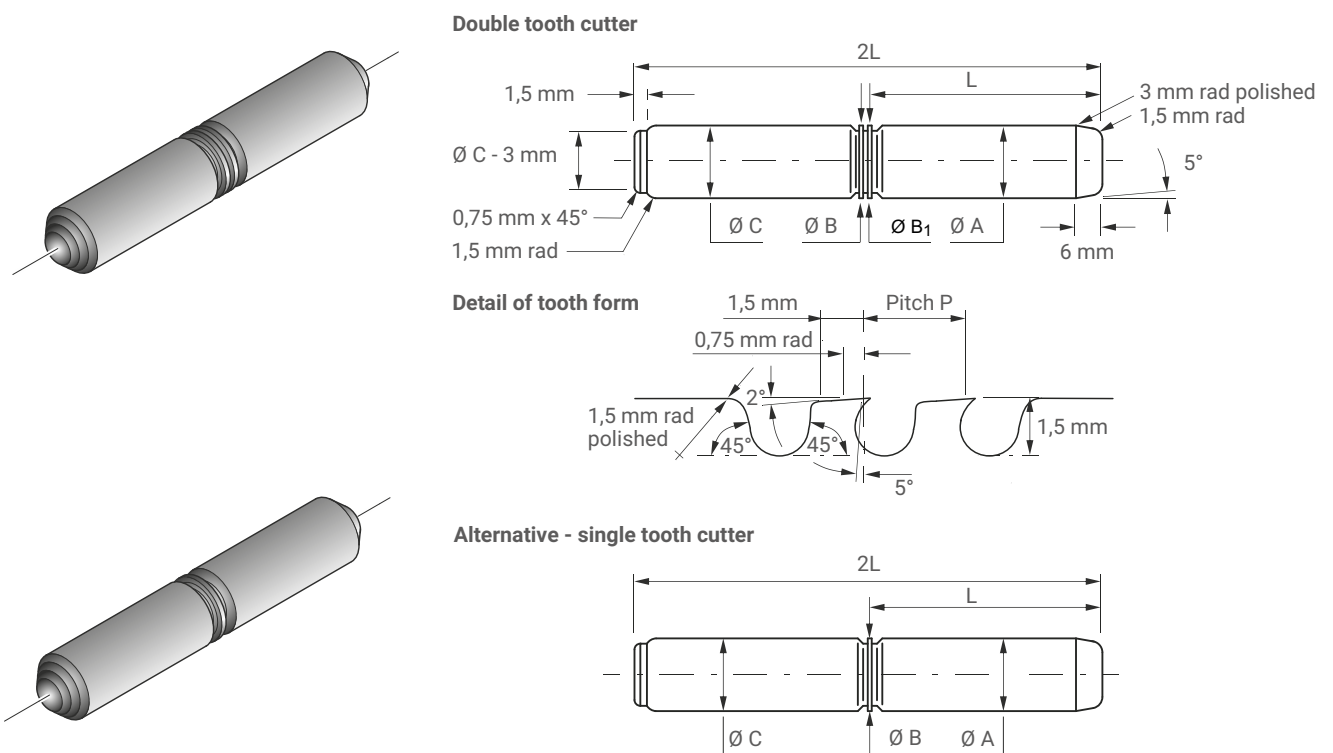
7 Machining

7.3 REAMING

MB DX® bushes can be reamed satisfactorily by hand with a straight-fluted expanding reamer. For best results the reamer should be sharp, the cut 0,025 - 0,050 mm and the feed slow. Where hand reaming is not desired machining speeds of about 0,05 m/s are recommended with the cuts and feeds as for boring.

7.4 BROACHING

Fig. 33 shows broaches suitable for finishing bushes up to 65 mm diameter. The broach should be used dry, at a speed of 0,1 - 0,5 m/s.



BUSH WIDTH B OVER	TO	PITCH P
10	13	3
13	20	4
20	30	5
30	50	5,5
50	70	6
70	95	7
95	130	8

DIAMETER		
Ø A	Min. ass. bore	+0,013 +0
Ø B	Nominal bore	+0,038 +0,025
Ø C	Nominal bore	+0,015 +0,005
Min. ass. bore = $D_{0 \min} - 2 \cdot S_{3 \max}$		
Nominal bore = min. finished bore		
Ø B ₁ *	Nominal bore	-0,065 -0,076

MIN. LENGTH OF PILOT GUIDE	
L_{\min}	
Single bush	B + 6
2 or more bushes in line	B + 6 + bush spacing

Fig. 33: Suitable broaches for DX

* First tooth of double tooth cutter

Use the single tooth version where the bush is less than 25 mm long, and the double tooth broach for longer bushes or for two or more bushes together.

If it is necessary to make up a special form of broach the following points should be noted:

- Adequate provision should be made for locating the bush by providing a pilot to suit the bore of the bush when pressed home. A rear support shoulder should locate in the broached bore of the bush after cutting. Alternatively, special guides may be provided external to the workpiece.

- If two bushes are to be broached in line, then the pilot guide and rear support should be longer than the distance between the two bushes.
- For large bushes it may be necessary to provide axial relief along the length of the pilot guide and rear support, in order to reduce the broaching forces.
- Unless a guided broach is used, the tool will follow the initial bore alignment of the bush, broaching cannot improve concentricity and parallelism unless external guides are used.

In general owing to the variation in wall thickness of large diameter bushes, broaching is not suitable for finishing bores of more than 60 mm diameter unless external guides are used.

7.5 VIBROBROACHING

This technique may also be used. A single cutter is propelled with progressive reciprocating motion with a vibration frequency of typically 50 Hz. The cutter should have a primary rake of 1,5° for 0,5 mm. A cut of 0,25 mm on diameter may be made at an average cutting speed of 0,15 m/s to give a surface finish of better than 0,8 µm R_a, which is acceptable.

7.6 MODIFICATION OF COMPONENTS

The modification of DX[®] bearing components requires no special procedures. In general it is more satisfactory to perform machining or drilling operations from the polymer lining side in order to avoid burrs. When cutting is done from the steel side, the minimum cutting pressure should be used and care taken to ensure that any steel or bronze particles protruding into the remaining bearing material, and all burrs, are removed.

7.7 DRILLING OIL HOLES

Bushes should be adequately supported during the drilling operation to ensure that no distortion is caused by the drilling pressure.

7.8 CUTTING STRIP MATERIAL

DX[®] strip material may be cut to size by any one of the following methods. Care must be taken to protect the bearing surface from damage and to ensure that no deformation of the strip occurs.

- Using side and face cutter, or slitting saw, with the strip held flat and securely on a horizontal milling machine
- Cropping
- Guillotine (For widths less than 90 mm only)
- Water-jet cutting, laser cutting

7 Machining

7.9 ELECTROPLATING

DX® components

To provide corrosion protection the mild steel backing of DX® may be electroplated with most of the conventional electroplating metals including the following:

- zinc ISO 2081-2
- cadmium ISO 2081-2
- nickel ISO 1456-8
- hard chromium ISO 1456-8

For the harder materials if the specified plating thickness exceeds approximately 5µm then the housing diameter should be increased by twice the plating thickness in order to maintain the correct assembled bearing bore size.

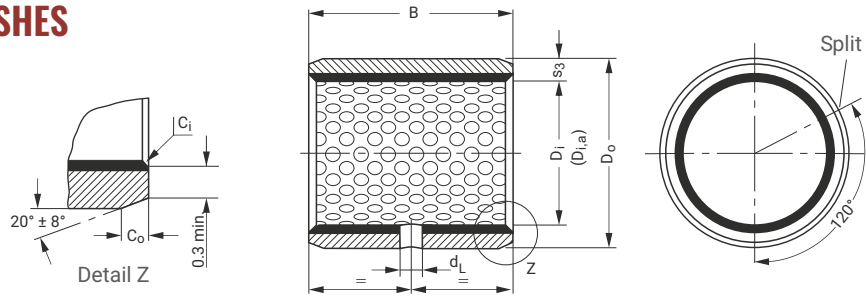
Where electrolytic attack is possible tests should be conducted to ensure that all the materials in the bearing environment are mutually compatible.

Mating surfaces

DX® can be used against hard chrome plated materials and care should be taken to ensure that the recommended shaft sizes and surface finish are achieved after the plating process.

8 Standard Products

8.1 PM DX® CYLINDRICAL BUSHES



Dimensions and Tolerances according to ISO 3547 and GGB-Specifications

Outside C₀ and Inside C_i chamfers

WALL THICKNESS S ₃	C ₀ (a)		C _i (b)
	MACHINED	ROLLED	
0,75	0,5 ± 0,3	0,5 ± 0,3	-0,1 to -0,4
1	0,6 ± 0,4	0,6 ± 0,4	-0,1 to -0,5
1,5	0,6 ± 0,4	0,6 ± 0,4	-0,1 to -0,7

WALL THICKNESS S ₃	C ₀ (a)		C _i (b)
	MACHINED	ROLLED	
2	1,2 ± 0,4	1,0 ± 0,4	-0,1 to -0,7
2,5	1,8 ± 0,6	1,2 ± 0,4	-0,2 to -1,0

(a) = chamfer C₀ machined or rolled at the opinion of the manufacturer

(b) = C_i can be a radius or a chamfer in accordance with ISO 13715

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S ₃ max. min.	WIDTH B max. min.	SHAFT Ø D _J [h8] max. min.	HOUSING Ø D _H [H7] max. min.	BUSH Ø D _{i,a} ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C _D max. min.	OIL HOLE Ø d _L														
	D _i	D _o																					
PM0808DX	8	10	0,980 0,955	8,25	8,000	10,015	8,105	0,127	No hole														
PM0810DX				7,75						7,978	10,000	8,040	0,040										
PM0812DX				10,25						10,000	10,018	10,108	0,130										
PM1010DX	10	12		11,75						9,978	12,000	12,018	10,040	0,040	3								
PM1015DX				15,25											12,000	14,018	12,108	0,135					
PM1020DX				14,75											11,973	14,000	12,040	0,040					
PM1210DX				20,25											12,000	14,018	12,108	12,040	0,135	4			
PM1212DX				19,75																11,75	14,000	12,040	0,040
PM1215DX				15,25																11,973	14,018	12,108	0,135
PM1220DX	14,75	11,973		14,000						12,040	0,040												
PM1415DX	20,25	14,000		16,018						14,108	14,040	0,135	4										
PM1420DX	19,75												13,973	16,000						14,040	0,040		
PM1508DX	8,25		15,000		17,018	15,108	15,040	0,135	3														
PM1510DX	7,75								14,973				17,000	15,040	0,040								
PM1512DX	10,25								15,000				17,018	15,108	15,040	0,135	3						
PM1515DX	9,75																14,973	17,000	15,040	0,040			
PM1520DX	12,25	15,000		17,018						15,108	15,040	0,135					4						
PM1525DX	11,75																14,973	17,000	15,040	0,040			
PM1525DX	15,25		15,000		17,018	15,108	15,040	0,135									4						
PM1525DX	14,75																	14,973	17,000	15,040	0,040		

All dimensions in mm. For stock availability please contact your local sales representative.

8 Standard Products

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S_3 max. min.	WIDTH B max. min.	SHAFT Ø D_j [h8] max. min.	HOUSING Ø D_H [H7] max. min.	BUSH Ø $D_{i,a}$ ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C_D max. min.	OIL HOLE Ø d_l
	D_i	D_o							
PM1615DX	16	18	0,980 0,955	15,25	16,000 15,973	18,018 18,000	16,108 16,040	0,135 0,040	4
PM1620DX				14,75					
PM1625DX				20,25 19,75					
PM1815DX	18	20	0,980 0,955	25,25	18,000 17,973	20,021 20,000	18,111 18,040	0,135 0,040	
PM1820DX				15,25 14,75					
PM1825DX				20,25 19,75					
PM2010DX	20	23	0,980 0,955	25,25	20,000 19,967	23,021 23,000	20,131 20,050	0,135 0,040	
PM2015DX				24,75					
PM2020DX				30,25					
PM2025DX				29,75					
PM2030DX				10,25 9,75					
PM2215DX	22	25	1,475 1,445	15,25	22,000 21,967	25,021 25,000	22,131 22,050	0,164 0,050	
PM2220DX				14,75					
PM2225DX				20,25 19,75					
PM2230DX				25,25 24,75					
PM2415DX	24	27	1,475 1,445	30,25	24,000 23,967	27,021 27,000	24,131 24,050	0,164 0,050	
PM2420DX				29,75					
PM2425DX				15,25 14,75					
PM2430DX				20,25 19,75					
PM2515DX	25	28	1,475 1,445	25,25	25,000 24,967	28,021 28,000	25,131 25,050	0,164 0,050	
PM2520DX				24,75					
PM2525DX				30,25					
PM2530DX				29,75					
PM283130DX	28	31	1,970 1,935	30,25	28,000 27,967	31,025 31,000	28,135 28,050	0,168 0,050	6
PM2820DX		32		29,75					
PM2825DX				20,25 19,75					
PM2830DX	32	34	1,970 1,935	25,25	30,000 29,967	32,025 32,000	28,155 28,060	0,188 0,060	
PM3020DX				24,75					
PM3025DX	30	34	1,970 1,935	30,25	30,000 29,967	34,025 34,000	30,155 30,060	0,188 0,060	
PM3030DX				29,75					
PM3040DX				40,25 39,75					
PM3220DX	32	36	1,970 1,935	20,25	32,000 31,961	36,025 36,000	32,155 32,060	0,194 0,060	
PM3230DX				19,75					
PM3235DX				30,25 29,75					
PM3240DX				35,25 34,75					

All dimensions in mm. For stock availability please contact your local sales representative.

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S_3 max. min.	WIDTH B max. min.	SHAFT Ø D_j [h8] max. min.	HOUSING Ø D_H [H7] max. min.	BUSH Ø $D_{i,a}$ ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C_D max. min.	OIL HOLE Ø d_L	
	D_i	D_o								
PM3520DX	35	39	1,970 1,935	20,25 19,75	35,000 34,961	39,025 39,000	35,155 35,060	0,194 0,060	6	
PM3530DX				30,25 29,75						
PM3535DX				35,25 34,75						
PM3540DX				40,25 39,75						
PM3550DX				50,25 49,75						
PM3635DX	36	40	1,970 1,935	35,25 34,75	36,000 35,961	40,025 40,000	36,155 36,060	0,194 0,060	6	
PM3720DX	37	41		20,25 19,75	37,000 36,961	41,025 41,000				37,155 37,060
PM4020DX	40	44		1,970 1,935	20,25 19,75	40,000 39,961				44,025 44,000
PM4030DX			30,25 29,75							
PM4040DX			40,25 39,75							
PM4050DX			50,25 49,75							
PM4520DX	45	50	2,460 2,415	20,25 19,75	45,000 44,961	50,025 50,000	45,195 45,080	0,234 0,080	8	
PM4525DX				25,25 24,75						
PM4530DX				30,25 29,75						
PM4540DX				40,25 39,75						
PM4545DX				45,25 44,75						
PM4550DX				50,25 49,75						
PM5030DX	50	55	2,460 2,415	30,25 29,75	50,000 49,961	55,030 55,000	50,200 50,080	0,239 0,080	8	
PM5040DX				40,25 39,75						
PM5045DX				45,25 44,75						
PM5050DX				50,25 49,75						
PM5060DX	55	60	2,460 2,415	60,25 59,75	55,000 54,954	60,030 60,000	55,200 55,080	0,246 0,080	8	
PM5520DX				20,25 19,75						
PM5525DX				25,25 24,75						
PM5530DX				30,25 29,75						
PM5540DX				40,25 39,75						
PM5550DX	50,25 49,75									
PM5560DX	60,25 59,75									
PM6030DX	60	65	2,460 2,415	30,25 29,75	60,000 59,954	65,030 65,000	60,200 60,080	0,246 0,080	8	
PM6040DX				40,25 39,75						
PM6050DX				50,25 49,75						
PM6060DX				60,25 59,75						
PM6070DX				70,25 69,75						

All dimensions in mm. For stock availability please contact your local sales representative.

8 Standard Products

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S_3 max. min.	WIDTH B max. min.	SHAFT Ø D_j [h8] max. min.	HOUSING Ø D_H [H7] max. min.	BUSH Ø $D_{i,a}$ ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C_D max. min.	OIL HOLE Ø d_l
	D_i	D_o							
PM6530DX	65	70	2,450 2,384	30,25	65,000 64,954	70,030 70,000	65,262 65,100	0,308 0,100	8
PM6540DX				29,75					
PM6550DX				40,25					
PM6560DX				39,75					
PM6570DX				50,25					
PM7030DX	49,75	70,000 69,954		30,25	75,030 75,000	70,262 70,100			
PM7040DX	29,75								
PM7045DX	40,25								
PM7050DX	39,75								
PM7060DX	45,25								
PM7065DX	44,75	75,000 74,954		50,25	80,030 80,000	75,262 75,100			
PM7070DX	49,75								
PM7080DX	60,25								
PM7540DX	59,75								
PM7560DX	70,25			80,000 79,954			40,25		
PM7580DX	39,75								
PM8040DX	60,25								
PM8050DX	59,75								
PM8060DX	80,25	85,000 84,946	40,50		90,035 90,000	85,267 85,100			
PM8080DX	39,50								
PM80100DX	49,50								
PM8530DX	60,50								
PM8540DX	59,50		90,000 89,946	30,50			95,035 95,000	90,267 90,100	
PM8560DX	29,50								
PM8580DX	40,50								
PM85100DX	39,50								
PM9040DX	60,50	95,000 94,946		40,50	100,035 100,000	95,267 95,100			
PM9060DX	39,50								
PM9080DX	80,50								
PM9090DX	79,50								
PM90100DX	90,50								
PM9560DX	89,50	95,000 94,946	100,50	95,267 95,100	95,267 95,100				
PM95100DX	99,50								

All dimensions in mm. For stock availability please contact your local sales representative.

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S_3 max. min.	WIDTH B max. min.	SHAFT Ø D_j [h8] max. min.	HOUSING Ø D_H [H7] max. min.	BUSH Ø $D_{i,a}$ ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C_D max. min.	OIL HOLE Ø d_L
	D_i	D_o							
PM10040DX	100	105		40,50	100,000	105,035	100,267		
PM10050DX				59,50					
PM10060DX				50,50					
PM10080DX				49,50					
PM10095DX				60,50					
PM10095DX				59,50					
PM10095DX				80,50					
PM10095DX	79,50								
PM10095DX	95,50								
PM10095DX	94,50								
PM100115DX	105	110	2,450 2,384	115,50	105,000	110,035	105,267	0,321 0,100	
PM10560DX				114,50					
PM10560DX				60,50					
PM10565DX				59,50					
PM105110DX				65,50					
PM105110DX				64,50					
PM105115DX				110,50					
PM105115DX	109,50								
PM105115DX	115,50								
PM105115DX	114,50								
PM11050DX	110	115		50,50	110,267	115,035	110,267		9,5
PM11060DX				49,50					
PM11060DX				60,50					
PM110100DX				59,50					
PM110100DX				100,50					
PM110100DX				99,50					
PM110110DX				110,50					
PM110110DX	109,50								
PM110115DX	115,50								
PM110115DX	114,50								
PM11550DX	115	120		50,50	115,000	120,035	115,267		
PM11550DX				49,50					
PM11570DX				70,50					
PM11570DX	69,95								
PM12060DX	120	125		60,50	120,000	125,040	120,280	0,334 0,130	
PM120100DX				59,50					
PM120100DX				100,50					
PM120100DX	99,50								
PM120110DX	110,50								
PM120110DX	109,50								
PM12560DX	125	130		60,50	125,000	130,040	125,280		
PM125100DX				59,50					
PM125100DX				100,50					
PM125100DX	99,50								
PM125110DX	110,50								
PM125110DX	109,50								
PM13050DX	130	135	2,435 2,380	50,50	130,000	135,040	130,280	0,343 0,130	
PM13060DX				49,50					
PM13060DX				60,50					
PM13060DX				59,50					
PM13080DX	80,50								
PM13080DX	79,50								
PM130100DX	100,50								
PM130100DX	99,50								
PM13560DX	135	140		60,50	135,000	140,040	135,280		No hole
PM13560DX				59,50					
PM13580DX				80,50					
PM13580DX	79,50								
PM14050DX	140	145		50,50	140,000	145,040	140,280		
PM14050DX				49,50					
PM14060DX				60,50					
PM14060DX				59,50					
PM14080DX				80,50					
PM14080DX	79,50								
PM140100DX	100,50								
PM140100DX	99,50								

All dimensions in mm. For stock availability please contact your local sales representative.

8 Standard Products

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S_3 max. min.	WIDTH B max. min.	SHAFT Ø D_j [h8] max. min.	HOUSING Ø D_H [H7] max. min.	BUSH Ø $D_{i,a}$ ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C_D max. min.	OIL HOLE Ø d_L
	D_i	D_o							
PM15050DX	150	155	2.435 2.380	50,50	150,000	155,040	150,280	0,343 0,130	No hole
PM15060DX				49,50					
PM15080DX				60,50					
				59,50					
PM150100DX				80,50					
	79,50								
	100,50								
	99,50								
PM16050DX	160	165		50,50	160,000	165,040	160,280		
PM16060DX				49,50					
PM16080DX				60,50					
				59,50					
PM160100DX				80,50					
	79,50								
	100,50								
	99,50								
PM17050DX	170	175		50,50	170,000	175,040	170,280		
PM17060DX				49,50					
PM17080DX				60,50					
				59,50					
PM170100DX			80,50						
	79,50								
	100,50								
	99,50								
PM18050DX	180	185	50,50	180,000	185,046	180,286			
PM18060DX			49,50						
PM18080DX			60,50						
			59,50						
PM180100DX			80,50						
	79,50								
	100,50								
	99,50								
PM19050DX	190	195	50,50	190,000	195,046	190,286			
PM19060DX			49,50						
PM19080DX			60,50						
PM190100DX			59,50						
			80,50						
	79,50								
	100,50								
	99,50								
PM190120DX			120,50						
			119,50						
PM20050DX	200	205	50,50	200,000	205,046	200,286			
PM20060DX			49,50						
PM20080DX			60,50						
PM200100DX			59,50						
			80,50						
	79,50								
	100,50								
	99,50								
PM200120DX			120,50						
			119,50						
PM22050DX	220	225	50,50	220,000	225,046	220,286			
PM22060DX			49,50						
PM22080DX			60,50						
PM220100DX			59,50						
			80,50						
	79,50								
	100,50								
	99,50								
PM220120DX			120,50						
			119,50						
PM24050DX	240	245	50,50	240,000	245,046	240,286			
PM24060DX			49,50						
PM24080DX			60,50						
PM240100DX			59,50						
			80,50						
	79,50								
	100,50								
	99,50								
PM240120DX			120,50						
			119,50						

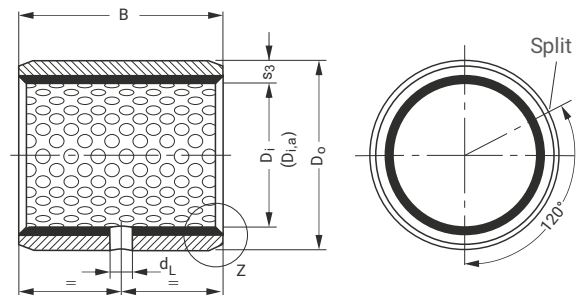
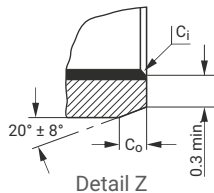
All dimensions in mm. For stock availability please contact your local sales representative.

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S_3 max. min.	WIDTH B max. min.	SHAFT \emptyset D_j [h8] max. min.	HOUSING \emptyset D_H [H7] max. min.	BUSH \emptyset $D_{i,a}$ ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C_D max. min.	OIL HOLE \emptyset d_l
	D_i	D_o							
PM25050DX	250	255	2,435 2,380	50,50	250,000 249,928	255,052 255,000	250,292 250,130	0,364 0,130	No hole
PM25060DX				49,50					
PM25080DX				60,50					
PM250100DX				59,50					
PM250120DX				80,50					
PM26050DX	260	265		100,50	260,000 259,919	265,052 265,000	260,292 260,130	0,373 0,130	
PM26060DX				99,50					
PM26080DX				120,50					
PM260100DX				119,50					
PM260120DX				50,50					
PM28050DX	280	285		49,50	280,000 279,919	285,052 285,000	280,292 280,130	0,373 0,130	
PM28060DX				60,50					
PM28080DX				59,50					
PM280100DX				80,50					
PM280120DX				79,50					
PM30050DX	300	305	100,50	300,000 299,919	305,052 305,000	300,292 300,130	0,373 0,130		
PM30060DX			99,50						
PM30080DX			120,50						
PM300100DX			119,50						
PM300120DX			50,50						

All dimensions in mm. For stock availability please contact your local sales representative.

8 Standard Products

8.2 MB DX® CYLINDRICAL BUSHES



Dimensions and Tolerances according to ISO 3547 and GGB-Specifications

Outside C₀ and Inside C₁ chamfers

WALL THICKNESS S ₃	C ₀ (a)		C ₁ (b)
	MACHINED	ROLLED	
0,75	0,5 ± 0,3	0,5 ± 0,3	-0,1 to -0,4
1	0,6 ± 0,4	0,6 ± 0,4	-0,1 to -0,5
1,5	0,6 ± 0,4	0,6 ± 0,4	-0,1 to -0,7

WALL THICKNESS S ₃	C ₀ (a)		C ₁ (b)
	MACHINED	ROLLED	
2	1,2 ± 0,4	1,0 ± 0,4	-0,1 to -0,7
2,5	1,8 ± 0,6	1,2 ± 0,4	-0,2 to -1,0

(a) = chamfer C₀ machined or rolled at the opinion of the manufacturer

(b) = C₁ can be a radius or a chamfer in accordance with ISO 13715

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S ₃ max. min.	WIDTH B max. min.	SHAFT Ø D _{Jm} [d8] max. min.	HOUSING Ø D _H [H7] max. min.	BUSH Ø D _{i,a,m} ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C _D max. min.	OIL HOLE Ø d _L
	D _i	D _o							
MB0808DX	8	10	1,108 1,082	8,25	7,960 7,938	10,015 10,000	8,015 8,000	0,077 0,040	No hole
MB0810DX				10,25					
MB0812DX				12,25					
MB1010DX	10	12		11,75	9,960 9,938	12,018 12,000	10,018 10,000	0,080 0,040	3
MB1012DX				12,25					
MB1015DX				14,75					
MB1020DX				19,75					
MB1210DX	12	14		10,25	11,950 11,923	14,018 14,000	12,018 12,000	0,095 0,050	3
MB1215DX				14,75					
MB1220DX				19,75					
MB1420DX	14	16		20,25	13,950 13,923	16,018 16,000	14,018 14,000	0,095 0,050	4
MB1425DX				24,75					
MB1510DX	15	17	10,25	14,950 14,923	17,018 17,000	15,018 15,000	0,095 0,050	3	
MB1512DX			12,25						
MB1515DX			14,75						
MB1525DX			24,75						

All dimensions in mm. For stock availability please contact your local sales representative.

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S_3 max. min.	WIDTH B max. min.	SHAFT Ø D_{jm} [d8] max. min.	HOUSING Ø D_H [H7] max. min.	BUSH Ø $D_{i.a.m}$ ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C_D max. min.	OIL HOLE Ø d_l					
	D_i	D_o												
MB1615DX	16	18	1,108 1,082	15,25	15,950 15,923	18,018 18,000	16,018 16,000	0,095 0,050	4					
MB1625DX				14,75										
MB1815DX	18	20		25,25						17,950 17,923	20,021 20,000	18,018 18,000		
MB1825DX				15,25										
MB2010DX	20	23		10,25						19,935 19,902	23,021 23,000	20,021 20,000		
MB2015DX				9,75										
MB2020DX			15,25											
MB2025DX			14,75											
MB2030DX			20,25											
MB2035DX			19,75											
MB2215DX	22	25	1,608 1,576	15,25	21,935 21,902	25,021 25,000	22,021 22,000	0,119 0,065						
MB2220DX				14,75										
MB2225DX				20,25										
MB2230DX				19,75										
MB2415DX				24						27	25,25	23,935 23,902	27,021 27,000	24,021 24,000
MB2420DX											24,75			
MB2425DX	30,25													
MB2430DX	29,75													
MB2515DX	25	28	15,25		24,935 24,902	28,021 28,000	25,021 25,000							
MB2520DX			14,75											
MB2525DX			20,25											
MB2530DX			19,75											
MB2820DX			28	32				2,108 2,072		25,25	27,935 27,902	32,025 32,000	28,021 28,000	
MB2825DX										24,75				
MB2830DX	30,25													
MB3020DX	29,75													
MB3030DX	30	34			20,25	29,935 29,902	34,025 34,000		30,021 30,000					
MB3040DX					19,75									
MB3045DX			30,25											
MB3050DX			29,75											

All dimensions in mm. For stock availability please contact your local sales representative.

8 Standard Products

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S_3 max. min.	WIDTH B max. min.	SHAFT Ø D_{jm} [d8] max. min.	HOUSING Ø D_H [H7] max. min.	BUSH Ø $D_{i,a,m}$ ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C_D max. min.	OIL HOLE Ø d_l
	D_i	D_o							
MB3220DX	32	36	2,108 2,072	20,25	31,920 31,881	36,025 36,000	32,025 32,000	0,144 0,080	6
MB3230DX				19,75					
MB3235DX				30,25					
MB3240DX				29,75					
MB3520DX	35	39		35,25	34,920 34,881	39,025 39,000	35,025 35,000		
MB3530DX				34,75					
MB3550DX				40,25					
MB3720DX	37	41		39,75	36,920 36,881	41,025 41,000	37,025 37,000		
MB4020DX	40	44		20,25	39,920 39,881	44,025 44,000	40,025 40,000		
MB4030DX				19,75					
MB4040DX				30,25					
MB4050DX				29,75					
MB4520DX	45	50	40,25	44,920 44,881	50,025 50,000	45,025 45,000			
MB4530DX			19,75						
MB4540DX			30,25						
MB4545DX			29,75						
MB4550DX			40,25						
MB5040DX	50	55	39,75	49,920 49,881	55,030 55,000	50,025 50,000			
MB5060DX			60,25						
MB5520DX	55	60	59,75	54,900 54,854	60,030 60,000	55,030 55,000			
MB5525DX			20,25						
MB5530DX			19,75						
MB5540DX			25,25						
MB5550DX			24,75						
MB5560DX			30,25						
MB6030DX	60	65	29,75	59,900 59,854	65,030 65,000	60,030 60,000			
MB6040DX			40,25						
MB6060DX			39,75						
MB6070DX			60,25						
			59,75						

All dimensions in mm. For stock availability please contact your local sales representative.

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S_3 max. min.	WIDTH B max. min.	SHAFT Ø D_{jm} [d8] max. min.	HOUSING Ø D_H [H7] max. min.	BUSH Ø $D_{i,a,m}$ ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C_D max. min.	OIL HOLE Ø d_l
	D_i	D_o							
MB6540DX	65	70	2,634 2,568	40,25	64,900 64,854	70,030 70,000	65,030 65,000	0,176 0,100	8
MB6550DX				39,75					
MB6560DX				50,25					
MB6570DX				49,75					
MB7040DX				60,25					
MB7050DX	59,75								
MB7065DX	70	75		70,25	69,900 69,854	75,030 75,000	70,030 70,000		
MB7070DX	69,75								
MB7080DX	40,25								
MB7540DX	39,75								
MB7560DX	60,25								
MB7580DX	59,75								
MB8040DX	75	80		80,25	74,900 74,854	80,030 80,000	75,030 75,000		
MB8060DX	79,75								
MB8080DX	40,25								
MB80100DX	39,75								
MB8530DX	60,25								
MB8540DX	59,75								
MB8560DX	80	85		80,50	79,900 79,854	85,035 85,000	80,030 80,000		
MB8580DX	79,50								
MB85100DX	40,50								
MB9040DX	39,50								
MB9060DX	60,50								
MB9090DX	59,50								
MB90100DX	85	90	80,50	84,880 84,826	90,035 90,000	85,035 85,000			
MB9560DX	79,50								
MB95100DX	100,50								
MB10050DX	99,50								
MB10060DX	40,50								
MB10080DX	39,50								
MB10095DX	60,50								
MB100115DX	59,50								
	90	95	90,50	89,880 89,826	95,035 95,000	90,035 90,000			
	89,50								
	100,50								
	99,50								
	60,50								
	59,50								
	95	100	100,50	94,880 94,826	100,035 100,000	95,035 95,000			
	99,50								
	50,50								
	49,50								
	60,50								
	59,50								
	100	105	80,50	99,880 99,826	105,035 105,000	100,035 100,000			
	79,50								
	95,50								
	94,50								
	115,50								
	114,50								

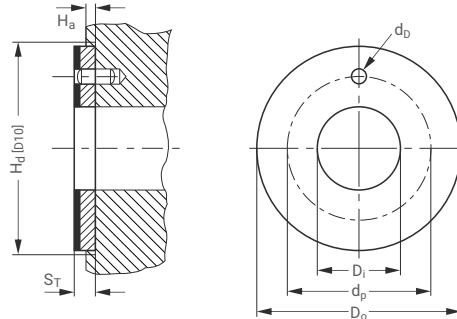
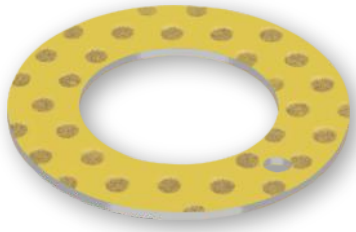
All dimensions in mm. For stock availability please contact your local sales representative.

8 Standard Products

PART NO.	NOMINAL DIAMETER		WALL THICKNESS S_3 max. min.	WIDTH B max. min.	SHAFT Ø D_{jm} [d8] max. min.	HOUSING Ø D_H [H7] max. min.	BUSH Ø $D_{i,a,m}$ ASSEMBLY IN H7 HOUSING max. min.	CLEARANCE C_D max. min.	OIL HOLE Ø d_l	
	D_i	D_o								
MB10560DX	105	110	2,634 2,568	60,50	104,880 104,826	110,035 110,000	105,035 105,000	0,209 0,120	9,5	
MB105110DX				59,50						
MB105115DX				110,50						
MB11060DX	109,50									
MB110115DX	115,50									
MB11550DX	114,50									
MB11570DX	110	115	60,50	109,880	115,035	110,035	0,248 0,145	No hole		
MB12060DX	120	125	59,50	119,880 119,826	125,040 125,000	120,035 120,000				
MB120100DX			100,50							
MB125100DX			99,50							
MB13050DX	130	135	100,50	124,855	130,040	125,040			0,248 0,145	No hole
MB13060DX			99,50	129,855 129,792	135,040 135,000	130,040 130,000				
MB130100DX			50,50							
MB13560DX	49,50									
MB13580DX	135	140	60,50	134,855	140,040	135,040	0,248 0,145	No hole		
MB14060DX			59,50	139,855 139,792	145,040 145,000	140,040 140,000				
MB140100DX			80,50							
MB15060DX	79,50									
MB15080DX	140	145	60,50	149,855 149,792	155,040 155,000	150,040 150,000			0,248 0,145	No hole
MB150100DX			59,50							
MB15080DX			80,50							
MB150100DX	150	155	79,50	149,855 149,792	155,040 155,000	150,040 150,000				
MB15080DX			100,50							
MB150100DX			99,50							

All dimensions in mm. For stock availability please contact your local sales representative.

8.3 DX® THRUST WASHERS

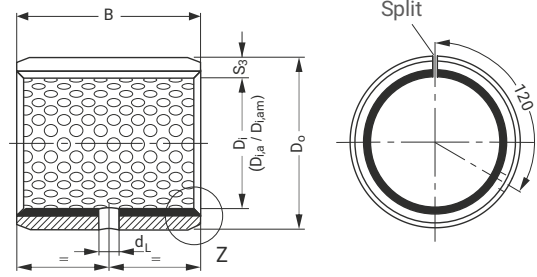
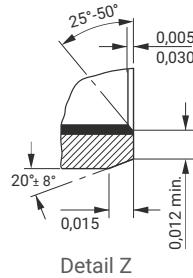


PART NO.	INSIDE DIAMETER D _i max. min.	OUTSIDE DIAMETER D _o max. min.	THICKNESS S _T max. min.	DOWEL HOLE		RECESS DEPTH H _a max. min.	
				Ø d _D max. min.	PCD Ø d _P max. min.		
WC08DX	10,25 10,00	20,00 19,75	1,58 1,49	No hole	No hole	1,20 0,95	
WC10DX	12,25 12,00	24,00 23,75		1,875 1,625	20,12 19,88		18,12 17,88
WC14DX	16,25 16,00	30,00 29,75		25,12 24,88	28,12 27,88		
							WC16DX
WC18DX	20,25 20,00	36,00 35,75		33,12 32,88	35,12 34,88		
							WC20DX
WC22DX	24,25 24,00	42,00 41,75		49,88	50,12 49,88		
							WC24DX
WC25DX	28,25 28,00	48,00 47,75		54,12 53,88	65,12 64,88		
							WC30DX
WC35DX	38,25 38,00	62,00 61,75		61,12 60,88	65,12 64,88		
							WC40DX
WC45DX	48,25 48,00	74,00 73,75		65,12 64,88	76,12 75,88		
			WC50DX			52,25 52,00	78,00 77,75
WC60DX	62,25 62,00	90,00 89,75					

All dimensions in mm. For stock availability please contact your local sales representative.

8 Standard Products

8.4 DX® CYLINDRICAL BUSHES - INCH SIZES



Detail Z

PART NO.	NOMINAL DIAMETER		HOUSING Ø D _H [BS 1916 H7]	WALL THICKNESS S ₃	AS SUPPLIED				MACHINED IN SITU			OIL HOLE Ø d _L	
	D _i	D _o			max. min.	max. min.	WIDTH B	SHAFT Ø D _J	BUSH Ø D _{i,a} ASS. IN AN H7 HOUSING	CLEARANCE C _D	SHAFT Ø D _{Jm} [BS 1916 d8]		BUSH Ø D _{i,am} [BS 1916 H7]
06DX06						0,385 0,365							No hole
06DX08	3/8	15/32	0,4694 0,4687			0,510 0,490	0,3648 0,3639	0,3694 0,3667	0,0055 0,0019	0,3734 0,3725	0,3756 0,3750	0,0031 0,0016	
06DX12						0,760 0,740							
07DX08		7/16	0,5319 0,5312			0,510 0,490	0,4273 0,4263	0,4319 0,4292	0,0056 0,0019	0,4355 0,4345	0,4382 0,4375		
07DX12						0,760 0,740							
08DX06						0,385 0,365							
08DX08		1/2	0,5944 0,5937			0,510 0,490	0,4897 0,4887	0,4944 0,4917		0,4980 0,4970	0,5007 0,5000		
08DX10		19/32		0,0510 0,0500		0,635 0,615			0,0057 0,0020				
08DX14						0,885 0,865							
09DX08		9/16	0,6569 0,6562			0,510 0,490	0,5522 0,5512	0,5569 0,5542		0,5605 0,5595	0,5632 0,5625	0,0037 0,0020	5/32
09DX12						0,760 0,740							
10DX08						0,510 0,490							
10DX10		5/8	0,7195 0,7187			0,635 0,615	0,6146 0,6136	0,6195 0,6167	0,0059 0,0021	0,6230 0,6220	0,6257 0,6250		
10DX12		23/32				0,760 0,740							
10DX14						0,885 0,865							
11DX14	11/16	25/32	0,7820 0,7812			0,885 0,865	0,6770 0,6760	0,6820 0,6792	0,0060 0,0022	0,6855 0,6845	0,6882 0,6875		
12DX08						0,510 0,490							
12DX12	3/4	7/8	0,8758 0,8750	0,0669 0,0657		0,760 0,740	0,7390 0,7378	0,7444 0,7412	0,0066 0,0022	0,7475 0,7463	0,7508 0,7500	0,0045 0,0025	
12DX16						1,010 0,990							

All dimensions in inch. For stock availability please contact your local sales representative.

PART NO.	NOMINAL DIAMETER		HOUSING Ø D _H [BS 1916 H7]	WALL THICKNESS S ₃	AS SUPPLIED				MACHINED IN SITU			OIL HOLE Ø d _L			
					WIDTH B	SHAFT Ø D _J	BUSH Ø D _{i,a} ASS. IN AN H7 HOUSING	CLEARANCE C _D	SHAFT Ø D _{Jm} [BS 1916 d8]	BUSH Ø D _{i,am} [BS 1916 H7]	CLEAR- ANCE C _{Dm}				
													max. min.	max. min.	max. min.
14DX12	7/8	1	1,0008 1,0000	0,0669 0,0657	0,760 0,740	0,8639 0,8627	0,8694 0,8662	0,0067 0,0023	0,8725 0,8713	0,8758 0,8750	0,0045 0,0025	1/4			
14DX14					0,885 0,865										
14DX16					1,010 0,990										
16DX12	1	1 1/8	1,1258 1,1250	0,0669 0,0657	0,760 0,740	0,9888 0,9876	0,9944 0,9912	0,0068 0,0024	0,9975 0,9963	1,0008 1,0000	0,0045 0,0025		1/4		
16DX16					1,010 0,990										
16DX24					1,510 1,490										
18DX12	1 1/8	19/32	1,2822 1,2812	0,0669 0,0657	0,760 0,740	1,1138 1,1126	1,1202 1,1164	0,0076 0,0026	1,1225 1,1213	1,1258 1,2500	0,0045 0,0025			1/4	
18DX16					1,010 0,990										
20DX12	1 1/4	1 13/32	1,4072 1,4062	0,0669 0,0657	0,760 0,740	1,2387 1,2371	1,2452 1,2414	0,0081 0,0027	1,2470 1,2454	1,2510 1,2500	0,0045 0,0025				1/4
20DX16					1,010 0,990										
20DX20					1,260 1,240										
20DX28					1,760 1,740										
22DX16	1 3/8	1 17/32	1,5322 1,5312	0,0824 0,0810	1,010 0,990	1,3635 1,3619	1,3702 1,3664	0,0083 0,0029	1,3720 1,3704	1,3760 1,3750	0,0045 0,0025	1/4			
22DX22					1,385 0,365										
22DX28					1,760 1,740										
24DX16	1 1/2	1 21/32	1,6572 1,6562	0,0669 0,0657	1,010 0,990	1,4884 1,4868	1,4952 1,4914	0,0084 0,0030	1,4970 1,4954	1,5010 1,5000	0,0056 0,0030		5/16		
24DX20					1,260 1,240										
24DX24					1,510 1,490										
24DX32					2,010 1,990										
26DX16	1 5/8	1 25/32	1,7822 1,7812	0,0669 0,0657	1,010 0,990	1,6133 1,6117	1,6202 1,6164	0,0085 0,0031	1,6220 1,6204	1,6260 1,6250	0,0045 0,0025			5/16	
26DX24					1,510 1,490										
28DX16	1 3/4	1 15/16	1,9385 1,9375	0,0669 0,0657	1,010 0,990	1,7383 1,7367	1,7461 1,7415	0,0094 0,0032	1,7470 1,7454	1,7510 1,7500	0,0045 0,0025				5/16
28DX24					1,510 1,490										
28DX28					1,760 1,740										
28DX32					2,010 1,990										
30DX16	1 7/8	2 1/16	2,0637 2,0625	0,0980 0,0962	1,510 1,490	1,8632 1,8616	1,8713 1,8665	0,0097 0,0033	1,8720 1,8704	1,8760 1,8750	0,0045 0,0025	5/16			
30DX30					1,885 1,865										
30DX36					2,260 2,240										
32DX16	2	2 3/16	2,1887 2,1875	0,0669 0,0657	1,010 0,990	1,9881 1,9863	1,9963 1,9915	0,0100 0,0034	1,9960 1,9942	2,0012 2,0000	0,0070 0,0040		5/16		
32DX24					1,510 1,490										
32DX32					2,010 1,990										
32DX40					2,510 2,490										

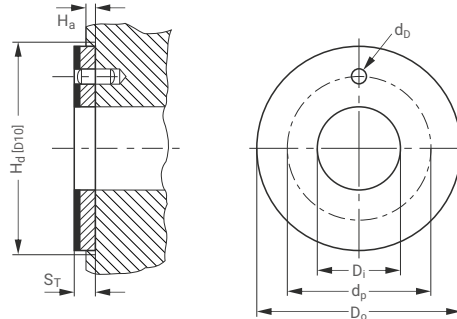
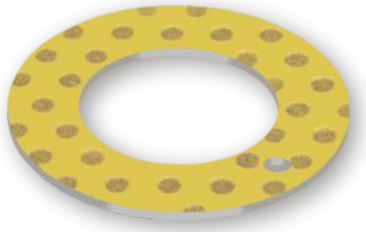
All dimensions in inch. For stock availability please contact your local sales representative.

8 Standard Products

PART NO.	NOMINAL DIAMETER		HOUSING Ø D _H [BS 1916 H7]	WALL THICKNESS S ₃	AS SUPPLIED				MACHINED IN SITU			OIL HOLE Ø d _L						
					WIDTH B	SHAFT Ø D _J	BUSH Ø D _{i,a} ASS. IN AN H7 HOUSING	CLEARANCE C _D	SHAFT Ø D _{Jm} [BS 1916 d8]	BUSH Ø D _{i,am} [BS 1916 H7]	CLEAR- ANCE C _{Dm}							
													max. min.	max. min.	max. min.	max. min.	max. min.	max. min.
36DX32	2 ¹ / ₄	2 ⁷ / ₁₆	2,4387 2,4375	0,0980 0,0962	2,010	2,2378 2,2360	2,2463 2,2415	0,0103 0,0037	2,2460 2,2442	2,2512 2,2500	0,0070 0,0040	5 ⁵ / ₁₆						
36DX36					2,260													
36DX40					2,510													
40DX32	2 ¹ / ₂	2 ¹¹ / ₁₆	2,6887 2,6875	0,0991 0,0965	2,010	2,4875 2,4857	2,4963 2,4915	0,0106 0,0040	2,4960 2,4942	2,5012 2,5000			0,0086 0,0050	3 ³ / ₈				
40DX40					1,990													
44DX32					2,510													
44DX40	2 ³ / ₄	2 ¹⁵ / ₁₆	2,9387 2,9375	0,0991 0,0965	2,490	2,7351 2,7333	2,7457 2,7393	0,0124 0,0042	2,7460 2,7442	2,7512 2,7500					0,0086 0,0050	3 ³ / ₈		
44DX48					3,010													
44DX56					2,990													
48DX32	3	3 ³ / ₁₆	3,1889 3,1875	0,0991 0,0965	2,010	2,9849 2,9831	2,9959 2,9893	0,0128 0,0044	2,9960 2,9942	3,0012 3,0000							0,0086 0,0050	3 ³ / ₈
48DX48					1,990													
48DX60					3,010													
56DX40	3 ¹ / ₂	3 ¹¹ / ₁₆	3,6889 3,6875	0,0991 0,0965	2,510	3,4844 3,4822	3,4959 3,4893	0,0137 0,0049	3,4950 3,4928	3,5014 3,5000	0,0086 0,0050	3 ³ / ₈						
56DX48					2,490													
56DX60					3,010													
64DX48	4	4 ³ / ₁₆	4,1889 4,1875	0,0991 0,0965	2,990	3,9839 3,9817	3,9959 3,9893	0,0142 0,0054	3,9950 3,9928	4,0014 4,0000			0,0086 0,0050	3 ³ / ₈				
64DX60					3,760													
64DX76					3,740													

All dimensions in inch. For stock availability please contact your local sales representative.

8.5 DX® THRUST WASHERS - INCH SIZES

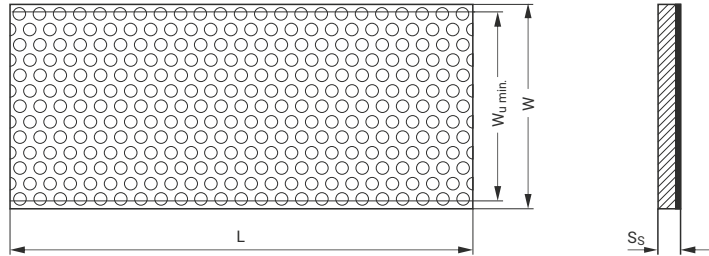
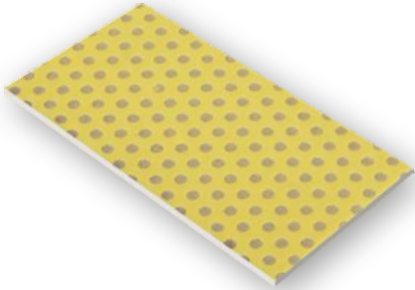


PART NO.	INSIDE DIAMETER D _i max. min.	OUTSIDE DIAMETER D _o max. min.	THICKNESS S _T max. min.	DOWEL HOLE		RECESS DEPTH H _a max. min.	
				Ø d _D max. min.	PCD Ø d _P max. min.		
DX06	0,5100 0,5000	0,8750 0,8650	0,0660 0,0625	0,0770 0,0670	0,6920	0,050 0,040	
DX07	0,5720 0,5620	1,0000 0,9900			0,7860 0,7760		
DX08	0,6350 0,6250	1,1250 1,1150		0,1090 0,0990	0,8800 0,8700		
DX09	0,6970 0,6870	1,1870 1,1770			0,9420 0,9320		
DX10	0,7600 0,7500	1,2500 1,2400		0,1400 0,1300	1,0050 0,9950		
DX11	0,8220 0,8120	1,3750 1,3650			1,0990 1,0890		
DX12	0,8850 0,8750	1,5000 1,4900		0,1710 0,1610	1,1920 1,1820		
DX14	1,0100 1,0000	1,7500 1,7400			1,3800 1,3700		
DX16	1,1350 1,1250	2,0000 1,9900		0,2020 0,1920	1,5670 1,5570		
DX18	1,2600 1,2500	2,1250 2,1150			1,6920 1,6820		
DX20	1,3850 1,3750	2,2500 2,2400		0,0970 0,0935	1,8170 1,8070		0,080 0,070
DX22	1,5100 1,5000	2,5000 2,4900			2,0050 1,9950		
DX24	1,6350 1,6250	2,6250 2,6150	2,2550 2,2450	2,1300 2,1200			
DX26	1,7600 1,7500	2,7500 2,7400		2,5050 2,4950			
DX28	2,0100 2,0000	3,0000 2,9900	2,6300 2,6200	2,7550 2,7450			
DX30	2,1350 2,1250	3,1250 3,1150		2,6300 2,6200			
DX32	2,2600 2,2500	3,2500 3,2400					

All dimensions in mm. For stock availability please contact your local sales representative.

8 Standard Products

8.6 DX[®] STRIP



PART NO.	LENGTH L max. min.	TOTAL WIDTH W	USABLE WIDTH $W_{U \text{ min}}$	THICKNESS S_s max. min.
S11090DX	503 500	102	90	1,12 1,08
S15190DX				1,56 1,52
S20190DX		200	190	2,05 2,01
S25190DX				2,57 2,53

All dimensions in mm. For stock availability please contact your local sales representative.

8.7 DX[®] STRIP - INCH SIZES

DX[®] Strip sizes are available as Non-Standard products, on request.

11 Bearing Application Data Sheet

Not sure which GGB part fits your application requirements?

Please complete the form below and share it with your GGB sales person or distributor representative.

DATA FOR BEARING DESIGN CALCULATION

Application: _____

Project/No.: _____ Quantity: _____ New Design Existing Design

Steady load Rotating load Rotational movement Oscillating movement Linear movement

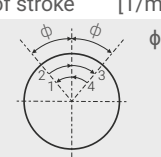
DIMENSIONS [MM]

Inside diameter	D_i	
Outside diameter	D_o	
Length	B	
Flange Diameter	D_{fl}	
Flange thickness	B_{fl}	
Wall thickness	S_T	
Length of slideplate	L	
Width of slideplate	W	
Thickness of slideplate	S_S	

LOAD

<input type="checkbox"/> Static load	
<input type="checkbox"/> Dynamic load	
Axial load F	[N]
Radial load F	[N]

MOVEMENT

Rotational speed	N [1/min]	
Speed	U [m/s]	
Length of stroke	L_s [mm]	
Frequency of stroke	[1/min]	
Oscillating cycle		ϕ [°]
Osc. frequency	N_{osz} [1/min]	

MATING SURFACE

Material	
Hardness	HB/HRC
Surface finish	Ra [µm]

CUSTOMER INFORMATION

Company _____

Street _____

City / State / Province / Post Code _____

Telephone _____ Fax _____

Name _____

Email Address _____ Date _____

FITS & TOLERANCES

Shaft	D_J	
Bearing housing	D_H	

OPERATING ENVIRONMENT

Ambient temperature	T_{amb} [°]	
Bearing housing material		
<input type="checkbox"/> Housing with good heating transfer properties		
<input type="checkbox"/> Light pressing or insulated housing with poor heat transfer properties		
<input type="checkbox"/> Non metal housing with poor heat transfer properties		
<input type="checkbox"/> Alternate operation in water and dry		

LUBRICATION

<input type="checkbox"/> Dry	
<input type="checkbox"/> Continuous lubrication	
<input type="checkbox"/> Process fluid lubrication	
<input type="checkbox"/> Initial lubrication only	
<input type="checkbox"/> Hydrodynamic conditions	
Process fluid	
Lubricant	
Dynamic viscosity	η [mPas]

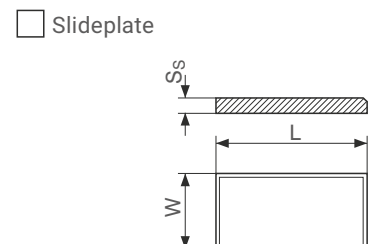
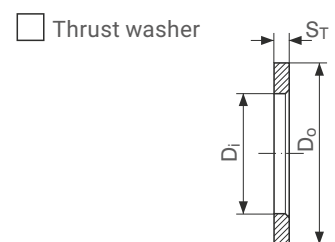
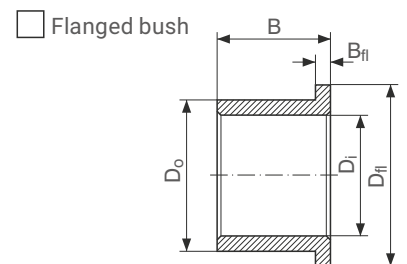
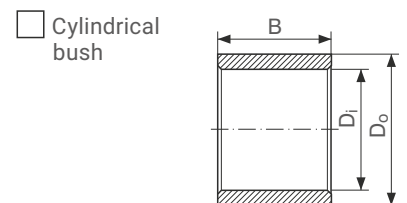
SERVICE HOURS PER DAY

Continuous operation	
Intermittent operation	
Operating time	
Days per year	

SERVICE LIFE

Required service life	L_H [h]
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BEARING TYPE



Special parts (sketch)

FORMULA SYMBOLS AND DESIGNATIONS

SYMBOL	UNIT	DESIGNATION
a_B	-	Bearing size factor
a_E	-	High load factor
a_Q	-	Speed / load factor
a_S	-	Surface finish factor
a_T	-	Temperature application factor
B	mm	Nominal bush length
C	1/min	Dynamic load frequency
C_D	mm	Installed diametrical clearance
C_{Dm}	mm	Diametral clearance machined
C_i	mm	ID chamfer length
C_o	mm	OD chamfer length
C_T	-	Total number of dynamic load cycles
D_H	mm	Housing Diameter
D_i	mm	Nominal bush and thrust washer ID
$D_{i,a}$	mm	Bush ID when assembled in housing
$D_{i,a,m}$	mm	Bush ID assembled and machined
D_J	mm	Shaft diameter
D_{Jm}	mm	Shaft diameter for machined bushes
D_o	mm	Nominal bush and thrust washer OD
d_D	mm	Dowel hole diameter
d_L	mm	Oil hole diameter
d_p	mm	Pitch circle diameter for dowel hole
F	N	Bearing load
F_i	N	Insertion force
f	-	Friction
H_a	mm	Depth of housing recess (e.g. for thrust washers)
H_d	mm	Diameter of housing recess (e.g. for thrust washers)
L	mm	Strip length
L_H	h	Bearing service life
L_{RG}	h	Relubrication interval

SYMBOL	UNIT	DESIGNATION
N	1/min	Rotational speed
N_{osc}	1/min	Oscillating movement frequency
p	N/mm ²	Specific load
p_{lim}	N/mm ²	Specific load limit
$p_{sta,max}$	N/mm ²	Maximum static load
$p_{dyn,max}$	N/mm ²	Maximum dynamic load
Q	-	Total number of cycles
R	-	Number of lubrication intervals
R_a	µm	Surface roughness (DIN 4768, ISO/DIN 4287/1)
s_3	mm	Bush wall thickness
s_S	mm	Strip thickness
s_T	mm	Thrust washer thickness
T	°C	Temperature
T_{amb}	°C	Ambient temperature
T_{max}	°C	Maximum temperature
T_{min}	°C	Minimum temperature
U	m/s	Sliding speed
u	-	Speed factor
W	mm	Strip width
$W_{U\ min}$	mm	Minimum usable strip width
Z_T	-	Total number of cycles
α_1	1/10 ⁶ K	Coefficient of linear thermal expansion parallel to surface
α_2	1/10 ⁶ K	Coefficient of linear thermal expansion normal to surface
σ_c	N/mm ²	Compressive yield strength
λ	W/mK	Thermal conductivity
φ	°	Angular displacement
η	Ns/mm ²	Dynamic viscosity

Product Information

GGB assures the products described in this document have no manufacturing errors or material deficiencies.

The details set out in this document are registered to assist in assessing material suitability for intended use. They have been developed from our own investigations as well as generally accessible publications. They do not represent any assurance for the properties themselves.

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Products are subject to continual development. GGB retains the right to make specification amendments or improvements to technical data without prior announcement. Edition 2023 (this edition replaces earlier editions which hereby lose their validity).

STATEMENT REGARDING LEAD CONTENT IN GGB PRODUCTS & EU DIRECTIVE COMPLIANCE

GGB is committed to adhering to all U.S., European and international standards and regulations with regard to lead content. We have established internal processes that monitor any changes to existing standards and regulations, and we work collaboratively with customers and distributors to ensure all requirements are strictly followed. This includes RoHS and REACH guidelines.

GGB makes it a top priority to operate in an environmentally conscious and safe manner. We follow numerous industry best practices and are committed to meeting or exceeding a variety of internationally recognized standards for emissions control and workplace safety.

Each of our global locations has management systems in place that adhere to IATF 16949, ISO 9001, ISO 14001, ISO 45001, and AS9100D/EN9100 quality regulations.

All of our certificates can be found here: <https://www.ggbearings.com/en/certificates>. A detailed explanation of our commitment to REACH and RoHS directives can be found at <https://www.ggbearings.com/en/who-we-are/quality-and-environment>.

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PUSHING BOUNDARIES TO CO-CREATE
A HIGHER QUALITY OF LIFE



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HB106ENG03-23HN