

FITTING METHODS

The most commonly used method for fitting the bushings is to press them into the housing. Having created the correct housing (H7), the following steps should be taken:

- Chamfer the lead-in to the housing by 20 ± 5 to a depth of 1-2mm
- Deburr and clean the mating surfaces
- Lubricate the outside surface of the bushing before fitting it (do not apply excessive lubricant as it may cause the bushing to move about when fitted in the housing)
- Check the alignment of the axes between the bushing and the housing
- Where several bushings are necessary, align the butt joints
- It is always advisable to use a guiding mandrel to insert the bushings in their housing

Press fitting is usually carried out using hydraulic, pneumatic or mechanical equipment (fig 1).

To fit bushings with a diameter or more than 55mm, it is advisable to use a retaining ring with a diameter that is 0.3/0.4mm larger (fig. 2) For flange bushings (fig. 3), the chamfer on the lead-in must have an angle of 45 and a depth of at least 2mm (2.55 for a bushing with a wall thickness of 2.5mm).

Approximate Values of the Pressing Force "F" in Newtons

Bushing Thickness 1 mm	$F = 300 \times L$
Bushing Thickness 1.5 mm	$F = 500 \times L$
Bushing Thickness 2 mm	$F = 700 \times L$
Bushing Thickness 2.5 mm	$F = 900 \times L$

