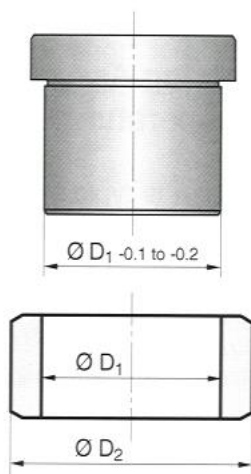


Object :	Assembly bushes small wall thickness (Dia. ≤ 80 mm)	Page 4
Object :	Assembly bushes small wall thickness (Dia. 80 à 200 mm)	Page 2
Object :	Assembly bushes small wall thickness (Dia. ≥ 200 mm)	Page 3
Object :	Assembly massive bearing	Page 1

Press-fitting of massive cylindrical bushings

Pusher



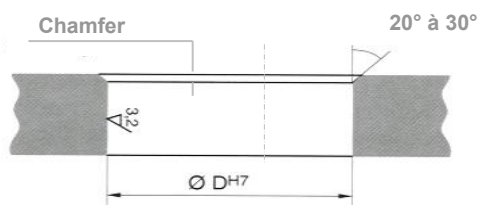
Massive bearing

The bushings must be press-fitted into their housing using the following method:

Press-fitting must be performed using a screw press, hydraulic press, or arbor press. Press-fitting the bushings by "hammering" is not recommended, as it may damage the material of the solid bushing.

A 20° to 30° entry chamfer must be provided on the housing to facilitate installation.

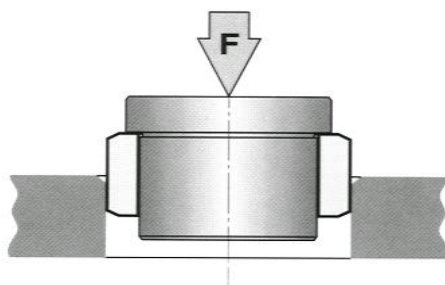
Housing



When installing solid flanged bushings, a larger chamfer must be provided on the housing to avoid interference with the radius connecting the outer diameter to the flange of the solid bushing.

The bushings must be press-fitted precisely along the axis of the housing.

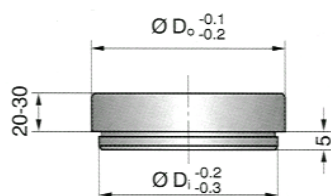
Fitting



Installation must be performed without impact, at a slow and steady speed. The use of a pressing tool is necessary to ensure correct installation of the bushings.

Press-fitting of thin-walled rolled cylindrical bushings Bushings with diameters < 200 mm and > 80 mm

Pusher



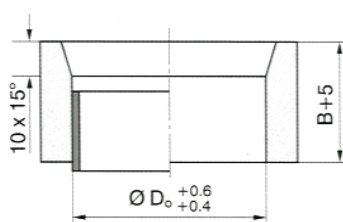
The bushings must be fitted into their housing using the following method:

Fitting must be performed using a screw press, hydraulic press, or arbor press. Fitting the bushings by hammering is not recommended, as it may damage the material of the wrapped bushing.

An entry chamfer of 20°–30° must be provided on the housing to facilitate fitting.

The bushings must be fitted precisely aligned with the housing axis.

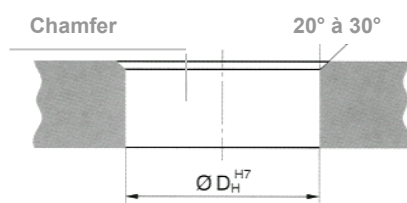
Guide ring



Fitting must be performed without impact, at a slow and steady speed. Using a mandrel or pusher is necessary to ensure correct bushing installation.

The back of the bushings may be lubricated with oil, talc, MoS2, or PTFE spray to facilitate assembly.

Housing

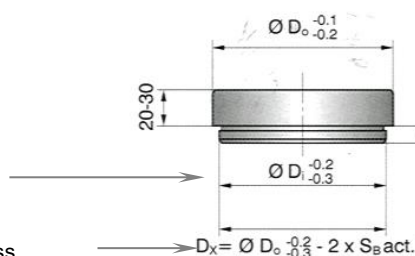


Press-fitting of thin-walled rolled cylindrical bushings Bushings with diameter ≥ 200 mm

Pusher

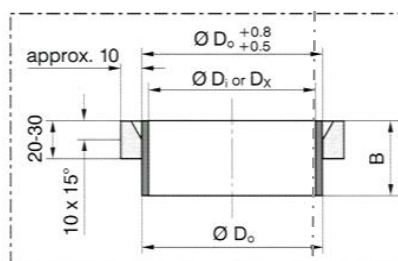
For standard bush

For bush with over thickness

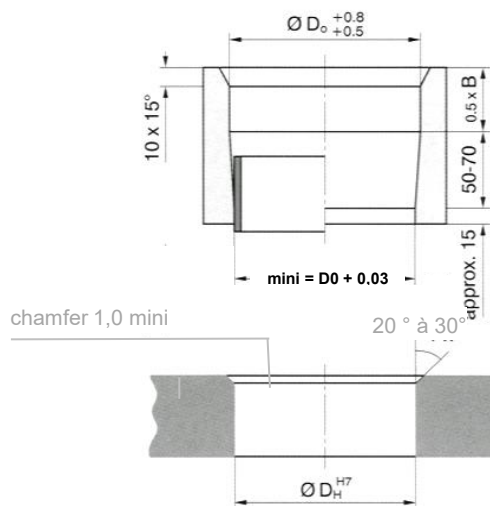


Additional guide ring

For long bush



Guide ring



Housing

avec : D_i = Inner diameter
 D_x = premachined inner diameter
 D_o = outer diameter
 B = length of bush
 $S_{B \text{ act.}}$ = wall thickness

The bushings must be fitted into their housing using the following method:

Installation should be performed using a screw press, hydraulic press, or arbor press. Installing the bushings by hammering is not recommended, as it can damage the material of the wrapped bushing.

A 20° to 30° entry chamfer must be provided on the housing to facilitate installation.

The bushings must be fitted precisely aligned with the housing axis.

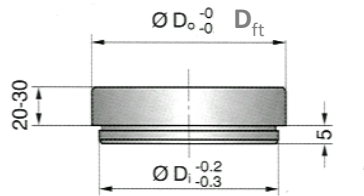
Installation must be performed without impact, at a slow and steady speed. Using a mandrel or pusher is necessary to ensure correct bushing installation.

For long bushings (length $> 2 \times$ diameter), an additional guide sleeve may be used.

The back of the bushings can be lubricated with oil, talc, MoS₂, or PTFE spray to facilitate assembly.
 l'huile ou talc ou MoS₂ ou PTFE en spray pour faciliter le montage

Press-fitting of thin-walled rolled flanged bushings Bushings with diameter ≤ 80 mm

Pusher


 D_{ft} = Flange diameter

The bushings must be press-fitted into their housing using the following method:

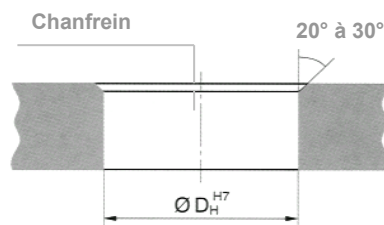
Installation must be performed using a screw press, hydraulic press, or arbor press. Installing the bushings by hammering is not recommended, as it may damage the material of the wrapped bushing.

An entry chamfer of 20° – 30° must be provided on the housing to facilitate installation.

The bushings must be press-fitted precisely in line with the housing axis.

Installation must be performed without impact, at a slow and steady speed. Using a mandrel or pusher is necessary to ensure correct bushing installation.

Housing



The back of the bushings may be lubricated with oil, talc, MoS₂, or PTFE spray to facilitate assembly.