



SOST
Flanged guide bush

Stepping forward together with our customers

For more than 50 years, **SANKYO OILLESS** has been one of the leading manufacturers of maintenance-free sliding elements. As a leading supplier and pioneer in the production of stamping and press tool components for the automotive industry, **SANKYO OILLESS** supplies an products for many other applications such as mold making, engineering, packaging, heavy industry, aerospace and many more.

The technologies developed by **SANKYO OILLESS** have reduced or eliminated friction, wear and tear. In addition, **SANKYO OILLESS** provides services and quality products to offer you the best possible solutions for your requirements at all times.

The benefits of slide bearings versus roller bearings

In a variety of applications, designers are increasingly replacing roller bearings with slide bearings. In addition to ease of installation and cost effectiveness, slide bearings offer a number of distinct advantages. Slide bearings require less installation space, have a larger load bearing capacity, are maintenance-free or require little maintenance, are easier to assemble and are less susceptible to noise and vibration.

The following list gives an overview of the general advantages of bearings compared to bearings.

Slide bearing

- Higher load bearing capacity and reduced footprint
- Higher resistance to vibration and increased lifetime
- Easier installation
- Lower installation costs
- Increased shaft tolerances possible
- Compensates misalignment and reduces the edge load

Roller bearing

- sensitive to shock, vibration and edge load
- high costs for bearings, housings, counterfaces and - fixing materials
- large space required
- is prone to noise development

Technologies for top performance

SANKYO products are manufactured in our own plants and distributed worldwide.

We offer high quality maintenance-free sliding elements acc. to international standards and standards for use in

- pressing tools
- injection molds
- general engineering

As an experienced specialist, we have the appropriate know-how in tribology to always offer the best solutions for your needs. We supply a large portfolio of lubrication-free sliding elements and also offer custom products acc. to customer drawing.

Quality and performance are our constant commitment!

Bushings with graphite

For a good distribution of the solid lubricant between the sliding element and the sliding partner, a small sliding gap is needed. This happens once by abrasion and by swelling from the depots in the micrometer range. As a result, pairing with clearance „0“ is not possible using our bronze lubricants with solid lubricant, which would inevitably result in jamming.

Bronze bushings with for example type SOB, narrows in the bore after insertion of the tolerance range F7 to a tolerance range H7. Prerequisites for this are:

- H7 *(the tolerance of the housing bore)*
- a corresponding wall thickness of the housing
- the control of the best wall strength of the socket
-

From the experience of the most diverse use cases, the following tolerance fields should be used when against run partner preferred:

- h6 *(for the highest precision in cutting tool / mold construction)*
- f7, e7 *(for highest accuracy in general engineering)*
- d8, e8 *(for highest accuracy in general engineering)*
- e8 + D9 *(for highest accuracy in general engineering)*

Attention

The graphite cannot be deposited on the entire surface with very small movements. Please contact the technical department if you want to realise very small movements.

Sliding partners

Suitable sliding partners for Sankyo Oilless Bushes and Plates are **gas nitrated or hardened steel** alloys with **HRC > 35**.

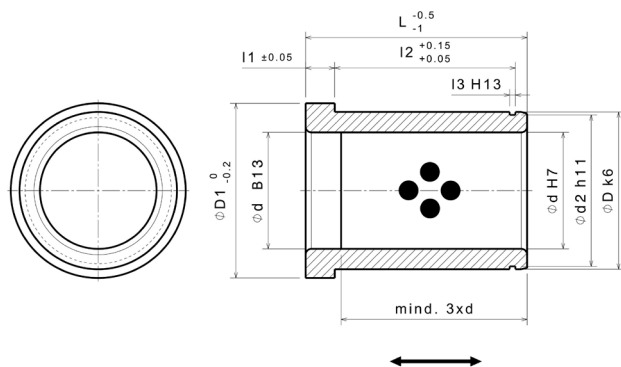
In order to ensure an optimal sliding behaviour, the difference in hardness between the sliding material and sliding partner should at least be **100 HB**.

The surface roughness of the sliding partner should be **Rz = 3...6,3 µm (grinding)**.

If guides, like in large dies of punching tools, are continuously moved apart during operation, the counterpart partner should be provided with correspondingly generous centering chamfers.

SOST - Flanged guide bush

Article informationen



Properties:

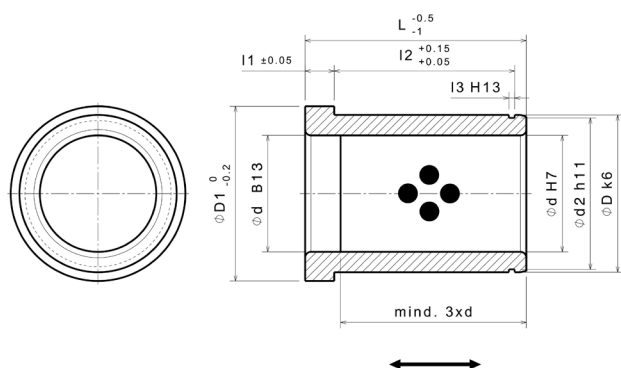
Base material	Special brass (SO#50SP2)
Self-lubricating	Yes
Lubricant	Graphite
Max. surface pressure P	100 N/mm ²
Max. sliding speed v	30 m/min
Max. P*v-Wert	200 N/mm ² x m/min
Operating temperature	-50°C / +200°C (max. 300°C)
Friction coefficient	0,07

Article no.:	Article name:	Inner Ø d:	Outer Ø D:	Length L:	D1 :	d2:	l1:	l2:	l3:
16709990	SOST 9-14-12	9	14	12	16	13,4	3	6,6	1,1
16709992	SOST 9-14-17			17				11,6	
16709994	SOST 9-14-22			22				16,6	
16709996	SOST 9-14-27			27				21,6	
16709998	SOST 9-14-36			36				30,6	
16710000	SOST 10-14-12	10	14	12				6,6	
16710005	SOST 10-14-17			17				11,6	
16710006	SOST 10-14-22			22				16,6	
16710007	SOST 10-14-27			27				21,6	
16710008	SOST 10-14-36			36				30,6	
16710010	SOST 12-18-17	12	18	17	23	17		8,3	
16710011	SOST 12-18-22			22				13,3	
16710012	SOST 12-18-27			27				18,3	
16710013	SOST 12-18-36			36				27,3	
16710015	SOST 14-20-17	14	20	17	25	19	6	8,3	1,3
16710020	SOST 14-20-22			22				13,3	
16710025	SOST 14-20-27			27				18,3	
16710030	SOST 14-20-36			36				27,3	
16710031	SOST 14-20-46			46				37,3	
16710032	SOST 14-20-56	56	47,3						
16710035	SOST 15-20-17	15	20	17				8,3	
16710040	SOST 15-20-22			22				13,3	
16710045	SOST 15-20-27			27				18,3	
16710050	SOST 15-20-36			36				27,3	
16710051	SOST 15-20-46			46				37,3	
16710052	SOST 15-20-56	56	47,3						
16710055	SOST 16-22-17	16	22	17	27	21		8,3	
16710060	SOST 16-22-22			22				13,3	
16710065	SOST 16-22-27			27				18,3	
16710070	SOST 16-22-36			36			27,3		
16710071	SOST 16-22-46			46			37,3		
16710072	SOST 16-22-56	56	47,3						
16710075	SOST 18-26-17	18	26	17	31	24,9	8,3		
16710080	SOST 18-26-22			22			13,3		
16710085	SOST 18-26-27			27			18,3		
16710090	SOST 18-26-36			36			27,3		
16710095	SOST 18-26-46			46			37,3		
16710096	SOST 18-26-56			56			47,3		

Article no.:	Article name:	Inner Ø d:	Outer Ø D:	Length L:	D1 :	d2:	l1:	l2:	l3:
16710097	SOST 18-26-66	18	26	66	31	24,9	6	57,3	1,3
16710100	SOST 20-26-17	20		17				8,3	
16710105	SOST 20-26-22			22				13,3	
16710110	SOST 20-26-27			27				18,3	
16710115	SOST 20-26-36			36				27,3	
16710120	SOST 20-26-46			46				37,3	
16710125	SOST 20-26-56			56				47,3	
16710126	SOST 20-26-66			66				57,3	
16710130	SOST 22-30-17		22	30	17	35		28,6	7,6
16710135	SOST 22-30-22	22			12,6				
16710140	SOST 22-30-27	27			17,6				
16710145	SOST 22-30-36	36			26,6				
16710150	SOST 22-30-46	46			36,6				
16710155	SOST 22-30-56	56			46,6				
16710156	SOST 22-30-66	66			56,6				
16710157	SOST 22-30-76	76			66,6				
16710158	SOST 22-30-86	86			76,6				
16710160	SOST 24-30-17	24	17		7,6				
16710165	SOST 24-30-22		22		12,6				
16710170	SOST 24-30-27		27		17,6				
16710175	SOST 24-30-36		36		26,6				
16710180	SOST 24-30-46		46		36,6				
16710185	SOST 24-30-56		56		46,6				
16710190	SOST 24-30-66		66		56,6				
16710191	SOST 24-30-76		76		66,6				
16710192	SOST 24-30-86		86		76,6				
16710195	SOST 30-42-27	30	42	27	47	39,5		15,85	1,85
16710200	SOST 30-42-36			36				24,85	
16710205	SOST 30-42-46			46				34,85	
16710210	SOST 30-42-56			56				44,85	
16710211	SOST 30-42-66			66				54,85	
16710215	SOST 30-42-76			76				64,85	
16710216	SOST 30-42-86			86				74,85	
16710220	SOST 30-42-96			96				84,85	
16710221	SOST 30-42-116			116				104,85	
16710225	SOST 32-42-27	32		27				15,85	
16710230	SOST 32-42-36			36				24,85	
16710235	SOST 32-42-46			46				34,85	
16710240	SOST 32-42-56			56				44,85	
16710241	SOST 32-42-66			66				54,85	
16710245	SOST 32-42-76			76				64,85	
16710246	SOST 32-42-86			86				74,85	
16710250	SOST 32-42-96			96				84,85	
16710251	SOST 32-42-116			116				104,85	
16710255	SOST 40-54-56	40	54	56	60	51	10	40,15	2,15
16710256	SOST 40-54-66			66				50,15	
16710260	SOST 40-54-76			76				60,15	
16710261	SOST 40-54-86			86				70,15	
16710265	SOST 40-54-96			96				80,15	
16710270	SOST 40-54-116			116				100,15	

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Article informationen



Properties:

Base material	Special brass (SO#50SP2)
Self-lubricating	Yes
Lubricant	Graphite
Max. surface pressure P	100 N/mm ²
Max. sliding speed v	30 m/min
Max. P*v-Wert	200 N/mm ² x m/min
Operating temperature	-50°C / +200°C (max. 300°C)
Friction coefficient	0,07

Article no.:	Article name:	Inner Ø d:	Outer Ø D:	Length L:	D1 :	d2:	l1:	l2:	l3:						
16710271	SOST 40-54-136	40	54	136	60	51	10	120,15	2,15						
16710272	SOST 40-54-156			156		-		-							
16710275	SOST 42-54-56	42		56		51		40,15	50,15	60,15	70,15	80,15	100,15	120,15	2,15
16710276	SOST 42-54-66			66											
16710280	SOST 42-54-76			76											
16710281	SOST 42-54-86			86											
16710285	SOST 42-54-96			96											
16710290	SOST 42-54-116			116											
16710291	SOST 42-54-136			136											
16710292	SOST 42-54-156			156											
16710295	SOST 50-66-76	50	66	76	72	-	-	-	-						
16710296	SOST 50-66-86			86											
16710300	SOST 50-66-96			96											
16710305	SOST 50-66-116			116											
16710310	SOST 50-66-136			136											
16710311	SOST 50-66-156			156											
16710312	SOST 50-66-196			196											
16710315	SOST 60-80-96			60						80	96	86	20		
16710320	SOST 60-80-116	116													
16710325	SOST 60-80-136	136													
16710326	SOST 60-80-156	156													
16710327	SOST 60-80-196	196													

Finishing

SANKYO OILLESS - bronze is easy to machine. Basically, there is no great difference between the machining of our products and normal steel. No special tools are required but be sure to use sharp and preferably new tools.

Milling

The use of cooling lubricants is recommended by using HSS or carbide tools. First pre-roughing to approx. distance of 0,3mm to nominal. In general: Milling / rough machining with little effort, slow forward feed, at high rotation-speeds and small depths of cut.

Drilling

The use of cooling lubricants is recommended by using HSS or carbide tools. Drill as with normal steel and if it's necessary increase the forward feed with same rotation-speed. Flat plates have to be drilled from backside and countersink on the sliding surface if it's necessary to drill through a solid-lubricant depot.

Grinding

The use of cooling lubricants is recommended by working with grinding wheels.

Grain size	46 - 60
Material	Silicon carbid
Rotation speed	1500 U/min
Working speed	30 m/min

Reaming

The use of cooling lubricants is recommended by using HSS reamers. Proceed as with normal steel and if it's necessary increase the forward feed with same rotation-speed.

Turning

Example (up to 100mm)	External turning	Internal turning
Rotation speed	approx. 1000 U/min	approx. 500 U/min
Feed rate	ca. 0,1 m/min	approx. 0,07 m/min
Tool	Carbide	Carbide

Custom-made products

Beside to the big variety of standard products, we offer custom-made rotation- and milled-parts. We are producing these products out of steel or with our special Sankyo bronze with solid lubrication. Also, it is possible to get standard products with modifications. We only need your drawing or 3D-model with the assembly situation, like load cases and operating conditions, to prove the feasibility.

Our expert team will gladly advise you, also at your side. You can contact the department „Engineering“ by:

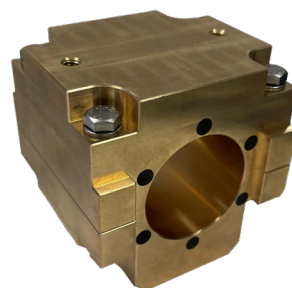
Tel.: [+49 2103 584 800](tel:+492103584800)

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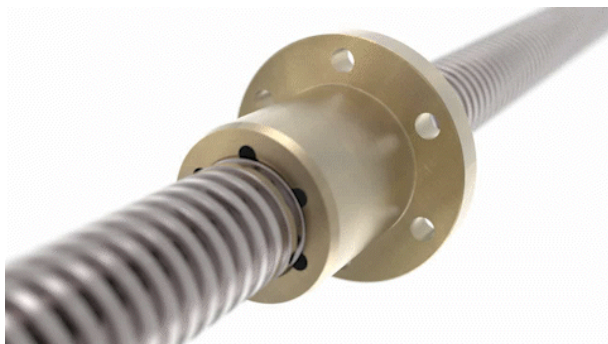
Examples



Custom-made products



Prefabricated deidable bush set to add a thread at the customer's site



Special design of a special spindle nut



Large bushings for all applications

SOST - Flanged guide bush

General and technical information



Material data

Material		SO#50SP2*	SO#50SP5	SO#50SP7	SO#50SP8	SO#50SP13	SO#50B
		<i>Hard brass with graphite</i>	<i>Alu-bronze with graphite</i>	<i>Alu-bronze with graphite</i>	<i>Hard brass with graphite</i>	<i>Bronze with graphite</i>	<i>Red brass with graphite</i>
Self-lubricating		Yes	Yes	Yes	Yes	Yes	Yes
Lubricant		Graphite	Graphite	Graphite	Graphite	Graphite	Graphite
Max. surface pressure [N/mm ²]		100	100	120	130	120	50
Max. sliding speed [m/min]		30	10	10	15	10	50
Max. P*v-Wert [N/mm ² * m/min]		200	150	200	200	200	100
Temperature [°C]	Standard Max	-50 / +200 +300	-50 / +200 +300	-50 / +200 +300	-50 / +200 +300	-50 / +200 +300	-50 / +200 +400
Friction coefficient**	initial long term	0,15 0,07	0,15 0,07	0,15 0,07	0,15 0,07	0,2 0,15	0,15 0,07
Brinell hardness [HB]		>210	>210	>260	220 ~ 260	>280	>60
Further information							
Elongation [%]		>12	>18	>2	>3	>0,5	>15
Density [kg/dm ³]		7,9	7,7	7,8	7,8	7,2	8,7
Tensile strength [N/mm ²]		>755	>686	>833	>700	>550	>195
Yield strength [N/mm ²]		>412	>372	>509	-	-	>105
E-Module [N/mm ²]		97000	108000	123600	108000	145000	96000
Thermal expansion [10 ⁻⁵ * grd.-1]		1,9	1,6	1,6	1,9	1,71	1,8

*: Material used according to SANKYO OILLESS standards

**: against steel, hardened and grinded

Tin bronze	Sinter-bronze	SO#50PB	CuSn8	SO#50S45C	SO#50F	Polyacetal
		<i>Ton bronze</i>	<i>acc. to DIN 17662</i>	<i>Steel with graphite</i>	<i>Grey cast iron with graphite</i>	<i>Plastic</i>
No	Yes	No	No	Yes	Yes	No
-	Oil	-	-	Graphite	Graphite	Graphite
80	50	80	40	30	5	25 35 (with oil)
20	300	50	120	10	10	50 200 (with oil)
-	96	100	-	80	50	100 200 (with oil)
-50 / +200 +300	-12 / +90	-50 / +200 +300	-200 / +200	-50 / +150	-50 / +150	-50 / +80
0,16	0,09	0,15 0,07	-	0,01	-	-
>80	>25	>80	-	>375	160 ~ 220	115 (HRR)
n						
>6	-	>5	-	19	-	73
8,7	6,5 ~ 7,0	8,2	8,8	7,8	7,1 ~ 7,3	1,4
>295	-	>295	-	>690	>250	69
>161	-	>161	-	-	-	-
108000	-	108000	115000	-	-	-
1,8	-	1,8	-	1,1	1	7,7

SOST - Flanged guide bush

General and technical information



Chemical resistance

Water

Material	SO#50SP2 SO#50SP8	SO#50B	SO#50SP5 SO#50SP7 SO#50SP13 SO#50AIB	SO#50F	SO#50S45C	Polyacetal
	<i>High strength brass casting</i>	<i>Red brass</i>	<i>Alu-bronze</i>	<i>Grey cast</i>	<i>Steel</i>	<i>Red brass mit FSS</i>
Fresh Water	○	◎	◎	X	◎	○
Sea Water	△	○	○	X	◎	○

Acid

Material	SO#50SP2 SO#50SP8	SO#50B	SO#50SP5 SO#50SP7 SO#50SP13 SO#50AIB	SO#50F	SO#50S45C	Polyacetal
	<i>High strength brass casting</i>	<i>Red brass</i>	<i>Alu-bronze</i>	<i>Grey cast</i>	<i>Steel</i>	
Alcohol	◎	◎	◎	-	◎	-
Formic acid	-	-	-	-	-	X
Chlorine (dry)	◎	◎	◎	-	◎	-
Chlorine (wet)	X	△	△	-	-	-
Chromic acid	X	X	X	X	-	-
Acetic acid	X	X	◎ (20°C) △ (118°C)	X	◎	○
Hydrochloric acid	-	○	○	X	-	X
Concentrated hydrochloric acid	X	X	△	X	X	-
Lactic acid	X	X	X	X	○	X
Phenol	-	-	-	-	-	X
Phosphoric acid	X	○	○	X	△	X
Nitric acid	X	X	X	X	○	-
Sulfuric acid (40-80%)	X	△	△	X	△	X* △**
Sulfuric acid (80-95%)	X	○	○	X	△	X* △**
Diluted hydrochloric acid	△	-	-	-	-	X
Hydrogen peroxide	△	○	○	X	○	-

*: High concentration

** : Low concentration

Explanation		
◎: Preferred	○: no problem in use	△: Affected
X: Not allowed for use	-: unknown	

Chemical resistance

Alkali

Material	SO#50SP2 SO#50SP8	SO#50B	SO#50SP5 SO#50SP7 SO#50SP13 SO#50AIB	SO#50F	SO#50S45C	Polyacetal
	<i>High strength brass casting</i>	<i>Red brass</i>	<i>Alu-bronze</i>	<i>Grey cast</i>	<i>Steel</i>	
Ammonia (dry)	◎	◎	◎	O	◎ (20°C) X (Gas)	X
Ammonia (wet)	X	X	X	O	◎ (20°C) X (Gas)	X
Ammonia (liquid)	X	X	X	-	◎	X
Iron chloride	X	O	O	X	△	-
Potassium hydroxide	O	O	O	-	-	-
Calcium chloride	X	O	O	△	O	-
Calcium hydroxide	O	◎	◎	O	-	O
Sodium hydroxide	O	O	O	-	◎	-
Sulfur (dry)	◎	O	O	△	-	O
Sulfur (wet)	X	X	X	△	-	O

Solvent

Material	SO#50SP2 SO#50SP8	SO#50B	SO#50SP5 SO#50SP7 SO#50SP13 SO#50AIB	SO#50F	SO#50S45C	Polyacetal
	<i>High strength brass casting</i>	<i>Red brass</i>	<i>Alu-bronze</i>	<i>Grey cast</i>	<i>Steel</i>	
Acetone	◎	◎	◎	O	◎	△
Benzene	-	-	-	-	-	△
Ethylene glycol	O	◎	◎	△	-	-
Carbon tetrachloride (dry)	◎	◎	◎	X	◎	-
Carbon tetrachloride (wet)	X	O	O	X	-	-
Methyl alcohol	◎	◎	◎	O	O	△
Toluene	◎	◎	◎	O	-	-

Explanation		
◎: Preferred	O: no problem in use	△: Affected
X: Not allowed for use	-: unknown	

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General and technical information



Chemical resistance

Grease and others

Material	SO#50SP2 SO#50SP8	SO#50B	SO#50SP5 SO#50SP7 SO#50SP13 SO#50AIB	SO#50F	SO#50S45C	Polyacetal
	<i>High strength brass casting</i>	<i>Red brass</i>	<i>Alu-bronze</i>	<i>Grey cast</i>	<i>Steel</i>	
Gasoline	◎	◎	◎	○	◎	○
Diesel	-	-	-	-	-	○
Crude oil	△	○	○	○	○	-
Lacquer	◎	◎	◎	△	-	-
Kerosene	◎	◎	◎	○	◎	-
Vegetable oil	◎	◎	◎	△	-	-
Lubricants	◎	◎	◎	◎	◎	○
Heavy oil	○	◎	◎	○	○	-
Animal oil	◎	◎	◎	-	-	-

Explanation		
◎: Preferred	○: no problem in use	△: Affected
X: Not allowed for use	-: unknown	

Maintenance and lubrication

Before inserting the sliding elements, clear the mounting surfaces of the housing. An oil film on the back surface will make it easier to mount the bearing. Before mounting the axle, lubricate the sliding surfaces with a light greasy film to avoid wear of the inlet and to activate the solid lubricant.

The following greases should be preferred:

ELKALUB GLS 364	ELKALUB	120°C	For the food industry
ELKALUB GLS 595/N2	ELKALUB	300°C	For the food industry
ELKALUB GLS 993 H1	ELKALUB	150°C	For the food industry
GLEITMO 805	FUCHS	110°C	
ALTEMP QNB 50	KLÜBER	150°C	
Klüberalfa DH 3-350	KLÜBER	230°C	
Klüberfood NH1 CH 2-150	KLÜBER	250°C	For the food & pharmaceutical industry
Klübertemp GR AR 555	KLÜBER	250°C	
PARALIQ P 68	KLÜBER	100°C	For the food & pharmaceutical industry
Gadus S2 V100 2	SHELL	130°C	
Gadus S3 V100 2	SHELL	160°C	
Multi-purpose grease Nr.12511	PRESSOL	80°C	

The greases have to be free of Additives like MoS2 (molybdenum disulfide) and EP.

The work to be carried out is usually limited to an inspection of the wear in the period from ½ to 2 years, depending on the duration of use and load. After each disassembly, a single re-greasing should be carried out, but the sintered sliding film of solid lubricant should not be removed. Continuous introduction of lubricant is not necessary, as the parts are maintenance-free under consideration of the application criteria for sliding elements made of bronze with solid lubricant.

Transport and storage

The parts are to be stored dust-free and dry, mechanical damages during transport and storage are to be avoided. Contact with organic and inorganic solvents must also be prevented, as this may destroy the solid lubricant.

