



SGL-BS & SGL-SS

L-shaped cam guides

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!

Plates, angle strips and the like

According to the case of application and the desired accuracy, between 0.02 and 0.15 mm.

In general, guide slides are made to give a clearance of 0.05 mm and a vertical clearance of 0.1 mm.

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**.

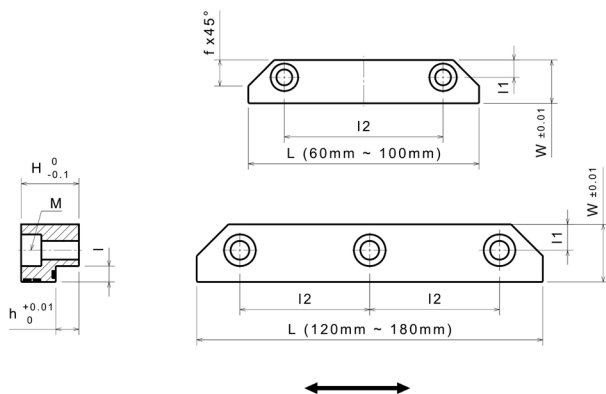
In order to ensure an optimal sliding behaviour, the difference in hardness between the sliding material and sliding partner should at least be **100 HB**.

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.

SGL-BS & SGL-SS - L-shaped cam guides

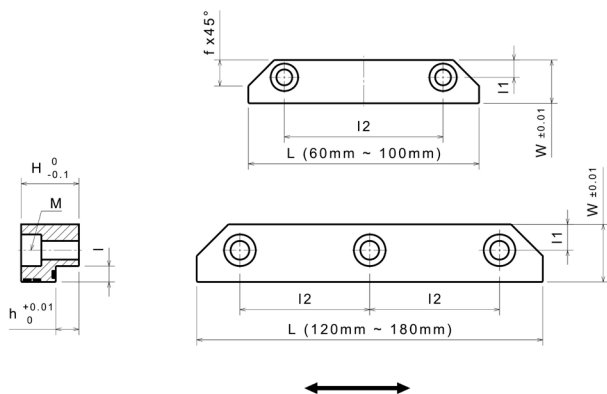
Article informationen



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:	Width W:	Length L:	Height H:	l:	h:	l1:	l2:	f:	M (ISO 4762):
21303600	SGL-BS 15-60-15	15	60	15	4,5	8	6	20	9	M5
21303601	SGL-BS 15-80-15		80					55		
21303602	SGL-BS 15-100-15		100					75		
21303603	SGL-BS 20-60-20	20	60	20	5,5	10	9	20	11	M6
21303604	SGL-BS 20-80-20		80					50		
21303605	SGL-BS 20-100-20		100					70		
21303606	SGL-BS 20-120-20		120					45		
21303607	SGL-BS 25-80-25	25	80	25	7,5	10	9	45	13	M8
21303608	SGL-BS 25-100-25		100					65		
21303609	SGL-BS 25-120-25		120					42,5		
21303610	SGL-BS 25-140-25		140					52,5		
21303611	SGL-BS 30-120-30	30	120	30	11	15	11	40	16	M10
21303612	SGL-BS 30-140-30		140					50		
21303613	SGL-BS 30-160-30		160					60		
21303614	SGL-BS 30-180-30		180					70		



Properties:

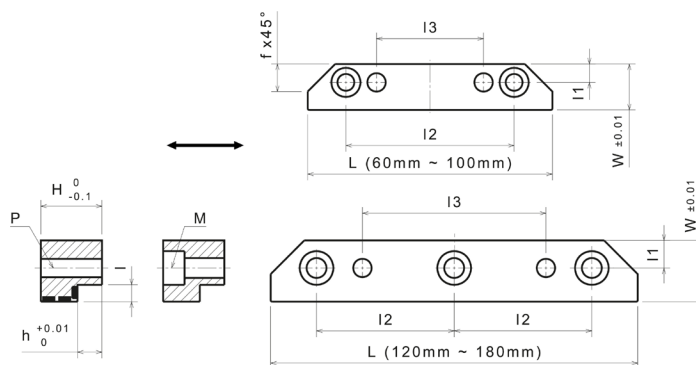
Base material	Steel with solid lubricant
Self-lubricating	Yes
Lubricant	Graphite
Max. surface pressure P	30 N/mm ²
Max. sliding speed v	15 m/min
Max. P*v-Wert	80 N/mm ² x m/min
Operating temperature	-50°C / +200°
Friction coefficient	0,10

Article no.:	Article name:	Width W:	Length L:	Height H:	l:	h:	l1:	l2:	f:	M (ISO 4762):
21303500	SGL-SS 15-60-15	15	60	15	4,5	8	6	20	9	M5
21303501	SGL-SS 15-80-15		80					55		
21303502	SGL-SS 15-100-15		100					75		
21303503	SGL-SS 20-60-20	20	60	20	5,5	10	9	20	11	M6
21303504	SGL-SS 20-80-20		80					50		
21303505	SGL-SS 20-100-20		100					70		
21303506	SGL-SS 20-120-20		120					45		
21303507	SGL-SS 25-80-25	25	80	25	7,5	10	9	45	13	M8
21303508	SGL-SS 25-100-25		100					65		
21303509	SGL-SS 25-120-25		120					42,5		
21303510	SGL-SS 25-140-25		140					52,5		
21303511	SGL-SS 30-120-30	30	120	30	11	15	11	40	16	M10
21303512	SGL-SS 30-140-30		140					50		
21303513	SGL-SS 30-160-30		160					60		
21303514	SGL-SS 30-180-30		180					70		

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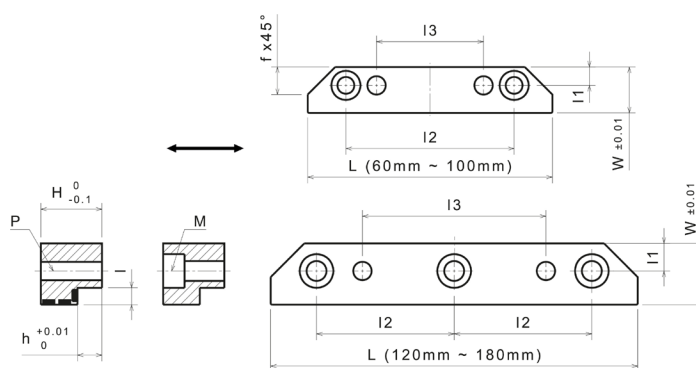
Article informationen



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:	Width W:	Length L:	Height H:	l:	h:	I1:	I2:	I3:	f:	M (ISO 4762):	P (ISO 8734):
21303650	SGL-BS-P 15-60-15	15	60	15	4,5	8	6	20	40	9	M5	6
21303651	SGL-BS-P 15-80-15		80					55	35			
21303652	SGL-BS-P 15-100-15		100					75	55			
21303653	SGL-BS-P 20-60-20	20	60	20	5,5	10	9	20	40	11	M6	8
21303654	SGL-BS-P 20-80-20		80					50	20			
21303655	SGL-BS-P 20-100-20		100					70	40			
21303656	SGL-BS-P 20-120-20		120					45	60			
21303657	SGL-BS-P 25-80-25	25	80	25	7,5	15	11	65	40	13	M8	8
21303658	SGL-BS-P 25-100-25		100					42,5	60			
21303659	SGL-BS-P 25-120-25		120					52,5	80			
21303660	SGL-BS-P 25-140-25		140					40	40			
21303661	SGL-BS-P 30-120-30	30	120	30	11	15	11	50	60	16	M10	8
21303662	SGL-BS-P 30-140-30		140					60	80			
21303663	SGL-BS-P 30-160-30		160					70	100			
21303664	SGL-BS-P 30-180-30		180									



Properties:

Base material	Steel with solid lubricant
Self-lubricating	Yes
Lubricant	Graphite
Max. surface pressure P	30 N/mm ²
Max. sliding speed v	15 m/min
Max. P*v-Wert	80 N/mm ² x m/min
Operating temperature	-50°C / +200°
Friction coefficient	0,10

Article no.:	Article name:	Width W:	Length L:	Height H:	l:	h:	I1:	I2:	I3:	f:	M (ISO 4762):	P (ISO 8734):
21303550	SGL-SS-P 15-60-15	15	60	15	4,5	8	6	20	40	9	M5	6
21303551	SGL-SS-P 15-80-15		80					55	35			
21303552	SGL-SS-P 15-100-15		100					75	55			
21303553	SGL-SS-P 20-60-20	20	60	20	5,5	9	9	20	40	11	M6	6
21303554	SGL-SS-P 20-80-20		80					50	20			
21303555	SGL-SS-P 20-100-20		100					70	40			
21303556	SGL-SS-P 20-120-20		120					45	60			
21303557	SGL-SS-P 25-80-25	25	80	25	7,5	10	9	65	40	13	M8	8
21303558	SGL-SS-P 25-100-25		100					42,5	60			
21303559	SGL-SS-P 25-120-25		120					52,5	80			
21303560	SGL-SS-P 25-140-25		140					40	40			
21303561	SGL-SS-P 30-120-30	30	120	30	11	15	11	50	60	16	M10	8
21303562	SGL-SS-P 30-140-30		140					60	80			
21303563	SGL-SS-P 30-160-30		160					70	100			
21303564	SGL-SS-P 30-180-30		180									

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:

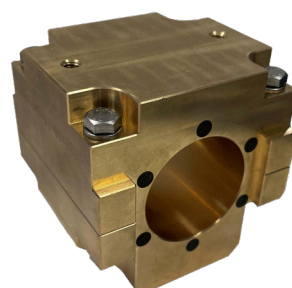
Tel.: [+49 2103 584 800](tel:+492103584800)

E-Mail: technik@de.sankyo-oilless.com

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

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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]	<i>Standard Max</i>	-50 / +200 +300	-50 / +200 +300	-50 / +200 +300	-50 / +200 +300	-50 / +200 +300	-50 / +200 +400
Friction coefficient**	<i>initial long term</i>	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

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	

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.

