



Gun Drill and other
deep hole tooling.

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How to use this Guide

All part specification pages are arranged with the following helpful guide points as shown below.

The diagram illustrates the layout of a SnapGuide part specification page for a 17 mm OD SnapGuide. The page is divided into several sections, each labeled with a line pointing to its location:

- Page Subject:** Points to the top left section containing the product name "17 MM OD SnapGuide™" and the International Drill Guide, Inc. logo.
- Page Number:** Points to the number "6" in the top left corner.
- Part Notes:** Points to a "NOTE" section on the left side of the page.
- Advice in selecting the best parts:** Points to a section at the bottom left titled "The BEST SnapGuide™" with the text "To use when drilling any hole .0008\" or smaller."
- Size Selection Guide:** Points to the top right section, which includes a "Size Selection Guide" and a "Schematic Size Guide".
- Part Sizes:** Points to the large table on the right side of the page, which lists various part sizes and their corresponding dimensions.

About International Drill Guide, Inc.

International Drill Guide, Inc. manufactures a full line of plastic support bushings and chip box seals for all deep hole drilling machines. Our products stop drill whipping, reduce vibration, increase hole accuracy and seal the chip box on every gun drill machine. We offer the best application engineering to optimize your job coupled with expertise in Chemistry and Polymers to maximize bushing life and performance. The products are molded on our state of the art CNC molding machine. Specials can be designed and built with minimal lead time in our own CNC mold making shop. Our signature Blue Bushings always guarantee you top quality.

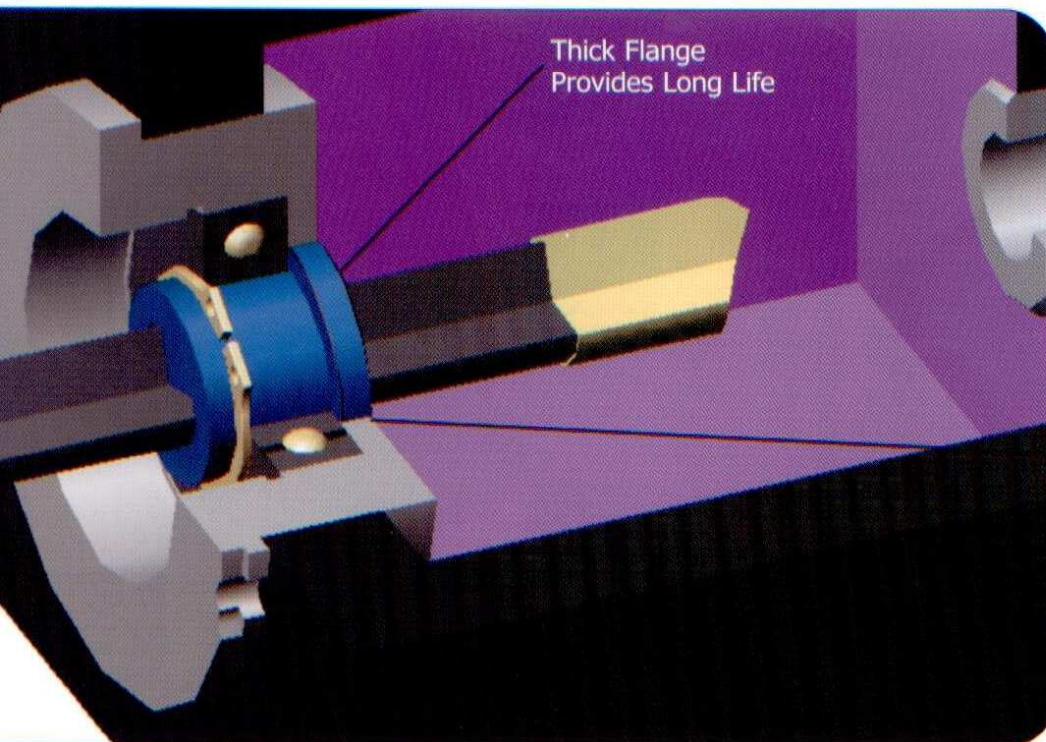
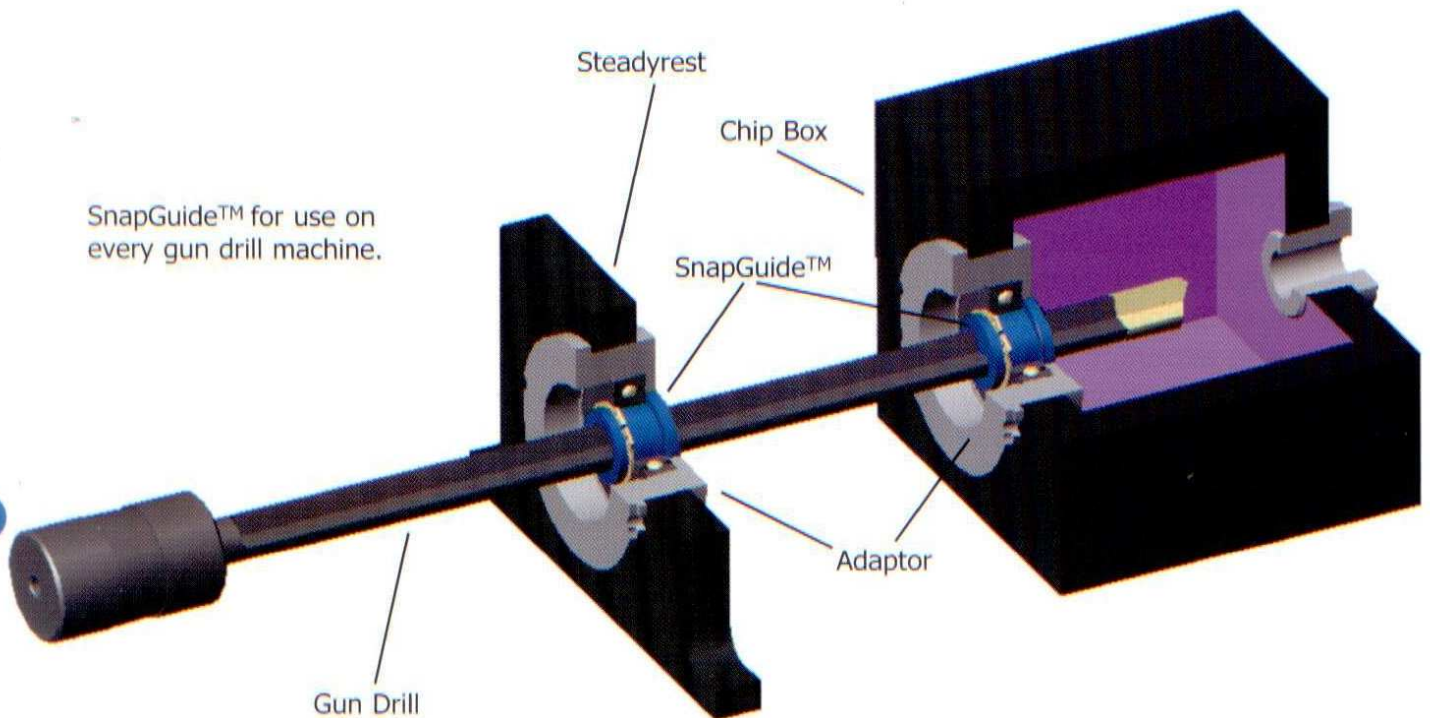


SnapGuide™

Quick-change support bushing held in place with snap ring.

SnapGuide™ for use on every gun drill machine.

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Chip Box

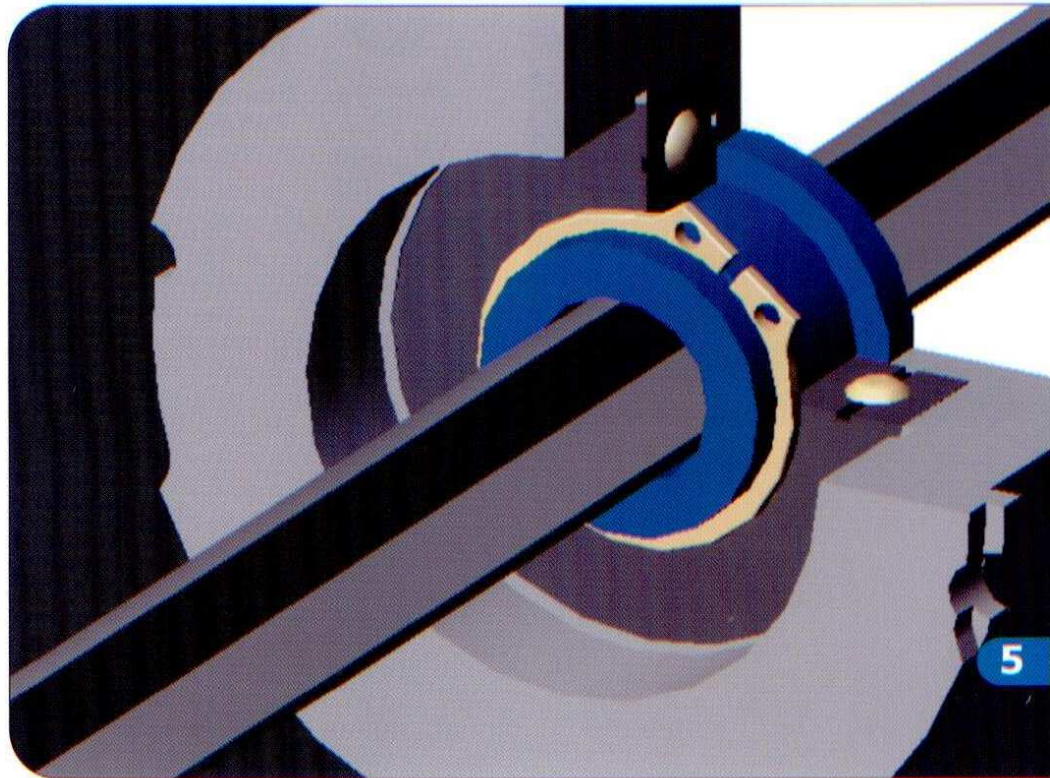
Flexible plastic SnapGuide™ stretch over carbide gun drill tip and contract over steel tube to stop drill whipping and vibration. Contoured hole in SnapGuide™ forms perfect seal on gun drill.

Excellent Bearing Protection

Our signature **Blue Bushings** always guarantee you top quality.

Steadyrest

SnapGuide™ with round holes are used in the steadyrest. This speeds drill loading by eliminating the need to orient the contoured hole in the SnapGuide™ with the drill. Extra clearance in SnapGuide™ allows drill tip to slide through easier. Also helps prevent steadyrest from being dragged out of position.

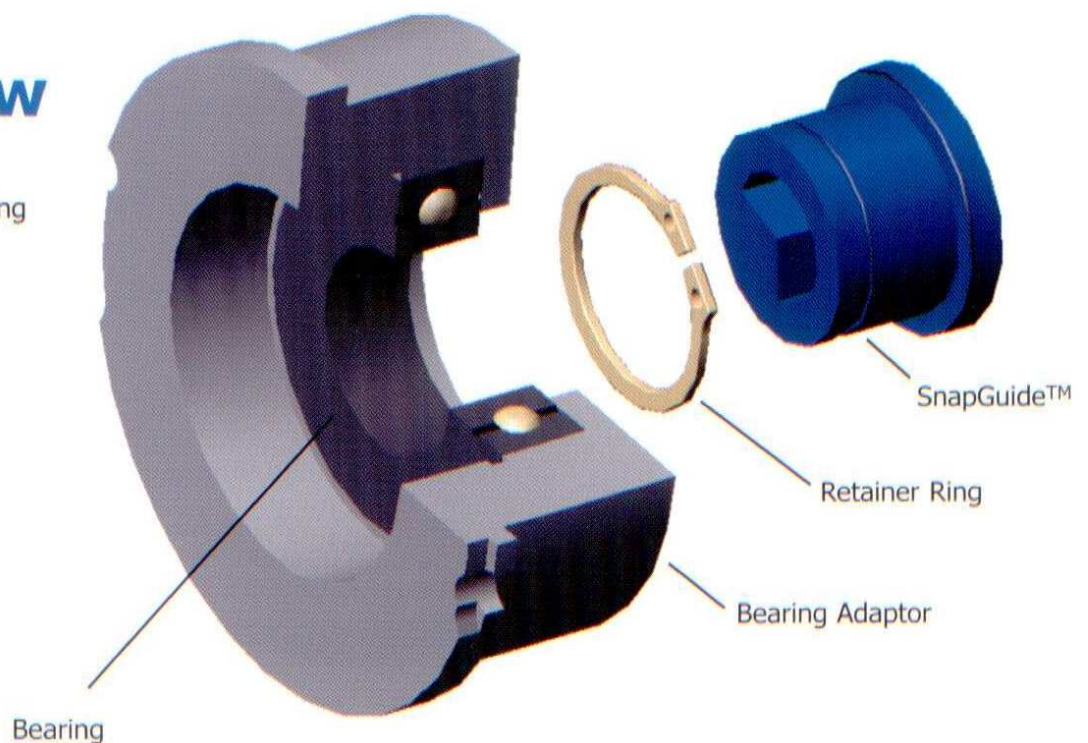


Exploded View

Each bearing holder has large drill range capacity reducing or eliminating holder change-overs on machine.

SnapGuide™ Drill Range

17mm OD - .070-.509
20mm OD - .070-.625
30mm OD - .125-1.0449
45mm OD - .800-1.5199
75mm OD - 1.520-2.044+



17 MM OD SnapGuide™

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NOTE

All SnapGuide™ bushings shaded **red** have round holes. Contour hole bushings in these ranges may contribute to premature drill breakage- Call us for contour bushings in this range and we will review your application.

The **BEST** SnapGuide™ to use when drilling any hole .509" or smaller.

Chip Box		Appropriate Drill Sizes		Steady Rest	
SnapGuide™		SnapGuide™		SnapGuide™	
Bushing ID	Standard Part No.	Drill Range		Steadyrest Part No.	Bushing ID
.066	1,67R-17	<=.0769		1,67R-17	.066
.070	1,77R-17	.077	.0831	1,77R-17	.070
.074	1,87R-17	.0832	.0892	1,87R-17	.074
.078	1,97R-17			1,97R-17	.078
.082	2,07R-17	.0883	.0933	2,07R-17	.082
.085	2,17R-17	.0934	.0984	2,17R-17	.085
.090	2,27R-17	.0985	.1010	2,27R-17	.090
.094	2,37R-17	.1011	.1035	2,37R-17	.094
.097	2,47R-17	.1036	.1086	2,47R-17	.097
.101	2,57R-17	.1087	.1137	2,57R-17	.101
.105	2,67R-17	.1138	.1179	2,67R-17	.105
.110	2,8R-17	.1180	.1239	2,8R-17	.110
.117	3,0R-17	.1240	.1329	3,0R-17	.117
.125	3,2R-17	.1330	.1369	3,2R-17	.125
.133	3,4R-17	.1370	.1430	3,4R-17	.133
.137	3,5R-17	.1431	.1519	3,5R-17	.137
.150	3,8R-17	.1520	.1609	3,8R-17	.150
.153	3,87-17	.1610	.1666	4,0R-17	.157
.160	4,07-17	.1667	.1718	4,27R-17	.171
.168	4,27-17	.1719	.1823	4,47R-17	.176
.176	4,47-17	.1824	.1949	4,6R-17	.181
.184	4,67-17	.1950	.2049	4,8R-17	.189
.192	4,87-17	.2050	.2099	5,0R-17	.197
.200	5,07-17	.2100	.2239	5,2R-17	.205
.208	5,27-17	.2240	.2289	5,4R-17	.213
.216	5,47-17	.2290	.2399	5,47R-17	.215
.223	5,67-17	.2400	.2449	5,67R-17	.223
.226	5,75-17	.2450	.2499	5,75R-17	.226
.236	6,0-17	.2500	.2599	6,0R-17	.236
.246	6,25-17	.2600	.2799	6,25R-17	.246
.260	6,6-17	.2800	.2869	6,6R-17	.260
.272	6,90-17	.2870	.3079	6,9R-17	.272
.283	7,20-17	.3080	.3199	7,2R-17	.283
.295	7,50-17	.3200	.3299	7,45R-17	.293
.307	7,80-17	.3300	.3399	7,8R-17	.307
.321	8,15-17	.3400	.3499	8,15R-17	.321
.332	8,45-17	.3500	.3599	8,45R-17	.333
.341	8,65-17	.3600	.3699	8,65R-17	.341
.360	9,15-17	.3700	.3929	9,15R-17	.360
.372	9,45-17	.3930	.4009	9,45R-17	.372
.384	9,75-17	.4010	.4059	9,75R-17	.384
.396	10,05-17	.4060	.4249	10,05R-17	.396
.411	10,45-17	.4250	.4479	10,45R-17	.411
.427	10,85-17	.4480	.4629	10,9R-17	.429
.439	11,15-17	.4630	.4779	11,15R-17	.439
.455	11,55-17	.4780	.4909	11,55R-17	.455
.463	11,75-17			11,75R-17	.463
.475	12,1-17	.4910	.5099	12,1R-17	.475

Bearing dimensions 35 mm OD x 10 mm wide x 17 mm bore



Bushing
ID

Chip Box

SnapGuide™



Standard
Part No.

Appropriate
Drill
Sizes



Drill Range

Steady
Rest

SnapGuide™



Steadyrest
Part No.



Bushing
ID

20 MM OD

SnapGuide™

.071	1,8R-20	<=.0831		1,8R-20	.071
.075	1,9R-20	.0832	.0882	1,9R-20	.075
.079	2,0R-20			2,0R-20	.079
.083	2,1R-20	.0883	.0933	2,1R-20	.083
.087	2,2R-20	.0934	.0984	2,2R-20	.087
.091	2,3R-20	.0985	.1010	2,3R-20	.091
.094	2,4R-20	.1011	.1035	2,4R-20	.094
.098	2,5R-20	.1036	.1086	2,5R-20	.098
.102	2,6R-20	.1087	.1137	2,6R-20	.102
.106	2,7R-20	.1138	.1179	2,7R-20	.106
.110	2,8R-20	.1180	.1239	2,8R-20	.110
.118	3,0R-20	.1240	.1329	3,0R-20	.118
.126	3,2R-20	.1330	.1369	3,2R-20	.126
.134	3,4R-20	.1370	.1430	3,4R-20	.134
.138	3,5R-20	.1431	.1519	3,5R-20	.138
.150	3,8R-20	.1520	.1609	3,8R-20	.150
.157	4,0R-20	.1610	.1666	4,0R-20	.157
.165	4,2R-20	.1667	.1718	4,2R-20	.165
.168	4,27-20	.1719	.1823	4,4R-20	.173
.176	4,47-20	.1824	.1949	4,47R-20	.176
.184	4,67-20	.1950	.2049	4,8R-20	.189
.192	4,87-20	.2050	.2099	5,0R-20	.197
.200	5,07-20	.2100	.2239	5,2R-20	.205
.208	5,27-20	.2240	.2289	5,4R-20	.213
.216	5,47-20	.2290	.2399	5,47R-20	.215
.223	5,67-20	.2400	.2449	5,6R-20	.220
.226	5,75-20	.2450	.2499	5,75R-20	.226
.236	6,0-20	.2500	.2599	6,0R-20	.236
.246	6,25-20	.2600	.2799	6,25R-20	.246
.260	6,6-20	.2800	.2869	6,6R-20	.260
.272	6,9-20	.2870	.3079	6,9R-20	.272
.283	7,2-20	.3080	.3199	7,2R-20	.283
.295	7,50-20	.3200	.3299	7,5R-20	.295
.307	7,8-20	.3300	.3399	7,80R-20	.307
.321	8,15-20	.3400	.3499	8,15R-20	.321
.333	8,45-20	.3500	.3599	8,45R-20	.333
.341	8,65-20	.3600	.3699	8,65R-20	.341
.360	9,15-20	.3700	.3929	9,15R-20	.360
.372	9,45-20	.3930	.4009	9,45R-20	.372
.384	9,75-20	.4010	.4059	9,75R-20	.384
.396	10,05-20	.4060	.4249	10,05R-20	.396
.411	10,45-20	.4250	.4479	10,45R-20	.411
.427	10,85-20	.4480	.4629	10,85R-20	.427
.439	11,15-20	.4630	.4779	11,15R-20	.439
.455	11,55-20	.4780	.4901	11,55R-20	.455
.463	11,75-20	.4902	.5099	11,75R-20	.463
.488	12,4-20	.5100	.5249	12,4R-20	.488
.504	12,8-20	.5250	.5399	12,8R-20	.504
.524	13,3-20	.5400	.5649	13,3R-20	.524
.543	13,8-20	.5650	.5799	13,8R-20	.543
.563	14,3-20	.5800	.5999	14,3R-20	.563
.583	14,8-20	.6000	.6199	14,8R-20	.583
.600	15,25-20	.6200	.6399	15,25R-20	.600
.606	15,4-20			15,4R-20	.606

Bearing dimensions 42 mm OD x 12 mm wide x 20 mm bore

NOTE

All SnapGuide™ bushings shaded **red** have round holes. Contour hole bushings in these ranges may contribute to premature drill breakage- Call us for contour bushings in this range and we will review your application.

The **BEST** SnapGuide™ to use for any hole smaller than .629" but larger than .509". Also best when a bushing with total range of .070'-.629 is required.

30 MM OD SnapGuide™

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All SnapGuide™ bushings shaded **red** have round holes. Contour hole bushings in these ranges may cause premature drill breakage- Call us for contour bushings in this range and we will review your application.

The best SnapGuide™ for large holes up to 1.0449". Excellent job shop bushing with largest range of any of our bushings. Drill range is .0985"-1.0449.



Bushing
ID



Standard
Part No.



Appropriate
Drill
Sizes



Steadyrest
Part No.



Bushing
ID

Bushing ID	Standard Part No.	Drill Range	Steadyrest Part No.	Bushing ID
.090	2,3R-30	.0985 .1010	2,3R-30	.090
.110	2,8R-30	.1180 .1239	2,8R-30	.110
.118	3,0R-30	.1240 .1329	3,0R-30	.118
.126	3,2R-30	.1330 .1369	3,2R-30	.126
.134	3,4R-30	.1370 .1430	3,4R-30	.134
.137	3,5R-30	.1431 .1519	3,5R-30	.137
.149	3,8R-30	.1520 .1609	3,8R-30	.149
.157	4,0R-30	.1610 .1666	4,0R-30	.157
.165	4,2R-30	.1667 .1718	4,2R-30	.165
.173	4,4R-30	.1719 .1823	4,4R-30	.173
.181	4,6R-30	.1824 .1949	4,6R-30	.181
.189	4,8R-30	.1950 .2049	4,8R-30	.189
.192	5,0R-30	.2050 .2099	5,0R-30	.197
.200	5,07-30	.2100 .2239	5,2R-30	.204
.208	5,27-30	.2240 .2289	5,4R-30	.212
.216	5,47-30	.2290 .2399	5,47R-30	.215
.223	5,67-30	.2400 .2449	5,6R-30	.220
.226	5,75-30	.2450 .2499	5,8R-30	.228
.236	6,0-30	.2500 .2599	6,0R-30	.236
.246	6,25-30	.2600 .2799	6,25R-30	.246
.260	6,6-30	.2800 .2869	6,6R-30	.260
.272	6,9-30	.2870 .3079	6,9R-30	.272
.283	7,2-30	.3080 .3199	7,2R-30	.283
.295	7,50-30	.3200 .3299	7,45R-30	.293
.307	7,8-30	.3300 .3399	7,80R-30	.307
.321	8,15-30	.3400 .3499	8,15R-30	.321
.333	8,45-30	.3500 .3599	8,45R-30	.332
.341	8,65-30	.3600 .3699	8,65R-30	.341
.360	9,15-30	.3700 .3929	9,15R-30	.360
.372	9,45-30	.3930 .4009	9,45R-30	.372
.384	9,75-30	.4010 .4059	9,75R-30	.384
.396	10,05-30	.4060 .4249	10,05R-30	.396
.411	10,45-30	.4250 .4479	10,45R-30	.411
.427	10,85-30	.4480 .4629	10,9R-30	.429
.439	11,15-30	.4630 .4779	11,15R-30	.439
.455	11,55-30	.4780 .4909	11,55R-30	.455
.463	11,75-30	.4910 .5099	11,75R-30	.463
.488	12,4-30	.5100 .5249	12,4R-30	.488
.504	12,8-30	.5250 .5399	12,8R-30	.504
.524	13,3-30	.5400 .5649	13,3R-30	.524
.543	13,8-30	.5650 .5799	13,8R-30	.543
.563	14,3-30	.5800 .5999	14,3R-30	.563
.583	14,8-30	.6000 .6199	14,8R-30	.583
.600	15,25-30	.6200 .6399	15,25R-30	.600
.614	15,6-30	.6400 .6799	15,6R-30	.614
.646	16,4-30	.6800 .6999	16,4R-30	.646
.677	17,2-30	.7000 .7399	17,2R-30	.677
.709	18,0-30	.7400 .7599	17,9R-30	.705
.740	18,8-30	.7600 .7999	18,8R-30	.740
.778	19,75-30	.8000 .8399	19,75R-30	.778
.819	20,8-30	.8400 .8699	20,8R-30	.819
.845	21,5-30	.8700 .8799	21,5R-30	.845
.854	21,7-30	.8800 .9199	21,8R-30	.858

Chip Box		Appropriate Drill Sizes		Steady Rest	
Bushing ID	Standard Part No.	Drill Range		Steadyrest Part No.	Bushing ID
.866	22,0-30	.9200	.9399	22,0R-30	.866
.894	22,7-30			22,8R-30	.898
.906	23,0-30	.9400	.9599	23,0R-30	.906
.933	23,7-30			23,8R-30	.937
.945	24,0-30	.9600	.9799	24,0R-30	.945
.960	24,4-30	.9800	1.0049	24,4R-30	.960
.980	24,9-30	1.005	1.0449	24,9R-30	.980

Bearing dimensions 55mm OD x 13mm wide x 30mm bore

30 MM OD

SnapGuide™

CONTINUED

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Chip Box		Appropriate Drill Sizes		Steady Rest	
Bushing ID	Standard Part No.	Drill Range		Steadyrest Part No.	Bushing ID
.780	19,8-45	.800-.8399		19,8R-45	.780
.819	20,8-45	.840-.8799		20,8R-45	.819
.858	21,8-45	.880-.920		21,8R-45	.858
.906	23,0-45	.9201-.9399		23,0R-45	.906
.945	24,0-45	.940-1.0049		24,0R-45	.945
.984	25,0-45	1.105-1.1399		25,0R-45	.984
1.023	26,0-45	1.045-1.1049		26,0R-45	1.023
1.063	27,0-45	1.105-1.1399		27,0R-45	1.063
1.102	28,0-45	1.140-1.1749		28,0R-45	1.102
1.142	29,0-45	1.175-1.2199		29,0R-45	1.142
1.181	30,0-45	1.220-1.2749		30,0R-45	1.181
1.260	32,0-45	1.275-1.3449		32,0R-45	1.260
1.339	34,0-45	1.345-1.4299		34,0R-45	1.339
1.417	36,0-45	1.430-1.4799		36,0R-45	1.417
1.455	37,0-45	1.480-1.5199		37,0R-45	1.455

Bearing dimensions: 75 mm OD x 16 mm wide x 45 mm bore

45 MM OD

SnapGuide™

For Drills from .800-1.5199

75 mm

SnapGuide™

Bushing for drills from
1.520-2.044+



Bushing ID



Standard Part No.



Appropriate
Drill
Sizes

Drill Range



Steadyrest Part No.



Bushing ID

1.496	38,0-75	1.520-1.5709	38,0R-75	1.496
1.535	39,0-75	1.571-1.6089	39,0R-75	1.535
1.575	40,0-75	1.609-1.6499	40,0R-75	1.575
1.614	41,0-75	1.650-1.6899	41,0R-75	1.614
1.654	42,0-75	1.690-1.7289	42,0R-75	1.654
1.693	43,0-75	1.729-1.7679	43,0R-75	1.693
1.732	44,0-75	1.768-1.8069	44,0R-75	1.732
1.772	45,0-75	1.807-1.8469	45,0R-75	1.772
1.811	46,0-75	1.847-1.8859	46,0R-75	1.811
1.850	47,0-75	1.886-1.9309	47,0R-75	1.850
1.890	48,0-75	1.9310-1.9799	48,0R-75	1.890
1.929	49,0-75	1.980-2.0039	49,0R-75	1.929
1.969	50,0-75	2.004-2.044	50,0R-75	1.969

Bearing OD 115 mm x 20 mm wide x 75 mm bore

Quantity - Quantity discounts for individual sizes only

10

PRICING
US Dollars
75 mm OD Bushing

1-24	25-47	48-99	100+	Bearings	Snap Rings
\$11.00	\$10.50	\$9.50	\$9.00	\$40.00 (6015-2RS)	\$.50 DSH-75

2 Flute

SnapGuide™



Bushing ID



Bushing OD



Shape Part #



Drill Diameter

Bearing Number

Bearing OD

.184	17mm	C	4,7-2-17	.203	6003-2rs	35 mm
.205	"	C	5,2-2-17	.212	"	"
.212	"	C	5,4-2-17	.219	"	"
.407	"	M	10,35-2-17	.423	"	"
.476	"	C	12,1-2-17	.500	"	"
.347	30 mm	M	8,81-2-30	9.6 mm	6006-2RS	55 mm
.350	30 mm	C	8,9-2-30	9.6 mm	"	"
.418	"	M	10,3-2-30	11.1 mm	"	"
.653	"	M	16,6-2-30	.688	"	"
.740	"	M	18,88-2-30	.759	"	"
.748	"	M	19,0-2-30	.767	"	"



BTA

SnapGuide™

Bushing ID	Standard Part No.	Drill Range	Fits BTA Tube Dia.	Required Bearing	Bearing OD
.272	6,9R-30	.315-.354	.280	6006-2RS	55mm
.321	8,15R-30	.355-.393	.327	"	(2.1653)
.350	8,9R-30	.394-.432	.354	"	"
.390	9,9R-30	.433-.472	.394	"	"
.429	10,9R-30	.473-.535	.433	"	"
.468	11,9R-30	.536-.575	.472	"	"
.508	12,9R-30	.576-.614	.512	"	"
.547	13,9R-30	.615-.657	.551	"	"
.587	14,9R-30	.658-.696	.591	"	"
.626	15,9R-30	.697-.744	.630	"	"
.665	16,9R-30	.745-.787	.669	"	"
.705	17,9R-30	.788-.858	.709	"	"
.783	19,9R-30	.859-.948	.787	"	"
.862	21,9R-30	.949-1.039	.866	"	"
.941	23,9R-30	1.040-1.129	.945	"	"
1.024	26,0R-45	1.130-1.220	1.024	6009-2rs	75mm
1.102	28,0R-45	1.221-1.311	1.102	"	(2.9528)
1.181	30,0R-45	1.312-1.425	1.181	"	"
1.299	33,0R-45	1.426-1.559	1.299	"	"
1.417	36,0R-45	1.560-1.692	1.417	"	"
1.535	39,0R-75	1.693-1.850	1.535	6015-2RS	115mm
1.693	43,0R-75	1.851-2.035	1.693	"	(4.5276)
1.850	47,0R-75	2.036-2.212	1.850	"	"
2.008	51,0R-75	2.213-2.559	2.008	"	"
2.205	56,0R-75	2.560-2.637	2.205	"	"
2.441	62,0R-75	2.638-2.873	2.441	"	"

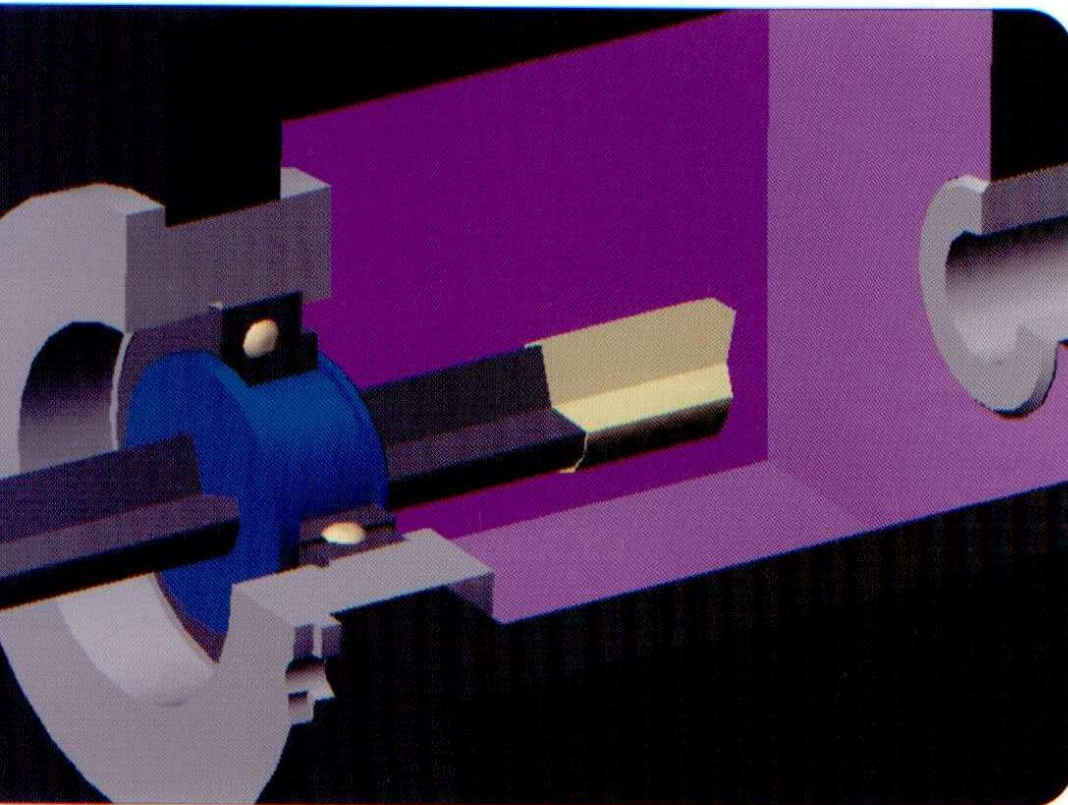
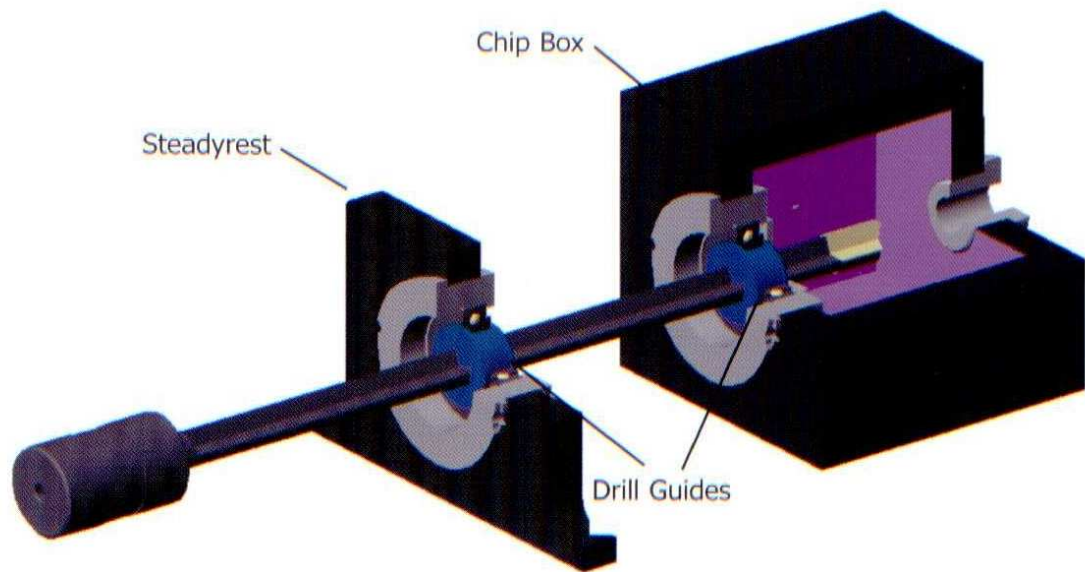


BTA bushings are round hole bushings designed to be used on the steadyrest of BTA drilling machines. They support the drill tube with a slight compression fit and help limit vibration.

About Drill Guides

Flexible plastic Drill Guide bushings stop drill whipping and seal the chip box by stretching over the carbide drill tip and contracting onto the steel drill body. They are typically mounted in a bearing and rotate with the drill. This is our first and oldest product and is still used by many customers to maximize drill penetration rates, stop vibration and maximize accuracy. These bushings perform the same function as our SnapGuide™. Our signature **Blue Bushings** guarantee you top quality.

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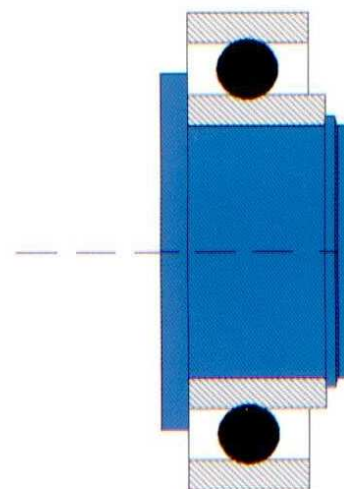
Appropriate
Drill
Sizes



Bushing ID	Part No.	Drill Range	Bearing ID	Bearing OD
.070	A100	<=.0831	.315	.9449
.080	A110	.0832-.0933	"	"
.090	A120	.0934-.1035	"	"
.105	A130	.1036-.120	"	"
.120	A140	.1201-.1329	"	"
.130	A150	.133-.1459	"	"
.140	A160	.146-.1561	"	"
.156	A170	.1562-.1823	"	"
.171	A180	.1824-.1949	"	"
.187	A190	.195-.2099	"	"
.203	B100	.210-.2289	.590	1.378
.219	B110	.229-.2499	"	"
.237	B120	.250-.2649	"	"
.250	B130	.265-.2799	"	"
.263	B140	.280-.2949	"	"
.281	B150	.295-.3079	"	"
.298	B160	.308-.3299	"	"
.314	B170	.330-.3399	"	"
.328	B174	.340-.3599	"	"
.343	B180	.360-.3699	"	"
.357	B190	.370-.3799	"	"
.375	B200	.393-.4059	"	"
.390	B210	.406-.4249	"	"
.406	C100	.425-.4479	.787	1.8504
.429	C110	.448-.4629	"	"
.437	C120	.463-.4779	"	"
.453	C130	.478-.4909	"	"
.468	C140	.491-.5099	"	"
.484	C150	.510-.5249	"	"
.500	C160	.525-.5399	"	"
.509	C170	.540-.5549	"	"
.531	C180	.555-.5649	"	"
.546	C190	.565-.5799	"	"
.562	C200	.580-.5999	"	"
.466	D030	.491-.5099	.984	2.0472
.482	D050	.510-.5249	"	"
.510	D070	.540-.5549	"	"
.578	D100	.600-.6199	"	"
.593	D110	.620-.6399	"	"
.609	D120	.640-.6599	"	"
.625	D130	.660-.6799	"	"
.640	D140		"	"
.656	D150	.680-.6999	"	"
.671	D160	.700-.7199	"	"
.687	D170		"	"
.703	D180	.720-.7399	"	"
.718	D190	.740-.7599	"	"
.703	E090	.720-.7399	1.378	2.8346
.718	E100	.740-.7599	"	"
.734	E110	.760-.7799	"	"
.750	E120	.780-.7899	"	"
.765	E130	.790-.7999	"	"
.781	E140	.800-.8199	"	"
.796	E150	.820-.8399	"	"
.812	E160	.840-.8599	"	"
.828	E170	.860-.8699	"	"
.843	E180	.870-.8799	"	"
.859	E190	.880-.9199	"	"
.875	E200		"	"
.890	E210	.920-.9399	"	"
.906	E220		"	"

Drill Guide Parts

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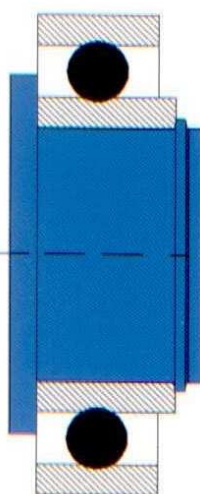
NOTE

Drill Guides are also available in a softer material by placing an "S" at the end of the part # example A100S

Drill Guide Parts

CONTINUED

14



Bushing
ID

Part No.

Appropriate
Drill
Sizes

Drill Range

Bearing
ID

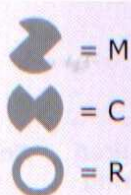
Bearing
OD

.921	E230	.940-.9599	1.378	2.8346
.937	E240	.960-.9699	"	"
.953	E250	.970-.9799	"	"
.968	E260	.980-1.0049	"	"
1.008	E280	1.045-1.1049	"	"
1.073	E290	1.105-1.1699	"	"
1.138	E300	1.170-1.219	"	"
1.183	E310	1.220-1.250	"	"
.965	F100	.980-1.0049	1.772	3.3465
.988	F104	1.005-1.0449	"	"
1.005	F110	1.045-1.1049	"	"
1.028	F114		"	"
1.065	F120	1.105-1.1699	"	"
1.135	F130	1.170-1.1999	"	"
1.145	F134	1.200-1.2349	"	"
1.180	F140	1.235-1.2599	"	"
1.235	F150	1.260-1.2999	"	"
1.275	F160	1.300-1.3409	"	"
1.305	F170	1.3410-1.399	"	"
1.335	F180	1.400-1.4439	"	"
1.346	F356		"	"
1.378	F363		"	"
1.365	G090		2.165	3.937
1.400	G100	1.444-1.4949	"	"
1.440	G110	1.495-1.5032	"	"
1.475	G120	1.503-1.5699	"	"
1.545	G130	1.570-1.6899	"	"
1.665	G140	1.690-1.7599	"	"
1.720	H100	1.760-1.8209	2.559	4.7244
1.805	H110	1.821-1.9309	"	"
1.925	H120	1.980-2.000	"	"
2.035	H130		"	"
2.180	H140		"	"

NOTE

Drill Guides are also available in a softer material by placing an "S" at the end of the part # example A100S

"G" and "H" series parts also available to fit old style 211kld and 213kld. Call for details.



Appropriate
Drill
Sizes

Bushing ID & Shape	Part No.	Drill Diameter	Bearing ID	Bearing OD
.057 R	R057	.0600-.0649	.315	.9449
.072 R	R072	.0760-.0831		
.076 R	R076	.0832-.0882		
.080 R	R080	.0883-.0933		
.083 R	R083			
.087 R	R087	.0934-.0984		
.091 R	R091	.0985-.1035		
.095 R	R095	.1036-.1086		
.100 R	R100	.1087-.1137		
.105 R	R105	.1138-.1179		
.110 R	R110	.1180-.1239		
.115 R	R115			
.119 R	R119	.1240-.1279		
.134 R	R134	.1410-.1459		
.169 R	R169	.1719-.1875		
.167 C	A185	.1875		
.218 R	R218	.2290-.2399	.590	1.378
.230 R	R230	.2450-.2499		
.239 R	R239	.2500-.2599		
.218 M	B115	.250		
.260 C	B123	.281		
.251 M	B135	.281		
.260 M	B137	.281		
.290 C	B145	.312		
.280 M	B155	.312		
.285 C	B157	.312		
.312 M	B175	.344		
.343 M	B195	.375		
.374 M	B215	.406		
.385 M	C103	.417	.7874	1.8504
.405 M	C105	.437		
.437 M	C125	.468		
.468 M	C145	.500		
.500 M	C165	.531		
.530 M	C185	.562		
.550 M	C195	.583		
.562 M	C205	.593		
.585 M	D115	.625	.9843	2.0472
.615 M	D135	.656		
.645 M	D155	.687		
.665 M	D165	.697		
.680 M	D175	.718		
.710 M	D185	.750		
.772 M	E103	.812	1.378	2.8346
.775 C	E104	.812		
.767 M	E105	.787		
1.005 M	E295	1.075		
1.150 M	E305	1.181		

Note: More round hole bushings on page 16

Drill Guide Parts

Two Flute &
Special Bushings



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Drill Guide, INC.

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Can't find the special
bushing you need? Let
us quote it!

BTA

Drill Guides



Bushing ID



Standard Part No.

Appropriate Drill Sizes

Drill Range

Fits BTA Tube Dia.

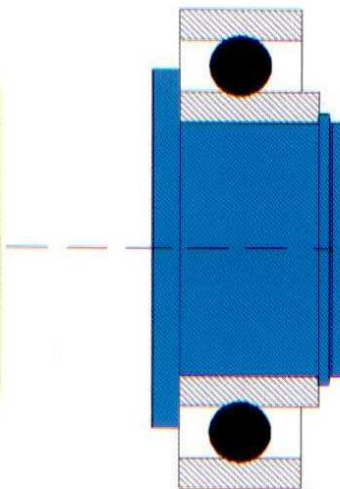
Required Bearing

Bearing OD

.276	R276	.315-.354	.280	87502	1.378
.323	R323	.355-.393	.327	"	"
.350	R350	.394-.432	.354	"	"
.390	R390	.433-.472	.394	"	"
.429	R429	.473-.535	.433	87504	1.8504
.468	R468	.536-.575	.472	"	"
.508	R508	.576-.614	.512	"	"
.547	R547	.615-.657	.551	"	"
.587	R587	.658-.696	.591	87505	2.0472
.626	R626	.697-.744	.630	"	"
.666	R666	.745-.787	.670	"	"
.705	R705	.788-.858	.709	"	"
.783	R783	.859-.948	.787	87507	2.8436
.862	R862	.949-1.039	.866	"	"
.941	R941	1.040-1.129	.945	"	"
1.020	R1020	1.130-1.220	1.024	87509	3.3465
1.098	R1098	1.221-1.311	1.102	"	"
1.177	R1177	1.312-1.425	1.181	"	"
1.295	R1295	1.426-1.559	1.299	"	"
1.413	R1413	1.560-1.692	1.417	6211-2RS	3.9370
1.531	R1531	1.693-1.850	1.535	"	"
1.689	R1689	1.851-2.035	1.693	"	"
1.846	R1846	2.036-2.212	1.850	6213-2RS	4.7244
2.004	R2004	2.213-2.559	2.008	"	"
2.201	R2201	2.560-2.637	2.205	"	"
2.437	R2437	2.638-2.873	2.441	"	"

16

BTA bushings are round hole bushings designed to be used on the steadyrest of BTA drilling machines. They support the drill tube with a slight compression fit and help limit vibration.

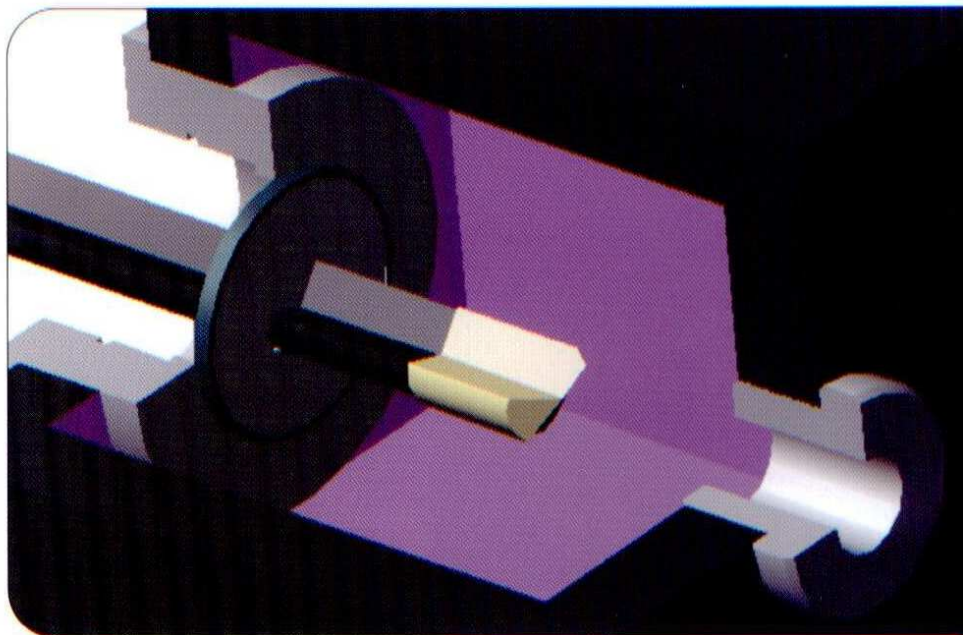


Chip Deflectors

Chip Deflectors stop metal chips and cutting oil from exiting the back of the chip box. They provide sealing only and no drill support. They are used on gun drill machines on short rigid drills when whipping is not a problem. They are also used in front of a Drill Guide or a SnapGuide to extend bushing and bearing life. Chip Deflectors feature a hardened steel face bonded to a flexible polymer backing to provide perfect sealing on the drill and long life.



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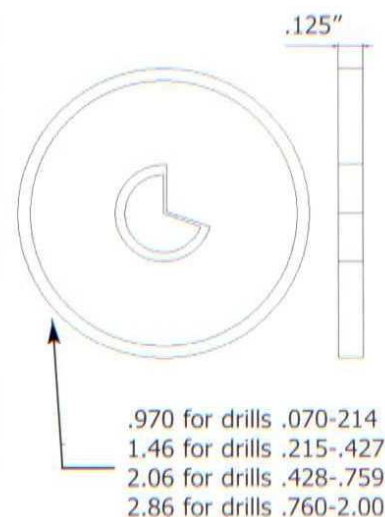


Chip Deflectors

18



		Appropriate Drill Sizes			Appropriate Drill Sizes			Appropriate Drill Sizes
Part #	Drill Range		Part #	Drill Range		Part #	Drill Range	
070	.0781-.0831		315	.3300-.3399		960	.9800-1.0049	
075	.0832-.0882		325	.3400-.3499		980	1.0050-1.0449	
080	.0883-.0933		335	.3500-.3599		1020	1.0450-1.1049	
085	.0934-.0984		345	.3600-.3699		1080	1.1050-1.1749	
090	.0985-.1035		355	.3700-.3799		1150	1.1750-1.2199	
095	.1036-.1086		365	.3800-.3879		1195	1.2200-1.2749	
100	.1087-.1137		370	.3880-.3929		1250	1.2750-1.3449	
105	.1138-.1188		375	.3930-.4029		1320	1.3450-1.4799	
110	.1189-.1239		385	.4030-.4179		1455	1.4800-1.5849	
115	.1240-.1295		400	.4130-.4279		1560	1.5850-1.7049	
120	.1296-.1350		410	.4280-.4329		1680	1.7050-1.8449	
125	.1351-.1405		415	.4330-.4379		1820	1.8450-1.9649	
130	.1406-.1458		420	.4380-.4479		1940	1.9650-2.0000	
135	.1459-.1510		430	.4480-.4629				
140	.1511-.1561		445	.4630-.4779				
145	.1562-.1614		460	.4780-.4949				
150	.1615-.1666		475	.4950-.5099				
155	.1667-.1718		490	.5100-.5249				
160	.1719-.1771		505	.5250-.5399				
165	.1772-.1823		520	.5400-.5549				
170	.1824-.1874		535	.5550-.5649				
175	.1875-.1949		545	.5650-.5799				
180	.1950-.1999		560	.5800-.5899				
185	.2000-.2049		570	.5900-.5999				
190	.2050-.2099		580	.6000-.6199				
195	.2100-.2149		600	.6200-.6399				
200	.2150-.2199		620	.6400-.6499				
205	.2200-.2249		630	.6500-.6599				
210	.2250-.2299		640	.6600-.6799				
215	.2300-.2349		660	.6800-.6999				
220	.2350-.2399		680	.7000-.7199				
225	.2400-.2449		700	.7200-.7399				
230	.2450-.2499		720	.7400-.7599				
235	.2500-.2549		740	.7600-.7799				
240	.2550-.2599		760	.7800-.7999				
245	.2600-.2649		780	.8000-.8199				
250	.2650-.2699		800	.8200-.8399				
255	.2700-.2799		820	.8400-.8599				
265	.2800-.2899		840	.8600-.8799				
275	.2900-.2949		860	.8800-.8999				
280	.2950-.2999		880	.9000-.9199				
285	.3000-.3099		900	.9200-.9399				
295	.3100-.3199		920	.9400-.9599				
305	.3200-.3299		940	.9600-.9799				



Bearing Adaptors

International Drill Guide Inc. has designed and manufactured a variety of special bearing adaptors to retrofit our products onto countless gundrill machines, transfer lines, and other special machines. We can help you retrofit our product simply and economically on any machine with little or no lead time. Most gun drill machine builders currently stock holders for our SnapGuide™ or Drill Guide designed specifically for their machines. They are another quality source for your bearing adaptor inquiries.



