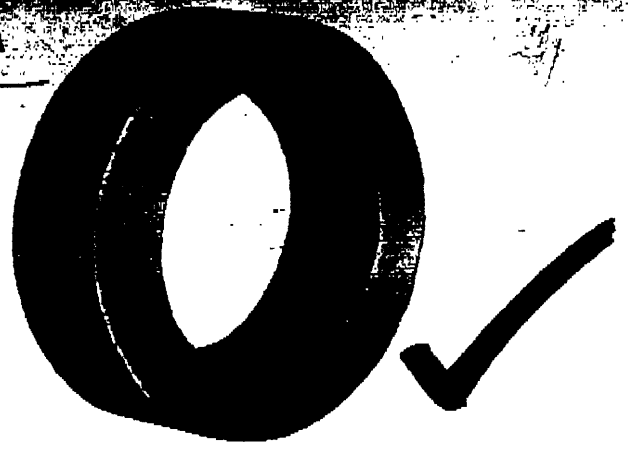
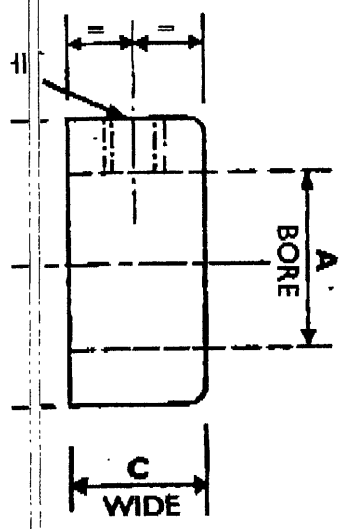


F.A.O. RACUSE MANSLOW

OLLARS ?



solid mild steel



- ✓ Manufactured from the best quality bar
- ✓ Accurately bored
- ✓ Generously dimensioned on outside diameter and width
- ✓ Fitted with unbreakable set screws
- ✓ Highly finished with smoothly ground outside diameter
- ✓ Produced entirely in our own works
- ✓ Large stock of standard sizes
- ✓ Largest size range in Britain
- ✓ 1/2" to 10" dia.

B O/DIA	C WIDTH	D TAPPED
Ins. 1/2	Ins. 1/2	Ins. 2 B.A.
3/8	5/8	"
1/2	3/4	"
3/4	7/8	1/2 Whit.
1	1 1/8	"
1 1/4	1 1/4	"
1 1/2	1 1/2	3/4 Whit.
1 3/4	1 3/4	"
2	2	1 Whit.

A BORE	B O/DIA	C WIDTH	D TAPPED
Ins. 1 1/2	Ins. 2 1/4	1 1/2	1/2 Whit.
1 3/4	2 3/4	1	"
2	3	1	3/4 Whit.
2 1/4	3 1/4	1 1/2	"
2 1/2	3 1/2	1 3/4	"
2 3/4	3 3/4	2	1 Whit.
3	4	2 1/2	"
3 1/4	4 1/4	3	"
3 1/2	4 1/2	3 1/2	"
3 3/4	4 3/4	4	"
4	5	4 1/2	"

FORDSMITH
MANCHESTER

H. FORDSMITH LIMITED
HADFIELD STREET WORKS
CORNBROOK MANCHESTER 10

TABLE 2. INCH DIMENSIONS OF COLLARS

All dimensions in inches. (See Fig. 1.)

1		2		3		4		5		6		7		8		9		10		11		1		
Bore diameter d		Tolerance H7 \dagger		Nominal D		Tolerance H4 \dagger		Length C		Chamfer D_1		Chamfer D_2		Socket set screw J^*		Taper pin pilot hole diameter H		Large end diameter Recommended taper pin \dagger		Length		Bore diameter d		
1/4		+0.0006		5/8		+0		5/16						10-32 UNF $\times 3/16$	3/64	1/16	5/64	3/32	3/4	1/4		1/4		
5/16		-0		1 1/16	3/4	-0.015		3/8		1/2		1/2			1/16	5/64	3/32	1/8	7/8	1/2	5/8	5/16	3/8	
7/16 \S				7/8		+0		7/16						1/4-28 UNF $\times 1/4$	3/32	1/8	5/32	1/8	1	7/16 \S	1/2	7/16 \S	1/2	
1/2		-0.0007		1		-0.020		1/2		3/4		3/4			1/8	5/32	5/32	5/32	1 1/4	1/2	5/8	9/16 \S	9/16 \S	
5/8		-0		1 1/8				3/4		1 1/4		1 1/4			3/16	3/16	3/16	1 1/2	1 1/2	1 1/2	1 1/16 \S	3/4	1 1/16 \S	
1 1/16 \S				1 1/4		+0		9/16						5/16-24 UNF $\times 1/4$	5/32	3/16	3/16	1 1/2	1 1/2	1 1/2	1 3/16 \S	7/8	1 3/16 \S	
1 3/16 \S		+0.0008		1 1/2		-0.025		1 1/8							1 1/64	7/32	7/32	1 3/4	2	1	1 5/16 \S	1 5/16 \S	1 5/16 \S	
7/8		-0		1 5/8				5/8							3/8-24 UNF $\times 3/8$	1 1/64	1/4	1 3/4	2	1	1 1/8	1 1/8	1 5/16 \S	
1				2				1 1/4								1 5/64	1/4	2 1/4	2 1/4	1	1 1/8	1 1/4	1 5/16 \S	
1 1/8				2 1/4				3/4								1 5/64	5/16	2 1/4	2 3/4	1 3/8	1 1/2	1 1/2	1 5/8	
1 3/8		+0.001		2 1/2		-0.030				1 1/2		1 1/2				1 5/64	5/16	2 3/4	2 3/4	1 3/8	1 1/2	1 5/8	1 5/8	
1 1/2		-0																						
1 5/8																								

* See 3.3.

† B.S. 46, 'Keys and keyways and taper pins', Part 3, 'Solid and split taper pins'.

‡ See B.S. 1916, 'Limits and fits for engineering', Part 1, 'Limits and tolerances'.

§ Non-preferred.

TABLE 1. MILLIMETRE DIMENSIONS OF COLLARS

All dimensions in millimetres. (See Fig. 1.)

1	2	3	4	5	6	7	8	9	10	11	1
Nominal Bore diameter d	Tolerance $H7/f7$	Nominal Outside diameter B	Tolerance $h14/f4$	Length C	Chamfer D_1 D_2		Thread and Socket set screw f^*	Taper pin pilot hole diameter H	Small end Recommended taper pin	Length	Nominal Bore diameter d
6	± 0.012 0	16	± 0 -0.43	8			M 4 \times 5	1.3	1.5	18	6
7											7
8	± 0.015 0	20		10	0.3	1					8
9											9
10		25		12				2.8	3	24	10
12	± 0.018 0	28	± 0 -0.52	14			M 6 \times 8	3.8	4	28	12
15											15
17											17
20		32		16					6	36	20
22											22
25	± 0.021 0	40	± 0 -0.62	18				5.8	6	45	25
28		45		20						50	28
30							M 8 \times 10				30
32		55		22					8	60	32
35										70	35
40	± 0.025 0	70	± 0 -0.74	25				7.8		85	40
45		80								90	45
50		90								100	50
55											55
60		100		22					10	110	60
65	± 0.030 0	110	± 0 -0.87							120	65
70					0.5	2					70
75		125									75
80											80
85		140									85
90	± 0.035 0		± 0 -1								90
95											95
100							M 12 \times 20	11.8	12	150	100

* See 3.3.
† See B.S. 1916, 'Limits and fits for engineering', Part 1, 'Limits and tolerances'.