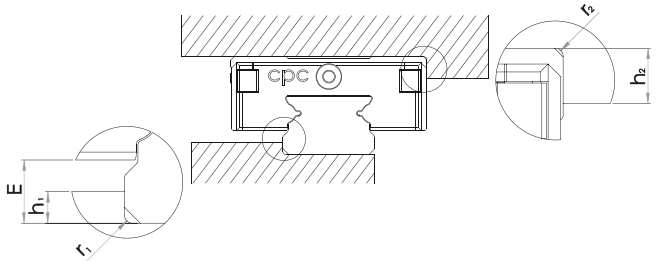
Installation Instructions

Height and Chamfer of Reference Edge

To avoid interference, the corner of the reference edge should have a chamfer. If not, please refer to the following table for the height of the reference edge corner and the height of the reference edge.



Height and chamfer of the reference surface

Size	h2	r2max	r1max	SS		ZUE	
				h1	E	h1	E
3M	1.5	0.3	0.1	0.8	1	-	-
5M	1.9	0.3	0.2	1.1	1.3	0.7	1.0
7M	2.8	0.3	0.2	1.2	1.4	-	-
9M	3	0.3	0.2	1.8	2.1	1.1	1.5
12M	4	0.5	0.3	2.6	2.9	1.7	2.1
15M	4.5	0.5	0.3	3.6	3.9	2.4	2.9

Size	h2	r2max	r1max	SS		ZUE	
				h1	E	h1	E
2WL	1.5	0.3	0.1	0.6	0.8	0.4	0.6
3W	1.7	0.3	0.1	0.4	0.6	-	-
5W	2	0.3	0.2	1.2	1.4	-	-
7W	2.8	0.3	0.2	1.7	1.9	1.1	1.4
9W	3	0.3	0.2	3	3.3	2.2	2.6
12W	4	0.5	0.3	3.5	3.7	2.4	2.8
15W	4.5	0.5	0.3	3.5	3.7	2.4	2.8

Screw tightening torque (Nm)

Screw grade 12.9 Alloy Steel Screw	Steel	Cast Iron	Non Iron Metal
M2	0.6	0.4	0.3
M2.5/M2.6	1.2	0.8	0.6
M3	1.8	1.3	1
M4	4	2.5	2

SO 3506-1 A2-70 Stainless Screw	Cast Iron
M1.6	0.15
M2	0.3
M2.5/M2.6	0.6
M3	1.1
M4	2.5

The mounting surface

The mounting surface should be ground or fine milled to reach a surface roughness of Ra1.6 µm.

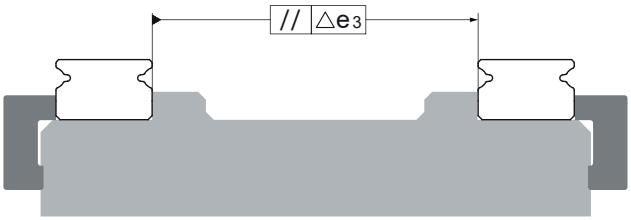
Geometric and Positional Accuracy of the Mounting Surface

Inaccurate mounting surfaces will affect the operational accuracy of the linear guide when the mounting surface height differential is greater than the values calculated by formulas (15), (16), and (17). The rating lifetime will also be shortened.

$$e1\ (mm) = b\ (mm) \cdot f1 \cdot 10^{-4} \quad \text{____(15)}$$

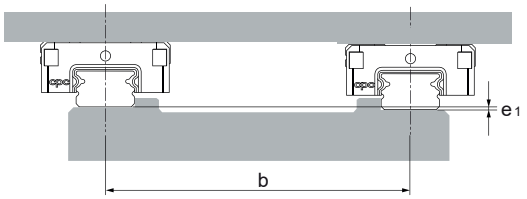
$$e2\ (mm) = d\ (mm) \cdot f2 \cdot 10^{-4} \quad \text{____(16)}$$

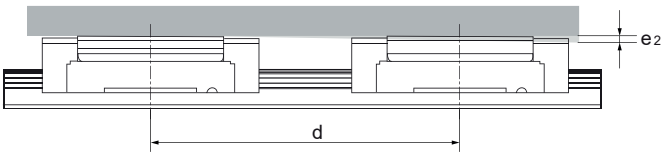
$$e3\ (mm) = f3 \cdot 10^{-3} \quad \text{____(17)}$$



Reference Edge

Rail: Both sides of the track rail can serve as the reference edge without any special marking. Block: Reference edge is opposite to the groove marking side.





Size	V0/VS			V1		
	f1	f2	f3	f1	f2	f3
3MN	4	9	2	3	9	1
5MN	4	8	2	2	8	2
7MN	5	11	4	3	10	3
9MN	5	11	6	4	10	4
12MN	6	13	8	4	12	6
15MN	7	11	12	5	10	8
3ML	4	5	2	3	5	1
5ML	3	5	2	2	5	1
7ML	4	6	4	3	6	3
9ML	5	7	5	3	7	4
12ML	5	8	8	3	7	5
15ML	7	8	11	4	8	7

Size	2V0/VS			V1		
	f1	f2	f3	f1	f2	f3
2WL	4	5	2	3	5	1
3WN	2	5	2	4	3	1
5WN	2	5	2	1	3	1
7WN	2	6	4	2	4	3
9WN	2	7	6	2	5	4
12WN	3	8	8	2	5	5
15WN	2	9	11	1	6	7
3WL	2	3	1	1	2	1
5WL	2	3	2	1	2	1
7WL	2	4	4	1	3	3
9WL	2	5	5	2	3	3
12WL	2	5	7	2	3	5
15WL	2	5	10	1	4	7