

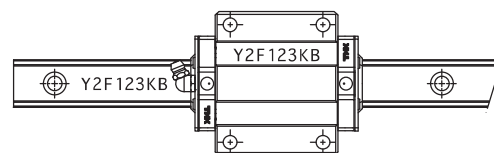
Mounting the LM Guide

Marking on the Master LM Guide and Combined Use

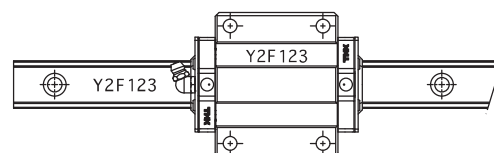
[Marking on the Master LM Guide]

All LM rails mounted on the same plane are marked with the same serial number. The LM rail marked with “KB” after the serial number is the master LM rail. The LM block on the master LM rail has its reference surface finished to a designated precision, allowing it to serve as the positioning reference for tables. (See Fig.1)

Normal grade LM Guides are not marked with “KB.” Therefore, any one of the LM rails having the same serial number can be used as the master LM rail.



Master LM Guide



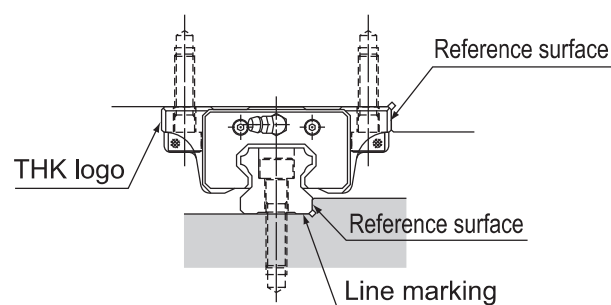
Subsidiary LM Guide

Y2F123 KB
 Master mark
 Serial number

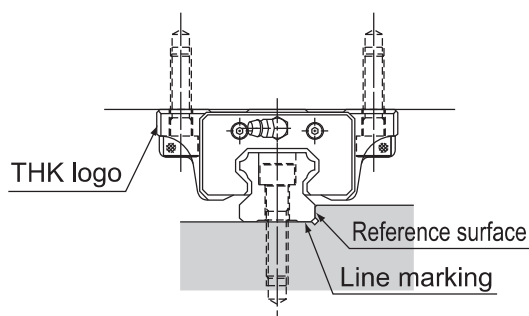
Fig.1 Master and Subsidiary LM Guides (E.g. Model HSR-B)

[Markings on the Reference Surface]

In the LM Guide, the reference surface of the LM block is opposite the surface marked with the THK logo, and that of the LM rail is on the surface marked with a line (see Fig.2). If it is necessary to reverse the reference surface of the LM rail and block, or if the grease nipple must be oriented in the opposite direction, specify it.



Master LM Guide



Subsidiary LM Guide

Fig.2 Markings on the Reference Surface

[Serial Number Marking and Combined Use of an LM Rail and LM Blocks]

An LM rail and LM block(s) used in combination must have the same serial number. When removing an LM block from the LM rail and reinstalling the LM block, make sure that they have the same serial number and the numbers are oriented in the same direction. (Fig.3)

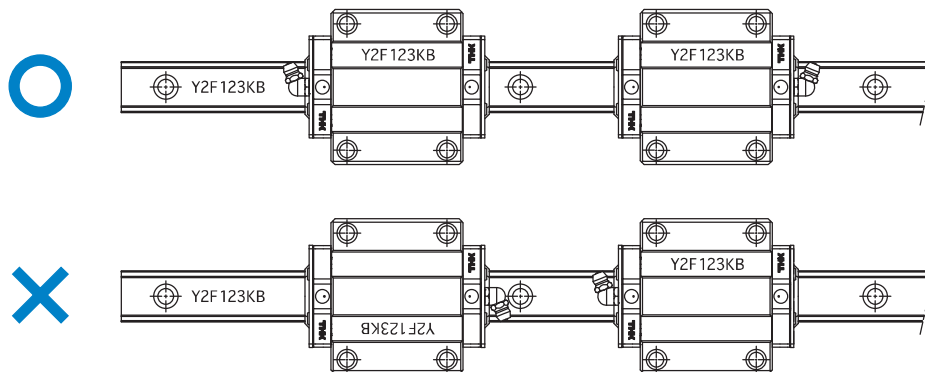


Fig.3 Serial Number Marking and Combined Use of an LM Rail and LM Blocks (E.g. Model HSR-A)

[Use of Jointed Rails]

When a long LM rail is ordered, two or more rails will be jointed together to the desired length. When jointing rails, make sure that the joint match marks shown in Fig.4 are correctly positioned.

When two LM Guides with connected rails are to be arranged in parallel to each other, the two LM Guides will be manufactured so that the two LM Guides are axisymmetrically aligned.

If a large load is applied near the LM rail joint, the LM rail may deflect and cause misalignment. Therefore, we recommend securely fastening the joint section by pressing the LM rail against the datum plane using a set screw or the like and keeping the L dimension as short as possible (Fig.4). For details, contact THK.

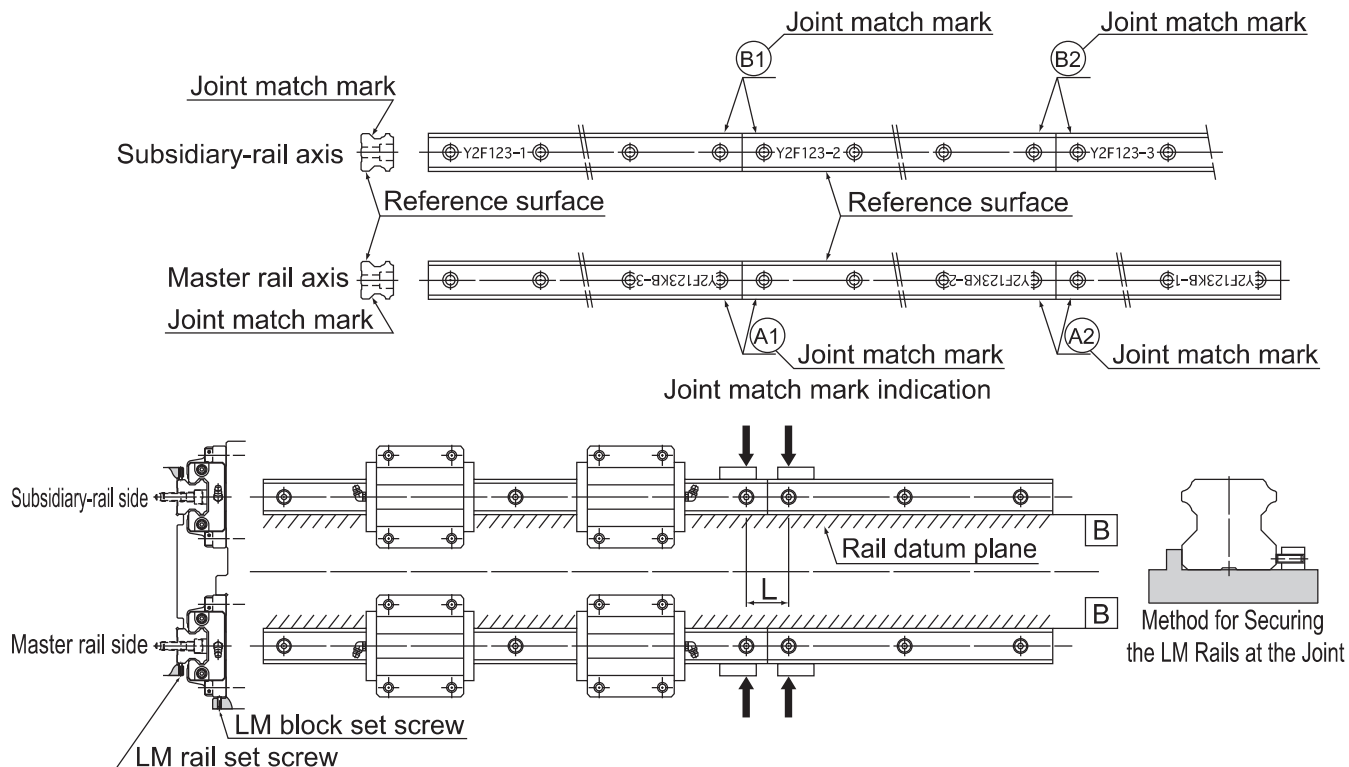


Fig.4 Use of Jointed Rails

Mounting Procedure

[Example of Mounting the LM Guide When an Impact Load is Applied to the Machine and therefore Rigidity and High Accuracy are Required]

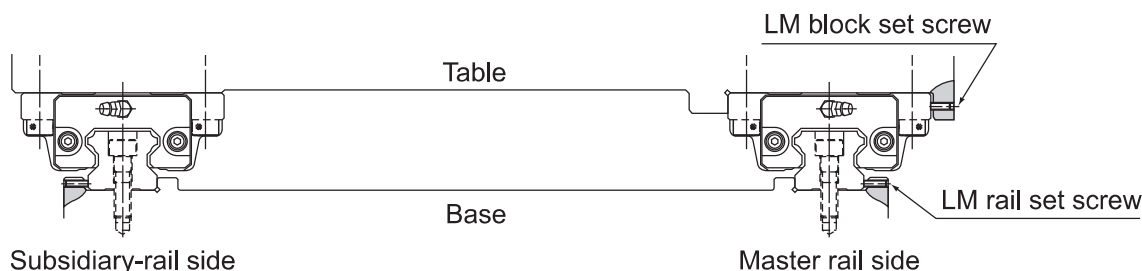


Fig.5 When an Impact Load is Applied to the Machine

● Mounting the LM Rail(s)

- (1) Be sure to remove burr, dent and dust from the mounting surface of the machine to which the LM Guide is to be mounted before installing the LM Guide. (Fig.6)

Note) Since the LM Guide is coated with anti-rust oil, remove it from the reference surface by wiping the surface with washing oil before using the guide. Once the anti-rust oil has been removed, the reference surface is prone to getting rusted. We recommend applying low-viscosity spindle oil.

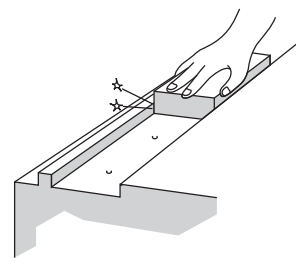


Fig.6 Checking the Mounting Surface

- (2) Gently place the LM rail onto the base, and temporarily secure the bolts to the extent that the LM rail lightly contacts the mounting surface (align the line-marked side of the LM rail with the side reference-surface of the base). (Fig.7)

Note) The bolts for securing the LM Guide must be clean. When placing the bolts into the mounting holes of the LM rail, check if the bolt holes are displaced. (Fig.8) Forcibly tightening the bolt into a displaced hole may deteriorate the accuracy.

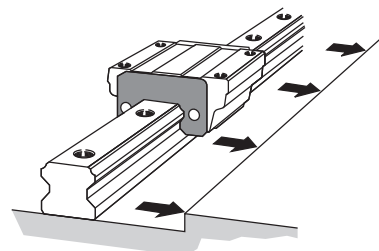


Fig.7 Aligning the LM Rail with the Reference-Surface

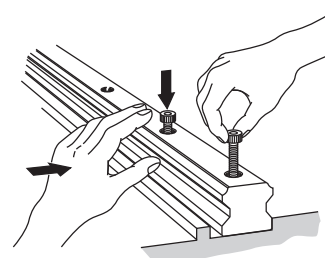


Fig.8 Checking with the Bolt for an Allowance