

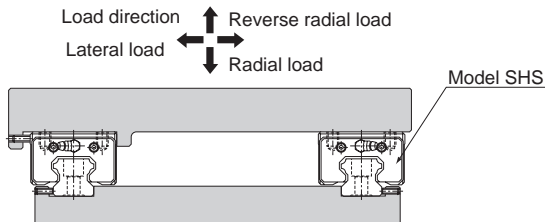
Designing the Guide System

THK offers various types of LM Guides in order to meet diversified conditions. Supporting ordinary horizontal mount, vertical mount, inverted mount, slant mount, wall mount and single-axis mount, the wide array of LM Guide types makes it easy to achieve a linear guide system with a long service life and high rigidity while minimizing the required space for installation.

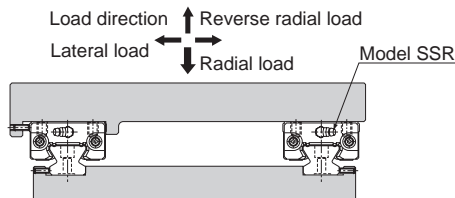
Examples of Arrangements of the Guide System

The following are representative guide systems and arrangements when installing the LM Guide. (For indication of the reference surface, see A-338.)

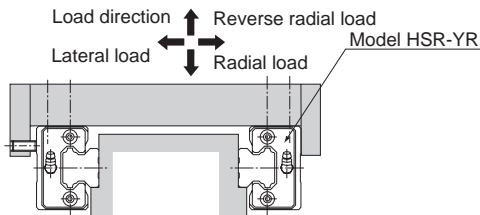
Double-rail configuration when high rigidity is required in all directions



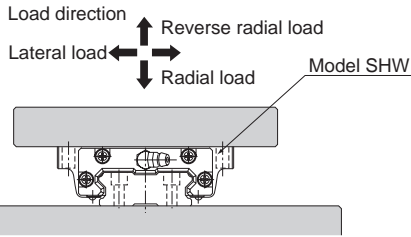
Double-rail configuration when high rigidity is required in the radial direction



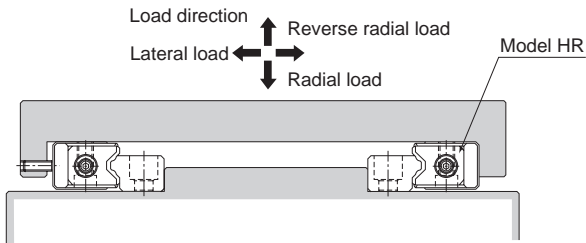
When high rigidity is required in all directions and the installation space is limited in height



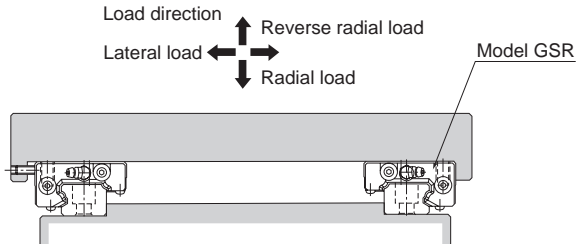
Single-rail configuration



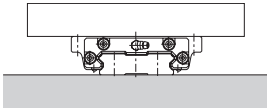
When the minimum possible height of the equipment is allowed (Adjustable preload type)



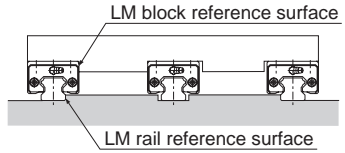
When a medium load is applied and the mounting surface is rough (Preload, self-adjusting type)



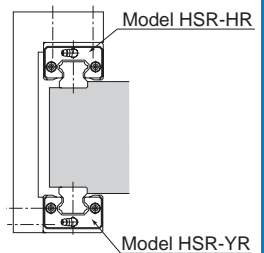
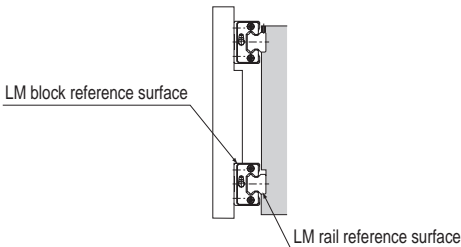
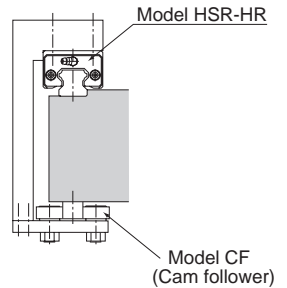
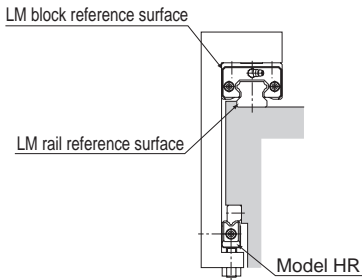
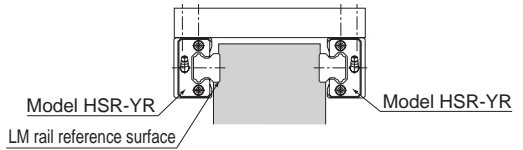
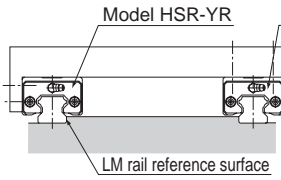
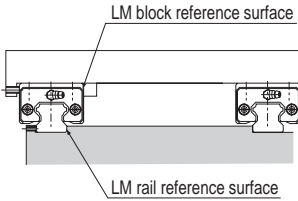
Single-rail configuration



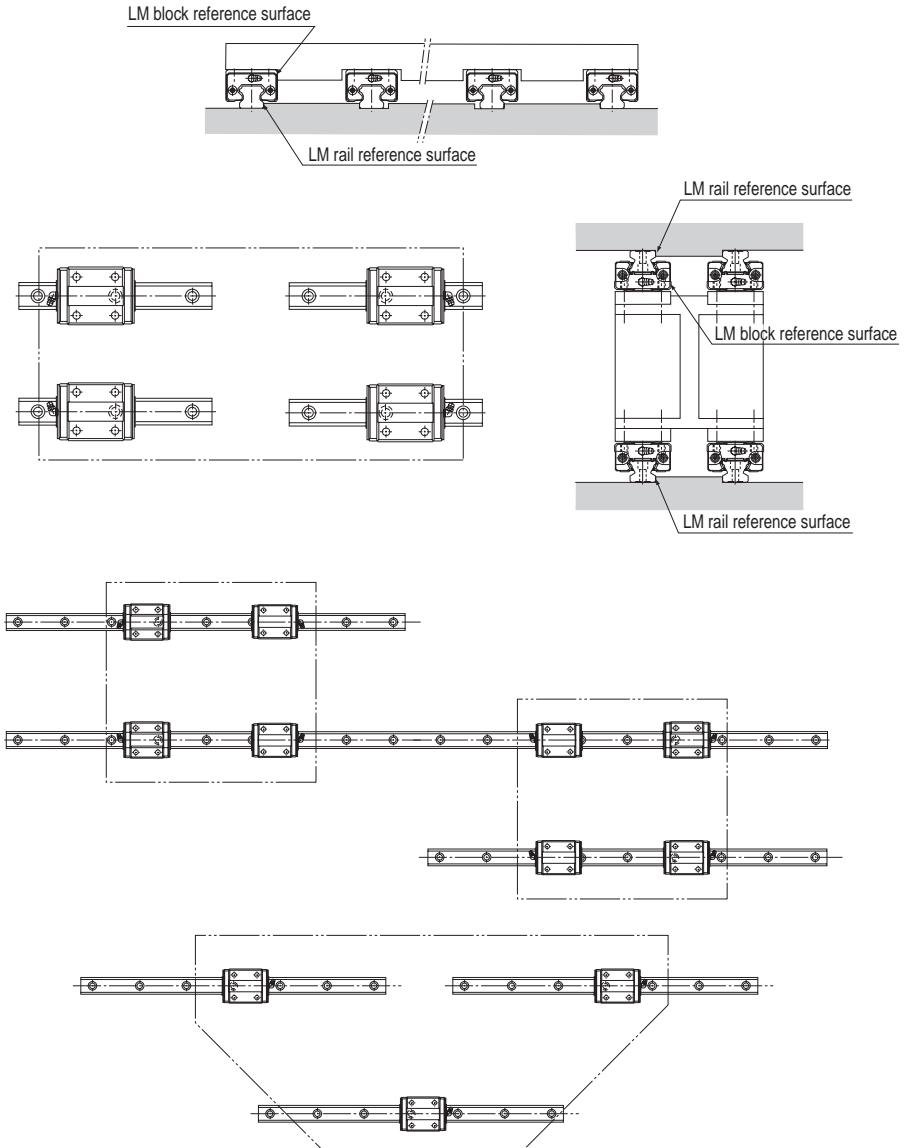
Triple-rail configuration



Double-rail configuration



4-rail configuration



Method for Securing an LM Guide to Meet the Conditions

LM Guides are categorized into groups of types by mounting space and structure: a group of types to be mounted with bolts from the top, and another of types to be mounted from the bottom. LM rails are also divided into types secured with bolts and those secured with clamps (model JR). This wide array of types allows you to make a choice according to the application.

There are several ways of mounting the LM Guide as shown in Table1. When the machine is subject to vibrations that may cause the LM rail(s) or LM blocks to loosen, we recommend the securing method indicated by Fig.1 on A-323. (If 2 or more rails are used in parallel, only the LM block on the master rail should be secured in the crosswise direction.) If this method is not applicable for a structural reason, hammer in knock pins to secure the LM block(s) as shown in Table2 on A-323 When using knock pins, machine the top/bottom surfaces of the LM rail by 2 to 3 mm using a carbide end mill before drilling the holes since the surfaces are hardened.

Table1 Major Securing Methods on the Master-rail Side

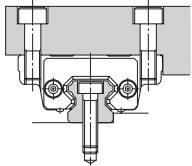
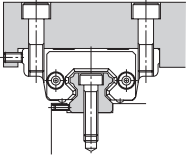
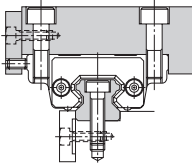
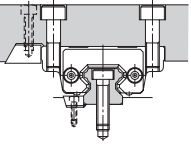
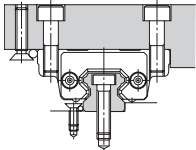
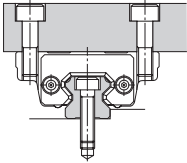
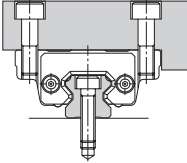
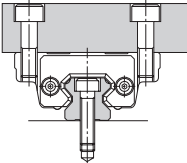
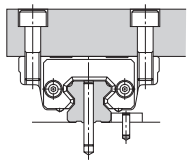
(a) Secured only with side reference surfaces	(b) Secured with set screws
	
(c) Secured with a presser plate	(d) Secured with tapered gibs
	
(e) Secured with pins	
	

Table 2 Major Securing Methods on the Subsidiary-rail Side

(a) Secured only with the side reference surface of the rail	(b) Secured only with the side reference surface of the block
	
(c) Secured without a side reference surface	(d) Secured with dowel pins
	

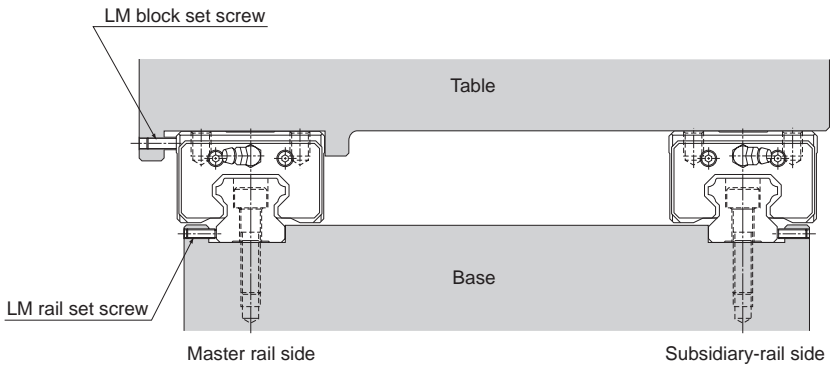
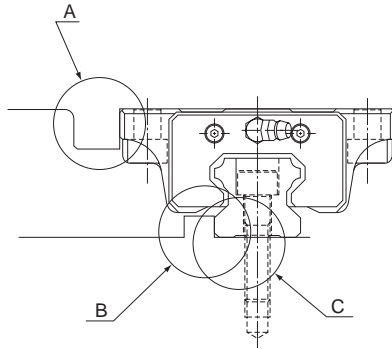


Fig.1 When the Machine Receives Vibrations or Impact

Designing a Mounting Surface

Designing a Mounting Surface

If particularly high accuracy is required for the machine to which an LM Guide is to be mounted, it is necessary to mount the LM rail with high accuracy. To achieve the desired accuracy, be sure to design the mounting surface while taking the following points into account.



[Corner Shape]

If the corner on the surface on which the LM rail or LM block is to be mounted is machined to be shaped R, which is greater than the chamfer dimension of the LM rail or LM block, then the rail or the block may not closely contact its reference surface. Therefore, when designing a mounting surface, it is important to carefully read the description on the "corner shape" of the subject model. (Fig.2)

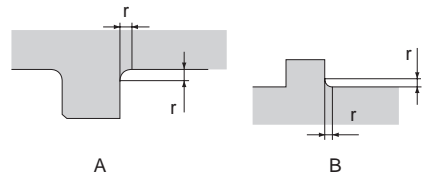


Fig.2

[Perpendicularity with the Reference Surface]

If the perpendicularity between the base mounting surface for the LM rail or the LM block and the reference surface is not accurate, the rail or the block may not closely contact the reference surface. Therefore, it is important to take into account an error of the perpendicularity between the mounting surface and the reference surface. (Fig.3)

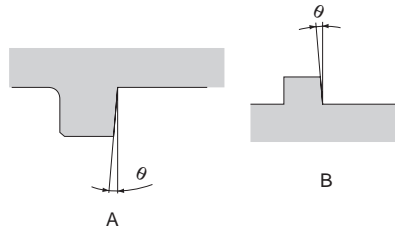


Fig.3

[Dimensions of the Reference Surface]

When designing the reference surface, be sure to take into account the height and the thickness of the datum area. If the datum area is too high, it may interfere with the LM block. If it is too low, the LM rail or the LM block may not closely contact the reference-surface depending on the chamfer of the rail or the block. Additionally, if the datum area is too thin, the desired accuracy may not be obtained due to poor rigidity of the datum area when a lateral load is applied or when performing positioning using a lateral mounting bolt . (Fig.4)

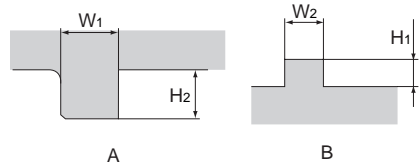


Fig.4

[Dimensional Tolerance between the Reference Surface and the Mounting Hole]

If the dimensional tolerance between the reference surface of the LM rail or the LM block and the mounting hole is too large, the rail or the block may not closely contact the reference surface when mounted on the base.

Normally, the tolerance should be within ± 0.1 mm depending on the model. (Fig.5)

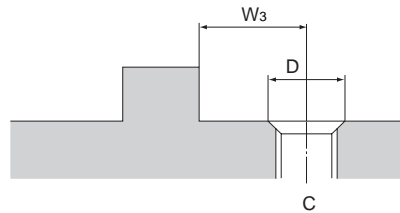


Fig.5

[Chamfer of the Tapped Mounting Hole]

To mount the LM rail, the mounting surface needs to be tapped and the tapped hole has to be chamfered. If the chamfer of the tapped hole is too large or too small, it may affect the accuracy . (Fig.6)

Guidelines for the chamfer dimension:

Chamfer diameter D = nominal diameter of the bolt + pitch

Example: Chamfer diameter D with M6 (pitch):

$$D = 6 + 1 = 7$$

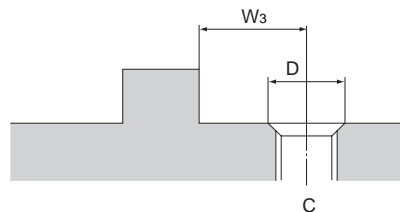


Fig.6

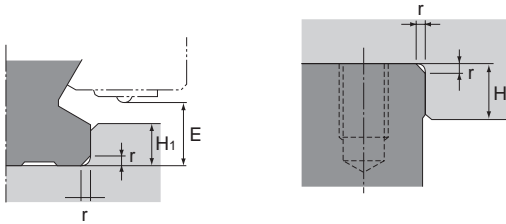
Shoulder Height of the Mounting Base and the Corner Radius

Normally, the mounting base for the LM rail and the LM block has a reference-surface on the side face of the shoulder of the base in order to allow easy installation and highly accurate positioning.

The height of the datum shoulder varies with model numbers. See A-326 to A-332 for details.

The corner of the mounting shoulder must be machined to have a recess, or machined to be smaller than the corner radius "r," to prevent interference with the chamfer of the LM rail or the LM block.

The corner radius varies with model numbers. See A-326 to A-332 for details.



Shoulder for the LM Rail

Shoulder for the LM Block (LM casing)

Fig.7

[Model SR, SR-M1]

Unit: mm

Model No.	Corner radius r(max)	Shoulder height for the LM rail H ₁	Maximum shoulder height for the LM block H ₂	E
15	0.5	3.8	4	4.5
20	0.5	5	5	6
25	1	5.5	5	7
30	1	8	6	9.5
35	1	9	6	11.5
45	1	10	8	12.5
55	1.5	11	8	13.5
70	1.5	12	10	15
85	1.2	8	12	18.5
100	1.2	10	15	19
120	1.2	12	20	15
150	1.2	12	20	22

[Model CSR]

Unit: mm

Model No.	Corner radius r(max)	Shoulder height for the LM rail H ₁	E
15	0.5	3	3.5
20	0.5	3.5	4
25	1	5	5.5
30	1	5	7
35	1	6	7.5
45	1	8	10

[Model NSR-TBC]

Unit: mm

Model No.	Corner radius r(max)	Shoulder height for the LM rail H ₁	Shoulder height for the LM block H ₂	E
20	1	5	5	5.5
25	1	6	6	6.5
30	1	7	6	9
40	1	7	8	10.5
50	1	7	8	8
70	1	7	10	9.5

[Model JR]

Unit: mm

Model No.	Corner radius r(max)	Shoulder height for the LM block H ₂
25	1	5
35	1	6
45	1	8
55	1.5	10

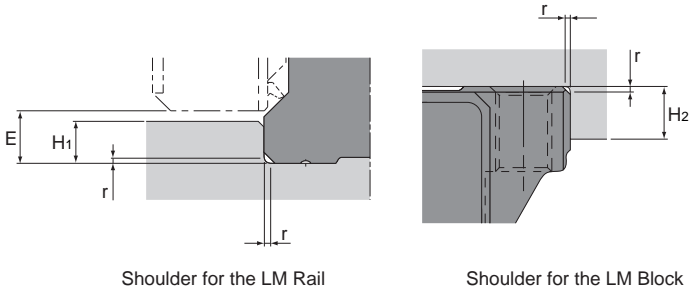


Fig.8

[Model SHS]

Unit: mm

Model No.	Corner radius r(max)	Shoulder height for the LM rail H ₁	Shoulder height for the LM block H ₂	E
15	0.5	2.5	4	3
20	0.5	3.5	5	4.6
25	1	5	5	5.8
30	1	5	5	7
35	1	6	6	7.5
45	1	7.5	8	8.9
55	1.5	10	10	12.7
65	1.5	15	10	19

[Model SCR]

Unit: mm

Model No.	Corner radius r(max)	Shoulder height for the LM rail H ₁	E
15	0.5	2.5	3
20	0.5	3.5	4.6
25	1	5	5.8
30	1	5	7
35	1	6	7.5
45	1	7.5	8.9
65	1.5	15	19

[Models SNR/SNS, SNR/SNS-H and NR/NRS]

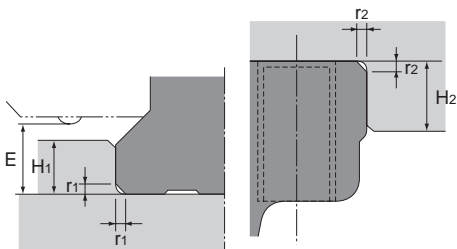
Unit: mm

Model No.	Corner radius r(max)	Shoulder height for the LM rail H ₁	Shoulder height for the LM block H ₂	E
25X	1.5	5	5	5.5
30	1	5	5	7
35	1	6	6	9
45	1	8	8	11.5
55	1.5	10	10	14
65	1.5	10	10	15
75	1.5	12	12	15
85	1.5	14	14	17
100	2	16	16	20

[Model MX]

Unit: mm

Model No.	Corner radius for the LM rail r(max)	Shoulder height for the LM rail H ₁	E
5	0.1	1.2	1.5
7W	0.1	1.7	2



Shoulder for the LM Rail

Shoulder for the LM Block

Fig.9

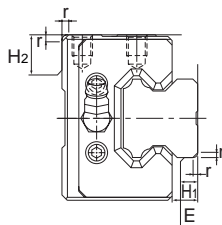


Fig.10

[Model HSR, HSR-M1 and HSR-M2]

Unit: mm

Model No.	Corner radius for the LM rail $r_1(\text{max})$	Corner radius for the LM block $r_2(\text{max})$	Shoulder height for the LM rail H_1	Shoulder height for the LM block H_2	E
8	0.3	0.5	1.6	6	2.1
10	0.3	0.5	1.7	5	2.2
12	0.8	0.5	2.6	4	3.1
15	0.5	0.5	3	4	4.7
20	0.5	0.5	3.5	5	4
25	1	1	5	5	5.5
30	1	1	5	5	7
35	1	1	6	6	7.5
45	1	1	8	8	10
55	1.5	1.5	10	10	13
65	1.5	1.5	10	10	14
85	1.5	1.5	12	14	16
100	2	2	16	16	20.5
120	2.5	2.5	17	18	20
150	2.5	2.5	20	20	22.5

[Model HSR-YR]

Unit: mm

Model No.	Corner radius $r(\text{max})$	Shoulder height for the LM rail H_1	Shoulder height for the LM block H_2	E
15	0.5	3	4	3.5
20	0.5	3.5	5	4
25	1	5	5	5.5
30	1	5	5	7
35	1	6	6	7.5
45	1	8	8	10
55	1.5	10	10	13
65	1.5	10	10	14

[Models HCR and HMG]

Unit: mm

Model No.	Corner radius for the LM rail $r_1(\text{max})$	Corner radius for the LM block $r_2(\text{max})$	Shoulder height for the LM rail H_1	Maximum shoulder height for the LM block H_2	E
12	0.8	0.5	2.6	6	3.1
15	0.5	0.5	3	4	3.5
25	1	1	5	5	5.5
35	1	1	6	6	7.5
45	1	1	8	8	10
65	1.5	1.5	10	10	14

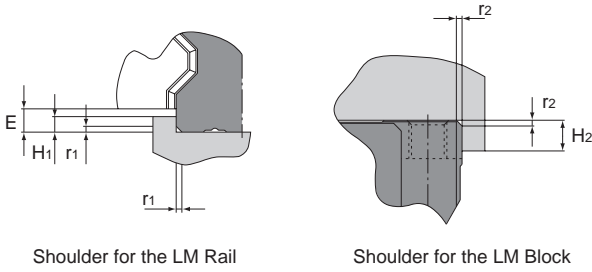


Fig.11

[Model SRG]

Unit: mm

Model No.	Corner radius for the LM rail $r_1(\text{max})$	Corner radius for the LM block $r_2(\text{max})$	Shoulder height for the LM rail H_1	Shoulder height for the LM block H_2	E
15	0.5	0.5	2.5	4	3.0
20	0.5	0.5	3.5	5	4.6
25	1	1	4	5	4.5
30	1	1	4.5	5	5
35	1	1	5	6	6
45	1.5	1.5	6	8	8
55	1.5	1.5	8	10	10
65	1.5	2	9	10	11.5

[Model SRN]

Unit: mm

Model No.	Corner radius for the LM rail $r_1(\text{max})$	Corner radius for the LM block $r_2(\text{max})$	Shoulder height for the LM rail H_1	Shoulder height for the LM block H_2	E
35	1	1	5	6	6
45	1.5	1.5	6	8	7
55	1.5	1.5	8	10	10
65	1.5	2	8	10	10

[Model SRW]

Unit: mm

Model No.	Corner radius for the LM rail $r_1(\text{max})$	Corner radius for the LM block $r_2(\text{max})$	Shoulder height for the LM rail H_1	Shoulder height for the LM block H_2	E
70	1.5	1.5	6	8	8
85	1.5	1.5	8	10	10
100	1.5	2	9	10	11.5

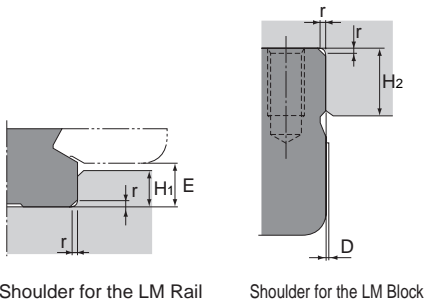


Fig.12

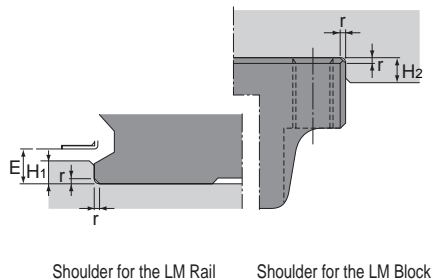


Fig.13

[Model SSR]

Unit: mm

Model No.	Corner radius r(max)	Shoulder height for the LM rail H ₁	Maximum shoulder height for the LM block H ₂	E	D
15 X	0.5	3.8	5.5	4.5	0.3
20 X	0.5	5	7.5	6	0.3
25 X	1	5.5	8	6.8	0.4
30 X	1	8	11.5	9.5	0.4
35 X	1	9	16	11.5	0.4

[Models SHW and HRW]

Unit: mm

Model No.	Corner radius r(max)	Shoulder height for the LM rail H ₁	Shoulder height for the LM block H ₂	E
12	0.5	1.5	4	2
14	0.5	1.5	5	2
17	0.4	2	4	2.5
21	0.4	2.5	5	3
27	0.4	2.5	5	3
35	0.8	3.5	5	4
50	0.8	3	6	3.4
60	1	5	8	6.5

Note) When closely contacting the LM block with the datum shoulder, the resin layer may stick out from the overall width of the LM block by the dimension D. To avoid this, machine the datum shoulder to have a recess or limit the datum shoulder's height below the dimension H₂.

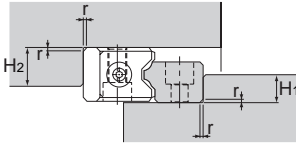


Fig.14

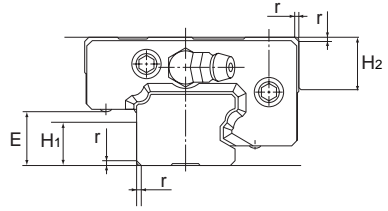


Fig.15

[Model HR]

Unit: mm

Model No.	Corner radius $r(\max)$	Shoulder height for the LM rail H_1	Shoulder height for the LM block H_2
918	0.3	5	6
1123	0.5	6	7
1530	0.5	8	10
2042	0.5	11	15
2555	1	13	18
3065	1	16	20
3575	1	18	26
4085	1.5	21	30
50105	1.5	26	32
60125	1.5	31	40

[Model GSR]

Unit: mm

Model No.	Corner radius $r(\max)$	Shoulder height for the LM rail H_1	Shoulder height for the LM block H_2	E
15	0.6	7	7	8
20	0.8	9	8	10.4
25	0.8	11	11	13.2
30	1.2	11	13	15
35	1.2	13	14	17.5

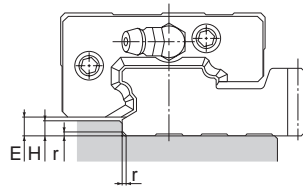
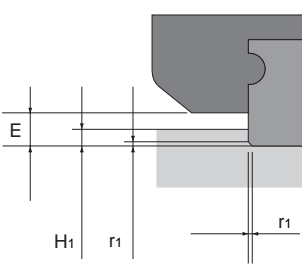


Fig.16

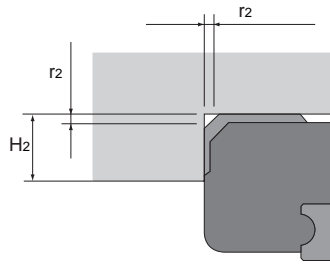
[Model GSR-R]

Unit: mm

Model No.	Corner radius $r(\max)$	Shoulder height for the LM rail H	E
25	0.8	4	4.5
30	1.2	4	4.5
35	1.2	4.5	5.5



Shoulder for the LM Rail



Shoulder for the LM Block

Fig.17

[Model SRS]

Unit: mm

Model No.	Corner radius for the LM rail $r_1(\max)$	Corner radius for the LM block $r_2(\max)$	Shoulder height for the LM rail H_1	Shoulder height for the LM block H_2	E
7 M	0.1	0.2	0.9	3.3	1.3
7 WM	0.1	0.1	1.4	3.8	1.8
9 M	0.1	0.3	0.5	4.9	0.9
9 WM	0.1	0.5	2.5	4.9	2.9
12 M	0.3	0.2	1.5	5.7	2
12 WM	0.3	0.3	2.5	5.7	3
15 M	0.3	0.4	2.2	6.5	2.7
15 WM	0.3	0.3	2.2	6.5	2.7
20 M	0.3	0.5	3	8.7	3.4
25 M	0.5	0.5	4.5	10.5	5

[Model RSR, RSR-M1 and RSH]

Unit: mm

Model No.	Corner radius for the LM rail $r_1(\max)$	Corner radius for the LM block $r_2(\max)$	Shoulder height for the LM rail H_1	Shoulder height for the LM block H_2	E
3	0.1	0.3	0.8	1.2	1
5	0.1	0.3	1.2	2	1.5
7	0.1	0.5	1.2	3	1.5
9	0.3	0.5	1.9	3	2.2
12	0.3	0.3	1.4	4	3
15	0.3	0.3	2.3	5	4
20	0.5	0.5	5.5	5	7.5
3 W	0.1	0.3	0.7	2	1
5 W	0.1	0.3	1.2	2	1.5
7 W	0.1	0.1	1.7	3	2
9 W	0.1	0.1	3.9	3	4.2
12 W	0.3	0.3	3.7	4	4
15 W	0.3	0.3	3.7	5	4

[Models RSR-Z and RSH-Z]

Unit: mm

Model No.	Corner radius for the LM rail $r_1(\max)$	Corner radius for the LM block $r_2(\max)$	Shoulder height for the LM rail H_1	Shoulder height for the LM block H_2	E
7 Z	0.1	0.5	1.2	3	1.5
9 Z	0.3	0.5	1.9	3	2.2
12 Z	0.3	0.3	2.1	4	2.4
15 Z	0.3	0.3	2.5	5	3.4
7 WZ	0.1	0.1	1.7	3	2
9 WZ	0.1	0.1	2.5	3	2.9
12 WZ	0.3	0.3	3	4	3.4
15 WZ	0.3	0.3	3	5	3.4

Permissible Error of the Mounting Surface

The LM Guide allows smooth straight motion through its self-aligning capability even when there is a slight distortion or error on the mounting surface.

[Error Allowance in the Parallelism between Two Rails]

The following tables show error allowances in parallelism between two rails that will not affect the service life in normal operation.

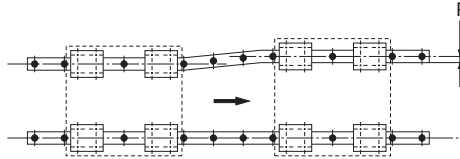


Fig.18 Error Allowance in Parallelism (P) between Two Rails

[Models SHS, HSR, CSR, HSR-M1, and HSR-M2]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
8	—	10	13
10	—	12	16
12	—	15	20
15	—	18	25
20	18	20	25
25	20	22	30
30	27	30	40
35	30	35	50
45	35	40	60
55	45	50	70
65	55	60	80
85	70	75	90
100	85	90	100
120	100	110	120
150	115	130	140

[Model JR]

Unit: μm

Model No.	—
25	100
35	200
45	300
55	400

[Model SSR, SR, SR-M1]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
15	—	25	35
20	25	30	40
25	30	35	50
30	35	40	60
35	45	50	70
45	55	60	80
55	65	70	100
70	65	80	110
85	80	90	120
100	90	100	130
120	100	110	140
150	110	120	150

[Models SNR, SNR-H and NR]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
25	14	15	21
30	19	21	28
35	21	25	35
45	25	28	42
55	32	35	49
65	39	42	56
75	44	47	60
85	49	53	63
100	60	63	70

dammy

[Models SNS, SNS-H and NRS]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
25	10	11	15
30	14	15	20
35	15	18	25
45	18	20	30
55	23	25	35
65	28	30	40
75	31	34	43
85	35	38	45
100	43	45	50

[Models SHW and HRW]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
12	—	10	13
14	—	12	16
17	—	15	20
21	—	18	25
27	—	20	25
35	20	22	30
50	27	30	40
60	30	35	50

[Models SRS, RSR, RSR-W, RSR-Z, RSH, RSH-Z and RSR-M1]

Unit: μm

Model No.	Gothic-arch groove		Circular-arc groove
	Clearance C1	Normal clearance	Normal clearance
3	—	2	—
5	—	2	—
7	—	3	—
9	3	4	11
12	5	9	15
15	6	10	18
20	8	13	25
25	10	15	30

[Model HR]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
918	—	7	10
1123	—	8	14
1530	—	12	18
2042	14	15	20
2555	20	24	35
3065	22	26	38
3575	24	28	42
4085	30	35	50
50105	38	42	55
60125	50	55	65

[Models GSR and GSR-R]

Unit: μm

Model No.	—
15	30
20	40
25	50
30	60
35	70

[Model NSR-TBC]

Unit: μm

Model No.	Clearance C1	Normal clearance
20	40	50
25	50	70
30	60	80
40	70	90
50	80	110
70	90	130

[Flatness of the Mounting Surface]

The following tables show errors in flatness of the mounting surface with models SRS, RSR, RSR-W and RSH that will not affect their service lives in normal operation. Note that if the flatness of the mounting surface is poorly established for models other than those above, it may affect the service life.

[Model SRS]

Unit: mm

Model No.	Flatness error
7 M	0.025/200
7 WM	0.025/200
9 M	0.035/200
9 WM	0.035/200
12 M	0.050/200
12 WM	0.050/200
15 M	0.060/200
15 WM	0.060/200
20 M	0.070/200
25 M	0.070/200

[Models RSR, RSR-W, RSR-Z, RSH and RSH-Z]

Unit: mm

Model No.	Flatness error
3	0.012/200
5	0.015/200
7	0.025/200
9	0.035/200
12	0.050/200
15	0.060/200
20	0.110/200
7 A	0.100/200
9 A	0.160/200
12 A	0.200/200
15 A	0.250/200
20 A	0.300/200

Note1) With the mounting surface, multiple accuracies are combined in many cases. Therefore, we recommend using 70% or less of the values above.

Note2) The above figures apply to normal clearances. When using two or more rails with clearance C1, we recommend using 50% or less of the values above.

[Error Allowance in Vertical Level between Two Rails]

The values in the tables on A-336 and A-337 represent error allowances in vertical level between two rails per axis-to-axis distance of 500 mm and are proportionate to axis-to-axis distances (200 mm for model RSR).

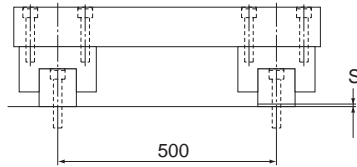


Fig. 19 Error Allowance in Vertical Level (S) between Two Rails

[Models SHS, HSR, CSR, HSR-M1, and HSR-M2]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
8	—	11	40
10	—	16	50
12	—	20	65
15	—	85	130
20	50	85	130
25	70	85	130
30	90	110	170
35	120	150	210
45	140	170	250
55	170	210	300
65	200	250	350
85	240	290	400
100	280	330	450
120	320	370	500
150	360	410	550

[Model SSR, SR, SR-M1]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
15	—	100	180
20	80	100	180
25	100	120	200
30	120	150	240
35	170	210	300
45	200	240	360
55	250	300	420
70	300	350	480
85	350	420	540
100	400	480	600
120	450	540	720
150	500	600	780

[Models SNR, SNR-H and NR]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
25	35	43	65
30	45	55	85
35	60	75	105
45	70	85	125
55	85	105	150
65	100	125	175
75	110	135	188
85	120	145	200
100	140	165	225

[Model JR]

Unit: μm

Model No.	—
25	400
35	500
45	800
55	1000

dummy

[Models SNS, SNS-H and NRS]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
25	49	60	91
30	63	77	119
35	84	105	147
45	98	119	175
55	119	147	210
65	140	175	245
75	154	189	263
85	168	203	280
100	196	231	315

[Models SRS, RSR, RSR-W, RSR-Z, RSH, RSH-Z and RSR-M1]

Unit: μm

Model No.	Gothic-arch groove		Circular-arc groove
	Clearance C1	Normal clearance	Normal clearance
3	—	15	—
5	—	20	—
7	—	25	—
9	6	35	160
12	12	50	200
15	20	60	250
20	30	70	300
25	40	80	350

[Models SHW and HRW]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
12	—	11	40
14	—	16	50
17	—	20	65
21	—	85	130
27	—	85	130
35	70	85	130
50	90	110	170
60	120	150	210

[Model HR]

Unit: μm

Model No.	Clearance C0	Clearance C1	Normal clearance
918	—	15	45
1123	—	20	50
1530	—	60	90
2042	50	60	90
2555	85	100	150
3065	95	110	165
3575	100	120	175
4085	120	150	210
50105	140	175	245
60125	170	200	280

[Models GSR and GSR-R]

Unit: μm

Model No.	—
15	240
20	300
25	360
30	420
35	480

[Model NSR-TBC]

Unit: μm

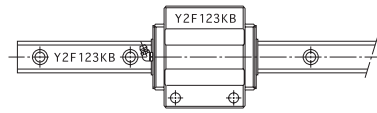
Model No.	Clearance C1	Normal clearance
20	210	300
25	240	360
30	270	420
40	360	540
50	420	600
70	480	660

Marking on the Master LM Guide and Combined Use

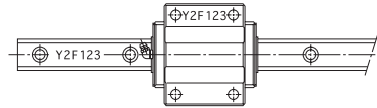
[Marking on the Master LM Guide]

All LM rails mounted on the same plane are marked with the same serial number. Of those LM rails, the one 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 accuracy, allowing it to serve as the positioning reference for the table. (See Fig.20.)

LM Guides of normal grade 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

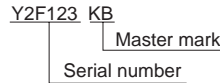
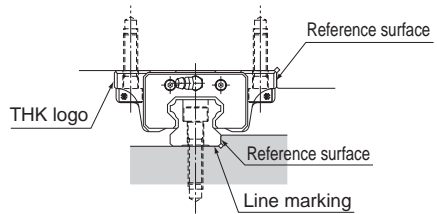


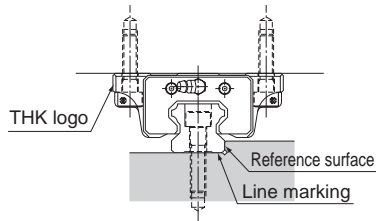
Fig.20 Master LM Guide and Subsidiary LM Guide

[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.21). 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.21 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.22)

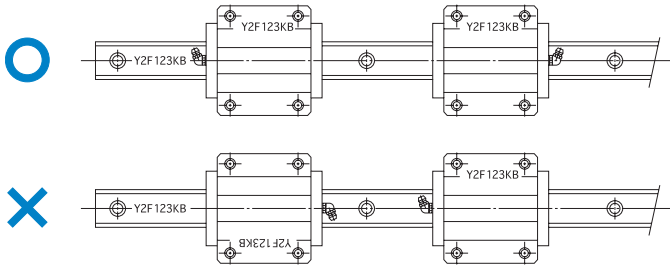


Fig.22 Serial Number Marking and Combined Use of an LM Rail and LM Blocks

[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.23 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.

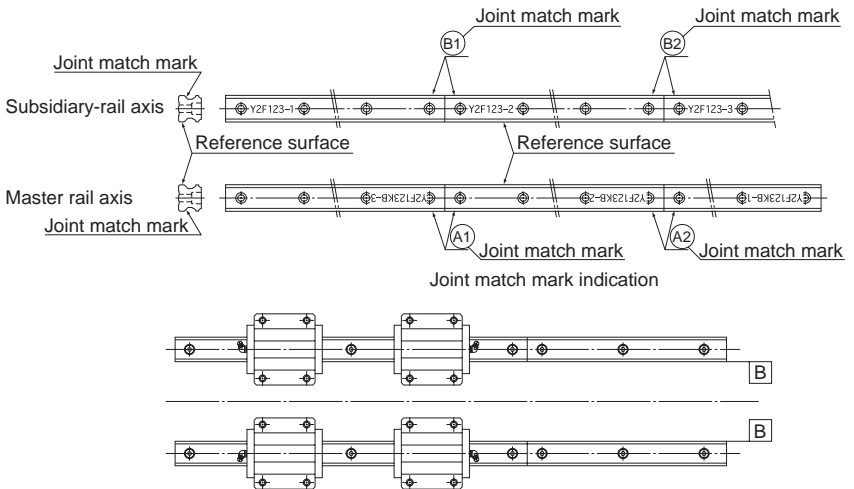


Fig.23 Use of Jointed Rails

Mounting the LM Guide

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]

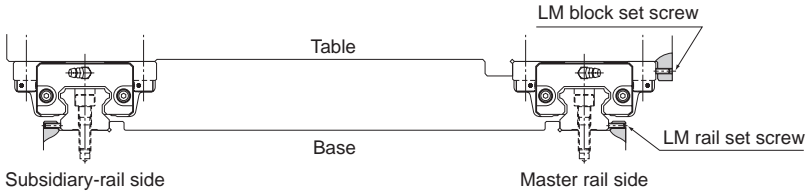


Fig.1 When an Impact Load is Applied to the Machine

● 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.2)

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.

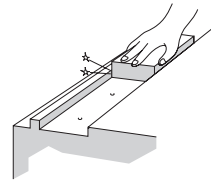


Fig.2 Checking the Mounting Surface

- (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.3)

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.4) Forcibly tightening the bolt into a displaced hole may deteriorate the accuracy.

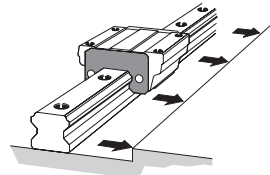


Fig.3 Aligning the LM Rail with the Reference-Surface

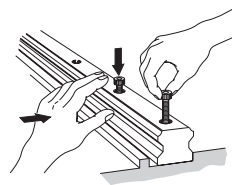


Fig.4 Checking with the Bolt for an Allowance

(3) Secure the set screws for the LM rail in order with a tightening force just enough to have the rail closely contact the side mounting surface. (Fig.5)

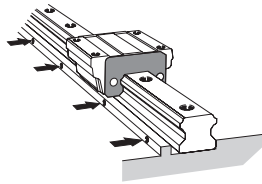


Fig.5 Tightening the Set screws

(4) Tighten the mounting bolts at the designated torque using a torque wrench. (See Fig.6, and Table1 and Table2 on A-350.)

Note) To achieve stable accuracy when tightening the LM rail mounting bolts, tighten them in order from the center to the rail ends.

(5) Mount the other rail in the same manner to complete the installation of the LM rails.

(6) Hammer in caps into the bolt holes on the top face of each LM rail until the top of the cap is on the same level as the top face of the rail.

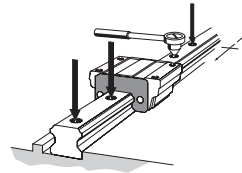


Fig.6 Fully Fastening the Mounting Bolts

● Mounting the LM Blocks

(1) Gently place the table on the LM blocks and temporarily fasten the mounting bolts.

(2) Press the master side LM blocks to the side reference surface of the table using set screws and position the table. (See Fig.1 on A-340.)

(3) Fully fasten the mounting bolts on the master side and the subsidiary side to complete the installation.

Note) To evenly secure the table, tighten the mounting bolts in diagonal order as shown in Fig.7.

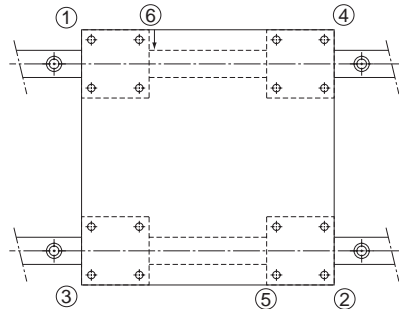


Fig.7 Sequence of Tightening the LM Blocks

This method saves time in establishing straightness of the LM rail and eliminates the need to machine securing dowel pins, thus to drastically shorten the installation man-hours.

[Example of Mounting the LM Guide When the Master LM Rail is not Provided with Set screws]

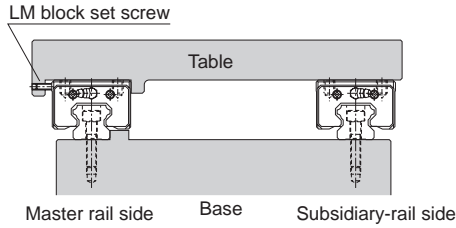


Fig.8 When the Master LM Rail is not Provided with Set screws

● **Mounting the Master LM Rail**

After temporarily fastening the mounting bolts, firmly press the LM rail to the side reference surface at the position of each mounting bolt using a small vice and fully fasten the bolt. Perform this in order from either rail end to the other. (Fig.9)

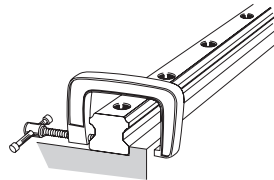


Fig.9

● **Mounting the Subsidiary LM Rail**

To mount the subsidiary LM rail in parallel with the master LM rail, which has been correctly installed, we recommend adopting the methods below.

■ **Using a Straight-edge**

Place straight-edges between the two rails, and arrange the straight-edges in parallel with the side reference surface of the master LM rail using a dial gauge. Then, secure the mounting bolts in order while achieving straightness of the subsidiary rail with the straight edge as the reference by using the dial gauge. (Fig.10)

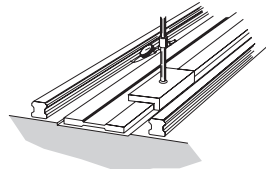


Fig.10

■Using Parallelism of the Table

Secure the two LM blocks on the master LM rail with the table (or a temporary table for measurement), and temporarily fasten the LM rail and the LM block on the subsidiary LM rail with the table. Place a dial gauge to the side face of the LM block on the subsidiary rail from the dial stand fixed on the table top, then fasten the bolts in order while achieving parallelism of the subsidiary LM rail by moving the table from the rail end. (Fig.11)

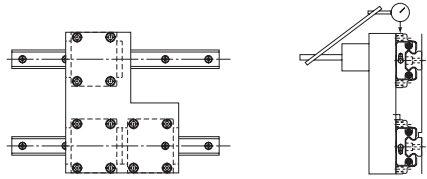


Fig.11

■Having the Subsidiary LM Rail Follow the Master LM Rail

Place the table on the blocks of the correctly mounted master LM rail and the temporarily fastened subsidiary LM rail, and fully fasten the two LM blocks on the master rail and one of the two LM blocks on the subsidiary rail with bolts. Fully tighten the mounting bolts on the subsidiary LM rail in order while temporarily fastening the remaining LM block on the subsidiary LM rail. (Fig.12)

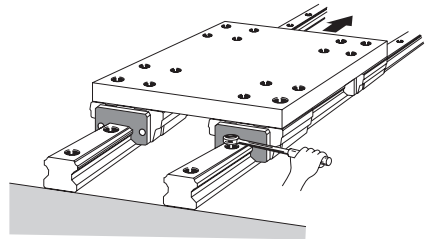


Fig.12

■Using a Jig

Use a jig like the one shown in Fig.13 to achieve parallelism of the reference surface on the subsidiary side against the side reference surface of the master side from one end of the rail by the mounting pitch, and at the same time, fully fasten the mounting bolts in order. (Fig.13)

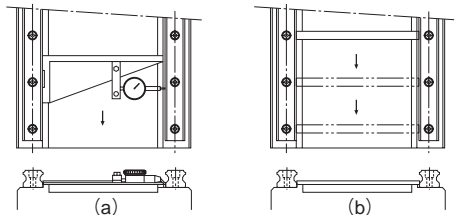


Fig.13

[Example of Mounting the LM Guide When the Master LM Rail Does not Have a Reference Surface]

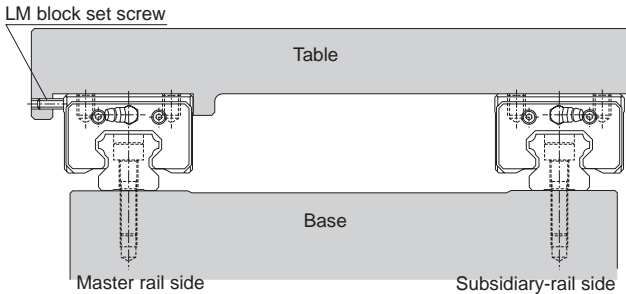


Fig.14

● Mounting the Master LM Rail

■ Using a Temporary Reference Surface

You can temporarily set a reference surface near the LM rail mounting position on the base to achieve straightness of the LM rail from the rail end. In this method, two LM blocks must be joined together and attached to a measurement plate, as shown in Fig.15.

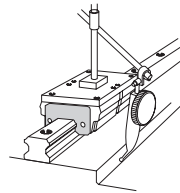


Fig.15

■ Using a Straight-edge

After temporarily fastening the mounting bolts, use a dial gauge to check the straightness of the side reference surface of the LM rail from the rail end, and at the same time, fully fasten the mounting bolts.(Fig.16)

To mount the subsidiary LM rail, follow the procedure described on A-342.

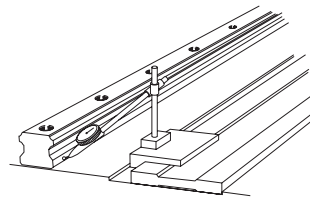


Fig.16

[Procedure for Assembling Model HR]

The following procedure is recommended for assembling model HR.

- (1) Remove burr or knots from the LM rail mounting surface of the base using an oil-stone. (Fig.17)
- (2) Use a small vice to press the two LM rails to the base so that they closely contact the reference surface, then tighten the mounting bolts to the recommended torque (see A-350). (Fig.18)
 - a. Check if any of the bolts has a sinking.
 - b. Use a torque wrench to tighten the bolts in order from the center to both ends.
- (3) Mount the LM blocks on the table, then install them onto the LM rails. Be sure the mounting bolts for the LM blocks are temporarily fastened.

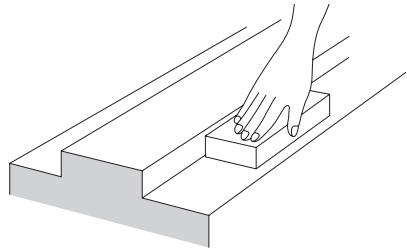


Fig.17

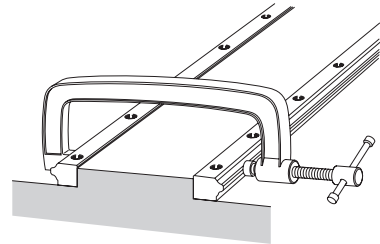


Fig.18

- (4) Tighten the clearance adjustment bolt alternately to adjust the clearance.

If a relatively large preload is applied in order to achieve high rigidity, control the tightening torque or the rolling resistance.

 - a. It is preferable to use three clearance adjustment bolts for each LM block as shown in Fig.19.
 - b. To obtain a favorable result of the clearance adjustment, set the tightening torque of the two outside screws at approx. 90% of that of the center screw.

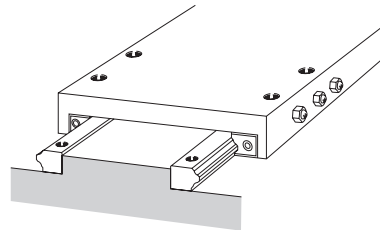


Fig.19

- (5) Secure each LM block by gradually tightening the two LM block mounting bolts, which have temporarily been fastened, while sliding the table. (Fig.20)

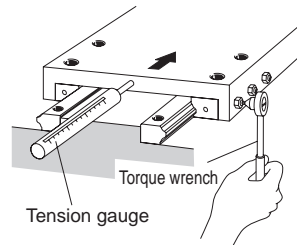


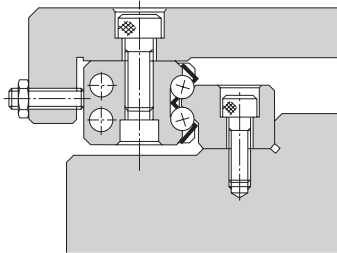
Fig.20

● **Example of Clearance Adjustment**

Design the clearance adjustment bolt so that it presses the center of the side face of the LM block.

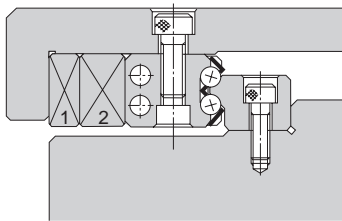
a. Using an adjustment screw

Normally, an adjustment screw is used to press the LM block.



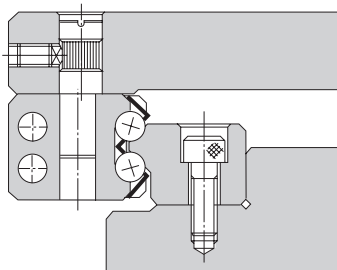
b. Using tapered gibs

When high accuracy and high rigidity are required, use tapered gibs 1) and 2).



c. Using an eccentric pin

A type using an eccentric pin to adjust the clearance is also available.



[Procedure for Assembling Model GSR]

The procedure for assembling model GSR is as follows:

- (1) Align the table with the reference-surface of each LM block and fully fasten the mounting bolts to secure the blocks. Both ends of the table must have a datum surface. (Fig.21)
- (2) Place LM rail A onto the base and align the rail with a straight-edge. Fully fasten the mounting bolts using a torque wrench. (Fig.22)
- (3) Temporarily secure LM rail B onto the base, then mount the blocks on the rail by sliding the blocks. Temporarily fasten LM rail B while pressing it toward the LM blocks. (Fig.23)
- (4) Slide the table a few strokes to fit the LM blocks to LM rail B, then fully fasten LM rail B using a torque wrench. (Fig.24)

If there are more GSR units to be assembled, we recommend producing a jig like the one shown in Fig.25 first. You can easily mount LM rails while achieving parallelism of the LM rails using the jig.

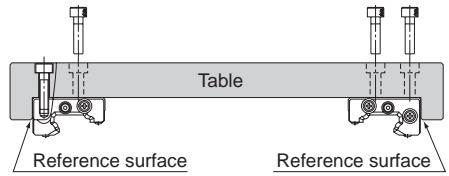


Fig.21

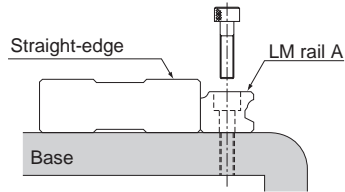


Fig.22

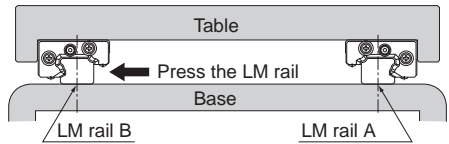


Fig.23

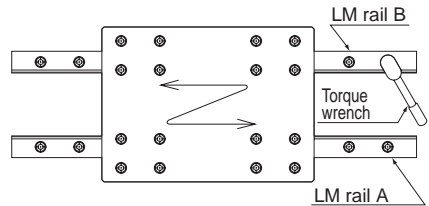


Fig.24

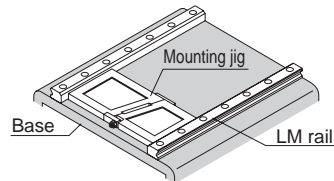


Fig.25

[Procedure for Assembling Model JR]

● Mounting the LM Rails

When two LM rails are to be used in parallel as shown in Fig.26, first secure one LM rail on the base, and place a dial gauge on the LM block. Then, place the pointer of the dial gauge on the side face and top face of the other LM rail to simultaneously adjust the parallelism and the level, thus to complete mounting the LM rails.

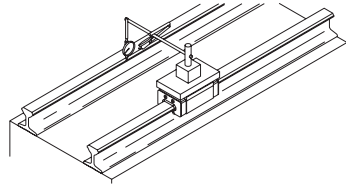


Fig.26

● Jointing LM Rails

When two or more LM rails are to be jointed, a special metal fitting as shown in Fig.27 is available. For such applications, specify this fitting when ordering the LM Guide.

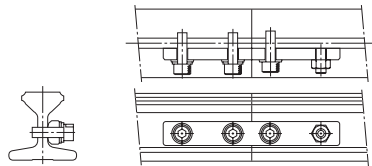


Fig.27

● Welding the LM Rail

When welding the LM rail, it is best to weld the LM rail while clamping it at the welding point with a small vice or the like as shown in Fig.28. For effective welding, we recommend the following welding conditions. (During welding the LM rail, take care to prevent spatter from contacting the LM rail raceway.)

[Welding conditions]

Preheating temperature: 200°C

Postheating temperature: 350°C

(Note) If the temperature exceeds 750°C, the LM rail may be hardened again.

[For shielded metal arc welding]

Welding rod: LB-52 (Kobelco)

[For carbon dioxide arc welding]

Wire: YGW12

Electric current: 200A

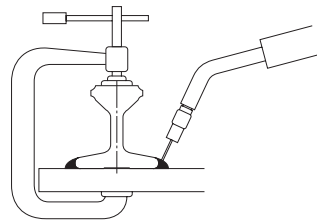


Fig.28

[Procedure for Assembling Model HCR]

To install the LM rails of R Guide model HCR, we recommend having any form of datum point (such as a pin) on the reference side (inside) of the LM rail, and pressing the LM rail to the datum point then stopping the LM rail with a presser plate from the counter-reference surface.

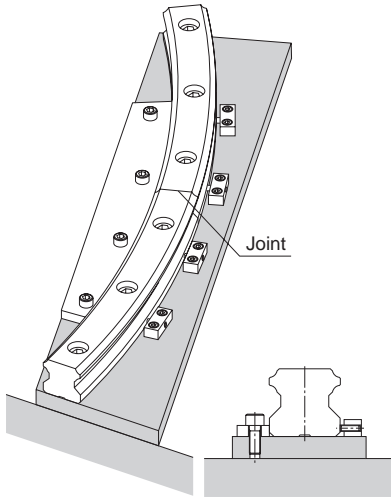


Fig.29 Method for Securing the LM Rails at the Joint

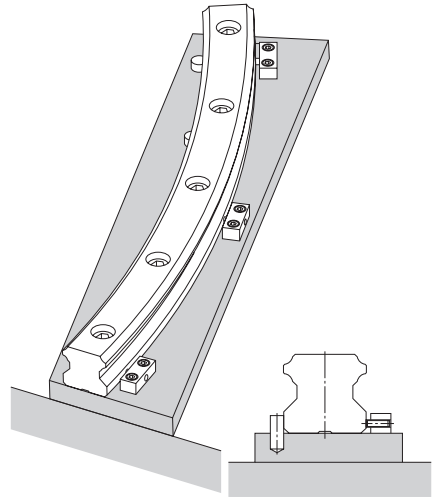


Fig.30 Method for Securing the LM Rail Using a Pin as a Datum Point

Methods for Measuring Accuracy after Installation

[When Measuring Running Accuracy for Single Rail Application]

When measuring running accuracy of the LM block, stable accuracy can be obtained by securing two LM blocks on an inspection plate, as shown in Fig.31. When using a dial gauge, we recommend placing the straight-edge as close as possible to the LM block in order to perform accurate measurement.

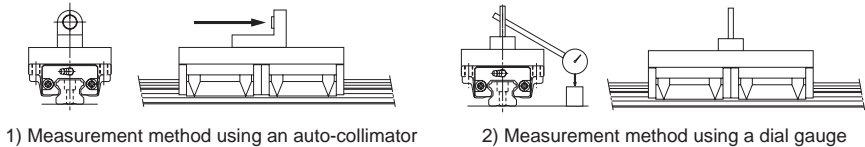


Fig.31 Methods for Measuring Accuracy after Installation

Recommended Tightening Torque for LM Rails

With high-precision LM rails for the LM Guide, their raceways are ground and accuracy is inspected with the rails tightened with bolts. When mounting a high-precision LM rail on a machine, we recommend using the corresponding tightening torque indicated in Table1 or Table2

Table1 Tightening Torques when Pan Head Screws are Used
Unit: N-cm

Screw model No.	Tightening torque	
	Not hardened	Hardened
M 2	17.6	21.6
M 2.3	29.4	35.3
M 2.6	44.1	52.9

Table2 Tightening Torques when Hexagonal-Socket-Head Type Bolts are Used
Unit: N-cm

Screw model No.	Tightening torque		
	Iron	Casting	Aluminum
M 2	58.8	39.2	29.4
M 2.3	78.4	53.9	39.2
M 2.6	118	78.4	58.8
M 3	196	127	98
M 4	412	274	206
M 5	882	588	441
M 6	1370	921	686
M 8	3040	2010	1470
M 10	6760	4510	3330
M 12	11800	7840	5880
M 14	15700	10500	7840
M 16	19600	13100	9800
M 20	38200	25500	19100
M 22	51900	34800	26000
M 24	65700	44100	32800
M 30	130000	87200	65200