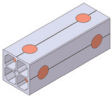
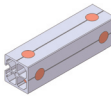
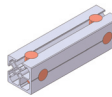
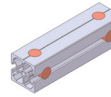
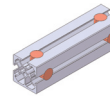
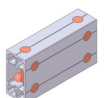
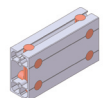
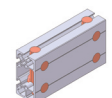
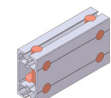
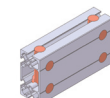


Alterations for SLF Series

Nut Hole Machining

- Alterations are required for connecting two extrusions of SLF Series.
- See below for the standardization of right/left-hand end face and horizontal/vertical positions.

Square				
SLF6-4040/SLF8-5050	SLFC6-4040/SLFC8-5050	SLFT6-4040/SLFT8-5050	SLFH6-4040/SLFH8-5050	SLFF6-4040/SLFF8-5050
				
Rectangle				
SLF6-4080/SLF8-50100	SLFC6-4080/SLFC8-50100	SLFT6-4080/SLFT8-50100	SLFH6-4080/SLFH8-50100	SLFF6-4080/SLFF8-50100
				

Nut Hole Machining in Fixed Position

Extrusion Series

H(mm)

SLF□6-40□□

20

SLF□8-50□□

25

Nut hole machining for 3-Way/2-Way Joint Kit connections and screw connections.

Left-hand Side Horizontal

LNH

Left-hand Side Vertical

LVN

Right-hand Side Horizontal

RNH

Right-hand Side Vertical

RNV

Both Sides Horizontal

NHW

Both Sides Vertical

NVW

Extrusion Series

H₁(mm)

H₂(mm)

SLF□6-4040

29

-

SLF□6-4080

69

29

SLF□8-5050

35

-

SLF□8-50100

85

35

When using Short Nuts (SNTTS) with Extrusions with Slot Type, nut holes not going through the slots can be provided.

Left-hand Side Horizontal

LSH

Left-hand Side Vertical

LSV

Right-hand Side Horizontal

RSH

Right-hand Side Vertical

RSV

Both Sides Horizontal

SHW

Both Sides Vertical

SVW

Ordering Example: Part Number - L
SLF6-4040 - 2000 - NHW

Type		Nut Hole Machining (Fixed Position)					
		Left-hand Side Horizontal	Left-hand Side Vertical	Right-hand Side Horizontal	Right-hand Side Vertical	Both Sides Horizontal	Both Sides Vertical
SLF6	4040						
SLF6	4080						
SLF6	5050						
SLF6	50100						

Type		Short Nut Hole Machining (Fixed Position)					
		Left-hand Side Horizontal	Left-hand Side Vertical	Right-hand Side Horizontal	Right-hand Side Vertical	Both Sides Horizontal	Both Sides Vertical
SLF6	4040	-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
SLF6	4080	-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
SLF6	5050	-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
SLF6	50100	-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-

Position Specification: Nut/Screw Hole Machining

Nut/screw hole machining is provided at specified positions. Hole positions are specifiable up to 5.

Horizontal
AH, BH, CH, DH, EH

Vertical
AV, BV, CV, DV, EV

*For standardized positions and machining directions, see figures on P.733.

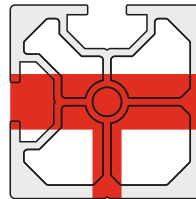
Specifications of Hole Size and Position

Extrusion Series	d (mm)
SLF□6-4040	6.5
SLF□6-4080	6.5
SLF□8-5050	9
SLF□8-50100	9

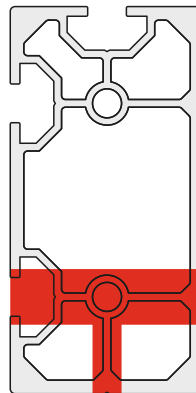
Ordering Example: Part Number - L
SLF6-4040 - 2000 - AH50 - BH600

Type		Nut Hole Machining (Specified Position)	
		Horizontal AH-EH	Vertical AV-EV
SLF6	4040		
SLFC6			
SLFT6			
SLFH6			
SLFF6	4080		
SLF6			
SLFC6			
SLFT6			
SLFH6	5050		
SLFF6			
SLF8			
SLFC8			
SLFT8	50100		
SLFH8			
SLFF8			
SLF8			
SLFC8	50100		
SLFT8			
SLFH8			
SLFF8			

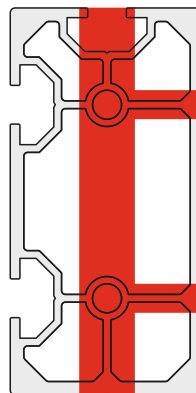
ex Example



■ Nut holes go through the extrusion when specified at slot direction for Slot Type.



■ Machining is provided at a bottom slot only when horizontal nut hole machining is specified for the rectangular extrusions.



■ 2 screw holes are provided when vertical nut hole machining is specified for the rectangular extrusions.

Alterations for SLF Series

Tapping for Vertical Type Joints / Counterbores in Specified Position / Tapping in Specified Position

■ Alterations are required for connecting two extrusions of SLF Series.

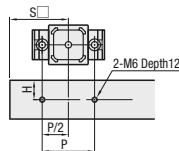
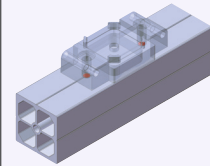
■ See below for the standardization of right/left-hand end face and horizontal/vertical positions.

Square					
Machined Surface	SLF6-4040/SLF8-5050	SLFC6-4040/SLFC8-5050	SLFT6-4040/SLFT8-5050	SLFH6-4040/SLFH8-5050	SLFF6-4040/SLFF8-5050

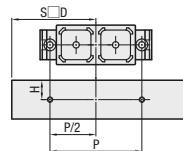
Rectangle					
Machined Surface	SLF6-4080/SLF8-50100	SLFC6-4080/SLFC8-50100	SLFT6-4080/SLFT8-50100	SLFH6-4080/SLFH8-50100	SLFF6-4040/SLFF8-50100

■ Tapping for Vertical Type Joints

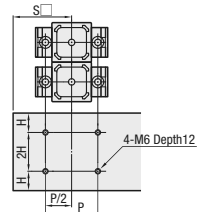
Tapping for Vertical Type Joint is provided at specified positions.



Alteration Code	Applicable Joint	H (mm)	P (mm)
SX, SY	SVJ6-4040	20	53
SZ, SQ	SVJ8-5050	25	63



Alteration Code	Applicable Joint	H (mm)	P (mm)
SXD, SYD	SVJ6-4080	20	93
SZD, SQD	SVJ8-50100	25	113



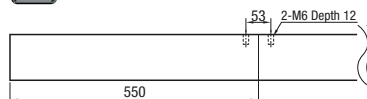
Alteration Code	Applicable Joint	H (mm)	P (mm)
SX, SY	SVJ6-4040	20	53
SZ, SQ	SVJ8-5050	25	63

■ How to Specify Ordering Code

- Confirm the left end face of the extrusion according to the standard positions.
- Decide a machining plane and measure the distance from the left end face to the joint center (0.5mm increment).



Ordering Example Part Number - L - Machined Surface, Position
SLF6-4040 - 1500 - SX550

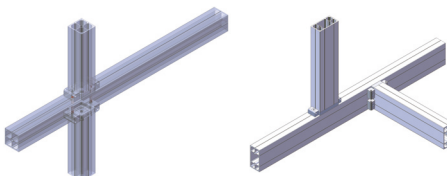


Type		Applicable Joint							
		SVJ6-4040/SVJ8-5050				SVJ6-4080/SVJ8-50100			
		Plane X SX	Plane Y SY	Plane Z SZ	Plane Q SQ	Plane X SXD	Plane Y SYD	Plane Z SZD	Plane Q SQD
Number of Tapped Holes	4040	2	2	2	2	2	2	2	2
		-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-
	5050	-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-
		-	-	-	-	-	-	-	-

Type		Applicable Joint					
		SVJ6-4040/SVJ8-5050				SVJ6-4080/SVJ8-50100	
		Plane X SX	Plane Y SY	Plane Z SZ	Plane Q SQ	Plane X SXD	Plane Z SZD
Number of Tapped Holes	4080	2	4	2	4	2	2
		-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
	50100	-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-
		-	-	-	-	-	-

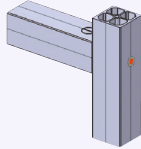


Example



Position Specification: Counterbore Hole Machining

Counterbore hole machining is provided at specified positions. Hole positions are specifiable up to 5.



Machined Surface, Position

From X Plane to Z Plane

AZX BZX CZX DXZ EZX

From Z Plane to X Plane

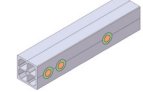
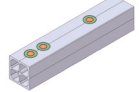
AZZ BZZ CZZ DZZ EZZ

From Y Plane to Q Plane

AZY BZY CZY DZY EZY

From Q Plane to Y Plane

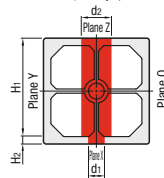
AZQ BZQ CZQ DZQ EQZ



For standard positions and machining planes, see the figures on P735.

Counterbore Hole Dia., Dimensions, Machined Surface

Cross Section View (Machining is provided from Z plane to X plane.)



Extrusion Type	Z	d1	d2	H1	H2
SLF□-4040	6	6.5	11	37.2	2.8
	8	9	14		
SLF□-4080	6	6.5	11	77.2	2.8
	8	9	14		
SLF□-5050	6	6.5	11	47	3
	8	9	14		
SLF□-50100	6	6.5	11	97	3
	8	9	14		

How to Specify Ordering Code

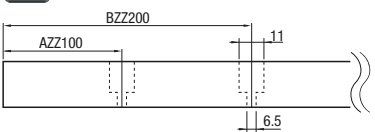
① Confirm the left end face of the extrusion according to the standard positions.

② Decide a machining plane and a counterbore hole dia. Specify the counterbore position in 0.5mm increment from the left end face to any desired position.

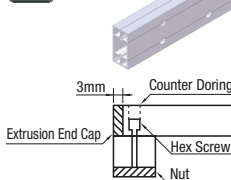
Type	Counterbore Hole Dia.	Position Specification: Counterbore Hole Machining			
		Plane X	Plane Y	Plane Z	Plane Q
		AZX-EZX	AZY-EZY	AZZ-EZZ	AZQ-EZQ
SLF6	4040	Z6			
SLFC6					
SLFT6					
SLFH6					
SLFF6					
SLF8	5050	Z6			
SLFC8					
SLFT8					
SLFH8					
SLFF8					

Type	Counterbore Hole Dia.	Position Specification: Counterbore Hole Machining			
		Plane X	Plane Y	Plane Z	Plane Q
		AZX-EZX	AZY-EZY	AZZ-EZZ	AZQ-EZQ
SLF6	4080	Z6			
SLFC6					
SLFT6					
SLFH6					
SLFF6					
SLF8	50100	Z6			
SLFC8					
SLFT8					
SLFH8					
SLFF8					

Ordering Example: SLF6-4040 - 1500 - Z6 - AZZ100-BZZ200



Example

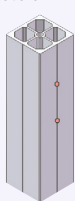


SLF8-50100-1000-Z8-AZQ120-BZQ250: When counterbored holes are specified on Y or Q plane for rectangular extrusions, 2 counterbored holes are provided at the same distance from the left end face.

When the extrusion and the extrusion end cap are desired to be flat, specify counterbore holes shifted by 3mm.

Position Specification: Tapped Hole Machining

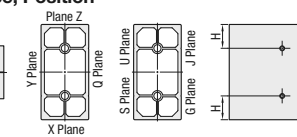
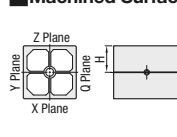
Tapped hole machining is provided at specified positions.



Tapped Hole Dia., Machined Surface

	T3	T5	T6	T8
Code	T3	T5	T6	T8
Dia.	M3	M5	M6	M8
Depth	6	10	12	12

Machined Surface, Position



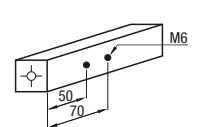
*2 tapped holes are provided when *1 tapped hole is provided when U, Y and Q planes are specified.

Extrusion Type	H
SLF6-4040	20
SLF8-5050	25

Extrusion Type	H
SLF6-4080	20
SLF8-50100	25

Alteration Specification Example

M6 Tapped Holes are machined on Q at 50mm and 70mm for the left end side.



Product Code: T6-ATQ50-BTQ70

How to Specify Ordering Code

① Confirm the left end face of the extrusion according to the standard positions.

② Decide a tapped hole dia. and machining plane. Specify the tapped hole position in 0.5mm increment from the left end face to any desired position.

Type	Tapped Hole Dia.	Position Specification: Tapped Hole Machining			
		Plane X	Plane Y	Plane Z	Plane Q
		ATX-ETX	ATY-ETY	ATZ-ETZ	ATQ-ETQ
SLF6	4040	T3			
SLFC6					
SLFT6					
SLFH6					
SLFF6					
SLF8	5050	T6			
SLFC8					
SLFT8					
SLFH8					
SLFF8					

Type	Tapped Hole Dia.	Position Specification: Tapped Hole Machining							
		Plane X	Plane Y	Plane Z	Plane Q	Plane U	Plane S	Plane J	Plane G
		ATX-ETX	ATY-ETY	ATZ-ETZ	ATQ-ETQ	ATU-ETU	ATS-ETS	ATJ-ETJ	ATG-ETG
SLF6	4080	T3							
SLFC6									
SLFT6									
SLFH6									
SLFF6									
SLF8	50100	T6							
SLFC8									
SLFT8									
SLFH8									
SLFF8									

Ordering Example: SLF6-4040 - 1500 - T6 - ATX100-BTX200