

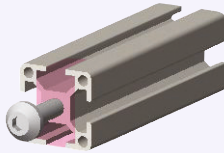
Tapping

Blind Joints which require this alteration

Screw Joints
P552, etc.

Simple Joints
P604

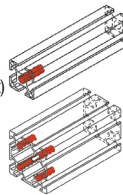
Adds tapped holes on extrusion ends.



Left Side

LTP
LHP

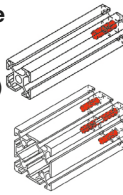
(Heli-Coil Insert)



Right Side

RTP
RHP

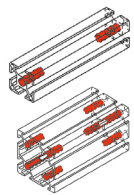
(Heli-Coil Insert)



Both Sides

TPW
HPW

(Heli-Coil Insert)



The number of tap varies depending on the extrusion type (the number of pilot hole for tapping in the end). See each product page for the tapping positions.

For specifying tapping hole dia. and depth of this alteration, check for the list of alteration fees.

See the table below for the applicable extrusions and alteration charges. Indicated with "-" in the table are not applicable.

Alterations				Tapping								
Code				End Tapping								
Features	Type	No.	Page	Tap Shape	Number of Tapped Holes (per End)	Left LTP	Right RTP	Both TPW	Tap Shape	Left LHP	Right RHP	Both HPW
Four-Side Slots	HFS5 NFS5 CAFS HFSY5	2020	P529	M5 Depth 15	2				M3 Depth 6			
		2040	P530		3							
		2060	P531	M8	4				M5 Depth 10			
		2525			1							
		2550	2									
		4040	P530		4							
		4050	P531									
		4080	P531									
		404020	P532									
		2020	P529									
3-Side Slot 1-Side Flat	HFSF5 NFSF5	2040	P530	M5 Depth 15	2				M3 Depth 6			
		2060	3									
		4040	4									
		2020	1									
Two-Side Slots Two Flats	HFSST5 NFSST5	2020	P529	M5 Depth 15	4				M3 Depth 6			
4040	P530											
Two Slots on Opposite Sides One-Side Slot Three Flats	HFSH5 NFSH5	2020	P529	M5 Depth 15	4				M3 Depth 6			
404020	P532											
Angled	HFS45 HFS45A HFS80A5	20	P532		1							
		2020	P529									
		2040	P530	M8 Depth 24	2				M5 Depth 10			
		2525	P531		4							
		2550	P530	M5 Depth 15	2							
		2020	P529	M4 Depth 12	1							
		2020	P529	M5 Depth 15	2							
		3030	P571		3							
		3060	P573									
		3090	P576		4							
50100	P579											
50500	P575		10									
60600	P578											
30300	P576		2									
30300	P572											
30600	P574		2									
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60600	P575		4									
60600	P576											
60600	P577		3									
60600	P578											
30300	P576		10									

For LHP, RHP and HPW, Heli-coil is inserted into the pilot holes to reduce the tapped hole diameter. Heli-coil is not RoHS compliant type.

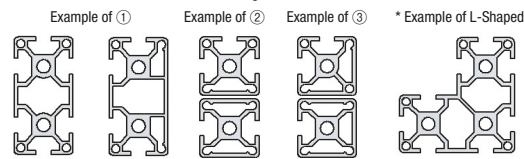


Ordering Example
Part Number
HFS6 - 3030 - 500 - LTP
HFS6 - 4080 - 1200 - TPW

Standard of Extrusion Position

Placing method of the extrusion, which is a basis to determine right and left is shown as follows.

- On the vertical length
- Flat side down
- One flat side down and another flat side right



When the extrusion is on the vertical length and also has a flat side, ① has the priority.

Notes for combination use of tapping hole (D Hole, S Hole and M Hole)

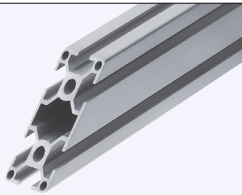
When D, S, M holes are specified in the same direction as the tapped holes, the tap depths will be changed to avoid interferences with D, S, and M holes.

Extrusion (Series)	Square (mm)	Standard Tap Depth	Tap Depth When D Type Hole and S Type Hole are Specified	Tap Depth When M Type Hole is Specified
5 Series	20,40	15mm	-	6mm
6 Series	25	24mm	-	-
8 Series	30,50,60,100	36mm	9mm	9mm
8 Series	40	24mm	13mm	13mm
8-45 Series	45	18mm	14mm	13mm
90	24mm	13mm	13mm	13mm
40,80	36mm	13mm	13mm	13mm
GFS8	45,50,60,90,100	36mm	14mm	13mm

- EFS and CAF are the same as HFS series.

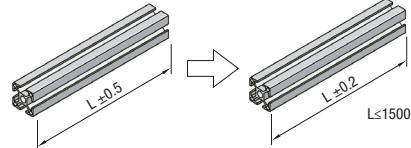
Extrusion Cut

45-Degree Cut / High Precision Cut



High Precision Cut SC

- Changes the tolerance of the full length L from $L \pm 0.5$ to $L \pm 0.2$.
- Applicable to L dimension 1500 or less only.



- 45-Degree Cut $\square$ T45 : Adds a 45 degree cut on the left end in the specified direction.
- $\square$ T45 : Adds a 45 degree cut on the right end in the specified direction.

Cut with cross the section facing down

Left

Right



LAT45

RAT45

Left

Right



LCT45

RCT45

Cut with cross the section facing back

Left

Right



LBT45

RBT45

Left

Right



LDT45

RDT45

- The cut direction can be specified as four directions against the cross section.

- In case of angled cut, it is impossible to specify other alterations in the same direction.

See the table below for the applicable extrusions and alteration charges. Indicated with "-" in the table are not applicable.

Alterations				Extrusion Cut			
Code				High Precision Cut	45-Degree Cut		
				SC	Left	Right	
Features	Type	No.	Page		LAT45 LBT45 LCT45	RAT45 RBT45 RCT45 RDT45	
Four-Side Slots	HFS5 NFS5 CAF5 HFSY5	2020	P529				
		2040	P530				
		2080					
		2525	P531				
		2550					
		4040	P530				
		4080					
		4080	P531				
3-Side Slot 1-Side Flat	HFSF5 NFSF5	404020	P532				
		2020	P529				
Two-Side Slots Two Flats	HFSF5 NFSF5	2040	P530				
		4040	P529				
Two Slots on Opposite Sides	HFSH5 NFSH5	2020	P529				
		4040	P530				
One-Side Slot Three Flats	HFSH5 NFSH5	2020	P529				
		4040	P530				
Angled	HFS30A5 HFS45A5 HFS60A5	20	P532				
		2020	P529				
Black Anodize	HFSB5 NFSB5	2040	P530				
		2525	P531				
		2550	P531				
		4040	P530				
Curved	HFSR5	2020	P529				
		404020	P532				
Four-Side Slots	HFS6 EFS6 NFS6 NEFS6 GFS6 CAF6 HFSY6	3030	P571				
		3060	P573				
		3090	P576				
		30120	P576				
		5050					
		50100	P579				
		6060	P575				
		6090	P577				
		60120	P578				
		606030	P578				
		303030	P576				
		3030	P572				
3-Side Slot 1-Side Flat	HFSF6 EFSF6 NFSF6 NEFSF6	3030	P574				
		3060	P579				
		3090	P575				
		6060	P576				
Two-Side Slots Two Flats	HFSF6 EFSF6	3030	P574				
		3060	P579				
Two Slots on Opposite Sides	HFSH6 EFSH6	3030	P572				
		3060	P574				
One-Side Slot Three Flats	HFSH6 EFSH6	3030	P572				
		3060	P574				
Light Type	NFSL6 EFSL6	3060	P573				
		5050	P579				
Heavy Type	HFS30A6 HFS45A6 HFS60A6	30	P578				
		3030	P571				
Black Anodize	HFSB6 EFSB6 NFSB6 NEFSB6	3060	P573				
		30120	P576				
		5050					
		50100	P579				
		6060	P575				
		3030	P572				
		3060	P574				
		3090	P575				
		6060	P576				
		3030	P572				
		3060	P574				
		3090	P575				
Curved	HFSR6	3030	P578				
		606030	P578				

Alterations				Extrusion Cut		
Code				High Precision Cut	45-Degree Cut	
				SC	Left	Right
Features	Type	No.	Page		LAT45 LBT45 LCT45 LDT45	RAT45 RBT45 RCT45 RDT45
Four-Side Slots	HFS8	4040	P631			
	EFS8	4080	P633			
	NFS8	40120	P636			
	NEFS8	40160	P636		-	-
	GFS8	5050	P635			
	CAF8	80160	P636			
	HFSY8	806040	P637		-	-
	HFSH8	5090	P636			
3-Side Slot 1-Side Flat	HFSF8	4040	P632			
	EFSF8	4080	P634			
Two-Side Slots Two Flats	HFSF8	5050	P635			
	EFST8	4040	P632			
Two Slots on Opposite Sides	NEFSY8	4080	P634			
	EFST8	5050	P635			
One-Side Slot Three Flats	HFSH8	4040	P632			
	EFSH8	4080	P634			
Light Type	HFS8	4040	P631			
	NFSL8	4080	P633			
Angled	HFS30A8					
	HFS45A8	40	P637		-	-
	HFS60A8					
Black Anodize	HFSB8	4040	P631			
	EFSB8	4080	P633			
		40120	P636			
		40160	P636		-	-
		5050	P635			
		8080	P635			
		80160	P636		-	-
Curved	HFSR8	4040	P637			
		806040				
		4545	P681			
		4590	P684			
		45180	P685		-	-
		5050	P687			
		50100	P689			
		6060	P689			
Four-Side Slots	HFS8	4545	P681			
	EFS8	4590	P684			
	NFS8	50100	P687			
	NEFS8	6060	P689			
	GFS8	9090	P685			
	CAF8	90180	P685			
		909045	P686			
		100100	P688			
3-Side Slot 1-Side Flat	HFSF8	4545	P682			
	EFSF8	4590	P684			
	NEFSF8	5050	P687			
	GFSF8	6060	P689			
	HFSF8	9090	P683			
	EFST8	5050	P687			
	NEFSY8	4545	P683			
	GFSY8	6060	P689			
Two-Side Slots Two Flats	HFSH8					
	EFSH8	4545	P683			
Two Slots on Opposite Sides	HFSH8					
	HFSY8					
One-Side Slot Three Flats	HFSH8					
	HFSY8					
Light Type Four-Side Slots	HFSL8	4545	P681			
	NFSL8	4590	P684			
Two-Side Slots	HFSL8					
	HFSY8	4545	P683			
Angled	HFS30A8					
	HFS45A8	45	P686		-	-
	HFS60A8					
		4545	P681			
		4590	P684			
		45180	P685		-	-
		5050	P687			
		50100	P687			
Black Anodize	HFSB8	4545	P681			
	EFSB8	5050	P687		-	-
		50100	P687			
		9090	P685			
		90180	P685			
		909045	P686			
		100100	P688			
		4545	P682		-	-
Curved	HFSR8	4545	P686			
		909045				