



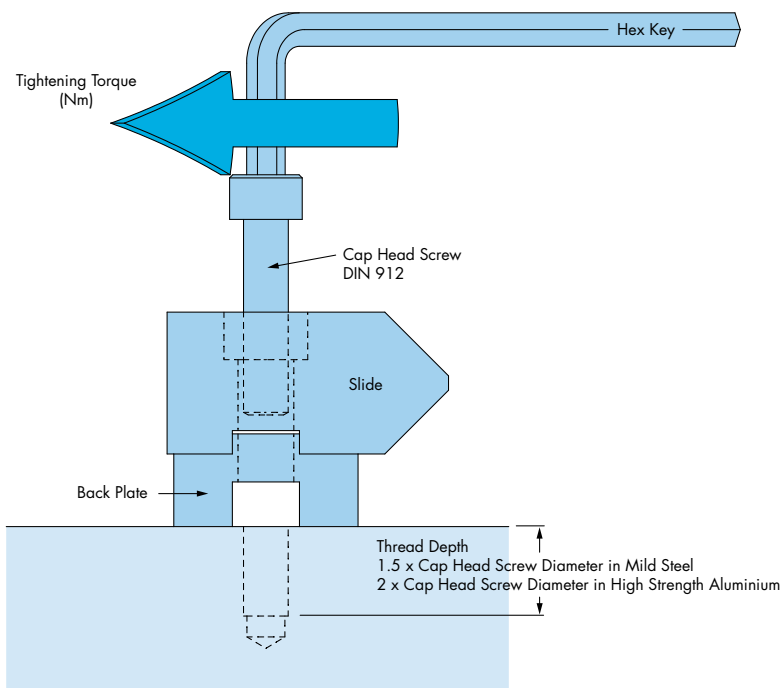
This data sheet interacts with	
HDS2 Catalogue	
	14 to 15 18 to 21 & 49

No. 7 HDS2 Fixing of Slides and Bearing Elements

HDS2 slides and flat tracks are designed to accept the very high loads, which can be applied when using bearing blocks and large bearings. In these cases, it is important that the fixing screws used to attach the slides and flat tracks are securely fastened, and suitable cap head screws with a minimum property class of 8.8 for standard systems, and A2-70 class for corrosion resistant systems, are used.

Details of required thread sizes, engagement depths, and tightening torques are given in the tables provided.

When size 25 slides and flat tracks are fitted using T-nuts, the M8 screw should have a sufficient thread length to ensure at least 8mm of engagement with the high tensile steel T-nut.



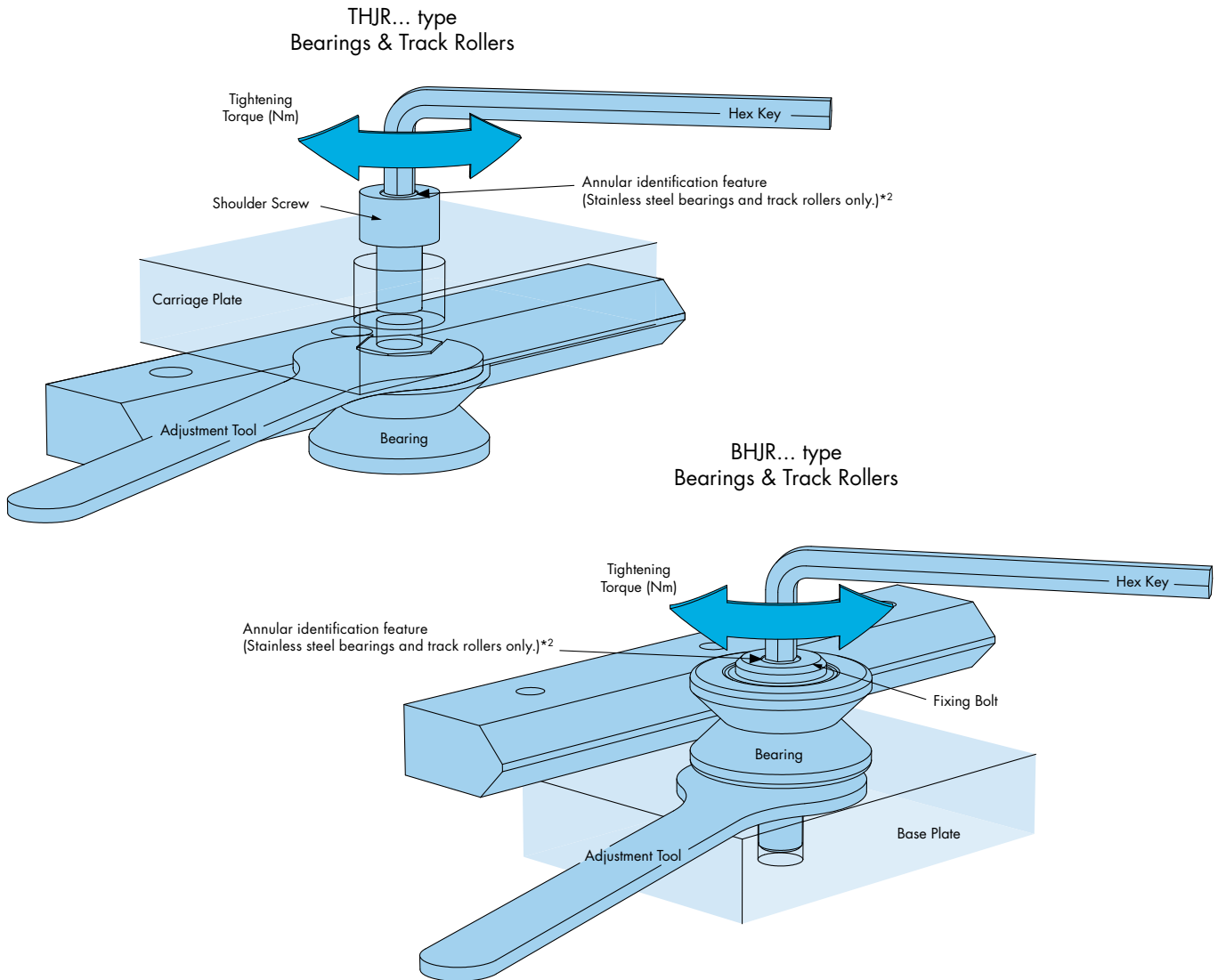
Part Number	Fixing Screw Size	Standard Systems		Corrosion Resistant Systems		Minimum Thread Depths (mm)	
		Recommended Tightening Torque (Nm) [Property Class 8.8]	Minimum Tightening Torque (Nm) [Property Class 8.8]	Recommended Tightening Torque (Nm) [Grade/Class Austenitic A2-70]	Minimum Tightening Torque (Nm) [Grade/Class Austenitic A2-70]	Mild Steel [Minimum 300 MPa yield strength (Rp0.2)]	High Strength Aluminium [Minimum 220 MPa yield strength (Rp0.2)]
.HSS25..	M8	25	20	20	16	12	16
.HTS25..	M8	25	20	20	16	12	16
.HSD25..	M8* ¹	25	20	20	16	12	16
.HTD25..	M8* ¹	25	20	20	16	12	16
.HSS33..	M12	85	65	70	65	18	24
.HTS33..	M12	85	65	70	65	18	24

*¹ Low head cap screws DIN 7984 are required for .HSD25 & .HTD25. All other slides and flat tracks, please use a standard DIN912 cap head screw.

Hepco recommends that all fixing screw holes are used along the length of the slide and flat track, however, in light duty applications it is possible to use alternative mounting holes, which save on installation costs.

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Below are details of the recommended tightening torques for non-stainless steel and stainless steel*² bearings and track rollers.



Part Number	SS/THJR64 SS/THRR58	SS/THJR95 SS/THRR89	SS/THJR120 SS/THJR128 SS/THRR122	SS/THJR150 SS/THRR144	SS/BHJR64 SS/BHRR58	SS/BHJR95 SS/BHRR89	SS/BHJR120 SS/BHJR128 SS/BHRR122	SS/BHJR150 SS/BHRR144
Tightening Torque Nm	80 Nm	180 Nm	500 Nm	750 Nm	40 Nm	180 Nm	500 Nm	750 Nm
Hex Key Size	8 mm	10 mm	14 mm	22 mm	10 mm	12 mm	14 mm	19 mm
Adjustment Tool	AT 54	AT 95	AT 128	AT 150	AT 54	AT 95	AT 128	AT 150

*² Please contact Hepco's technical department to confirm suitable tightening torques for stainless steel bearings and track rollers that do not have the identification feature shown in the illustrations above.

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