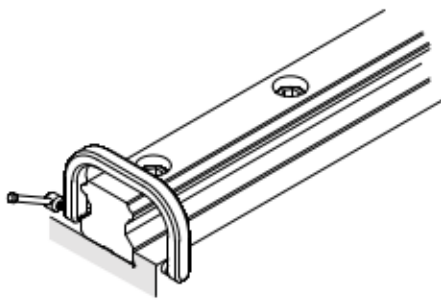
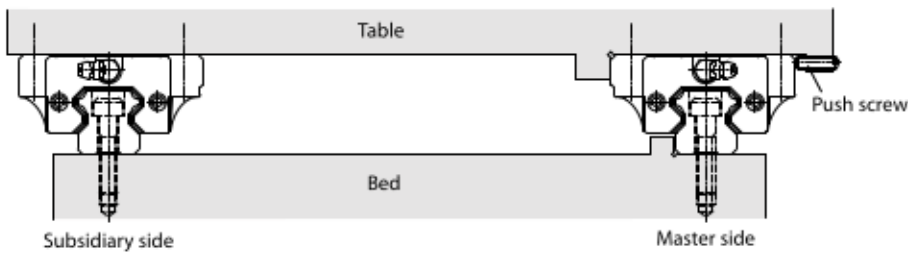


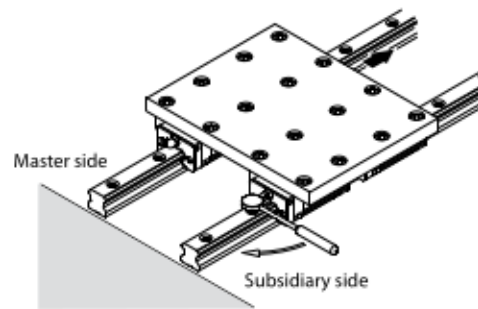
Installation of rail

Installation of parallel rail and carriage.



Using a vise

First tighten the mounting bolts temporarily, then use a C vise to press the master rail to reference side. Tighten the mounting bolts in sequence to specified torque.



Compare to master rail side

Tighten two master side carriages and one subsidiary side carriage onto the table. Then temporarily tighten another subsidiary carriage and rail to the table and bed. Move the table from one rail, check and align the parallelism of subsidiary rail based on moving resistance. Tighten the bolts in sequence.

Tightening torque for rails

An improper tightening torque could affect the mounting accuracy. Tightening the bolts with a torque wrench to the specified torque value is highly recommended. Different types of mounting materials, should have different torque value.

Unit: Nm

Bolt model	Torque Value		
	Iron	Cast iron	Aluminum
M2	0.6	0.4	0.3
M3	2	1.3	1
M4	4	2.7	2
M5	8.8	5.9	4.4
M6	13.7	9.2	6.8
M8	30	20	15
M10	68	45	33
M12	120	78	58