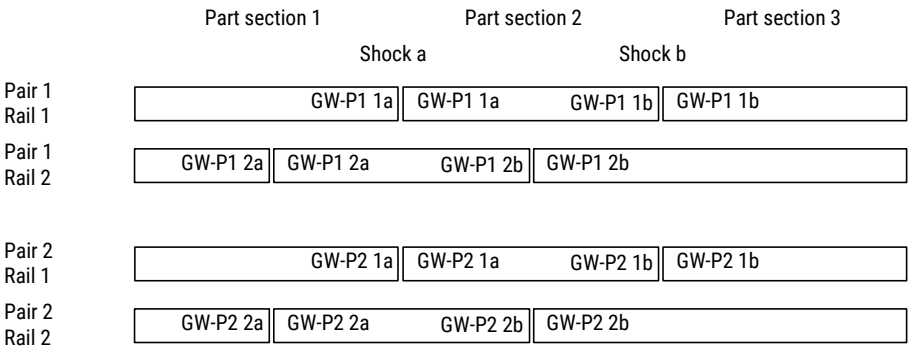
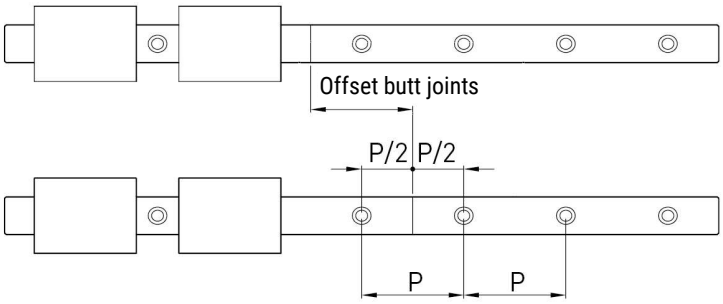
Fig. 5.13: Labelling of attached multi-part paired rails



With paired multi-part rails, mounting the butt joints with an offset is recommended.

Fig. 5.14: Arrangement of attached multi-part rails



5.3 Covering the mounting holes

To protect the block from soiling and to protect the dust protection sealing lips, the profile rails' mounting holes must be closed using cover caps (in the case of R-rails, fixing is carried out from above). The type of cover depends on the environmental and operating conditions: plastic, steel or brass cover caps, or a cover strip, may be used. Plastic cover caps are generally recommended when using coated rails. Plastic cover caps are mounted as described in section 5.3.1.2. Steel and brass cover caps are pressed in using an assembly tool as described in section 5.3.1.3. The cover strip is mounted as described in section 5.3.2.

5.3.1 Cover caps

Caution! Damage caused by cover caps that have been incorrectly pressed in!

Pressing in the cover caps can result in a burr or result in the cover caps being pressed in too deep. This can later result in damage to the block and dust protection.

- Use an oil stone to remove any burrs that have occurred.
- Remove any cover caps that have been pressed in too deep and press in new cover caps.

5.3.1.1 Requirements

- The profile rails are mounted and fixed in accordance with the descriptions in section 5.2.4 / 5.2.5.
- The profile rails are free of dirt and oil (see section 7.1).

5.3.1.2 Mounting plastic cover caps

- Place the plastic cover cap centrally on the hole.
- Ensure parallelism between the top of the rail and the top of the cover cap.

Fig. 5.15: Positioning the plastic cover cap

- Place a suitable press-in block vertically on the cover cap.
- Use a plastic hammer to drive the cover cap into the press-in block by hitting it in the centre.
- If the cover cap is not yet fully pressed in, repeat the described procedure until the cover cap is pressed in flush with the top of the profile rail.

Fig. 5.16: Pressing in the plastic cover cap using a press-in block

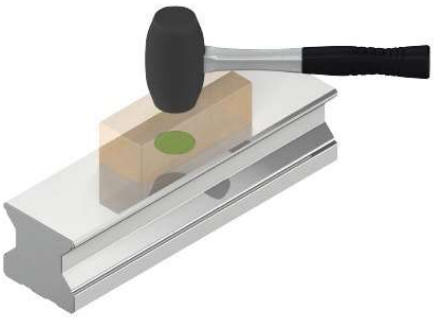


Fig. 5.17: Ready-mounted plastic cover cap

✓ The plastic cover cap is mounted.

5.3.1.3 Mounting steel or brass cover caps

Note

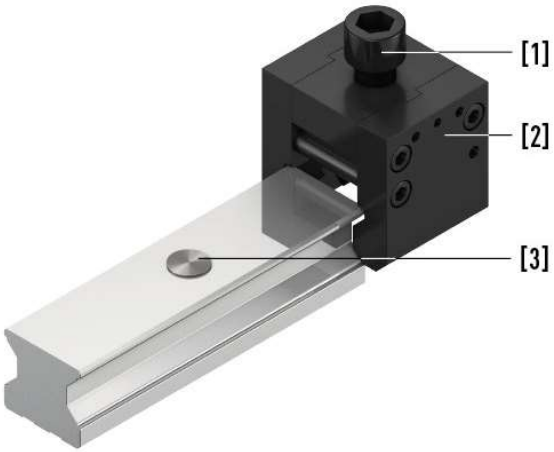
We recommend using the HIWIN assembly tool to ensure correct mounting of the steel and brass cover caps. Information on this can be found in section 11.2.

- Place the steel or brass cover cap centrally on the hole.
- Ensure parallelism between the top of the rail and the top of the cover cap.

Fig. 5.18: Positioning steel or brass cover cap

- Move the press-in block **[4]** (see Fig. 5.21) of the assembly tool **[2]** to the upper end position by loosening the screw **[1]**.
- Slide the assembly tool onto the front of the profile rail.

Fig. 5.19: Positioning the assembly tool on the profile rail

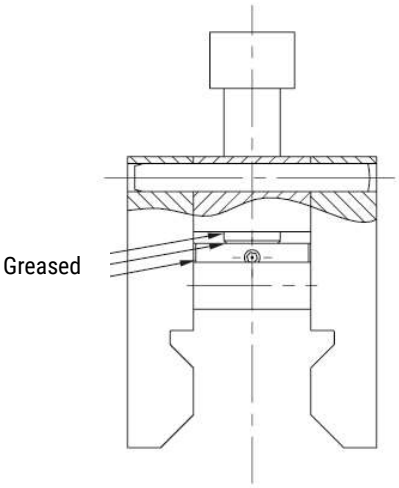


- Position the press-in block **[4]** (see Fig. 5.21) centrally over the hole or the cover cap **[3]**.
- Move out the press-in block by tightening the screw **[1]** until the stamp makes contact with the cover cap and some resistance can be felt when tightening the screw.
- Before actually pressing in the cover cap, check to make sure the cover cap has not tilted.
- Press the cover cap in by continuing to tighten the screw **[1]** until the press-in block makes contact with the profile rail.

Note

The assembly tool must be greased at the following points (see Fig. 5.20)

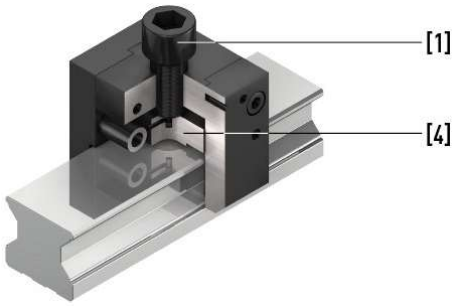
Fig. 5.20: Greasing the assembly tool



Note

The required tightening torque for pressing in the cover caps depends on several factors and can vary considerably. Please note the maximum values specified in Table 5.1.

Fig. 5.21: Pressing in the cover cap by tightening the screw



- Loosen the screw **[1]**.
- Check the results of the pressing process.
- If the cover cap is not yet fully pressed in, repeat the described procedure.
- A burr may form while the cover cap is being pressed in.
- Remove this burr.

Fig. 5.22: Ready-mounted steel or brass cover cap

✓ The steel or brass cover cap is mounted.

Table 5.1: Recommended maximum tightening torques for pressing in steel and brass cover caps

Series/size	Cover cap		
	Brass [1)]	Steel [1)]	Maximum tightening torque [Nm]
HG15, RG15	5-001344	–	15
HG20, RG20	5-001350	5-001352	20
HG25, RG25	5-001355	5-001357	20
HG30, HG35, RG30, RG35	5-001360	5-001362	20
HG45, RG45	5-001324	5-001327	85
HG55, RG55	5-001330	5-001332	85
HG65, RG65	5-001335	5-001337	110

[1)] Not recommended for coated rails

5.3.2 Cover strip

⚠ **Attention!** Risk of injury due to sharp-edged cover strip!

The edges of the cover strips can be very sharp.

- Wear protective gloves when unpacking, assembling and disassembling!
- Prevent uncontrolled unfurling when the cover bands are rolled up by holding the ends of the bands!