



This data sheet interacts with  
HDS2 Catalogue

## No. 6 HDS2 Matched System + Installation Details

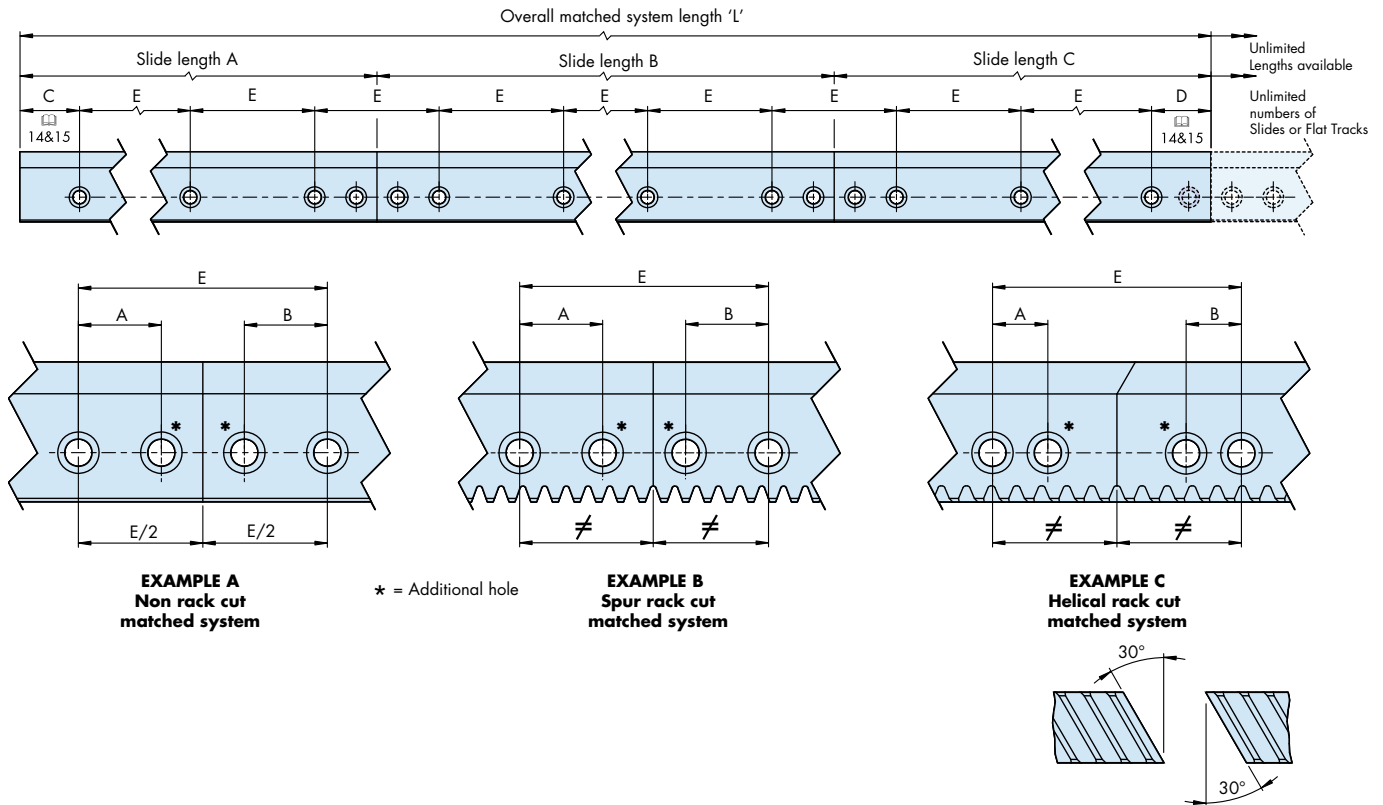
**IMPORTANT:** All matched system requirements should be referred to Hepco's technical department.

Slides or flat tracks can be ordered as matched sets to achieve any length. This is useful not only for achieving very long lengths but also for multiple short lengths to enable replacement of a damaged section.

**For standard matched system requirements,** Hepco will supply a number of slides or flat track lengths to achieve the overall length required with the minimum number of joins. A continuous hole pitch will be maintained along the entire length of the matched system and an additional hole will be provided either side of the joint for security and alignment. For plain, non rack cut matched systems, the joins will be central between mounting holes (see example A). For rack cut systems, the join position between teeth may not coincide with the centre position between holes and therefore could be up to one tooth pitch offset either side (see examples B & C).

**Where specific rack cut lengths or multiple identical rack cut lengths are required,** these must be ordered to a factor of the tooth pitch. Special hole positions may be required.

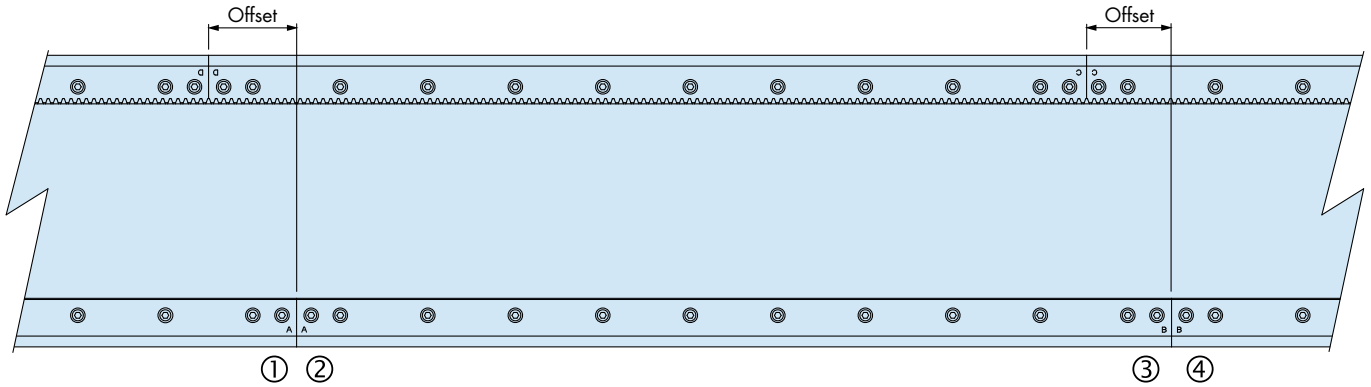
In all matched systems the details are recorded to enable the replacement of any individual slide or track.



	V Slides						Flat Tracks							
	.HSS25.		.HSS33.		...HSD25...	...HTS25...			...HTS33...			...HTD25...		
	Non Rack	Spur Rack	Helical Rack	Non Rack	Spur Rack	Helical Rack	Non Rack	Spur Rack	Helical Rack	Non Rack	Spur Rack	Helical Rack	Non Rack	
<b>A</b>	30		20	40		30	30		20	40		30	30	
<b>B</b>	30		20	40		30	30		20	40		30	30	
<b>E</b>	90		120		90	90			120			90		

## No. 6 HDS2 Matched System + Installation Details

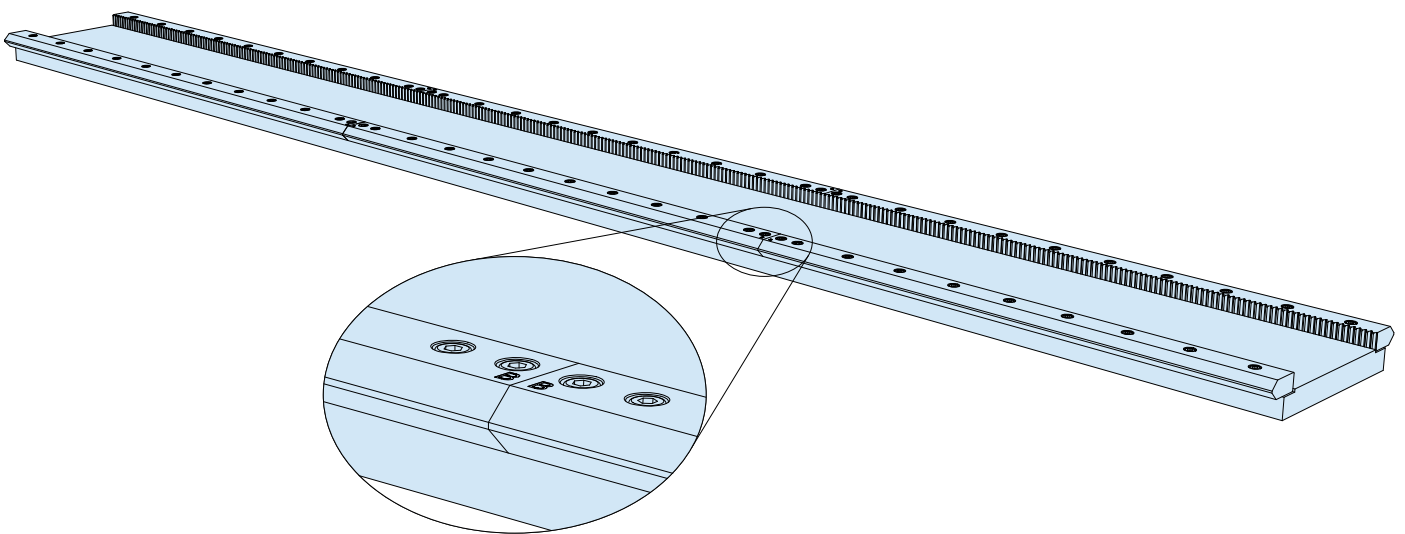
For best running quality when using single edge slides or flat tracks in parallel, it is advisable to offset the joints so they do not coincide. It is also important to ensure that slides and tracks overlap any joints in the back plates or beams where these have been supplied in joined condition for long length requirements.



During the selection and manufacturing process, each slide or flat track joint will be identified with a letter or number that corresponds to its position within the matched set.

For example a slide with one end labelled A①, should be assembled next to the slide with A② one end and B③ the other. Additional joints within the set will be labelled B:B, C:C, D:D and so on.

Each end with an identifying letter will be butted together, as shown below with joint B:B.



## No. 6 HDS2 Matched System + Installation Details

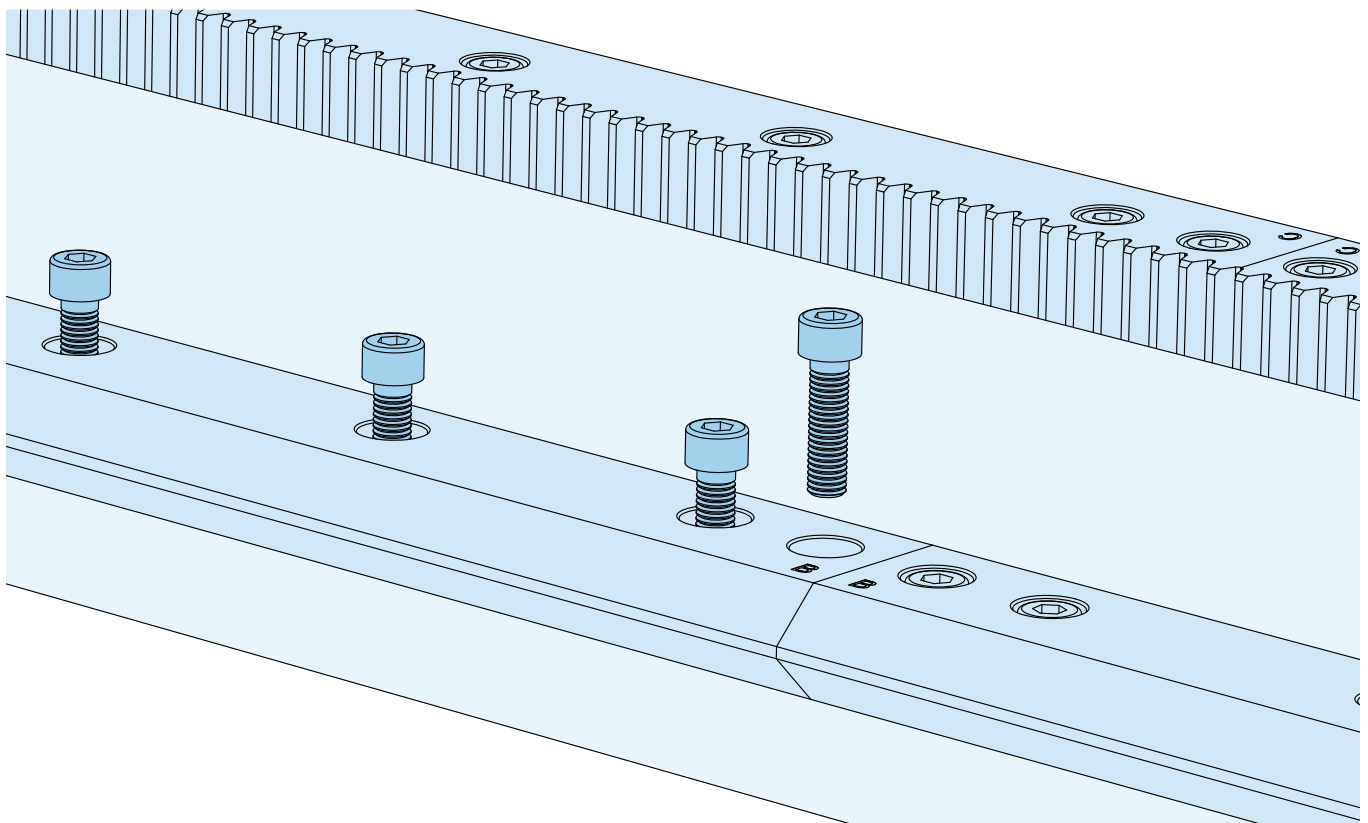
### Systems with replaceable short lengths

Where systems are required to have short replaceable sections, Hepco will need to record additional information of all sections within a set, therefore any requirement of this type will need to be stated at time of quoting / ordering. Replacement sections of rack cut slide / flat tracks will not be available unless this information is available.

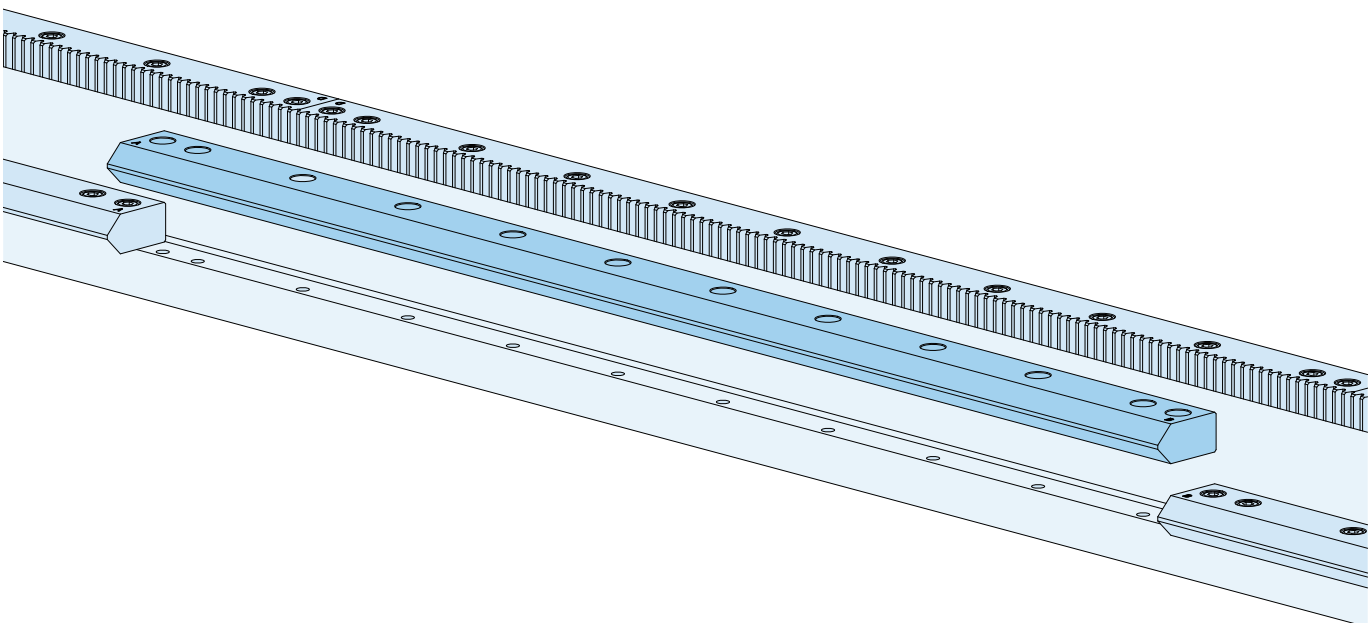
Due to manufacturing tolerances of the replacement section, the remaining sections within the matched set, may need to be readjusted to ensure a good quality joint. Clearances within the mounting holes should allow for this.

Rack cut sections will be available to a maximum length of 1900mm, and non rack cut sections to a maximum length of 3800mm.

1. Remove the fixing bolts from the section of slide or track which needs to be replaced. Make a note of all markings on the slide or flat track, and the labels on the adjacent slides or flat track. These will be needed to ensure replacement parts can be correctly identified.

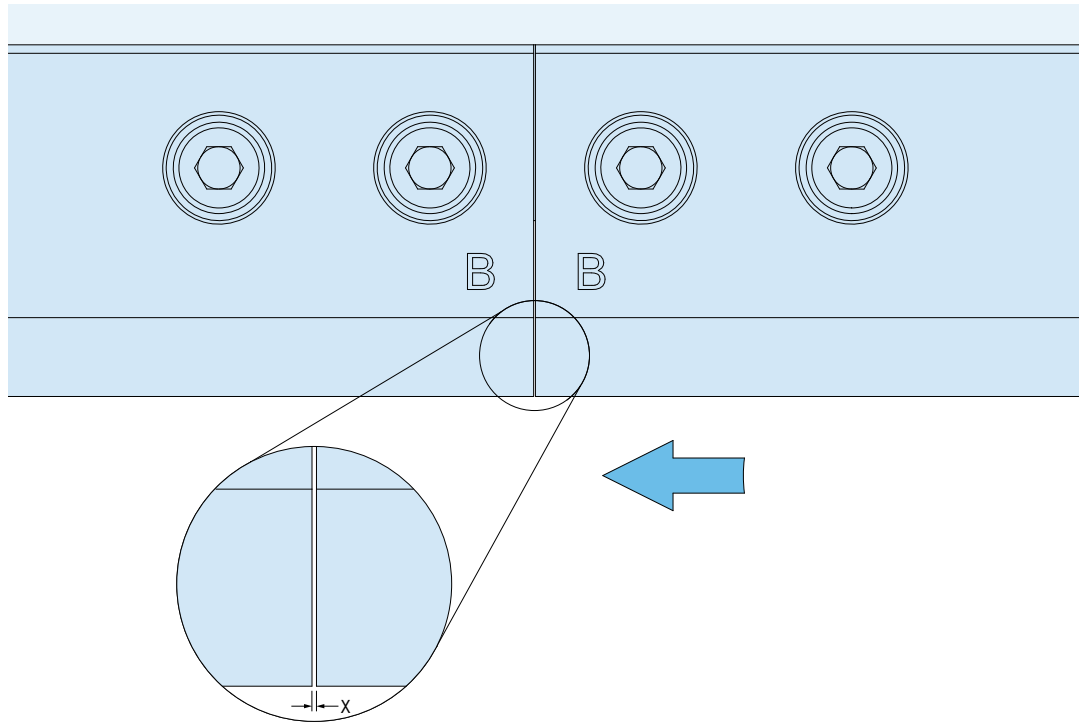


2. Remove the section of slide or flat track from the matched set.



## No. 6 HDS2 Matched System + Installation Details

3a. Refitting of the slide or flat track (see section 3b for rack cut slide or flat track) will be the reverse of the above procedure. When fitted the replacement slide may have a small gap or overlap between the end and the next adjacent slide, this is due to manufacturing tolerances of the replacement section. This is shown as dimension X in the drawing below.

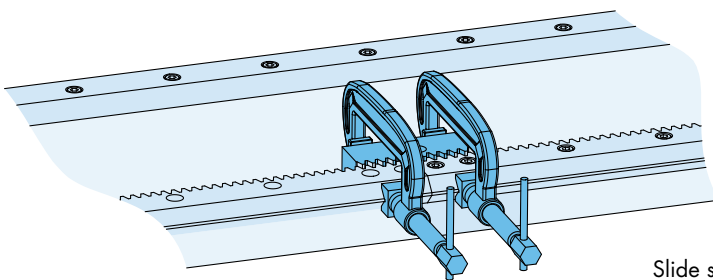


3b. When fitting or replacing the rack cut slide or flat track, a rack setting piece is required.

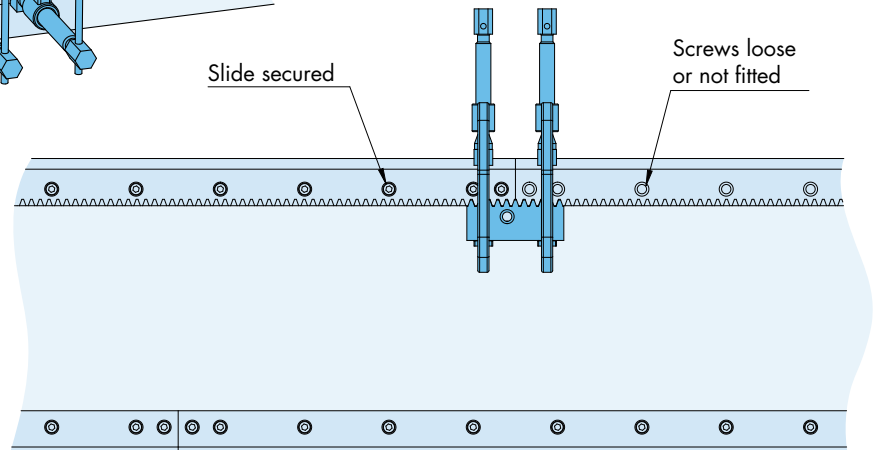
Ensure the slide is firmly butted up against the beam register. With one slide securely fixed in position and one slide loose, clamp the setting piece into the ends of the two racks and ensure all teeth are well engaged on both sides of the joint. Use vee blocks or a packing piece (for example, a small piece of wood) to protect the vee of the slide.

There may be a very small gap between the two slides. If this gap is more than 0.1 mm or if ends of the slides are butting up before the teeth are correctly engaged, please contact Hepco's technical department.

With the slide position set, and continuing to ensure the slide is firmly butted against the beam register, tighten the first few slide fixing screws before removing the setting piece to ensure the slide position is maintained.



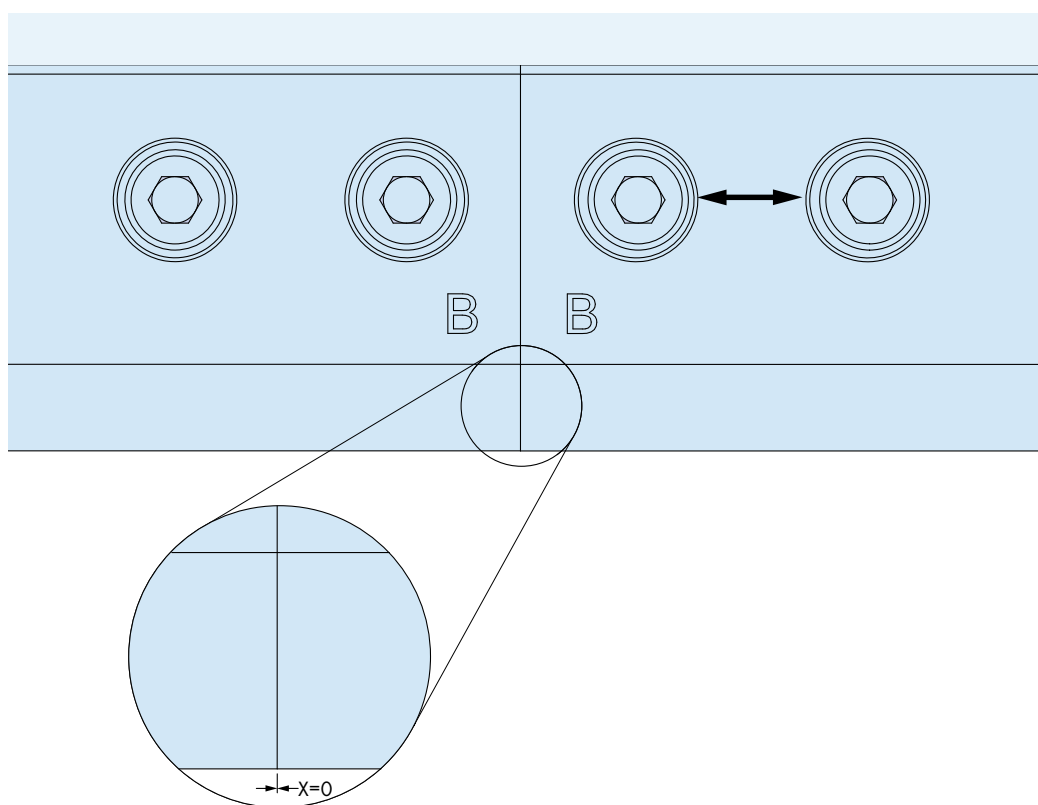
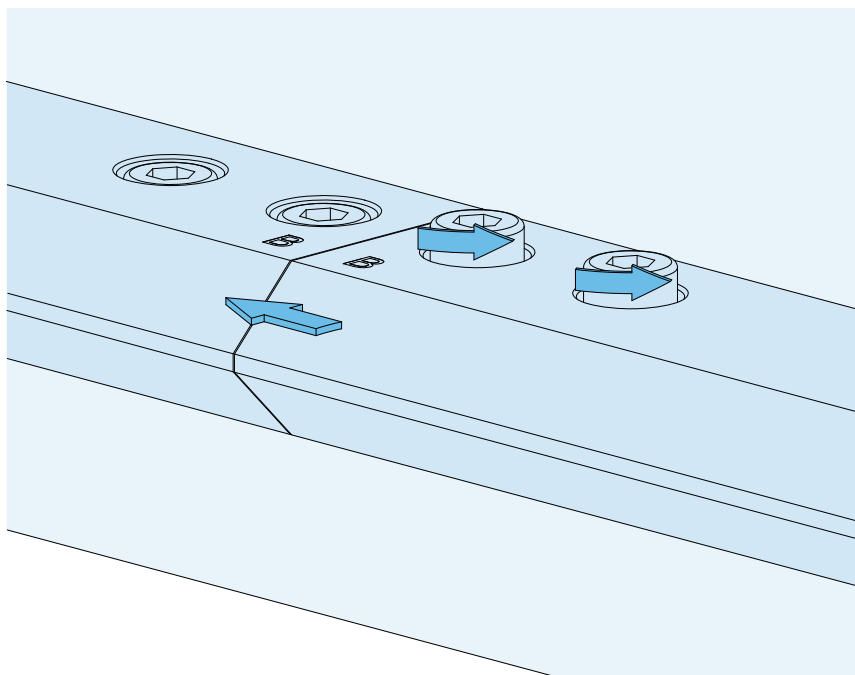
Once set, check that the rack setting piece does not rock over the central tooth. This would indicate the slides are set too close together and a larger gap is required.



Rack	Setting Piece Part Number
Mod 2.5, Spur	HD-RSP-2.5S
Mod 2.5, Helical	HD-RSP-2.5H
Mod 3, Spur	HD-RSP-3S
Mod 4, Helical	HD-RSP-4H
Mod 5, Spur	HD-RSP-5S

## No. 6 HDS2 Matched System + Installation Details

4. To complete this the fixing bolts of the adjacent slides must be loosened, then the slide can be adjusted to butt up to the replacement. (Non rack cut only)



5. To ensure that the slides are correctly located against the register face suitable clamps should be employed, before tightening the fixing bolts.
6. Once fitted it is recommended that the joints are 'stoned in'. This involves using a lubricated oilstone to abrade the slides at the joint to level out any minor deviations and optimize running quality. Use any carriage fitted to the system to assess running quality during this operation, by running the carriage across the joint.

**HepcoMotion**<sup>®</sup>, Lower Moor Business Park,  
Tiverton Way, Tiverton, Devon, England EX16 6TG  
Tel: +44 (0) 1884 257000  
E-mail: sales@hepcotion.com

[www.HepcoMotion.com](http://www.HepcoMotion.com)