Pre-assembly set:
Basic the Standard!

1. Pre-assemble clamp and screw.
2. Clip in connector on both sides of the designated support.
3a. Fasten Basic assembly set inside or outside 3b (Please check if the stability of the fixation is accordingly).
   Please note: half the length of the assembly set and connector must protrude out of the trough.
   The glide nut should be well fastened in the C-profile.

Pre-assembly set:
Heavy-Duty (Optional)

1. Pre-assemble Heavy-Duty bracket and screw set.
2. Fasten Heavy-Duty assembly set outside.
   Please note: half the length of the assembly set and connector must protrude out of the trough.

More information and assembly instructions ► www.igus.eu/eu/salun
Adding the rubber profile (optional)

Cut the rubber profile in accordance to the length of the trough (standard 2 m) and press it into the designated groove. (Pictured: although this shows the left hand side, the instructions are the same for the right hand side. To be repeated for each trough section.)

Connecting the trough sections

1. Join the sides of the trough side parts by pushing them together (min. +2 mm gap!).
2. The pre-assembled parts join each trough section centrally.

Adjusting the tolerance, aligning trough sections

1. Adjust by the necessary minimum "e-chain/trough" tolerance of 2 mm on both sides. Please note: the inner width of the trough decreases 2 mm per side with the assembled glide strip (pictured).
2. Test to ensure the e-chain runs problem free and with low friction in the channel.
3. After adjusting the minimum tolerance and alignment of all trough sections, please pull tight all screw tight all trough connections. Pay attention thereby to the correct installation direction of the sliding nut (see detail).

Starting torque of the assembly set’s fixing bolts: M6: 10 Nm / M8: 23 Nm.

Please consider health & safety regulations while handling sheet metals. We recommend using protective Category II gloves to protect against cuts when handling the aluminium profiles.
Parts list of guide trough set
Basic & Heavy-Duty

Parts list profiles
1. Aluminium profile, 2 m
2. Glide bar, plastic, 2 m
3. Glide strip, plastic, 2 m
4. Dampening profile, rubber
5. Assembly set Basic
   C-profile, steel
   Connector “Basic”, plastic
   Clamping parts, Aluminium
   Hexagon nut + Glide nut:
   971.3x / 972.3x = M6 x 16
   973.3x / 974.3x = M8 x 20

Assembly set Heavy-Duty
   C-profile, steel
   Clamping bracket “Heavy-Duty” (alternative)
   Hexagon nut + Glide nut:
   971.3x / 972.3x = M6 x 20
   973.3x / 974.3x = M8 x 25

Necessary tools
1. Rubber hammer
2. Hexagonal wrench:
   Size M6 for Part No. 971.3x, 972.3x
   Size M8 for Part No. 973.3x, 974.3x

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