

Quick & Easy Profiles

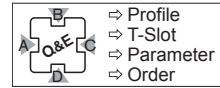
Product Selection Guide



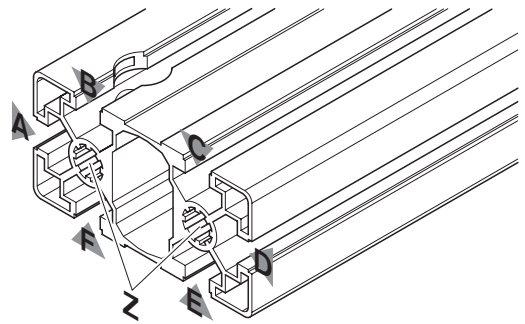
Quick & Easy profile finishes

Logical structure of the order key

Material number / length / [slot designation = finishing; parameter set]



Example: Profile 45x90L with through-hole D17 in slot B



3 842 993 662 / 393 / B = D17/-

Material number	Length	Standard profile finishes
3 842 993 662	393	D17 through-hole in slot B

Standard profile finishes

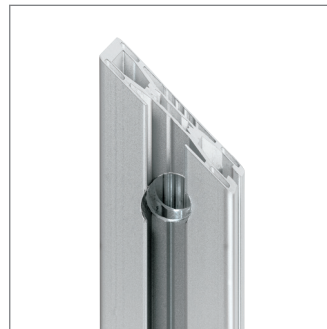
- ← Through-hole drilling D
- ← Blind hole drilling DB
- ← Thread cutting M
- ← Standard milling F1

Individual profile finishes

- ← Hole drilling DI
- ← Drilling sequence DIS
- ← Cross milling MT
- ← Cross milling sequence MTS
- ← Lengthwise milling MI
- ← Lengthwise milling sequence MIS
- ← Miter cutting S1 / S3



You can configure your profile really quickly and easily in the Rexroth eShop or with the profile configurator in MTpro



Standard profile finishes





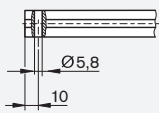
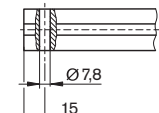
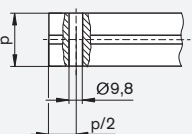

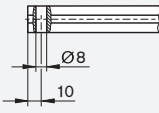
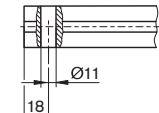
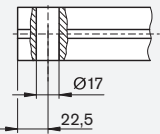
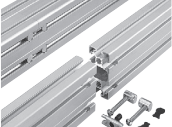
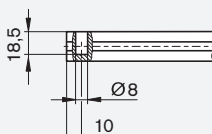
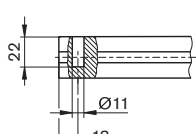
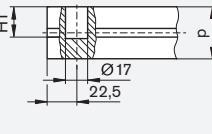

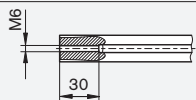
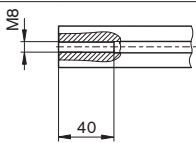
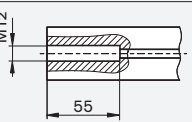
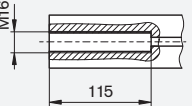
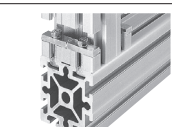

Order syntax for through-holes, blind holes, standard milling

Material number / length / slot designation = finishing at profile start / finishing at profile end; ...




Order syntax for threads

Material number / length / Z = Mx at profile start / Mx at profile end

Standard profile finishes

		Slot 6 mm 	Slot 8 mm 	Slot 10 mm 										
Through-hole for corner connections with central bolt		D5.8 	D7.8 	D9.8 										
Through-hole for bolt connectors and quick connectors		D8 	D11 	D17 										
Blind hole for longitudinal end connectors and quick connectors in closed profiles		DB8 	DB11 	DB17  <table border="1"> <tr> <td>p</td> <td>40</td> <td>45</td> <td>50</td> <td>60</td> </tr> <tr> <td>HT</td> <td>31</td> <td>34</td> <td>36</td> <td>41</td> </tr> </table>	p	40	45	50	60	HT	31	34	36	41
p	40	45	50	60										
HT	31	34	36	41										
Thread in all central holes for accessories		M6 	M8 	M12  M16 										
Standard milling for cross connectors				F1 										

Minimum profile lengths (mm) for standard profile finishes on one or both sides

	M6	D5.8	D8/ DB8		M8	D7.8	D11/ DB11		M12	M16	D9.8	D17/ DB17	F1		
-	50	50	50	50	50	50	50	-	50	60	120	50	60	60	
M6	50	70	50	70	M8	50	80	62	M12	60	110	180	90	60	110
D5.8	50	50	50	50	D7.8	50	62	60	M16	120	180	240	150	170	170
D8/ DB8	50	50	50	50	D11/ DB11	50	70	50	D9.8	50	90	150	80	70	90
									D17/ DB17	60	90	150	70	80	90
									F1	60	110	170	90	90	80

Notice: In the case of clashes with the values in the order table, the larger value applies.

Drilling DI, drilling sequence DIS

Material number / length / [slot designation=DI; PS=...; OS=...; DM=...; HT=...]; [...]

Material number / length / [slot designation=DIS; PS=...; OS=...; DM=...; HT=...; SN=...; SD=...]; [...]

End finishing	Parameter	Order example for profile 45x90L
Hole DI 	PS Center point of hole $PS_{\min} = DM/2 + 3 \text{ mm};$ $PS_{\max} = L - (DM/2 + 3 \text{ mm})$	
	OS Offset start point (optional) Select OS so that the hole does not cut through any slot edges	
	DM DM hole diameter DM; see table.	
	HT Depth of hole (optional) Through-holes made if no information provided HT_{\max} see table	
Drilling sequence DIS 	PS, OS, DM, HT As for DI hole drilling	
	SN Number of finishes $SN_{\max} = \text{INT}((L - 3 \cdot PS - DM/2) / SD) + 1$	
	SD Distance between adjacent finishes $SD_{\min} = DM + 3$	

Permissible hole diameters, permissible hole depths (in mm)

DM	5.8	6.4	7.8	8.0	8.4	9.8	11.0	17.0
HT_{\max}	40.0	45.0	45.0	45.0	45.0	50.0	60.0	75.0

ATTENTION: If HT_{\max} is not sufficient to drill through the profile, you must order two opposite bores!

Cross milling MT, cross milling sequence MTS

Material number / length / [slot designation=MT; PS=...; HT=...; PE=...]; [...]

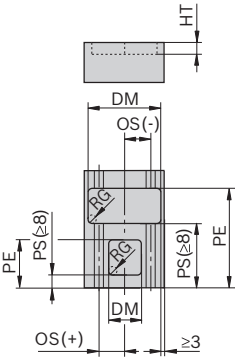
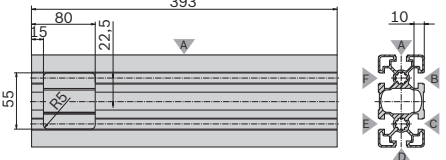
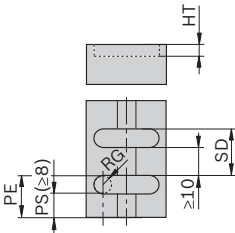
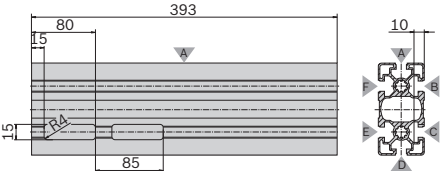
Material number / length / [slot designation=MTS; PS=...; HT=...; PE=...; SN=...; SD=...]; [...]

End finishing	Parameter	Order example for profile 45x90L
Cross milling MT 	PS Starting point of milling $PS_{\min} = 8 \text{ mm}; PS_{\min} = 60 \text{ mm}$ on the underside of the profile	
	HT Depth of milling $HT_{\max} = 5.5 \text{ mm}$ (slot 6 mm) $HT_{\max} = 9.0 \text{ mm}$ (slot 8 mm) $HT_{\max} = 12.5 \text{ mm}$ (slot 10 mm)	
	PE End point of milling $PE_{\max} = L - 8 \text{ mm}; 8 \text{ mm} \leq PE - PS \leq 100 \text{ mm}$	
Cross milling sequence MTS 	PS, HT, PE As for cross milling MT	
	SN Number of finishes $SN_{\max} = \text{INT}((L - 8 - PE) / SD) + 1$	
	SD Distance between adjacent finishes $SD_{\min} = (PE - PS) + 10$	

Lengthwise milling MI, lengthwise milling sequence MIS

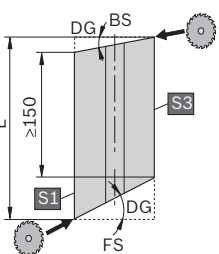
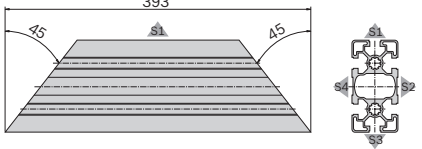
Material number / length / [slot designation=MI; PS=...; OS=...; DM=...; HT=...; PE=...; RG=...]; [...]

Material number / length / [slot designation=MIS; PS=...; OS=...; DM=...; HT=...; PE=...; RG=...; SN=...; SD=...]; [...]

End finishing	Parameter	Order example for profile 45x90L
Lengthwise milling MI 	PS Starting point of milling $PS_{\min} = 8 \text{ mm}$ $PS_{\min} = 60 \text{ mm}$ on the underside of the profile (see order tables for guidance)	 3 842 993 662 / 393 / [B=MI; PS=15; OS=22.5; DM=55; HT=10; PE=80; RG=5]
	OS Offset starting point (optional)	
	DM Milling width $DM_{\min} = 8 \text{ mm}$; $DM_{\max} = \text{profile width/height} - 6 \text{ mm}$ At least 3 mm of profile must remain on both sides	
	HT Depth of milling. $HT_{\max} = 5.5 \text{ mm}$ (slot 6 mm) $HT_{\max} = 9.0 \text{ mm}$ (slot 8 mm) $HT_{\max} = 12.5 \text{ mm}$ (slot 10 mm)	
	PE End point of milling $PE_{\max} = L - 8 \text{ mm}$ $8 \text{ mm} \leq PE - PS \leq 100 \text{ mm}$	
	RG Radius of milling geometry $RG = 3 \text{ mm}; 4 \text{ mm}; 5 \text{ mm}; 8 \text{ mm}$	
Lengthwise milling sequence MIS 	PS, OS, DM, HT, PE, RG As for lengthwise milling MI	 3 842 993 662 / 393 / [C=MIS; PS=15; DM=15; HT=10; PE=80; RG=4; SN=2; SD=85]
	SN Number of finishes $SN_{\max} = \text{INT}(L - 8 - PE / SD) + 1$	
	SD Distance between adjacent finishes $SD_{\min} = (PE - PS) + 10$	

Miter cutting

Material number / length/[FS=side; DG=miter angle]; [BS=side; DG=miter angle]

End finishing	Parameter	Order example for profile 45x90L
Miter cutting 	FS Front side S1, S3 – profile side on which the miter cut begins	 3 842 993 662 / 393 / [FS=S3; DG=45]; [BS=S3; DG=45]
	BS Back side S1, S3 – profile side on which the miter cut begins	
	DG Miter bracket $DG > 0$ The angle is always specified as a positive value. Note the maximum permissible miter angle (see order tables)	

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