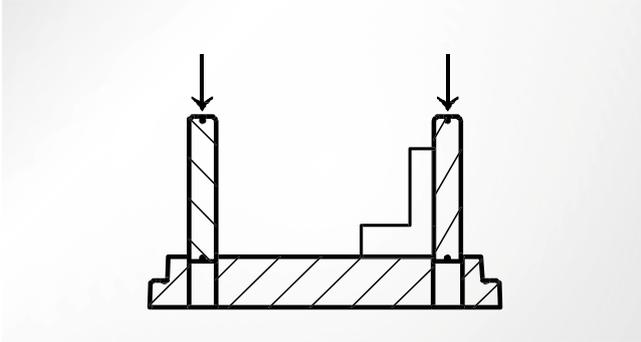


Guide pillar installation instructions

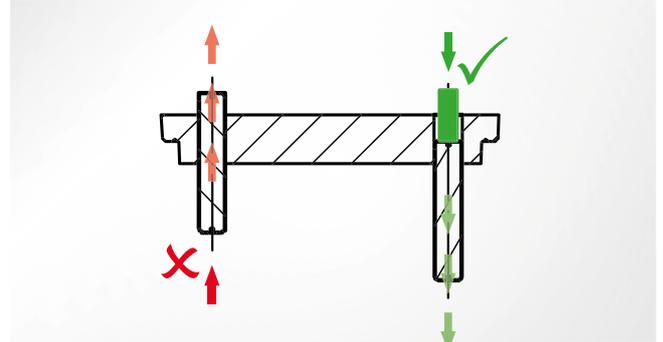
Installation instructions for smooth pillars

Installation of the guide pillar



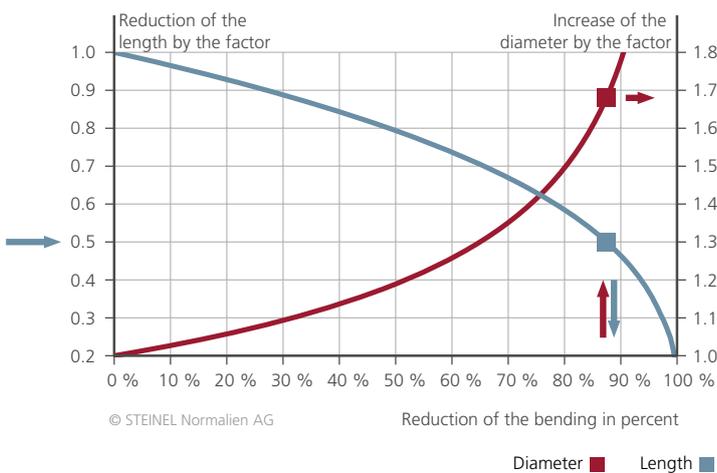
Carefully clean the boreholes in the top and bottom parts and apply oil to them (no grease). Slide the pillars in the top part. Place plane-parallel ground bars between the upper and bottom part. Drive the pillars approx. 3 mm deep into the bottom part. Push in the pillars using a hydraulic press or manual spindle press (the pillar has the fit ISO h3, the borehole has the fit ISO R6, therefore a press fit is guaranteed).

Disassembly of the guide pillar



In order to avoid damage to the surface of the guide pillars and mounting bores, the pillars must never be ejected via the running surface.

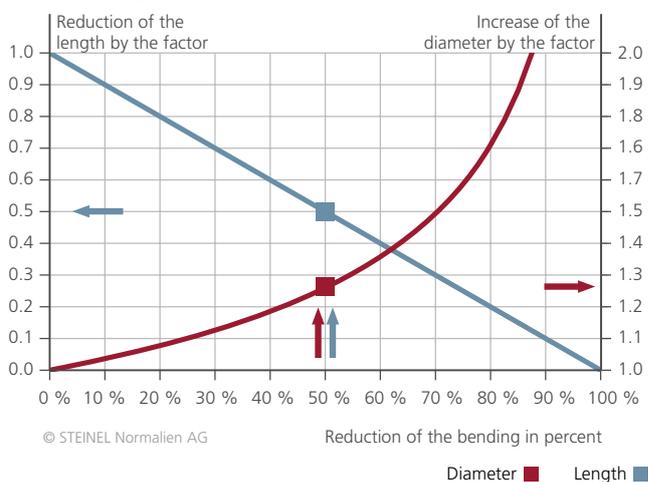
Pillars = bending subject to the length or diameter of the pillar



If the length of a pillar is reduced, the bending of the pillar is also reduced:

- If the length is halved, e.g. by a change from ST7120 (lower plate) to ST7117 (guide plate), the bending of the pillar is reduced by 87.5 %
- A reduction of 87.5 % can also be achieved when the diameter of the pillar is increased by the factor 1.68, e.g. from 25 mm to 42 mm.

Pillars = bending stress subject to the length or diameter of the pillar



There are two possibilities for the reduction of the bending stress in a pillar by 50 %;

- Halving the pillar length, e.g. from 300 mm to 150 mm
- Increasing the pillar diameter by a factor of 1.26, e.g. from 19 mm to 24 mm