

Original Assembly and Maintenance Manual

Linear Unit

HSB-beta®

Types
Beta 40-ZGS-ZSS
Beta 50-C-ZRS

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1 Safety

The Assembly and Maintenance Manual is a component element of the product package, and must always be kept to hand as a reference source.

The Manual must be passed on if the unit is sold on or given away.

If there is anything in this manual which you do not fully understand, please be sure to contact the manufacturers.

1.1 Symbols used

This Assembly and Maintenance Manual employs the following symbols to indicate hazards as well as other types of symbol:

DANGER



Indicates immediate danger.

Failure to observe this notice entails risk of death or very serious injury.

WARNING



Indicates a danger carrying a medium to high risk.


Failure to observe this notice may result in death or serious injury.

CAUTION



Indicates minor risk.

Failure to observe this notice may result in light to moderate injury or damage to property.

 Note

Indicates tips on use of the machine and optimising its efficiency.

1.2 Regulation use

The mechanical linear unit is intended for installation in machines, and is used solely for manipulating, positioning, transporting, palletising, loading, unloading, clamping, clocking, tensioning, testing, measuring, handling and pushing workpieces or tools.

Pay attention to the basic applications of the linear unit set out in sections 4 and 3.

In order to comply with the EU Directive governing Electromagnetic Compatibility (EMC), the mechanical linear unit may only be used in industrial environments.

Any other use, or use for purposes beyond those stipulated, will be classed as illegitimate. The manufacturers accept no liability for any loss thereby incurred. The risk is borne solely by the operators.

1.3 General safety

Preconditions for operation

The linear unit must not be put into operation until the machine or line into which it is installed conforms to the following:

- Relevant accident prevention regulations
- Generally accepted safety standards
- EU directives
- Standards governing the electromagnetic compatibility of machinery
- Other applicable standards
- Applicable national legislation.

Safe operation

To ensure safe operation, refer to the following documents:

- This operating manual for the linear unit, particularly the technical data
- The operating manual for the line into which it is installed

1.4 Use in clean rooms (ISO 14644)

The linear units used in clean rooms are fitted with a vent hole (generally G1/4") at the basic profile.

The following guidelines must be observed:

- The linear unit must be subjected to a negative pressure of 0.2 bar.
- The linear unit must be relubricated with a grease suitable for use in clean rooms (basic lubrication carried out using Klübersynth BEM 32-34).

1.5 Use in explosive environments



The linear units are suitable for use in potentially explosive atmospheres, but the supplement to these assembly and maintenance instructions "[FM_319_Use-in-Atex-zones-MuW](#)" must be observed.

1.6 Technical condition of the linear unit

State of the art

- The unit conforms to the current state of the art and applicable rules and regulations. The unit conforms to the EU Machinery Directive and the harmonised standards (European standards). Furthermore, the EC Declaration of Incorporation applies.

1.7 Modifications to the linear unit

Modifications

The linear unit must not be modified, either in its basic design or in its safety components, without our written consent. Any such unauthorised modification will void our liability in respect of the unit.

The operating company may only carry out the maintenance and repair work detailed in this operating manual. Any other measures, such as to replace wearing parts and components, may be carried out only in consultation with our service engineers, by the service engineers themselves, or by us directly.

Installed safety devices must never be dismantled or disabled.

When fitting special attachments to the unit, follow the fitting instructions provided by the manufacturers!

1.8 Requirements for personnel

The linear unit has been designed and built in accordance with the state of the art and accepted safety standards. Hazards may nevertheless be posed when operating it. Consequently, the unit may only be installed and operated by trained, competent personnel.

All personnel assigned to install, operate, maintain, repair or dismantle a linear unit must have read and understood this operating manual, and in particular section 1, "Safety".

Work on parts carrying live electrical current may be carried out only by trained electricians. Such work includes:

- Installing safety limit switches
- Mounting a drive unit
- Checking the direction of rotation of the drive

1.9 Obligations of the operating company

Instruction of personnel	In accordance with EU Health and Safety Directive 89/655/EEC articles 6(1) and 7 and with the Framework Directive 89/391/EEC articles 1(1) and 6(1), the company operating the linear unit must provide personnel assigned to install, operate, maintain, repair or dismantle the unit with appropriate instruction, in particular with regard to safety. We recommend that companies require their personnel to provide written confirmation of having received such instruction.
Checking the unit	In accordance with EU Health and Safety Directive 89/655/EEC article 4a, the operating company must subject the unit to thorough checking prior to putting it into operation, after carrying out repairs, and after malfunctions have occurred.
Legibility and maintenance of affixed notices and labels	The operating company must ensure that all notices and labels attached to the unit are fully legible (in particular details of the serial number) and must ensure compliance with all instructions contained on them. Damaged or illegible notices and labels must be replaced.

2 Warranty

The warranty conditions are laid down in the terms and conditions of delivery and payment issued at time of order. Warranty cover will be voided if:

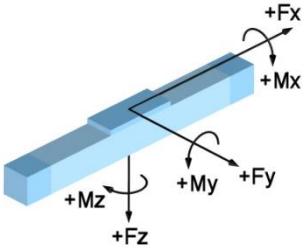
- the unit is not operated in accordance with the stipulated regulation use;
- the instructions set out in this operating manual are not followed;
- the unit is modified without the consent of the manufacturers;
- screws sealed by locking varnish are unlocked.

The manufacturer's warranty in respect of maintenance and repair work applies only if original replacement parts are used.

3 Technical data – Standard model

Technical data - Linear unit Beta type with timing belt drive	Sizes		
	Beta 40		Beta 50-C
	ZSS	ZGS	ZRS
Drive element	Timing belt		
Stroke per revolution [mm]	100	100	110
Velocity max. [m/s]	3,00	1,00	3,00
Acceleration max. [m/s ²]	30	20	30
No-load torque [Nm]	0,30	0,30	0,40
Maximum travel (standard) [mm]	850	2780	8710
Repeat accuracy [mm]	±0,08	±0,08	±0,08
Operating temperature [°C] (continuous operation)	0 ... 80	0 ... 80	0 ... 80
Geometrical moment of inertia I _y [mm ⁴]	88914		235424
Geometrical moment of inertia I _z [mm ⁴]	133632		294804
Length of standard carriage [mm]	120	120	150
Length of long carriage [mm]	-	-	200
Weight (without travel) [kg]	1,70	1,50	1,45
Weight (per 100 mm travel) [kg]	0,30	0,20	0,35
Weight of standard carriage [kg]	0,30	0,30	0,45
Weight of long carriage [kg]	-	-	0,60
Noise emission max. [dB A] ¹⁾	80	80	80

¹⁾ The figure will vary based on assembly with other system components

	Forces and moments - Beta linear unit with timing belt drive							
Type designation	Dynamic forces [N]				Dynamic moments [Nm]			
	F_x	F_y	F_z	$-F_z$	M_x	M_y	M_z	$M_{no-load}$
Beta 40-ZGS	500	80	150	75	6	6	8	0,30
Beta 40-ZSS	500	500	600	300	12	30	30	0,30
Beta 50-C-ZRS	700	300	600	400	30	50	50	0,40

Figures in () relate to the long carriage.

$M_{no-load}$ = No-load torque $\pm 30\%$

The forces and moments quoted are maximum values for the single load. In the event of combined loading or simultaneous occurrence of multiple moments or forces, the individual values must be reduced. In case of doubt consult Technical Support.

Dynamic load ratings of rail guides - Beta linear unit

Model	Size	Number of rails	Number of carriages	Load rating per carriage C_{dyn} [N] THK / Rex*	Pre-tension F_v [N] THK / Rex*	M_t [Nm] THK / Rex*	Guide spacing in direction x (lx1) [mm]	Guide spacing in direction y (ly) [mm]
Beta 40	12	1	2	3175 / 2310	-	25 / 14	83 (163)	-

Figures in () relate to the long carriage

The load rating and pre-tension figures relate to the standard linear guidance system with recirculating linear ball bearings

* Rex = Rexroth

Static and dynamic load ratings of roller guides - Beta linear unit

Model	Size (\varnothing) [mm]	Number of load-bearing rollers for F_z	Number of load-bearing rollers for F_y	Load rating per roller C_{stat} [N]	Load rating per roller C_{dyn} [N]	Guide spacing* in direction x [mm]		Guide spacing in direction y [mm]
						lx1	lx2	
Beta 50-C	20	4	2	600	1.500	86 (136)	86 (136)	30,5

The pre-tension per roller is approximately 5%

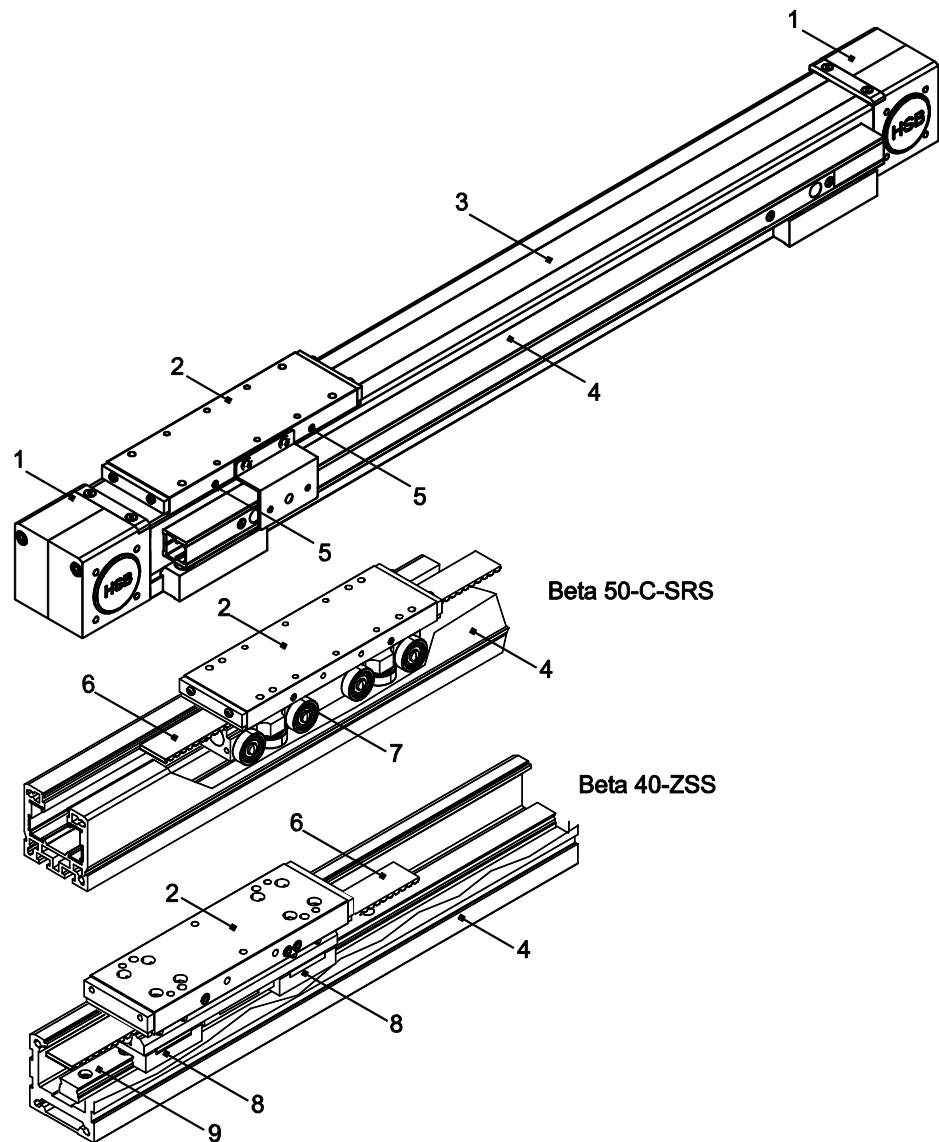
Tightening torques [Nm] for fixing screws							The figures given are intended as guides. For shorter insertion depths, the figures must be adjusted accordingly.
Fixing screws	M4	M5	M6	M8	M10	M12	
DIN912/ISO4762-8.8	2,7	5,4	9,0	22,0	43,0	74,0	
DIN912/ISO4762-10.9	3,0	5,7	9,0	22,0	43,0	74,0	
DIN912/ISO4762-12.9	3,0	5,7	9,0	22,0	43,0	74,0	

Tightening torques [Nm] for clutch with clamping hub					
Size	14	19	24	28	38
Clutch diameter [mm]	30	40	55	65	80
Screw size	M3	M6	M6	M8	M8
Tightening torque [Nm]	1,34	10,50	10,50	25,00	25,00

Tightening torques [Nm] for clutch with clamping ring hub					
Size	14	19	24	28	38
Clutch diameter [mm]	30	40	55	65	80
Screw size	M3	M4	M5	M5	M6
Tightening torque [Nm]	1,34	2,90	6,00	6,00	10,00

4 Product description

Linear unit with
timing belt drive



Key	1	Bearing casing	6	Timing belt
	2	Carriage	7	Roller bearing guidance system
	3	Cover band	8	Recirculating ball bearing
	4	Base profile	9	Guide rail
	5	Lubricating nipple		

Figure 1: Component assemblies of the Beta 50-C linear unit with timing belt drive

A mechanical linear unit converts rotational motion into linear motion and is used to move loads quickly, safely and precisely from one position to another. It consists of an aluminium base profile, a moving carriage supported by a guide element (recirculating ball bearing or roller bearing guidance system) and a drive element (screw or timing belt drive).

Depending on its design, the carriage is able to absorb forces and moments in all directions, and is positively connected to the guidance and drive elements by way of the so-called drivers.

The base profile is self-supporting up to a certain length, and is equipped with grooves for mounting.

As an option, the linear unit can be equipped with accessories such as a cover, screw supports, inductive or mechanical limit switches and other fittings (see section **6.3**).

The effective range can be flexibly configured. Multiple linear units of the Alpha, Beta or Delta type can be arranged two-dimensionally (2 axes) or three-dimensionally (3 axes).

Driven linear units can be connected to non-driven units of the same type by a plate, to be able to take large-area loads for example.

5 Transportation and storage

The mechanical linear unit is a precision item. Its mechanism may be damaged by heavy jolting, resulting in impairment of its functions.

CAUTION



Risk of damage by heavy jolting or bending!

Transport the assembled linear unit only with the transit protection fitted.

To prevent damage during transportation and storage, protect the linear unit against shaking and sliding as follows:

- Stow it in a box of sufficient size.
- Use packing.

Section 3 lists the unit weights.

Protect the unit against:

- dirt;
- corrosion;
- water;
- and aggressive atmospheres.

6 Installation and adjustment

The linear unit can be attached by the following methods:

- On mounting rails
- By screws inserted into the sliding blocks
- By screws inserted into the factory-fitted tapped hole rails

✎ Install the linear unit on a flat surface. Unit parallelism < 0.2 mm/1,000 mm.

✎ Mounting by the rails with tapped holes in them is the preferable solution:
for highly dynamic applications;
where the linear unit has only two attachment points.

6.1 Installing the linear unit by mounting rails

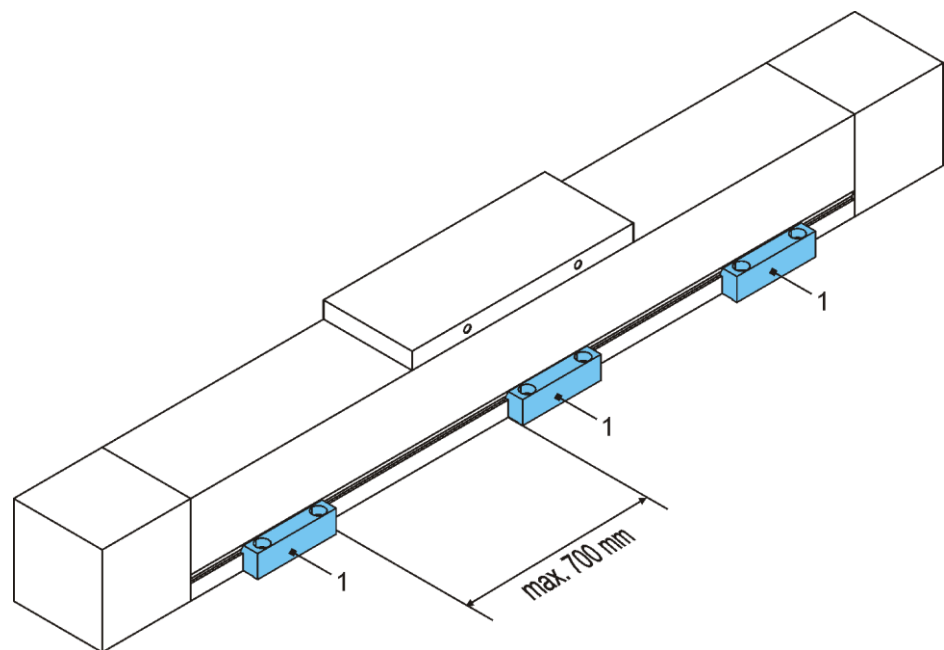


Figure 2: Mounting rails (1)

✎ The recommended maximum spacing between the mounting rails is 700 mm.

Procedure

1. Attach the mounting rails (1) loosely in position (figure 2).
2. Align the linear unit axially.
3. Tighten the mounting rails (1)
(for tightening torques see section 3).

6.2 Screwing the linear unit into place from below

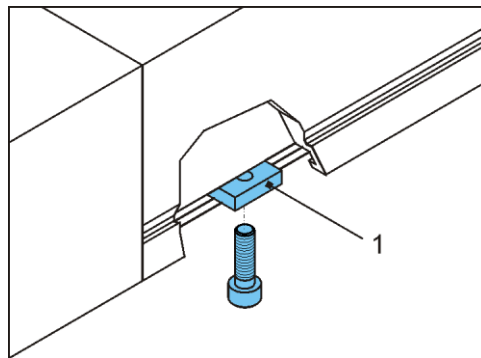


Figure 3: Sliding blocks (1) in the groove on the underside of the base profile

Attach the linear unit by the fixing screws from below using the sliding blocks or the tapped hole rails in the aluminium base profile (figure 3).

Procedure

1. Align the linear unit.
2. Align the sliding blocks (1)/tapped hole rails.
3. Tighten the linear unit
(for tightening torques see section 3).

6.3 Setting maximum travel

DANGER



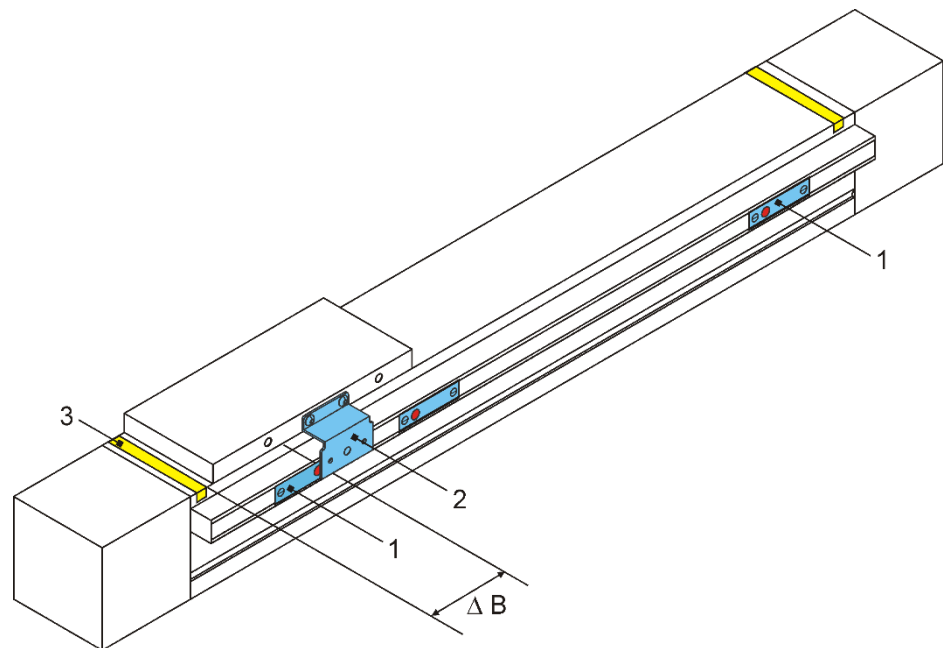
Serious injury may result if the transport carriers topple over. If the carriage moves to its full extent beyond the safety zone, the transport carrier mounted on it may break away or topple over. The linear unit may be destroyed. During setup, observe the specified safety zone and set the limit switches accordingly. Electrical switches may only be connected by qualified electricians.

☛ To stop the carriage promptly in the event of an emergency stop, allow for adequate braking distance.

6.3.1 Setting the positions of the inductive limit switches

The function of inductive proximity switches is to shut down the electric drive before the mechanical end position is reached.

The necessary braking distance (ΔB) depends on the velocity and deceleration of the carriage. The braking distance must be between the switching point of the proximity switch and the actual mechanical end position.



Key	1	Inductive limit switch
	2	Switching cam
	3	Band marking safety zone

Figure 4: Inductive limit switches

CAUTION



The limit switches must switch so that the carriage comes to a stop immediately before the safety zone. The safety zone is factory-marked on the unit by a band (3).

Procedure

1. Connect the power to the limit switches.
2. Slacken the limit switch fixing screws.
3. Run the carriage as far as the braking position.
4. Move the limit switch (NC contact) under the switching cam until it trips and the LED on the sensor goes out.
5. Move the carriage away.
6. Tighten the limit switch.
7. Check the correct position of the limit switch: Move the carriage manually and observe the switching operation.
8. Fit the limit switch array covering.

6.3.2 Setting the positions of the mechanical limit switches

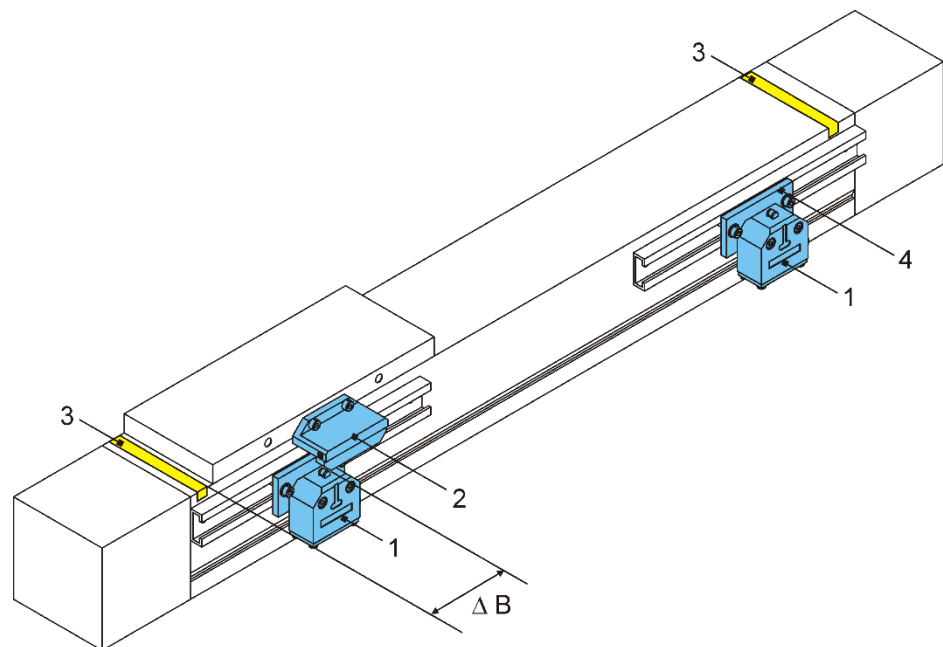
Mechanical safety limit switches (NC contacts) must be used if a hazard is posed to personnel as soon as the electric drive fails to shut down.

The drive may only be started up when all limit switches are connected and correctly set!

A combination with inductive proximity switches is possible.

External shock-absorbers must be fitted to protect against mechanical destruction.

The necessary braking distance (ΔB) depends on the velocity and deceleration of the carriage. The braking distance must be between the switching point of the limit switch and the actual mechanical end position (figure 5).



Key	1	Mechanical limit switches
	2	Switching cam
	3	Band marking safety zone
	4	Bracket
	B	Braking distance

Figure 5: Mechanical limit switches

CAUTION



The limit switches must switch so that the carriage comes to a stop immediately before the safety zone. The safety zone is factory-marked on the unit by a band (3).

Procedure

1. Connect the power to the limit switches.
2. Slacken the bracket fixing screw (figure 5).
3. Run the carriage as far as the safety zone.
4. Move the limit switch until it trips.
5. Tighten the bracket fixing screw.
6. Check the correct position of the limit switch: Move the carriage manually and observe the switching operation.
If the braking distance is too short, repeat the set-up.

6.4 Mounting a drive unit

Make sure the direction of rotation of the external drive unit takes into account the direction of the spindle or timing belt so that the limit switches work correctly.

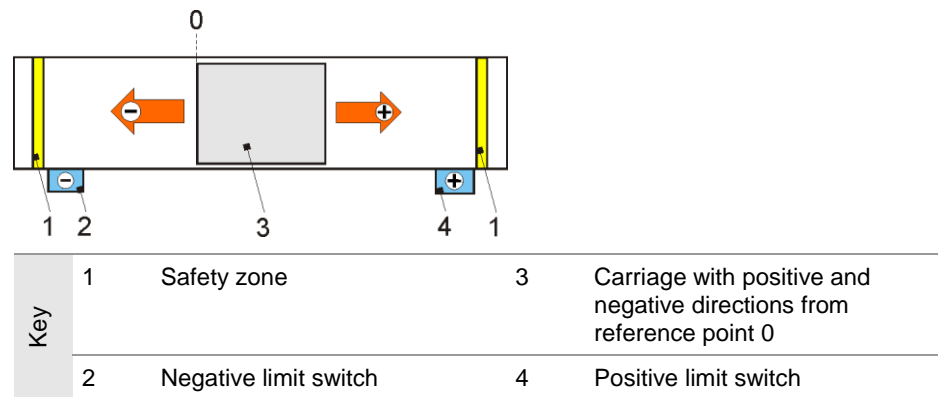


Figure 6: Example of travel direction and limit switch configuration

6.4.1 Mounting a motor

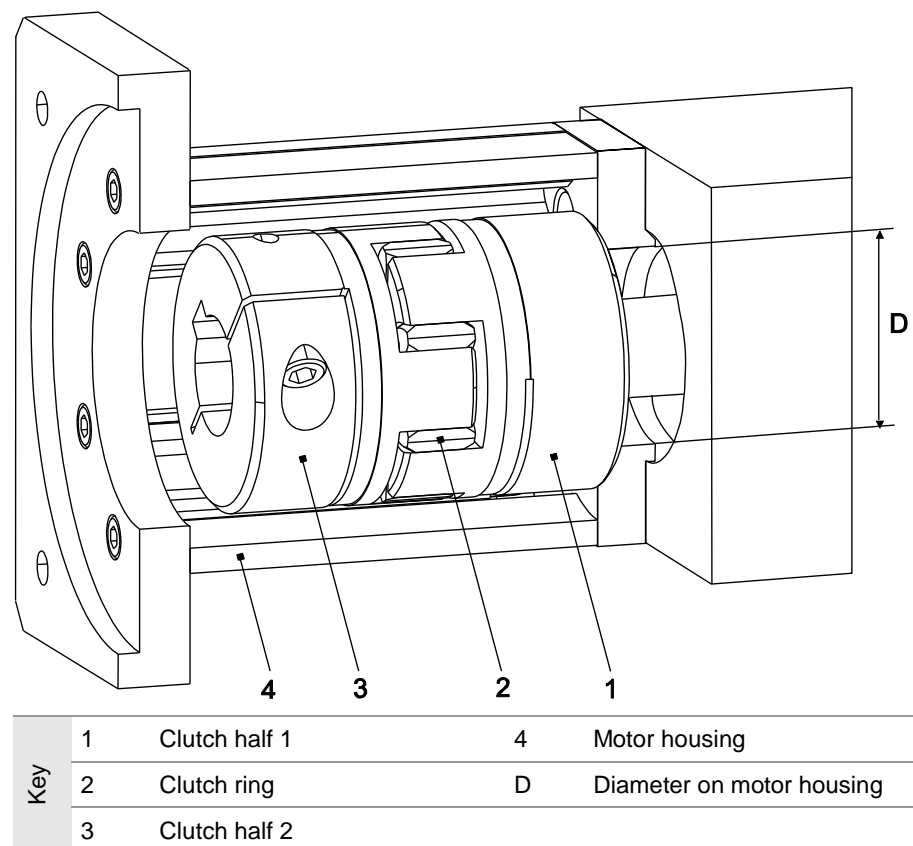


Figure 7: Motor housing with motor clutch on drive pin

Procedure

1. Place the motor and the clutch components in mounting position adjacent to the linear unit.
2. Check the direction of rotation of the motor. It must take into account the safety limit switches (figure 6). Alter the direction of the motor as necessary.
3. If the clutch diameter is less than the measure D on the motor housing (4), first mount clutch half 1 (1) (hole flush with drive shaft) and then the motor housing (4) (figure 7).

If the clutch diameter is greater than the measure D on the motor housing (4), first mount the motor housing (4) and then the clutch half 1 (1) (hole flush with drive shaft). Tighten the clutch clamping screw through the mounting hole on the motor housing (4).

4. Slot the clutch ring (2) onto the clutch.
5. Mount clutch half 2 (3) on the motor pin.
6. Mount the motor on the motor housing.

Tightening torque [Nm] of clamping screws

Screw	SW	Torque
M6	5	14
M8	6	35
M10	8	65
M12	10	74

7 Start-up

WARNING



Risk of personal injury or damage to other system components caused by rapid linear motion of the transport carrier, caused by thrown loads.
Only authorised specialist personnel may start up the linear unit.

DANGER



Risk of crushing due to incorrect direction of movement of the transport devices.
Should the direction of rotation of the drive (motor or gear) and the sliding carriage drive (spindle or toothed belt) not correspond, the mounted transport devices may travel in the wrong direction. Around all rotating parts, e.g. GX shaft and around the toothed belt (when used without cover band), there is a risk of being pulled in, and of clothing or body parts being caught up and trapped. There is also a risk of crushing around the moving carriage. These hazards can be countered by installing effective safety mechanisms that comply with the current standards and are state-of-the-art. These are not supplied with the linear unit and must be installed by the manufacturer of the overall installation.
Use of the deflection belt drive without the protective hood supplied is not permitted.
Only qualified electricians may carry out the electrical installation and check the direction of rotation.

Checks before start-up

Before starting the unit, check the following:

- Make sure the retaining fixtures conform to the mass and acceleration data provided by the manufacturers.
- Make sure the machine or line into which the linear unit is installed conforms to the EU Machinery Directive, the harmonised European standards or applicable national standards.
- Make sure the linear unit is correctly installed.
- Make sure the inductive and/or mechanical limit switches are correctly connected and working properly.
- Make sure the direction of rotation of the motor shaft and - where appropriate - of the interposed gearbox - matches that of the spindle or timing belt.

If the checks reveal any defects, prohibit start-up of the unit.

Trial run

To prevent accidents, collisions and possible errors in the programming, move the linear unit along the stroke several times at such a low speed that it can be stopped in good time in case of an emergency.

The line may be started up once it has been established that there is no risk of collision when the maximum travel is overrun.

8 Operation

WARNING



The drive motor can heat up considerably during operation. In this case, refer to the operating instructions supplied for the drive motor.

In addition, hazards can occur due to noise, tilting and falling, failure to observe ergonomic principles, and the surroundings in which the unit is used.

Various combinations of hazards are also possible.

These items should be analysed by the manufacturer or operator of the overall installation in a separate risk assessment.

CAUTION



Risk of damage from harmful environmental influences!

Operate the linear unit only under the ambient conditions approved by the manufacturers.

Ambient conditions

Operate the linear unit only within the permissible temperature range of 0 ... 80 °C.

If the linear unit is operated in moist, abrasive medium, foreign bodies may penetrate it. To prevent that, the operating company must take appropriate measures to prevent intrusion of foreign bodies, such as by installing deflectors, baffle plates or air barriers.

Duty of inspection

The proper functioning of the linear unit must be checked periodically during operation.

The responsible personnel must check the linear unit and the line for external signs of damage and defects at least once every shift.

If changes occur which are detrimental to safety, shut down the line immediately.

Emergency stop

The maximum permissible load values must not be exceeded even in an emergency stop situation.

As a rule, the category 1 emergency stop strategy (targeted braking to standstill, then de-energise) is chosen for automation equipment with moving masses. A simple emergency stop strategy is not usually effective, as the masses are still moving and can cause damage.

End position damping

The end stops and stop buffers installed in our linear modules protect the unit at low speed (commissioning). They are definitely not intended to completely protect the unit against damage at high speed and/or with a large mass.

9 Shutdown

WARNING



Risk of personal injury or damage to other system components caused by falling system components.
Only authorised specialist personnel may disassemble the linear unit.

1. Cut the power to the machine/line.
2. Dismantle the drive from the linear unit.
3. Detach the linear unit from the machine/line.

10 Maintenance

DANGER



Around all rotating parts, e.g. GX shaft and around the toothed belt (when used without cover band), there is a risk of being pulled in, and of clothing or body parts being caught up and trapped. There is also a risk of crushing around the moving carriage.

For this reason, lubrication of the linear unit may only be carried out while it is moving slowly (max. 0.025 m/s), and for any cleaning work the linear unit drive must be shut down and secured against being restarted.

- All installed ball bearings are sealed and maintenance-free.
- Remove excessive dust and dirt from the cover band and other components of the linear unit on a regular basis.
- The timing belt is maintenance-free. If the timing belt rips or is stretched beyond its elastic range, replace it.

10.1 Lubrication

Influencing factors

The following factors are key to determining the exact lubrication intervals required:

- Loading
- Velocity
- Motion
- Operating temperature
- Degree of dirtying

Short lubrication intervals

Short lubrication intervals are necessary:

- where there is susceptibility to dust and damp;
- under major loading;
- when running at high velocity (up to V_{max});
- when running over short travel distances.

Initial lubrication

☛ Carry out an initial lubrication after starting up the unit for the first time. A basic lubrication was applied at the factory.

Refer to the lubrication regulations on the following pages.

Note

Under normal operating conditions (dry environment, no dusts, etc.), the roller guide is lubricated for life with integrated lubricating felts.

Lubrication points on linear units

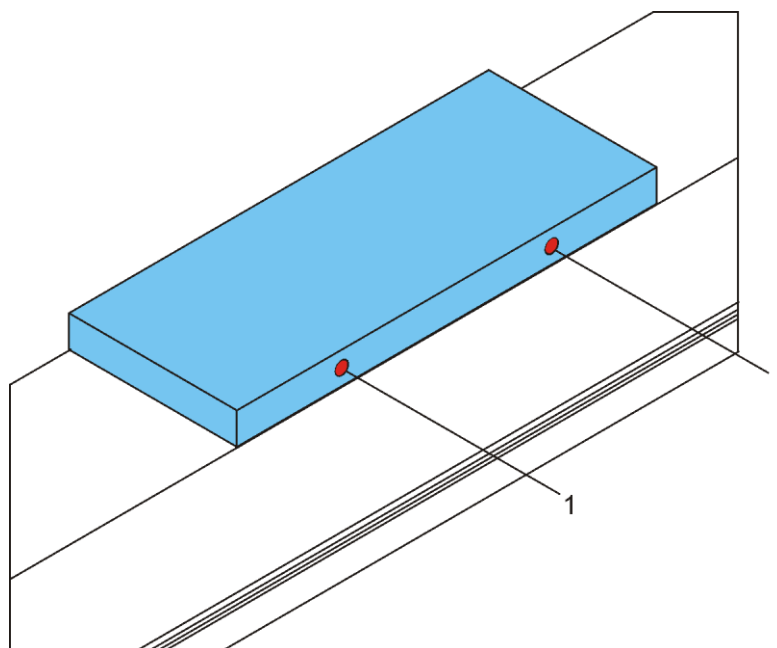


Figure 8: Possible lubrication points (1) on the carriage

The categories, quantity and positions of lubrication point depend on the model of linear unit. The categories of lubrication point are identified by the markings S, F, O on the unit.

There is a separate lubrication schedule for each lubrication point category.

Lubrication point category	Lubrication for...	Lubricant
S	Spindle	Grease
F	Guide elements	Grease
O	Guide elements	Oil

Lubrication method

Lubrication should, as far as possible, take place while the unit is running, so that the grease is distributed evenly and no pressure is built up.

Schedule for lubrication point F (for linear guide)

Carriage size	Lubrication interval	Grease quantity [cm ³] per carriage	Grease type
15 with ball chain	approx. 5,000 km*	ca. 0.4	Greases to DIN 51825-KP2N-20, e.g. Klüberplex BE 31-102 ☛ If other greases are used, pay attention to manufacturers' specifications! ☛ Greases containing solid lubricant (e.g. graphite, MoS ₂) must not be used!
20 with ball chain		ca. 0.6	
25(L) with ball chain		ca. 1.2	
30 with ball chain		ca. 1.5	
35 with ball chain		ca. 1.7	
12 with ball chain		ca. 0.14	
12 without ball chain	approx. 2,000 km*	ca. 0.15	
15 without ball chain		ca. 0.8	
20 without ball chain		ca. 1.4	
25(L) without ball chain		ca. 2.8	
30 without ball chain		ca. 4.4	
35 without ball chain		ca. 4.4	

* Or at least 2 x per year. The lubrication interval depends on the ambient temperatures and on the loading (see figure 11). Relubrication "in motion"!

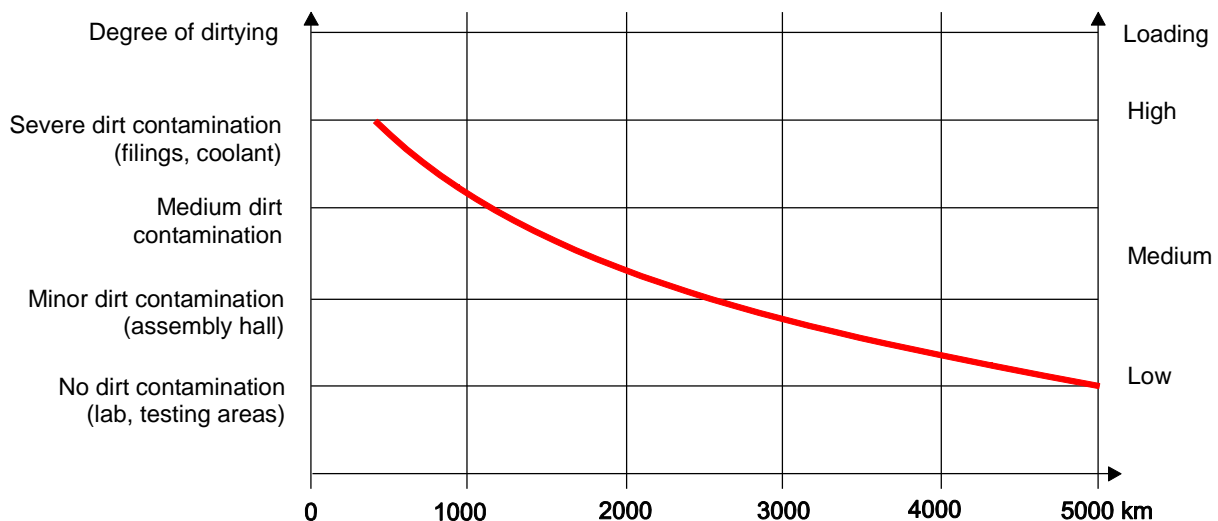



Figure 9: Relubrication intervals for the linear guidance system with recirculating linear ball bearings

Schedule for lubrication point O (for roller guideway)

Lubrication interval	Oil quantity [cm ³]	Oil type
Every 2,000 km*	approx. 0.4	Chainoil e.g. Klüberoil CM 1-220 (or similar oil on the basis of mineral oil according ISO-VG 220)  If other oils are used, pay attention to manufacturers' specifications!
* Or at least 2 x per year. The lubrication interval depends on the ambient temperatures and on the loading.		

10.2 Replacing the timing belt

✎ To preserve the optimum running of the linear unit and prevent it from being damaged during operation, take care that no foreign bodies penetrate the base profile or other linear unit components during installation and assembly.

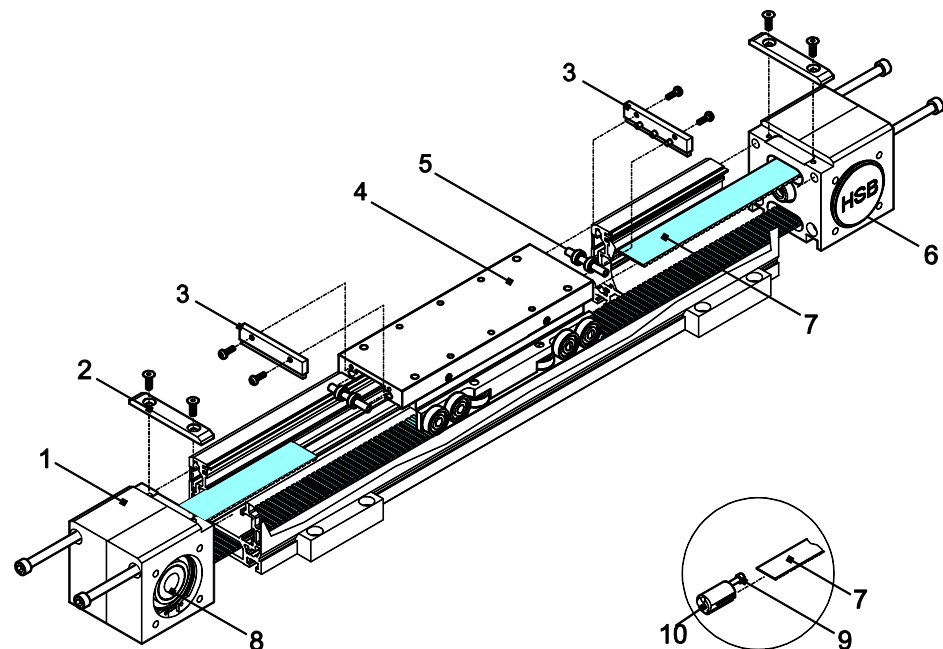
✎ Do not damage the standard parts (screws, pins, etc.) or the cover band and its elements; they will be re-used.

CAUTION



Risk of damage due to lack of lubrication!

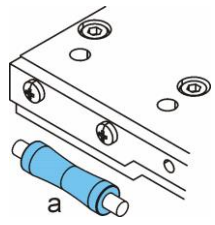
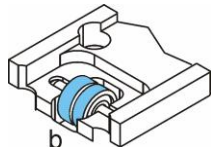
Do not lose or damage the O-rings fitted on the lubricating apertures, otherwise component lubrication will not be guaranteed.



Key	1	Driven bearing casing	6	Non-driven bearing casing
	2	Clamp fitting	7	Timing belt
	3	Stripper brush	8	Drive shaft
	4	Driver	9	Clamping screws
	5	Lift roller	10	Timing belt holder

Figure 10: Exposing and replacing the timing belt

Procedure

1. Dismantle the drive unit (motor, gearbox).
 2. Run the driver to the middle of the linear unit.
 3. Unfasten the stripper brushes (if fitted) from both front faces.
 4. Pull the press rollers (a) on both front faces of the driver out of the clamp (using a hook).
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5. Unscrew both cover band clamp fittings.
 6. Pull the cover band out of the driver.
 7. Remove the lifting rollers (b) on the front faces of the driver.
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8. Tighten the clamping screws on the timing belt holders.
 9. Pull the timing belt ends together with the timing belt holders out of the driver.
 10. Detach the two timing belt holders from the timing belt.
 11. Unscrew the non-driven bearing casing.
 12. Pull the defective timing belt out of the two bearing casings and remove it.
 13. Insert the right-hand end of the new timing belt with its teeth facing upwards into the bottom slot on the non-driven bearing casing and push it out through the top slot.
 14. Push the left-hand end of the new timing belt with its teeth facing upwards through the channel of the base profile.
 15. Unscrew the driven bearing casing.
 16. Push the left-hand end of the timing belt into the bottom slot on the driven bearing casing until the pulley engages.
 17. Rotate the drive shaft by hand and push the timing belt out through the top slot in the bearing.
 18. Push the timing belt holders onto the ends of the timing belt.
 19. Slot one timing belt holder into the driver and screw in the clamping screw. Do the same with the second timing belt holder.
 20. Screw both bearings correctly onto the base profile.
 21. Tighten the timing belt firmly by the clamping screws. Lock the screws with Loctite 243.

- 22.** Set the precise specified tension using a tension meter (see meter operating instructions).

☛ Only by setting the correct tension as specified can optimum running be ensured.

- 23.** The measurement position and the Hz figure applicable to the timing belt are provided along with the replacement belt. Tension the timing belt so that the specified Hz figure is indicated.

- 24.** Insert the lifting rollers.

- 25.** Push the cover band over the timing belt with its broader side (with the chamfered cutting edge) facing downwards through the driver.

- 26.** Carefully press the cover band into its guideway along its entire length until it audibly snaps into place.

- 27.** Secure the loose end of the cover band by the clamp fitting.

☛ The cover band must not stick out of its guideway at any point, otherwise it will be damaged.

- 28.** Clamp the press rollers in place.

- 29.** Bolt on the stripper brushes.

- 30.** Replace the bands indicating the safety zones at the right and left ends of the linear unit as necessary.

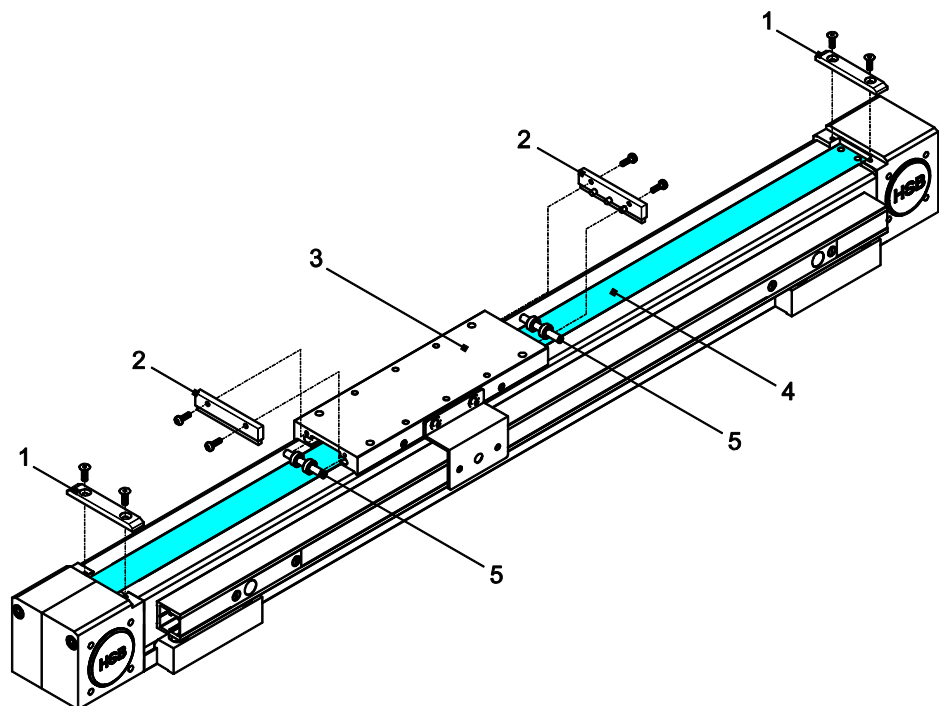
- 31.** To ensure the cover band engages safely in its guideway, slowly move the driver along its entire travel distance by hand.

10.3 Replacing cover bands

☛ To preserve the optimum running of the linear unit and prevent it from being damaged during operation, take care that no foreign bodies penetrate the base profile or other linear unit components during installation and assembly.

☛ Do not damage the standard parts (screws, pins, etc.) or the dismantled components; they will be refitted.

☛ If cover bands are worn, also replace the band guide elements. If cover bands are damaged, check the band guide elements for wear and replace them only as necessary.



Key	1	Clamp fittings
	2	Stripper brushes
	3	Driver
	4	Cover band
	5	Press rollers

Figure 11: Cover bands based on the example of the Beta 50-C-ZRS linear unit

Procedure

1. Move the driver into the middle.
2. Unfasten the stripper brushes (if fitted) from both front faces.
3. Detach the clamp fittings from the ends of the cover band and pull the cover band out of the driver.
4. Pull the press rollers (a) on both front faces of the driver out of the clamp (using a hook).
5. Check the band guide elements, such as the press rollers (a), lifting rollers (b) and locating pins, for wear.
 - If the cover band is worn, be sure also to replace the band guide elements. Worn guide elements will damage the new cover band.
 - If the cover band is damaged, only replace the band guide elements if they are damaged. Fit press rollers (a) with the larger diameter on the outer.
6. Push the new cover band with its broader side (with the chamfered cutting edge) facing downwards through the driver and fix it at one end by the clamp fitting.
7. Carefully press the cover band into its guideway along its entire length until it audibly snaps into place. It must not stick out at any point, otherwise it will be damaged.
8. Clamp the press rollers in place.
9. Stretch the cover band and fix it by the clamp fitting at the other end.
10. Bolt on the stripper brushes (if fitted).
11. To check that the carriage is correctly installed, run it slowly from one end of the linear unit to the other, ensuring the cover band is held all the time in its guideway.

