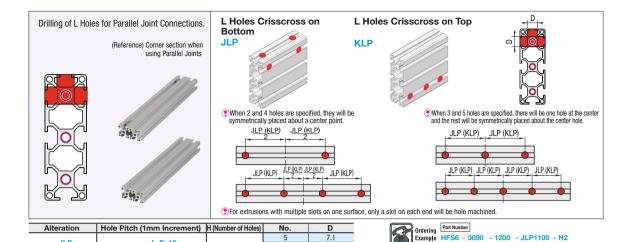
L Hole Alterations

Parallel Joints

- 1200 - JLP1100 - H2 - 1800 - KLP870 - H3 - 1800 - JLP870 - KLP870-H3



13.1

• Hole pitch on Top/Bottom can be separately specified, but the number of holes will be equal on top and bottom.

D+4.9~ L-D-10 H-1

See the table below for the applicable extrusions and alteration charges. Indicated with "-" in the table are not applicable.

2 3 4 5

See the table b	Delow for the	applicable	ZALI USIOIIS AIII		Charge per 1 Hol	
Alterations			L Hole (Crisscross on Top Section	Crisscross on Bottom Section	
	Code			L Hole Dia.	JLP	KLP
Features	Type	No.	Page	i	OL:	I CLI
		2020 2040	P.529			-
		2040	P.530	-		
Four-Side Slots	HFS5	2080	P.531			
	NFS5	2525 2550	1.551		-	-
	CAF5 HFSY5	4040	P.530	ł		
	111 010	4060	P.531	1		
		4080 404020	P.532			
		2020	P.529	1		
3-Side Slot 1Side Flat	HFSF5 NFSF5	2040	P.530	1		
Two-Side Slots Two		4040 2020	P.529			
Flats	HFST5 NFST5	4040	P.530	07.1		
Two Slots on Opposite Sides	HFSH5	2020	P529	1		
One-Side Slot Three Flats	HFSC5 HFS30A5	2020	1.020		-	-
Angled	HFS45A5 HFS60A5	20	P.532			
		2020	P.529			
	HFSB5	2040 2525	P.530	1		
Black Anodize	NFSB5	2550	P.531		-	-
		4040	P.530			
	HFSFB5 HFSTB5	2020	P.529			-
Curved	HFSR5	2020			-	
Ourved	111 0110	404020 3030	P.532 P.571	ļ		ļ
		3030	P.573			
	HFS6	3090	P.576	i		
	EFS6	30120 5050	1.570			
Four-Side Slots	NFS6 NEFS6	50100 100100	P.579		-	-
	GFS6	6060	P.575			
	CAF6 HFSY6	6090	P.577			
		60120 606030	P.578			
		30300	P.576			
	HFSF6	3030 3060	P.572 P.574	Į.		-
3-Side Slot 1Side Flat	EFSF6 NFSF6	5050	P.579	1	-	
	NEFSF6	6060	P.575	1		1
Two-Side Slots Two	HFST6	3030	P.572 P.574			
Flats	EFST6	5050	P.574 P.579	1		
	NEFST6	6060	P.575	1		-
Two Slots on Opposite Sides	HFSH6 EFSH6	3030 3060	P.572 P.574		-	
One-Side Slot Three Flats	HFSC6 EFSC6		P.572	1		
Unerdide didi Tillee Hats	EFSC6	3030	P.572	011.1		
Light Type	NFSL6	3060	P.573	011.1		
	HFSL6	5050	P.579	j	-	-
Heavy Type	HFSG6	6060	P.575			
Angled	HFS30A6 HFS45A6 HFS60A6	30	P.578		-	-
		3030	P.571	i		
	HFSB6	3060 3090	P.573			
	EFSB6 NFSB6 NEFSB6	30120	P.576			
		5050			-	-
		50100 100100	P.579			
Black Anodize		6060	P.575			
	HFSFB6					
	EFSFB6 HFSTB6 EFSTB6	3030	P.572			-
	HFSLB6	2000	DETO			-
	NFSR6	3060	P.573			
Curved	HFSR6	3030	P.578		-	
	5110	606030				

Color					L Hole (Charge per 1 Hol-	e Location)
Features		Alteratio	ns			Crisscross on Top Section	Crisscross on Bottom Section
Features		0-4-			L Hole Dia.		KID
Four-Side Slots Four-Side Slot Slot Flat Four-Side Slot Flat Four-Sid	Features			Page		JLP	KLP
Four-Side Slots Four-Side Slots NFSS NFSS A01200 P638 NFSS B00600 P637 NFSS B00600 P637 NFSS A01200 P638 NFSS B00600 P637 NFSS A01200 P638 A01200 P638 NFSS A01200 P638 A01200 P638 NFSS A01200 P638 NFSS A01200 P638 NFSS A01200 P638 NFSS A01200 P638 A01200 P638 NFSS A01200 P638 A01200 P	reatures						
Four-Side Slots NEFS					i		
Four-Side Slots OFS8 OFS8 S000 P635 S000 P635 S000 P635 S000 P636 S000 P637 Two-Side Slots Two Filts Filt		NES8			i		
GFS S0080				P.636			
HFSV6 800040 P637 HFSV6 000040 P637 HFSV6 000040 P635 HFSV6 000040 P635 HFSV6 4000 P632 HFSV6 4000 P632 HFSV6 4000 P634 HFSV6 4000 P631 HFSV6 4000 P633	Four-Side Slots	GFS8	8080	P.635	1		
HFSH8			80160	P.636	1		
3-Side Slot 1Side Flat Files		HFSY8	808040	P.637	1		1
3-Side Slot 1Side Flat Missing		HFSH8	8080	P.635	1		1
Two-Side Slots Two Flats		HFSF8	4040	P.632	i		-
Two-Side Slots Two Flats	3-Side Slot 1Side Flat	NFSF8	4080		1		
Two-Side Slots Two Flats		GFSF8		P.635	1		
Flats	Turo Cido Cloto Turo	HESTS			1		1
ivo Stoto n Opposite Sides B080		NEFST8			1		
wo bus on upparts sides FFSHB	riais	GFST8			1		1
De Side Sid Three Flats	Euro Cloto on Opposito Cidos			P.632	1		-
Design D	IWO SIDIS OII OPPOSITE SIDES	EFSH8	4080	P.634	1	-	
Angled HFSSAGA	One-Side Slot Three Flats	EFSC8					
Angled HFSB0A8 400 P633 HFSB0A8 404 P631 HFSB0A8 4040 P633 HFSB0A8 40400 P633 HFSB0A8 40120 P633 HFSB0 40120 P636 EFSB 40160 P636 HFSFB 60100 P636 HFSFB 4040 P632 HFSFB8 HFSFB H	Light Tune				Ø13.1		1
Angled HFS45A8 40 P637 HFS60A8 A00 P637 HFS60A8 A010 P633 HFSB8 A0100 P633 HFSB8 EFSB8 A0100 P635 BFSFB8 HFSFB8 HF	Light Type	NFSL8	4080	P.633	1		
HFSB8	Angled	HFS45A8	40	P.637		-	-
HFSB8					i		1
Black Anodize			4080		1		
Black Anodize			40120	P.636	i		
Black Anodize HF SFBB HF STB HF STB HF SLB8 H		EFSB8					
BIBOX ANODIZE HISSEB EFSFBB HISTEB EFSTBB HISTEB HISTEB HISTEB 4040 P631 HISTEB 4040 P633							
HFS/FB8 FFS/FB8 HFS/FB8 HFS/FB8 HFS/LB8 HFS/LB8 4040 P631 HFS/LB8 4090 P633 HFS/LB8 4090 P633	Plack Apadiza		80160	P.636			
HFSTB8 4040 P.632 EFSTB8 4040 P.631 HFSLB8 4040 P.633 HFSLB8 4040 P.633	DIGUN AITUUIZE						
HFSLB8 4040 P631 HFSLB8 4060 P633		EFSFB8	4040	D633			
HFSLB8 4040 P.631 4080 P.633			7040	P:032			-
HFSLB8 4080 P633		EFSTB8					
0 4000 F033		HESI BR					
		5200		P.633			
Curved HFSR8 808040 P.637	Curved	HFSR8		P.637		-	

* Number of holes determines the alteration fee. (Price in the Table x Number of Holes)

Standard of Extrusion Position

- Placing method of the extrusion, which is a basis to determine right and left is shown as follows.
- ① On the vertical length
- ② Flat side down

③ One flat side down and another flat side right

Example of ① Example of ② Example of ③ * Example of L-Shaped















do not penetrate through the smooth side.

Additional Info. on Smooth Sided Extrusions

D Holes in smooth side direction are blind holes, and



Notes on JLP / KLP Combination Use

Hole pitch on Top/Bottom can be separately specified, but the number of holes will be equal on top and bottom.

· Hole pitch on Top/Bottom can be specified separately.

 Uneven number of holes cannot be specified.





• When the extrusion is on the vertical length and also has a flat side, ① has the priority.

Other Special Alterations

■End plates mounting for GFS series

Machines countersink and tapped hole in order to mount the end plate for high rigidity aluminum extrusions.

Alteration	ons	Hole Machining for End Plate Mounting					
Code)	LTS	RTS	TSW			
Spec.		Machined on the Left End Screw Countersink Depth 36* * Depth 24 for GFS6 Series	Machined on the Right End Extrusion Screw Screw Countersink Depth 36* * Depth 24 for GFS6 Series	Machined on both ends. Countersink Depth 36* Countersink Depth 36*			
Applicable Extrusion	Applicable Screw			* Depth 24 for GFS6 Series			
GFS6-3030	SHFBS8-15 x 1 pc.						
GFS6-3060	SHFBS8-15 x 2 pcs.						
GFS8-4040							
GFS8-4545	SHFBS12-20						
GFS8-5050	x 1 pc.						
GFS8-6060							
GFS8-4080							
GFS8-4590							
GFS8-50100	SHFBS12-20						
GFS8-9090	x 2 pcs.						
GFS8-100100							
GFS8-100200							

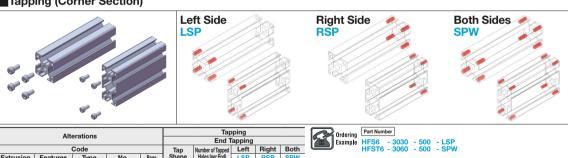
Screws are not included.

End plates mounting for HFSR5-404020 and HFSR6-606030

Machines countersunk and tapped holes to mount the plates on P.555, 568, 615, 628.

Alteration	ons	Hole Machining for End Plate Mounting				
Code	;	LTS	RTS	TSW		
Spec		The diagram below shows the basic ext LTS: Machined on the Left End RTS: Machined on the Right End TSW: Machined on Both Ends	trusion position.			
Applicable Extrusion	Applicable Screw		Ex. LTS			
HFSR5-404020	SHFBS5-6					
HFSR6-606030	SHFBS8-12					

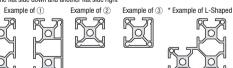
■Tapping (Corner Section)



Alterations											
							End Tapping				
Code					Тар	Number of Tapped	Left	Right	Both		
	Extrusion	Features	Type	No.	Page	Shape	Holes (per End)	LSP	RSP	SPW	
			CAF6	3030	P.571						
				3060	P.573						
			HFS6	3030	P.571						
				3060	P.573						
				3090	DEZC						
		Four-Side Slots		30120	P.576						
		Siots		6090	P.577						
				60120		M5 Depth 10					
				606030	P.578						
			HFSV6	3030	P.580						
	HFS6 Series			3060							
	nroo series	3-Side Slot 1Side Flat	HFSF6	3030	P.572						
				3060	P.574						
		Two-Side Slots Two Flats	HFST6	3030	P.572						
				3060	P.574						
		Two Slots on	HFSH6	3030	P.572						
		Opposite Sides		3060	P.574						
		One-Side Slot Three Flats	HFSC6	3030	P.572						
		Black Anodize	HFSB6	3030	P.571						
				3060	P.573						
			HFSFB6	HFSFB6 3030	P.572						
			HESTB6	3030							



- Placing method of the extrusion, which is a basis to determine right and left is shown as follows.
- ① On the vertical length 2 Flat side down
- 3 One flat side down and another flat side right



• When the extrusion is on the vertical length and also has a flat side, ① has the priority. For center section tapping, see P.757.