

## B. Installation of slide rail in hardened steel

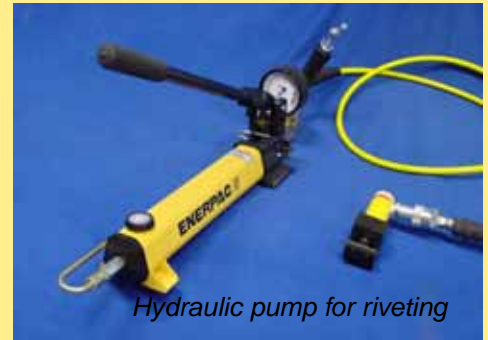
### Installation of hardened steel slide rail – XK

#### Tools required

Locking pliers	
Knife	
Drill	
Drill bit	Ø4,2 mm
Angle grinder	
Slide rail fixture	5056186 (see picture)
Hydraulic pump for riveting	See picture
Rivets	5056167



Slide rail fixtures



Hydraulic pump for riveting

#### Mounting at drive unit/idler ends

- 1 Cut off the flanges on the plastic guides.



#### Mounting in straight sections

- 2 Cut the slide rail. If necessary, drill a hole in the slide rail (See step 9).
- 3 Drill through the aluminium beam with a 4,2 mm drill bit.
- 4 Place a rivet in the hole and fasten (See step 12).
- 5 Polish all sharp edges.



#### Mounting at wheel bends

- 6 Place the slide rail on the beam. Mark the beam edge on the slide rail, add 50 mm and cut.
- 7 Cut the slide rail at an angle.



- 8 Round off the corner and polish all sharp edges.



- 9 If necessary, drill and countersink a new hole 40 mm from the edge.



- 10 Place the slide rail at the correct distance by using the fixtures. Fix the slide rail with locking pliers. Drill through the aluminium beam with a 4,2 mm drill bit.



- 11 Place the bend slide rail/rails on the wheel bend. Make sure the distance to the disc is 51–53 mm. Fix the slide rail with locking pliers. Drill through the aluminium beam.



- 12 Place the rivet in the hole, make sure the plunger hits the whole rivet and press. *Note. Use maximum pressure of 200 bar.*



- 13 Grind down the rivets with a grinding wheel until you have a smooth surface.



PO  
X45  
XS  
XL  
XLP  
X85  
X85P  
XH  
XK  
XKP  
X180  
X300  
GR  
CS  
XT  
XC  
XF  
XD  
FST  
XLX  
X85X  
X180X  
X300X  
GRX  
CSX  
ELV  
CTL  
TR  
APX  
IDX