High precision slide assemblies

Models L, H, CP, DC, HWS and HWL

Thank you for choosing a quality Gilman Precision product. For best results, read the following product warnings.

Gilman Precision slide assemblies are quality, high precision machine components that require special care and handling.

The following points should be followed to extend slide life and performance.

1. The mounting surface for a high precision slide assembly should be rigid and of good surface quality. A surface flatness of .0005 in./ft. is required.
2. When additional machining is required, observe caution not to generate excessive heat which could cause distortion.
3. Slide must be properly lubricated with contamination free Mobil Vactra #2 oil or equivalent. *Do not use grease.*

HWS/HWL lubrication formula: LD = (SL+T)(D)

SL = Saddle length (in.)
T = Travel (in.)
A = No. of lube points in saddle
D = Lube factor (cc/hr. per in. SL+T)
LD = Lube required for slide (cc/hr.)

SL	A*
5-18	4
19-36	8
37-60	12

Model	D
HWS5	.11
HWL7, HWS7	.16
HWL9, HWS9	.17
HWL12, HWS12	.26
HWL15, HWS15	.35
HWL18, HWS18	.40
HWL24, HWS24	.44
HWS5	.44

* Half of the lube points in the saddle are for the top of the way, half of the lube points in the saddle are for the side of the way. Top of way lube points should receive twice as much lube as the side of way lube points

DC and CP lubrication formula: LD = (SL+T)(D)

SL = Saddle length (in.)
T = Travel (in.)
A = No. of lube points in saddle
D = Lube factor (cc/hr. per in. SL+T)
LD = Lube required for slide (cc/hr.)

SL	A
2-12	2
13-24	4
25-36	6

Model	D
DC2	.08
DC3	.09
H4, CP4, DC4	.11
H6, CP6, DC6	.15
H8, CP8, DC8	.18
DC10	.25
DC12	.28
DC16	.44
DC20	.50

Note: All dovetail and hardened way slide assemblies that are lead screw driven will have an additional lube point for the lead screw. Lubrication requirements may vary depending on your application. Consult factory and your lubricator manufacturer for further assistance.

4. Slides that have wear surfaces lined with low friction bearing material should not be used in temperatures less than -60˚F (-51˚C) or more than + 150˚F (65˚C), and should not be subjected to fluoride base coolants or chlorinated cutting oils.

In design applications and installations using Gilman Precision machine modules, it is imperative to observe recognized safety standards or other applicable codes set forth by corporate, government and industry regulators.

Some Gilman Precision slide assemblies are shipped with gib screws locked for handling safety. These will be tagged and must be loosened and readjusted for proper operation of the slide assembly.

The following procedure should be used when any gib adjustment is necessary.

1. Loosen and slightly back off all gib screws and nuts.
2. Make sure the saddle is tight against the solid side way surface. Check for clearance with a .001 thick shim. If saddle is not tight, tighten the end gib screws to pull the saddle over. Recheck with shim and loosen the end gib screws.
3. Alternating from end to end, tighten each gib screw until it meets resistance, then continue tightening an additional 1/8 turn.
4. Starting at the center gib screw and alternating one at a time out towards the ends of the saddle, back off the gib screw slightly, while maintaining some resistance, until pressure is relieved. Back off the gib screw approximately an additional 1/8 turn. Tighten the gib screw nut against the saddle while holding the gib screw stationary.
5. Cycle the saddle to check for a smooth and even motion. If motion is not smooth, repeat the adjustment procedure.

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