

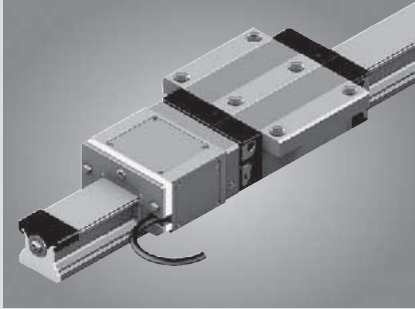
Linear Bushings and Shafts Inch Series

The Drive & Control Company

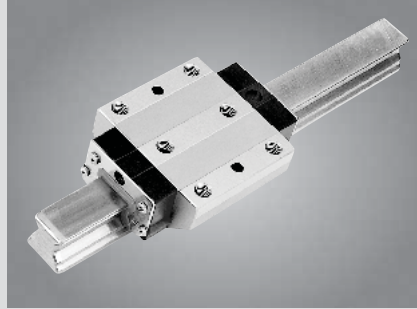


Linear Motion and Assembly Technologies

Ball Rail Systems



Roller Rail Systems



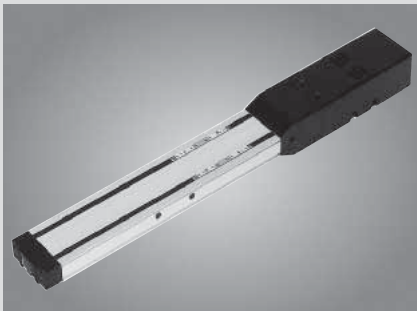
Linear Bushings and Shafts



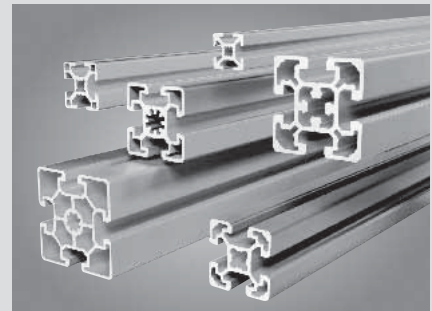
Ball Screw Drives



Linear Motion Systems



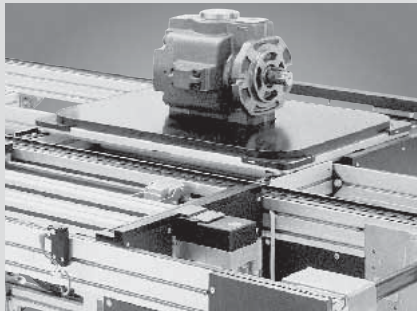
Basic Mechanical Elements



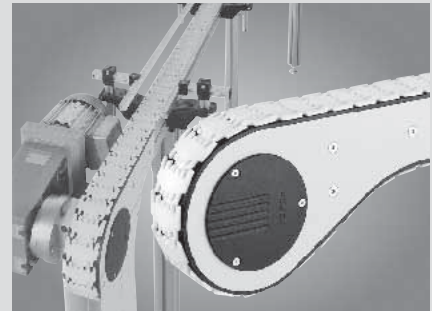
Manual Production Systems



Assembly Conveyors



VarioFlow Conveyors

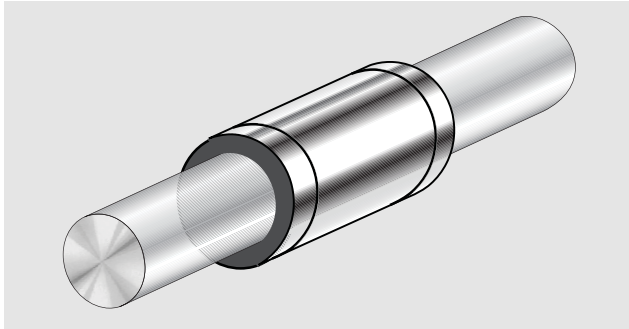


Linear Bushings and Shafts - Inch Series

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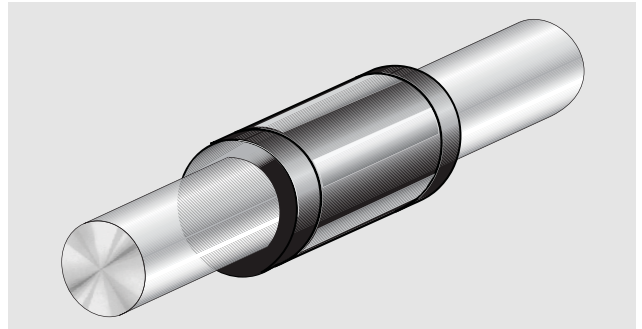
Product Overview

PRODUCT	TYPE	FEATURES
Linear Bushings	Standard R0750-..to R0753-..	- closed/adjustable/open - precision bore - with or without internal seals - corrosion-resistant
	Super R0755-..to R0756-..	- closed/open - self-aligning adjustable bore - with or without internal seals - light weight/high load capacity
Linear Pillow Block Sets	Cast Iron Blocks R1750-..to R1753-..	- closed/adjustable/open - rigid cast iron - self-aligning sleeve - standard bushing insert
Linear Shaft and Assemblies	Aluminum blocks Single R1755-..to R1757-.. Twin R1760-..to R1763-..	- closed/adjustable/open - super bushing insert - lightweight - anodized blocks
	Precision Steel Shaft R1700-..to R1771-..	- carbon/stainless steel - plain or pre-drilled - class L
	Shaft Support Rail Assemblies R1769-.. to R1770-..	- aluminum/steel
Shaft Supports	Support Rails R1767-..to R1768-..	- aluminum/steel material - with or without base flange - standard and low profile - rigid cast iron block

**Standard Linear Bushings**

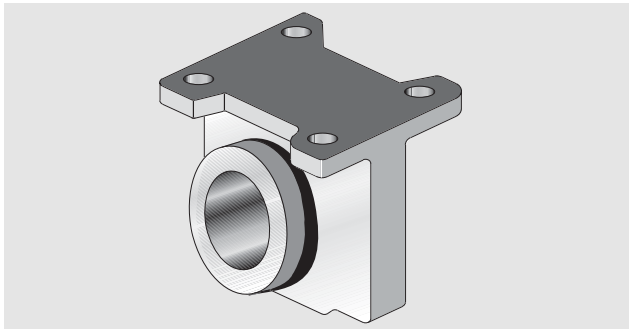
Sizes 1/4" through to 4"

Load capacities: 46 to 4061 lbs

**Super Linear Bushings**

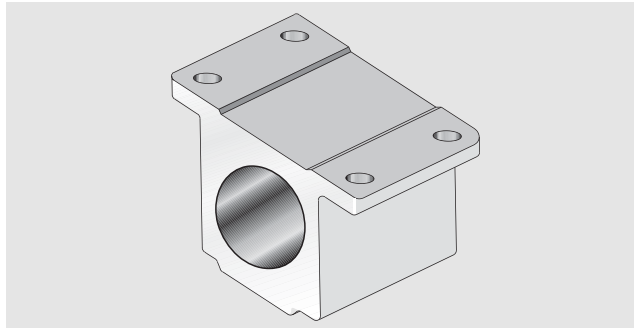
Sizes 1/4" through to 2"

Load capacities: 60 to 3110 lbs

**Cast Iron Pillow Block Sets**

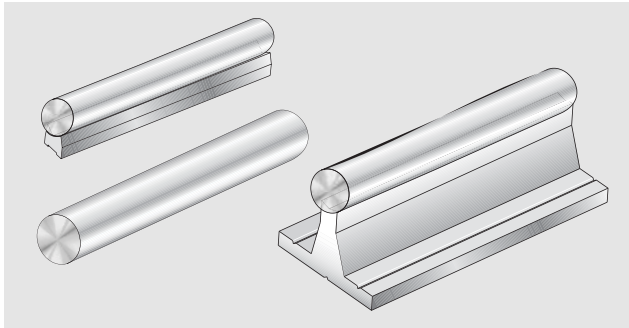
Sizes 1/2" through to 2"

Load capacities: 177 to 1320 lbs

**Aluminum Pillow Block Sets**

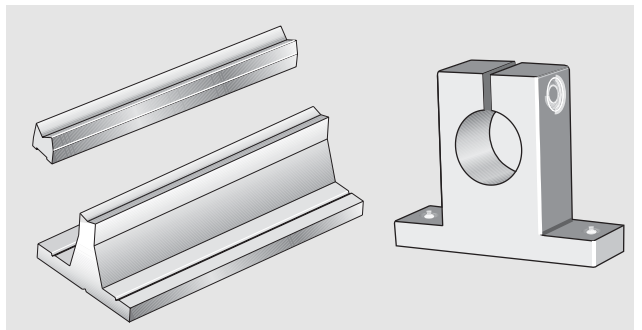
Sizes 1/4" through to 2" - single and twin blocks

Load capacities: 42 to 4000 lbs

**Precision Steel Shafts**

Shaft diameters 1/4" through to 4"

Assemblies 1/2" through to 2"

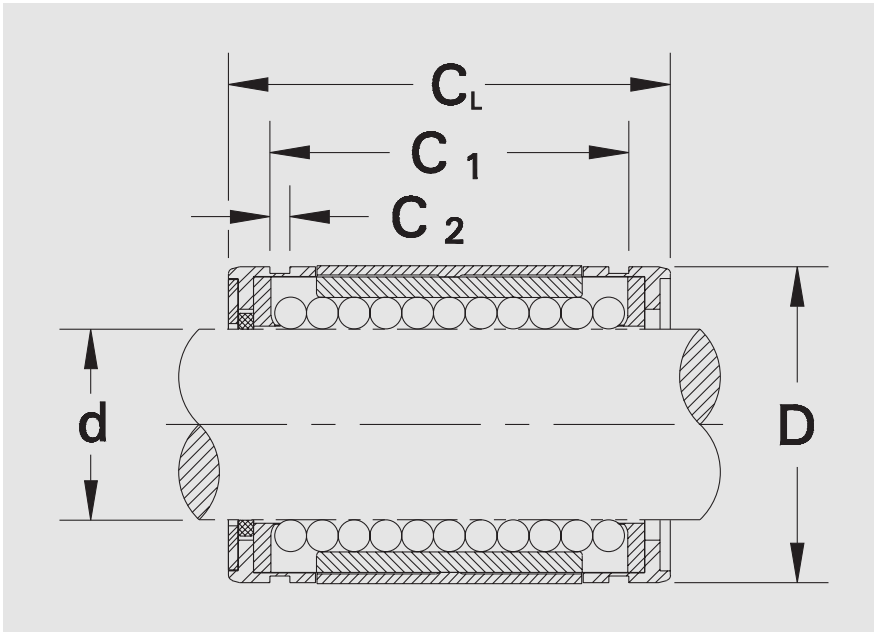
**Support Rails and Blocks**

Sizes 1/2" through to 2"

Support blocks sizes 1/4" through to 2"

Dimensions and Load Capacities

Basic Mounting Dimensions



Nominal Shaft Diameter	Standard Linear Bushings				Super Linear Bushings			
	D	C _L	C ₁	*C ₂	D	C _L	C ₁	*C ₂
0.2500	0.5000	0.7500	0.5110	0.0390	0.5000	0.750	0.515	0.0390
0.3750	0.6250	0.8750	0.6358	0.0390	0.6250	0.875	0.703	0.0390
0.5000	0.8750	1.2500	0.9625	0.0459	0.8750	1.250	1.032	0.0459
0.6250	1.1250	1.5000	1.1039	0.0559	1.1250	1.500	1.112	0.0559
0.7500	1.2500	1.6250	1.1657	0.0559	1.2500	1.625	1.272	0.0559
1.0000	1.5625	2.2500	1.7547	0.0679	1.5625	2.250	1.886	0.0679
1.2500	2.0000	2.6250	2.0047	0.0679	2.0000	2.625	2.011	0.0679
1.5000	2.3750	3.0000	2.4118	0.0859	2.3750	3.000	2.422	0.0859
2.0000	3.0000	4.0000	3.1917	0.1029	3.0000	4.000	3.206	0.1029
2.5000	3.7500	5.0000	3.9760	0.1200				
3.0000	4.5000	6.0000	4.7260	0.1200				
4.0000	6.0000	8.0000	6.2580	0.1389				

(Table 1)

*Groove dimensions conform to MIL-R-21248B (Industrial External Retaining Rings)

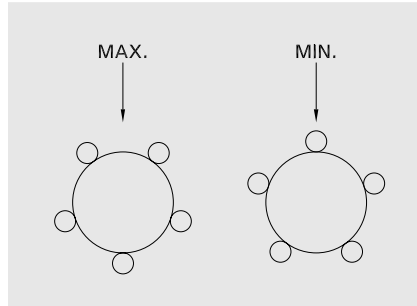
Note: Dimensions listed are nominal measurements in inches - see bushing spec sheets for tolerances

Load Capacities

Load Correction Factor ($f_{\max}$) $C_{\max} = C_{\min} \cdot f_{\max}$

Figure 2 illustrates the basic theory of Load Capacity $C_{\min}$ and $C_{\max}$ given in table 3. $C_{\min}$ and $C_{\max}$ represent the bushing capacity rating if the direction of load in relation to ball position is known.

The $f_{\max}$ load correction factor is used to calculate the maximum load capacity when the direction of load is known, and is shared by two or more ball circuits depending on the size of Linear Bushing.



(Figure 2)

Nominal Shaft Diameter (Standard)	Load Correction Factor $f_{\max}$	Nominal Shaft Diameter (Super)	Load Correction Factor $f_{\max}$
1/4"	1.000	1/4" - 1/2"	1.414
3/8"-5/8"	1.414	5/8"	1.463
3/4"	1.463	3/4" - 2"	1.280
1-4"	1.280		

(Table 2)

Capacity Rating

Nominal Shaft Diameter	Standard Linear Bushings			Super Linear Bushing		
	Dynamic C (lbf) min.	Dynamic C (lbf) **max.	Static C _o (lbf)	Dynamic C (lbf) min.	Dynamic C (lbf) **max.	Static C _o (lbf)
0.2500	46	46	60	60	85	80
0.3750	51	72	71	95	134	120
0.5000	115	163	176	230	325	290
0.6250	174	246	266	401	587	502
0.7500	194	284	308	470	602	592
1.0000	221	283	353	851	1089	1062
1.2500	353	452	617	1231	1576	1532
1.5000	491	628	905	1483	1898	1852
2.0000	860	1101	1787	2430	3110	3038
2.5000	1058	1354	2250			
3.0000	1654	2117	3600			
4.0000	3173	4061	7830			

(Table 3)

**Max. ratings are based upon the use of Load Correction Factor ($f_{\max}$) in Table 2

Note: Load ratings are based upon a nominal travel life of 2,000,000 inches, operating on a shaft with a hardness range of $R_c 58-64$.

General Technical Data & Mounting Instructions

Calculating Travel Life

In determining travel life of a Linear Bushing, there are several factors to be considered. These factors are the load rating of linear bushing, resultant forces acting on the linear bushing, shaft hardness, and operating temperature.

The values for dynamic load capacities (C) have been calculated based on a nominal travel life of 2,000,000 inches.

The formula for calculating travel life is as follows:

$$L = \frac{[C \cdot f_H \cdot f_t]^3 \cdot 2 \cdot 10^6}{P}$$

$$L_h = \frac{2 \cdot s \cdot n \cdot 60}{L}$$

L = nominal travel life (inches)

C = basic dynamic load rating (lbs)

P = resultant of external forces (lbs)

f_H = shaft hardness factor

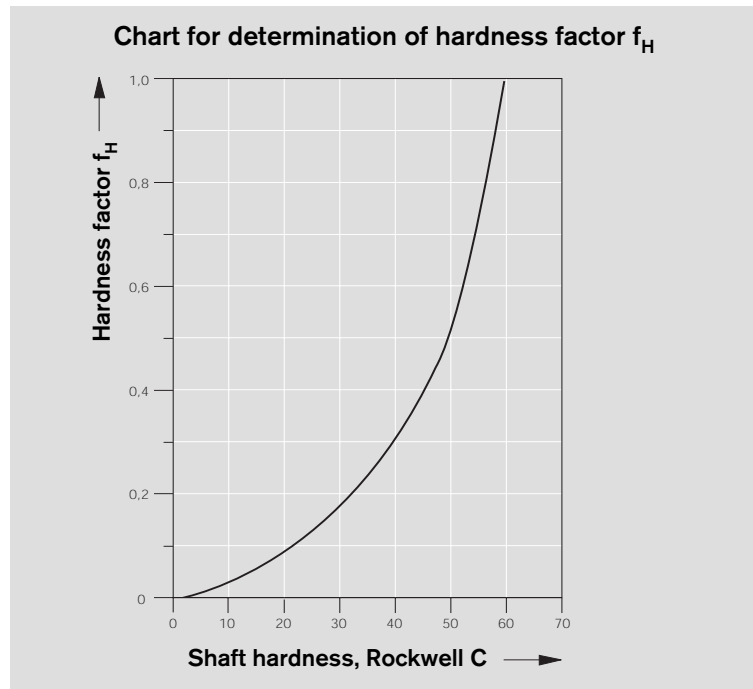
f_t = temperature factor

L_h = nominal rated life (hrs)

s = stroke length (inches)

n = stroke repetition rate (full cycle) (min^{-1})

Shaft Hardness Factor - f_H



Bushing temperature, °F	212	255	300	345	395
Temperature factor, f_t	1	0.95	0.90	0.84	0.73

(Table 4)

Calculating Load Capacity

The formula for calculating load capacity is as follows:

$$C = \frac{P}{f_H \cdot f_t \cdot f_L}$$

C = dynamic load capacity (lbs)

P = resultant of external forces (lbs)

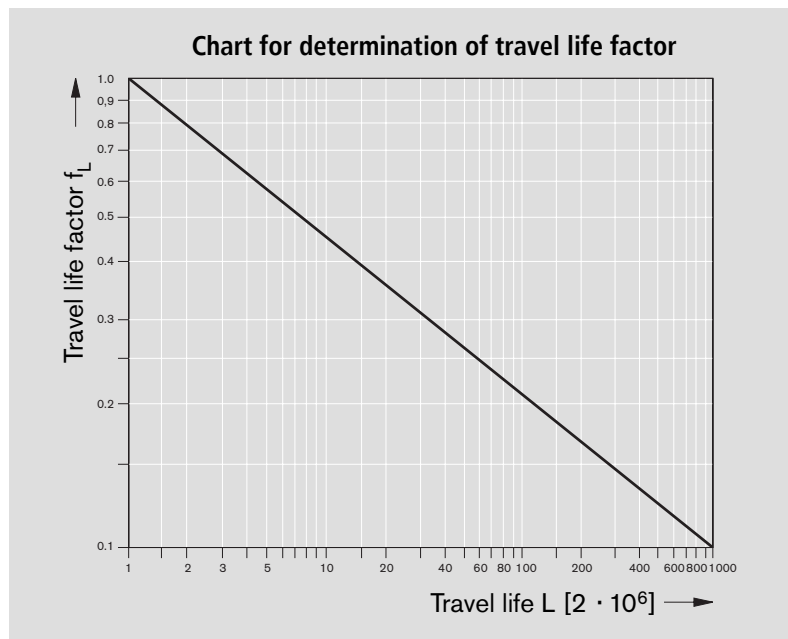
f_H = shaft hardness factor

f_t = temperature factor

f_L = travel life factor

Travel Life Factor - f_L

Chart for determination of travel life factor - f_L



Friction Evaluation - F

Frictional Resistance is expressed:

Calculating frictional resistance requires values for load and seal resistance.

$$F = \mu \cdot P + f^*$$

F = frictional resistance (lbs)

μ = coefficient of friction (Table 5)

P = load (lbs)

f^* = seal resistance (lbs)

*(range .4 to 1.1 lbs)

Coefficient of Friction - μ

Transition from low to high speeds in the Bosch Rexroth Assemblies is smooth due to the extremely low friction coefficients.

Bushing Type	**Coefficient of friction (μ)
Standard R0750 to R0753	0.002 to 0.004
Super R0755 to R0756	0.002 to 0.003

(Table 5)

** Based upon normal loading factors and proper lubrication

General Technical Data & Mounting Instructions

Maximum Velocity

Type	Vmax (ft/s)
Standard and Super Bushing, diameters 1/4" - 4"	5

(Table 6)

Lubrication

Rexroth Linear Bushings are supplied with an anti-corrosion agent that provides corrosion-resistant protection for their steel components. Bushings and linear sets *must* be lubricated prior to use. It is recommended that either grease or oil be used as the primary lubricant.

In most cases, the use of grease as a lubricant is preferable because it is more viscous than oil. Therefore, the grease will help to seal off the Linear Bushing and adhere to its surfaces better than oil. Longer relube intervals will result.

For Lubrication*: Use either a petroleum or ester base lubricant, or turbine oil conforming to ISO Standards G32 to G68 or lithium based grease grade NLGI 2.

Examples of factors affecting lubrication intervals:

- Load
- Velocity
- Motion sequence
- Temperature

Where short relube intervals may be necessary:

- High loads
- High velocity (up to Vmax)
- Short stroke (stroke is shorter than length of linear bushing)
- Low resistance to aging in the lubricant

Normal re-lubrication service intervals are recommended to be performed every 500,000 inches of travel or as needed.

**Note: For best results, observe the lubricant manufacturer's instruction for use.*

Installation and Mounting

Proper housing bore dimension, shaft diameter, and shaft alignment are critical for accuracy and extended service life of a Linear Bushing assembly.

Rexroth recommends a slight pressfit on both the Standard and Super Linear Bushing series. This can vary depending upon assembly configuration.

Mounting Examples

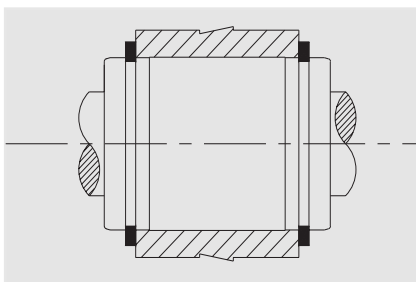


Figure 1
Retention by external retaining rings.

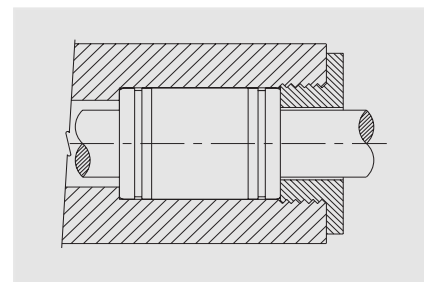


Figure 2
Retention by housing shoulder and threaded cap.

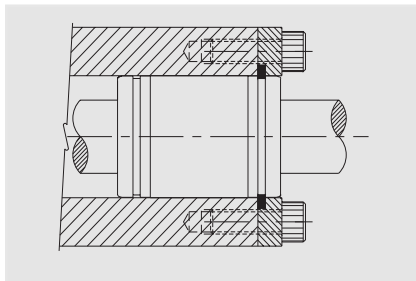


Figure 3
Retention by cover plate and external snap ring.

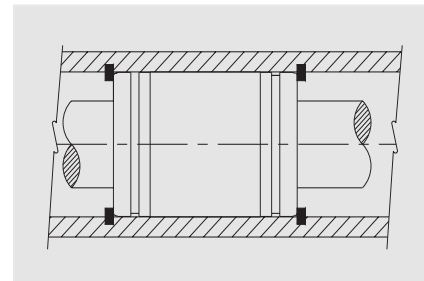


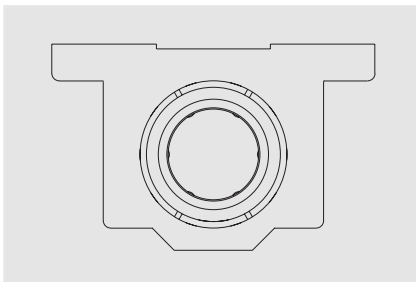
Figure 4
Retention by internal retaining rings.

Pillow Blocks

For simple bushing installation use Rexroth Aluminum or Cast Iron Pillow Blocks.

Available in closed, adjustable, open, single, twin, or flange styles.

(See the section for Pillow Block Sets starting on Page 30.)



Note: Linear Bushings should be handled with care during installation into the housing bore. A slight chamfer is preferred on the leading edge of the housing bore to prevent damage to the Linear Bushing during installation.

Technical Data, Design Notes, Mounting Instructions

Assembly Considerations

Assembly during installation, as this could cause early failure of the bushing. In order for components to operate properly, ensure that the mounting surface, bore tolerance and the proper shaft diameter are accurate prior to installation.

Housing Bore Considerations

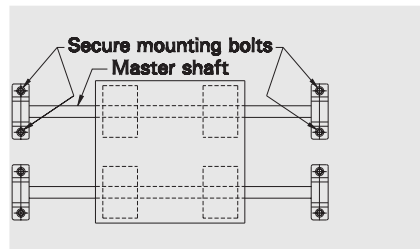
Clearance between the bushing bore and shaft is controlled by the housing bore tolerance and shaft diameter tolerance. These should be matched for a close tolerance fit.

Be careful of an interference fit between the outside diameter of the Linear Bushing and the bore diameter of the housing. An interference between the Linear Bushing and housing bore may cause a reduction in life for both the bushing and shaft, and may also effect the performance.

Shaft Alignment

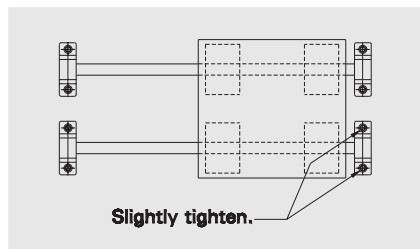
Parallelism on shaft alignment is critical for accuracy and to prevent binding of the assembly during operation. Bosch Rexroth recommends that parallelism not exceed .001" between shafts along the length of the assembly.

Example of Shaft Alignment



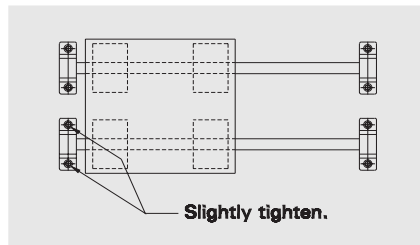
Step 1

Align the Master Shaft to reference points that are parallel to the centerline then secure mounting bolts.



Step 2

Once the Master Shaft is in place, mount a second shaft in place positioned off the same reference points. (Slightly tighten.)



Step 3

As the assembly is moved one end to the other, the mounting bolts should be secured. Then the mounting bolts may be tightened down for the final operation.

Note: Self-aligning bushings will not compensate for shaft out-of-parallelism specifications.

Shafts and Housings

Shaft Considerations

To ensure the optimal performance of Rexroth Linear Bushings, precision shafts and housings are essential.

Appropriate clearance between the Rexroth Bushings and shaft is necessary for reliable performance. Inadequate radial clearance could cause premature failure as well as rough travel.

Dimensional tolerance, hardness and surface finish of the shaft greatly affect the operational performance of Linear Bushings.

The shaft must meet these specifications:

- Correct O.D. tolerance of the nominal shaft size on table 60, page 52.
- Hardness of HRC 60-64. Hardness of less than HRC 60 will dramatically reduce life and permissible load. Hardness over HRC 64 will accelerate ball wear.
- Depth must be a minimum of .04 inches.
- Surface finish of 14 RA microinches (R_a 0.35) or less.

Recommended Tolerance for Housing Bore

Proper selection and sizing of a housing bore will ensure consistent bushing performance. Rexroth Bushing housing bore recommendations offer slip-fit with the bushing O.D. for improved service life.

See 'Recommended Housing Bore' section in the Dimensions and Specifications pages for Linear Inch Bushings. ISO recommendations are indicated on Table 7, page 14.

Technical Data, Design Notes, Mounting Instructions

Metric Tolerances for inside dimensions

Tolerances in μm = 0.001 mm

Rated dimensions (mm)	ISO Tolerances for inside dimensions														
	G7	H5	H6	H7	H8	H11	H12	H13	JS6	JS7	JS14	K6	K7	M6	P9
between 3 and 6	+16 +4	+5 0	+8 0	+12 0	+18 0	+75 0	+120 0	+180 0	+4 -4	+6 -6	+150 -150	+2 -6	+3 -9	-1 -9	-12 -42
between 6 and 10	+20 +5	+6 0	+9 0	+15 0	+22 0	+90 0	+150 0	+220 0	+4.5 -4.5	+7.5 -7.5	+180 -180	+2 -7	+5 -10	-3 -12	-15 -51
between 10 and 18	+24 +6	+8 0	+11 0	+18 0	+27 0	+110 0	+180 0	+270 0	+5.5 -5.5	+9 -9	+215 -215	+2 -9	+6 -12	-4 -15	-18 -61
between 18 and 30	+28 +7	+9 0	+13 0	+21 0	+33 0	+130 0	+210 0	+330 0	+6.5 -6.5	+10.5 -10.5	+260 -260	+2 -11	+6 -15	-4 -17	-22 -74
between 30 and 50	+34 +9	+11 0	+16 0	+25 0	+39 0	+160 0	+250 0	+390 0	+8 -8	+12.5 -12.5	+310 -310	+3 -13	+7 -18	-4 -20	-26 -88
between 50 and 80	+40 +10	+13 0	+19 0	+30 0	+46 0	+190 0	+300 0	+460 0	+9.5 -9.5	+15 -15	+370 -370	+4 -15	+9 -21	-5 -24	-32 -106
between 80 and 120	+47 +12	+15 0	+22 0	+35 0	+54 0	+220 0	+350 0	+540 0	+11 -11	+17.5 -17.5	+435 -435	+4 -18	+10 -25	-6 -28	-37 -124
between 120 and 180	+54 +14	+18 0	+25 0	+40 0	+63 0	+250 0	+400 0	+630 0	+12.5 -12.5	+20 -20	+500 -500	+4 -21	+12 -28	-8 -33	-43 -143
between 180 and 250	+61 +15	+20 0	+29 0	+46 0	+72 0	+290 0	+460 0	+720 0	+14.5 -14.5	+23 -23	+575 -575	+5 -24	+13 -33	-8 -37	-50 -165

(Table 7)

Conversion from millimeters to inches

	Millimeters	μm	Inches
1 millimeter	1	1000	0.0393701
1 μm	0.001	1	3.93701×10^{-5}
1 inch	25.4	25400	1

(Table 8)

Example of conversion from μm to inches:

What are the tolerances (in inches) for a bore of 3.5 inch diameter?

Bore diameter 3.5 inch = $3.5 \cdot 25.4 \text{ mm} = 88.9 \text{ mm}$

For a bore diameter of 88.9 mm and a tolerance range of H7, the upper tolerance limit is +35 μm and the lower tolerance limit 0 μm

Max. size = +35 $\mu\text{m} = +35 \cdot 3.93701 \times 10^{-5} \text{ inch} = 1.3779 \times 10^{-3} \text{ inch}$

Min. size = 0 μm (0 inch)

Metric Tolerances for Outside Dimensions

Tolerances in $\mu\text{m} = 0.001 \text{ mm}$

Rated dimensions (mm)	ISO Tolerances for outside dimensions														
	g7	h5	h6	h7	h8	h11	h12	h13	js6	js7	js14	k6	k7	m6	p9
between 3 and 6	-4 -16	0 -5	0 -8	0 -12	0 -18	0 -75	0 -120	0 -180	+4 -4	+6 -6	+150 -150	+9 +1	+13 +1	+12 +4	+42 +12
between 6 and 10	-5 -20	0 -6	0 -9	0 -15	0 -22	0 -90	0 -150	0 -220	+4.5 -4.5	+7.5 -7.5	+180 -180	+10 +1	+16 +1	+15 +6	+51 +15
between 10 and 18	-6 -24	0 -8	0 -11	0 -18	0 -27	0 -110	0 -180	0 -270	+5.5 -5.5	+9 -9	+215 -215	+12 +1	+19 +1	+18 +7	+61 +18
between 18 and 30	-7 -28	0 -9	0 -13	0 -21	0 -33	0 -130	0 -210	0 -330	+6.5 -6.5	+10.5 -10.5	+260 -260	+15 +2	+23 +2	+21 +8	-
between 30 and 50	-9 -34	0 -11	0 -16	0 -25	0 -39	0 -160	0 -250	0 -390	+8 -8	+12.5 -12.5	+310 -310	+18 +2	+27 +2	+25 +9	-
between 50 and 80	-10 -40	0 -13	0 -19	0 -30	0 -46	0 -190	0 -300	0 -460	+9.5 -9.5	+15 -15	+370 -370	+21 +2	+32 +2	+30 +11	-
between 80 and 120	-12 -47	0 -15	0 -22	0 -35	0 -54	0 -220	0 -350	0 -540	+11 -11	+17.5 -17.5	+435 -435	+25 +3	+38 +3	+35 +13	-
between 120 and 180	-14 -54	0 -18	0 -25	0 -40	0 -63	0 -250	0 -400	0 -630	+12.5 -12.5	+20 -20	+500 -500	+28 +3	+43 +3	+40 +15	-
between 180 and 250	-15 -61	0 -20	0 -29	0 -46	0 -72	0 -290	0 -460	0 -720	+14.5 -14.5	+23 -23	+575 -575	+33 +4	+50 +4	+46 +17	-

(Table 9)

Rexroth Linear Bushings

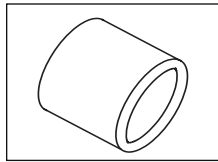
Linear Bushings Overview

Page

Standard Series

Closed Type

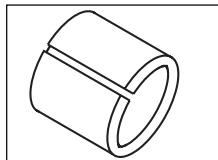
Standard bushing with precision fixed bore.



18

Adjustable Type

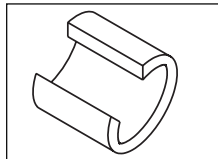
For use when zero clearance or pre-load is required.



20

Open Type

For use with assemblies where the shaft is fully supported.

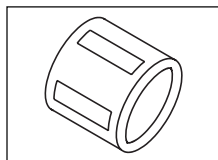


22

Super Series

Closed Type

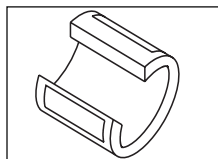
Self-aligning bushing with high load capacity and adjustable working bore.



26

Open Type

For use with the assemblies where the shaft is fully supported.



28

Standard Linear Bushings

The Rexroth Standard Linear Bushing consists of:

- A hardened and ground outer sleeve
- Low noise resin ball retainer
- Balls made of quality anti-friction bearing steel
- Available integral seal design
- Also available with outer sleeve and balls made of corrosion-resistant anti-friction bearing steel



Types

- Closed



- Adjustable



- Open



Advantages

- Low friction
- High running speeds
- Sturdy, solid steel construction suited to industrial workshop environments
- Insensitive to dirt, an important feature for industrial environments

Temperature Ratings

- Continuous: -4°F to 180°F

Rexroth Standard Linear Bushings

Standard Linear Bushings, 0750-

Closed type - for use on an unsupported shaft

Structural design

- Hardened and ground outer sleeve
- Low noise, lightweight resin ball retainer
- Balls made of high quality anti-friction bearing steel
- With or without integral seals



Ordering Data

Nominal Shaft Diameter (in.)	Part Numbers		Mass (lb)	Corresponding External Retaining Ring ⁽¹⁾	
	without seals	with two seals		New Part Number	Old Part Number
0.2500	R0750 004 00	R0750 204 00	0.02	R987 145 915	XR-4A
0.3750	R0750 006 00	R0750 206 00	0.03	R987 145 916	XR-6A
0.5000	R0750 008 00	R0750 208 00	0.09	R987 145 917	XR-8A
0.6250	R0750 010 00	R0750 210 00	0.19	R987 145 918	XR-10A
0.7500	R0750 012 00	R0750 212 00	0.23	R987 145 910	XR-12A
1.0000	R0750 016 00	R0750 216 00	0.44	R987 145 911	XR-16A
1.2500	R0750 020 00	R0750 220 00	0.98	R987 145 919	XR-20A
1.5000	R0750 024 00	R0750 224 00	1.48	R987 145 912	XR-24A
2.0000	R0750 032 00	R0750 232 00	2.52	R987 145 913	XR-32A
2.5000	*R0750 040 15	*R0750 240 15	5.73	call factory	XR-40**
3.0000	*R0750 048 15	*R0750 248 15	9.66	call factory	XR-48**
4.0000	*R0750 064 15	*R0750 264 15	22.49	call factory	XR-64**

(Table 10)

Consult factory for details and availability:

Single seal versions R0750 1...-

Corrosion resistant series R0750 .. 53

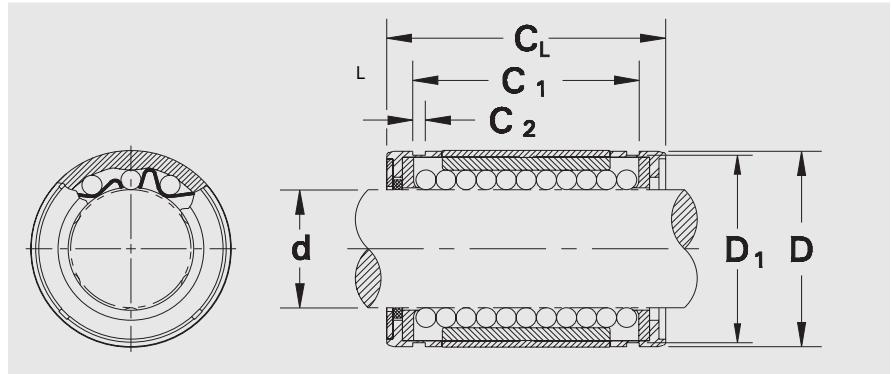
(0753 not available for 2.5", 3.0" and 4.0")

* Sizes available in steel ball cage only

**Commercial series XR-rings with end lugs

(1) See page 66 for retaining ring dimensions

Dimensions and Specifications



(Figure 3)

Dimensions (inches)

Bore d	D ₍₁₎	C _{L(2)}	C ₁	C ₂	D ₁
.2500/.2496	0.5000	0.7500	0.5110	0.0390	0.4687
.3750/.3746	0.6250	0.8750	0.6358	0.0390	0.5880
.5000/.4996	0.8750	1.2500	0.9625	0.0459	0.8209
.6250/.6246	1.1250	1.5000	1.1039	0.0559	1.0590
.7500/.7496	1.2500	1.6250	1.1657	0.0559	1.1760
1.0000/.9996	1.5625	2.2500	1.7547	0.0679	1.4687
1.2500/1.2495	2.0000	2.6250	2.0047	0.0679	1.8859
1.5000/1.4995	2.3750	3.0000	2.4118	0.0859	2.2389
2.0000/1.9995	3.0000	4.0000	3.1917	0.1029	2.8379
2.5000/2.4994	3.7500	5.0000	3.9760	0.1200	3.5519
3.0000/2.9994	4.5000	6.0000	4.7260	0.1200	4.3100
4.0000/3.9992	6.0000	8.0000	6.2580	0.1389	5.7450

(Table 11)

Specifications

Nominal Shaft Diameter (in.)	Recommended Housing Bore ⁽³⁾	Load Capacity ⁽⁴⁾		No. of Ball Circuits
		dyn. C (lbf)	stat. C _o (lbf)	
0.2500	0.5000 / 0.5004	46	60	3
0.3750	0.6250 / 0.6254	51	71	4
0.5000	0.8750 / 0.8755	115	176	4
0.6250	1.1250 / 1.1255	174	266	4
0.7500	1.2500 / 1.2506	194	308	5
1.0000	1.5625 / 1.5631	221	353	6
1.2500	2.0000 / 2.0007	353	617	6
1.5000	2.3750 / 2.3757	491	905	6
2.0000	3.0000 / 3.0007	860	1787	6
2.5000	3.7500 / 3.7509	1058	2250	6
3.0000	4.5000 / 4.5009	1654	3600	6
4.0000	6.0000 / 6.0010	3173	7830	6

(Table 12)

Notes:

(1) Outer diameter tolerance see ISO table, page 15.

(2) Length tolerance -
Bore size -

Ø 0.2500- 0.7500 + 0/ -0.008"
Ø 1.0000 - 2.5000 + 0/ -0.012"
Ø 3.0000 - 4.0000 + 0/ -0.016"

(3) Transition fit

(4) See table 2 on page 7 for load correction factors

Rexroth Standard Adjustable Linear Bushing

Standard linear Bushings, 0752-

Adjustable type - for use on unsupported shaft

Structural design

- Adjustable radial clearance
- Hardened and ground outer sleeve
- Low noise, lightweight resin ball retainer*
- Balls made of high quality anti-friction bearing steel
- With or without integral seals



Ordering Data

Nominal Shaft Diameter (inches)	Part Numbers		Mass (lb)	Corresponding External Retaining Ring ⁽¹⁾	
	without seals	with two seals		New Part Number	Old Part Number
0.5000	R0752 008 00	R0752 208 00	0.09	R987 145 917	XR-8A
0.6250	R0752 010 00	R0752 210 00	0.18	R987 145 918	XR-10A
0.7500	R0752 012 00	R0752 212 00	0.22	R987 145 910	XR-12A
1.0000	R0752 016 00	R0752 216 00	0.45	R987 145 911	XR-16A
1.2500	R0752 020 00	R0752 220 00	0.96	R987 145 919	XR-20A
1.5000	R0752 024 00	R0752 224 00	1.47	R987 145 912	XR-24A
2.0000	R0752 032 00	R0752 232 00	2.48	R987 145 913	XR-32A
2.5000	*R0752 040 15	*R0752 240 15	5.64	call factory	XR-40**
3.0000	*R0752 048 15	*R0752 248 15	9.59	call factory	XR-48**
4.0000	*R0752 064 15	*R0752 264 15	22.38	call factory	XR-64**

(Table 13)

Consult factory for details and availability:

Single seal versions R0752 1.. ..

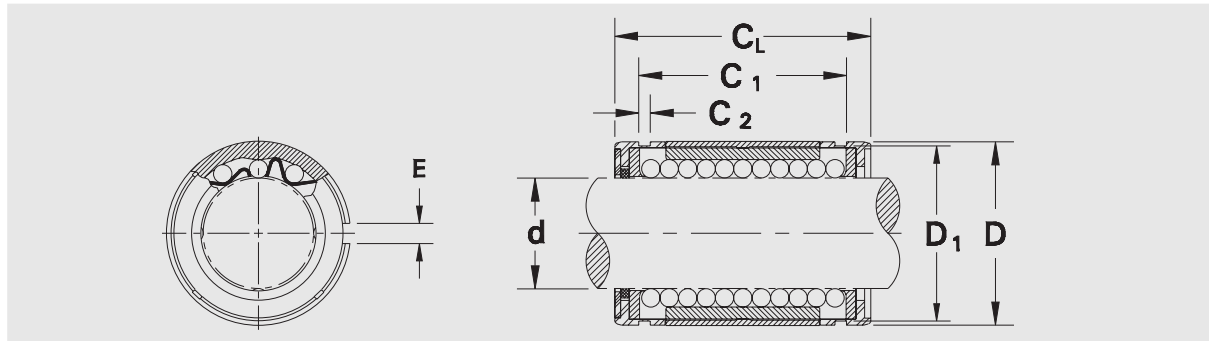
Corrosion resistant series R0752 .. 53

* Sizes available with steel ball cage only

**Commercial series XR-rings with end lugs

(1) See page 66 for retaining ring dimensions

Dimensions and Specifications



(Figure 4)

Dimensions (inches)

Bore d	D ₍₁₎	C _{L(2)}	C ₁	C ₂	D ₁	E
.5000/.4996	0.8750	1.2500	0.9625	0.0459	0.8209	0.06
.6250/.6246	1.1250	1.5000	1.1039	0.0559	1.0590	0.06
.7500/.7496	1.2500	1.6250	1.1657	0.0559	1.1760	0.06
1.0000/.9996	1.5625	2.2500	1.7547	0.0679	1.4687	0.06
1.2500/1.2495	2.0000	2.6250	2.0047	0.0679	1.8859	0.10
1.5000/1.4995	2.3750	3.0000	2.4118	0.0859	2.2389	0.12
2.0000/1.9995	3.0000	4.0000	3.1917	0.1029	2.8379	0.12
2.5000/2.4994	3.7500	5.0000	3.9760	0.1200	3.5519	0.12
3.0000/2.9994	4.5000	6.0000	4.7260	0.1200	4.3100	0.12
4.0000/3.9992	6.0000	8.0000	6.2580	0.1389	5.7450	0.12

(Table 14)

Specifications

Nominal Shaft Diameter	Recommended Housing Bore ⁽³⁾	Load Capacity ⁽⁴⁾		No. of Ball Circuits
		dyn. C (lbf)	stat. C ₀ (lbf)	
0.5000	0.8750 / 0.8755	115	176	4
0.6250	1.1250 / 1.1255	174	266	4
0.7500	1.2500 / 1.2506	194	308	5
1.0000	1.5625 / 1.5631	221	353	6
1.2500	2.0000 / 2.0007	353	617	6
1.5000	2.3750 / 2.3757	491	905	6
2.0000	3.0000 / 3.0007	860	1787	6
2.5000	3.7500 / 3.7509	1058	2250	6
3.0000	4.5000 / 4.5009	1654	3600	6
4.0000	6.0000 / 6.0010	3173	7830	6

(Table 15)

Notes:

(1) Outer diameter tolerance see ISO table, page 15

(2) Length tolerance -
Bore size -

Ø 0.2500- 0.7500 + 0/ -0.008"
Ø 1.0000 - 2.5000 + 0/ -0.012"
Ø 3.0000 - 4.0000 + 0/ -0.016"

(3) Transition fit

(4) See table 2 -page 7 for load
correction factors

Rexroth Standard Open Linear Bushings

Standard Linear Bushing, 0753-

Open type - for use on a supported shaft

Structural design

- Hardened and ground outer sleeve
- Low noise, lightweight resin ball retainer*
- Balls made of high quality anti-friction bearing steel
- With or without integral seals



Ordering Data

Nominal Shaft Diameter	Part Numbers		Mass (lb)	Corresponding External Retaining Ring ⁽¹⁾	
	without seals	with two seals		New Part Number	Old Part Number
0.5000	R0753 008 00	R0753 208 00	0.07	R987 145 917	XR-8A
0.6250	R0753 010 00	R0753 210 00	0.14	R987 145 918	XR-10A
0.7500	R0753 012 00	R0753 212 00	0.19	R987 145 910	XR-12A
1.0000	R0753 016 00	R0753 216 00	0.42	R987 145 911	XR-16A
1.2500	R0753 020 00	R0753 220 00	0.86	R987 145 919	XR-20A
1.5000	R0753 024 00	R0753 224 00	1.34	R987 145 912	XR-24A
2.0000	R0753 032 00	R0753 232 00	2.47	R987 145 913	XR-32A
2.5000	* R0753 040 15	* R0753 240 15	4.92	n/a	
3.0000	* R0753 048 15	* R0753 248 15	8.27	n/a	
4.0000	* R0753 064 15	* R0753 264 15	19.27	n/a	

(Table 16)

Consult factory for details and availability:

Single seal versions R0750 1.. ..

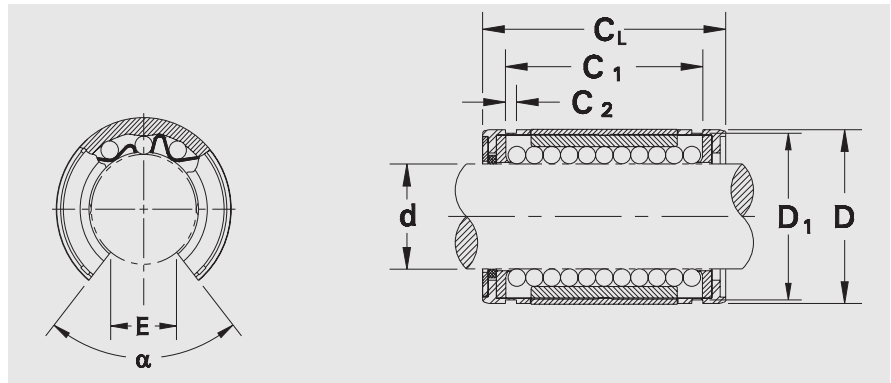
Corrosion resistant series R0750 .. 53
(0753 not available for 2.5", 3.0" and 4.0")

* Sizes available in steel ball cage only

**Commercial series XR-rings with end lugs

(1) See page 66 for retaining ring dimensions

Dimensions and Specifications



(Figure 5)

Dimensions (inches)

Bore d	D ₍₁₎	C _{L(2)}	C ₁	C ₂	D ₁	E	α
.5000/.4996	0.8750	1.2500	0.9625	0.0459	0.8209	0.340	80°
.6250/.6246	1.1250	1.5000	1.1039	0.0559	1.0590	0.375	80°
.7500/.7496	1.2500	1.6250	1.1657	0.0559	1.1760	0.438	60°
1.0000/.9996	1.5625	2.2500	1.7547	0.0679	1.4687	0.563	50°
1.2500/1.2495	2.0000	2.6250	2.0047	0.0679	1.8859	0.625	50°
1.5000/1.4995	2.3750	3.0000	2.4118	0.0859	2.2389	0.750	50°
2.0000/1.9995	3.0000	4.0000	3.1917	0.1029	2.8379	1.000	50°
2.5000/2.4994	3.7500	5.0000	3.9760	0.1200	3.5519	1.250	50°
3.0000/2.9994	4.5000	6.0000	4.7260	0.1200	4.3100	1.500	50°
4.0000/3.9992	6.0000	8.0000	6.2580	0.1389	5.7450	2.000	50°

(Table 17)

Specifications

Nominal Shaft Diameter (in.)	Recommended Housing Bore ₍₃₎	Load Capacity _{(4), (5)}		No. of Ball Circuits
		dyn. C (lbf)	stat. C ₀ (lbf)	
0.5000	0.8750 / 0.8755	115	176	3
0.6250	1.1250 / 1.1255	174	266	3
0.7500	1.2500 / 1.2506	194	308	4
1.0000	1.5625 / 1.5631	221	353	5
1.2500	2.0000 / 2.0007	353	617	5
1.5000	2.3750 / 2.3757	491	905	5
2.0000	3.0000 / 3.0007	860	1787	5
2.5000	3.7500 / 3.7509	1058	2250	5
3.0000	4.5000 / 4.5009	1654	3600	5
4.0000	6.0000 / 6.0010	3173	7830	5

(Table 18)

Notes:

(1) Outer diameter tolerance see ISO table, page 15.

(2) Length tolerance -
Bore size -

Ø 0.2500- 0.7500 + 0/ -0.008"
 Ø 1.0000 - 2.5000 + 0/ -0.012"
 Ø 3.0000 - 4.0000 + 0/ -0.016"

(3) Transition fit

(4) See table 2 on page 7 for load correction factors

(5) 50% derating required when load is applied through open side.

Super Linear Bushings

Super Linear Bushing

Self-aligning

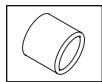
The Super Linear Bushing consists of:

- Ball retainer and outer sleeve made of light weight polyamide
- Hardened steel load plates with ground ball tracks
- Balls made of high quality anti-friction bearing steel
- Adjustable bores (open and closed)
- With or without integral seals

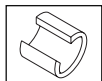


Types

- Closed



- Open



Advantages

- Low friction
- Low noise, lightweight
- Self-aligning to $\pm 0.5^\circ$
- Radial clearance adjustable
- High load capacities

Temperature Ratings

- Continuous: -4°F to 180°F

Self-alignment

Rexroth's Super Linear Bushings compensate for alignment errors of up to one degree without reduction of load capacity.

The steel load plates are designed with the central portion of the plate slightly larger than the ends. This design serves as a fulcrum point to allow for each load plate to compensate for minor errors in alignment between shaft and housing bore caused by inaccurate machining or shaft deflection.

Results

Much smoother operation, higher load capacity and substantially longer travel life than conventional Linear Bushings.

Ground Ball Tracks

Each load plate has a ground surface raceway providing low friction and high load.

Cost-effective Design

With its high load capacity and ability to compensate for inaccurate machine tolerances, the Super Linear Bushing allows for use of smaller components in the application. Shaft, bushing, and housing can be reduced, thereby saving money and design consideration of all the elements.

Load Capacity and Travel Life

The Super Linear Bushing provides up to three times the load capacity and 27 times the travel life of Standard Linear Bushings, due to its special load plate design.

Note: Contact the factory for details on the Rexroth Super Linear Bushing design and rating information

Rexroth Super Linear Bushing

Super Linear Bushing, 0755

Closed type - for use on unsupported shaft

Structural design

- Lightweight resin retainer and outer sleeve
- Hardened and ground steel bearing load plates
- Balls made of high quality anti-friction bearing steel
- With or without integral seals
- Self-aligning to $\pm 0.5^\circ$



Ordering Data

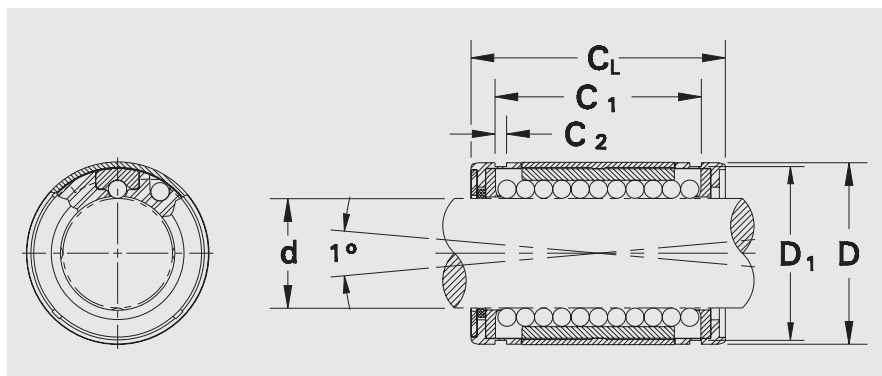
Nominal Shaft Diameter (inches)	Part Numbers		Mass (lb)	Corresponding External Retaining Ring ⁽¹⁾	
	without seals	with two seals		New Part Number	Old Part Number
0.2500	R0755 004 00	R0755 204 00	0.01	R987 145 915	XR-4A
0.3750	R0755 006 00	R0755 206 00	0.01	R987 145 916	XR-6A
0.5000	R0755 008 00	R0755 208 00	0.04	R987 145 917	XR-8A
0.6250	R0755 010 00	R0755 210 00	0.10	R987 145 918	XR-10A
0.7500	R0755 012 00	R0755 212 00	0.12	R987 145 910	XR-12A
1.0000	R0755 016 00	R0755 216 00	0.26	R987 145 911	XR-16A
1.2500	R0755 020 00	R0755 220 00	0.49	R987 145 919	XR-20A
1.5000	R0755 024 00	R0755 224 00	0.75	R987 145 912	XR-24A
2.0000	R0755 032-00	R0755 232 00	1.39	R987 145 913	XR-32A

(Table 16)

Consult factory for details and availability:
Single seal versions R0755 1... ..

(1) See page 66 for retaining ring dimensions

Dimensions and Specifications



(Figure 6)

Dimensions (inches)

Bore d	D	C _{L(1)}	C ₁	C ₂	D ₁
.2500/.2495	0.5000	0.7500	0.5150	0.0390	0.4687
.3750/.3745	0.6250	0.8750	0.7030	0.0390	0.5880
.5000/.4995	0.8750	1.2500	1.0320	0.0459	0.8209
.6250/.6245	1.1250	1.5000	1.1120	0.0559	1.0590
.7500/.7495	1.2500	1.6250	1.2720	0.0559	1.1760
1.0000/.9995	1.5625	2.2500	1.8860	0.0679	1.4687
1.2500/1.2494	2.0000	2.6250	2.0110	0.0679	1.8859
1.5000/1.4994	2.3750	3.0000	2.4220	0.0859	2.2389
2.0000/1.9992	3.0000	4.0000	3.2060	0.1029	2.8379

(Table 20)

Specifications

Nominal Shaft Diameter (in.)	Recommended Housing Bore ⁽²⁾	Load Capacity ⁽³⁾		No. of Ball Circuits
		dyn. C (lbf)	stat. C _o (lbf)	
0.2500	0.5000 / 0.5005	60	80	4
0.3750	0.6250 / 0.6255	95	120	4
0.5000	0.8750 / 0.8755	230	290	4
0.6250	1.1250 / 1.1255	400	502	5
0.7500	1.2500 / 1.2505	470	592	6
1.0000	1.5625 / 1.5630	850	1062	6
1.2500	2.0000 / 2.0008	1230	1532	6
1.5000	2.3750 / 2.3760	1483	1852	6
2.0000	3.0000 / 3.0010	2430	3038	6

(Table 21)

Notes:

(1) Length tolerance -
Bore size -

Ø 0.2500- 0.3750 + 0/ -0.015"
 Ø 0.5000- 1.0000 + 0/ -0.020"
 Ø 1.2500 + 0/ -0.025"
 Ø 1.5000 + 0/ -0.030"
 Ø 2.0000 + 0/ -0.040"

(2) Transition fit

(3) See table 2 on page 7 for load
correction factors

Rexroth Super Linear Bushings

Super Linear Bushing, 0756

Open type - for use on a supported shaft

Structural design

- Lightweight resin retainer and outer sleeve
- Hardened and ground steel bearing load plates
- Balls made of high quality anti-friction bearing steel
- With or without integral seals
- Self-aligning to $\pm 0.5^\circ$



Ordering Data

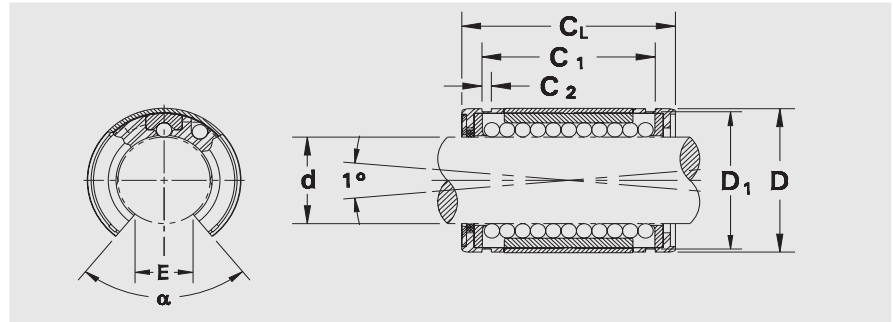
Nominal Shaft Diameter (in.)	Part Numbers		Mass (lb)	Corresponding External Retaining Ring ⁽¹⁾	
	without seals	with two seals		New Part Number	Old Part Number
0.5000	R0756 008 00	R0756 208 00	0.03	R987 145 917	XR-8A
0.6250	R0756 010 00	R0756 210 00	0.08	R987 145 918	XR-10A
0.7500	R0756 012 00	R0756 212 00	0.10	R987 145 910	XR-12A
1.0000	R0756 016 00	R0756 216 00	0.22	R987 145 911	XR-16A
1.2500	R0756 020 00	R0756 220 00	0.40	R987 145 919	XR-20A
1.5000	R0756 024 00	R0756 224 00	0.62	R987 145 912	XR-24A
2.0000	R0756 032 00	R0756 232 00	1.15	R987 145 913	XR-32A

(Table 22)

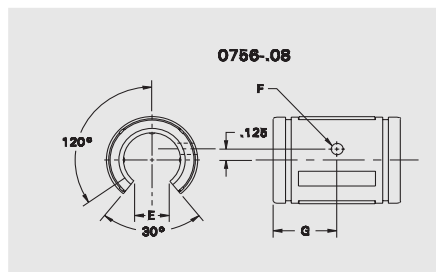
Consult factory for details and availability:
Single seal versions R0756 1... ..

(1) See page 66 for retaining ring dimensions

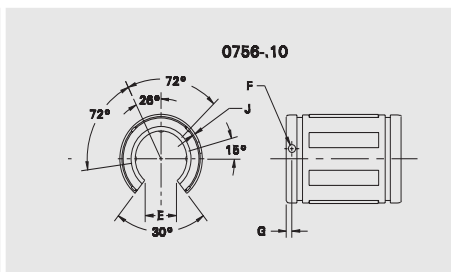
Dimensions and Specifications



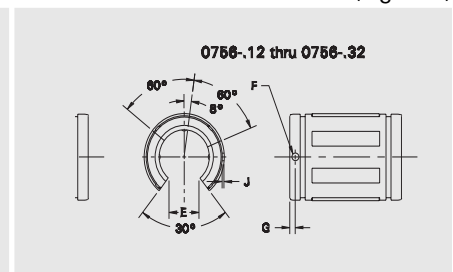
(Figure 7)



(Figure 8)



(Figure 9)



(Figure 10)

Dimensions (inches)

Bore d	D	C _{L(1)}	C ₁	C ₂	D ₁	E	α
.5000/.4995	0.8750	1.2500	1.0320	0.0459	0.8209	0.313	30°
.6250/.6245	1.1250	1.5000	1.1120	0.0559	1.0590	0.375	30°
.7500/.7495	1.2500	1.6250	1.2720	0.0559	1.1760	0.438	30°
1.0000/.9995	1.5625	2.2500	1.8860	0.0679	1.4687	0.563	30°
1.2500/1.2494	2.0000	2.6250	2.0110	0.0679	1.8859	0.625	30°
1.5000/1.4994	2.3750	3.0000	2.4220	0.0859	2.2389	0.750	30°
2.0000/1.9992	3.0000	4.0000	3.2060	0.1029	2.8379	1.000	

(Table 23)

Specifications

Nominal Shaft Diameter (in.)	Recommended Housing Bore (2)	Load Capacity (3), (4)		No. of Ball Circuits
		dyn. C (lbf)	stat. C _o (lbf)	
0.5000	0.8750 / 0.8755	230	290	3
0.6250	1.1250 / 1.1255	400	502	4
0.7500	1.2500 / 1.2505	470	592	5
1.0000	1.5625 / 1.5630	850	1062	5
1.2500	2.0000 / 2.0008	1230	1532	5
1.5000	2.3750 / 2.3760	1483	1852	5
2.0000	3.0000 / 3.0010	2430	3038	5

(Table 24)

Nominal Shaft Diameter (in.)	F Hole Dia.	J Depth
0.5000	0.136	Thru hole
0.6250	0.105	0.0390
0.7500	0.136	0.0590
1.0000	0.136	0.0470
1.2500	0.201	0.0900
1.5000	0.201	0.0900
2.0000	0.265	Thru hole

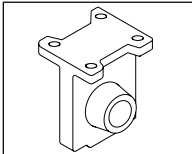
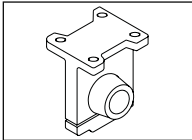
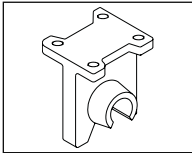
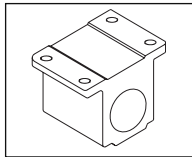
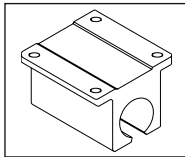
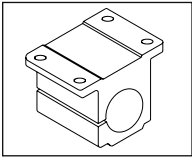
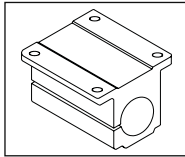
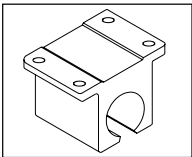
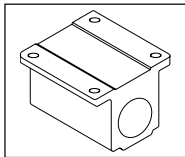
(Table 25)

Note: For notes 1, 2, and 3 refer to page 27

(4) 50 % derating required when load is applied through open side.

Rexroth Linear Pillow Block Sets

Overview

		Page	
Cast Iron Series			
Closed Type Standard type with fixed bore and self-aligning spherical sleeve.		32	
Adjustable Type For use when zero clearance or preload is required.		34	
Open Type For use with long guideways when the shaft is fully supported.		36	
Aluminum Series			
	Single Sets	Twin Sets	
Closed Type Standard type with self-aligning insert used for high load.			44
Adjustable Type For use when zero clearance or pre-load is required.			46
Open Type For use with long guideways when the shaft is fully supported.			48

Advantages/Notes for Mounting

High Load Capacity and Rigidity

Pillow Block Sets provide high rigidity regardless of the direction of load, even when the maximum load carrying capacities are achieved.

Compact Block Design & ease of mounting the Aluminum Series

The Super Linear Bushing is completely enclosed in the compact housing to protect it against all external impacts. Pre-machined blocks provide accurate bore tolerance for smooth operation.

Mounting holes in the four corners provide rigid mounting to carriage assemblies.

Adjustable versions are available to achieve zero clearance assemblies.

Vertical Dimensions

The tables for the Pillow Block Sets contain tolerance values for the height dimension "A". These tolerance values have been obtained by statistical methods and are representative of the values to be expected in actual practice.

Cast Iron Pillow Block Sets

The Cast Iron series consists of three major components:

- 1) A rigid, high quality, one-piece cast iron block
- 2) A precision, machined, spherical sleeve
- 3) A sealed Linear Bushing

Aluminum Pillow Block Sets

All three series, closed, adjustable, and open, are adjusted to proper clearances at the factory. In addition, the integral spherical sleeve provides three degrees self-alignment in all directions.

The Super Pillow Block Sets combine the many benefits of the Super Linear Bushing with the simplicity of a rugged, lightweight mounting assembly.

The Super Pillow Block Set consists of:

- 1) A precision machined aluminum housing with lube ports
- 2) A sealed Super Linear Bushing

Note: Standard Linear Bushings may be used in some of the Aluminum Pillow Block Sets - contact the factory for details.

Rexroth Linear Pillow Block Sets

Cast Iron Pillow Block Set, R1750

Closed type - for use on unsupported shaft

Structural design

- Rigid cast iron block
- Self-aligning sleeve
- Standard Bushing
- Fully sealed both ends



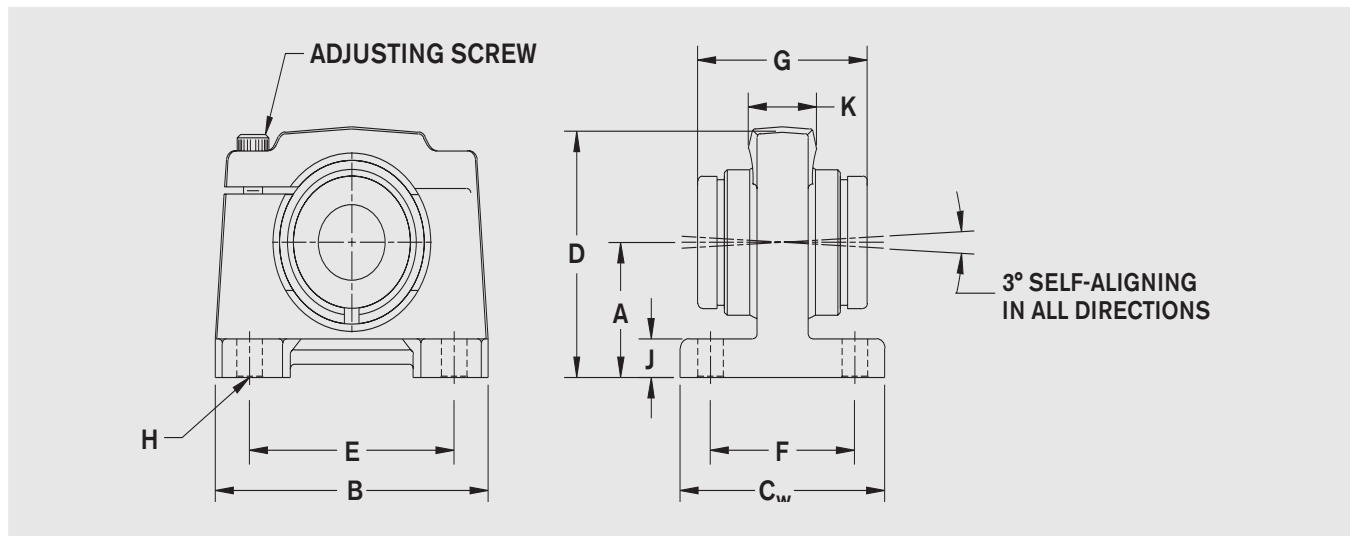
Ordering Data

Nominal Shaft Diameter (in.)	Part Number	Mass (lb)
	with two seals	
0.5000	R1750 208 00	0.50
0.7500	R1750 212 00	1.30
1.0000	R1750 216 00	2.10
1.2500	R1750 220 00	4.40
1.5000	R1750 224 00	5.70
2.0000	R1750 232 00	10.50

(Table 26)

Consult factory for details and availability:
No seal versions R0750 0..
Corrosion-resistant series R1750 .. 53

Dimensions and Specifications



(Figure 11)

Dimensions (inches)

Nominal Shaft Diameter	A ₍₁₎	B	C _w	D	E ₍₂₎	F ₍₃₎	G ₍₄₎	J	K
.5000	0.875	2.000	1.500	1.6250	1.500	1.000	1.250	0.2500	0.5000
.7500	1.125	2.750	2.000	2.1250	2.000	1.375	1.625	0.3125	0.6250
1.0000	1.375	3.250	2.250	2.5625	2.500	1.500	2.250	0.3750	1.0000
1.2500	1.750	4.000	2.750	3.2500	3.000	1.875	2.625	0.4375	1.2500
1.5000	2.000	4.750	3.000	3.7500	3.500	2.000	3.000	0.5000	1.4375
2.0000	2.500	6.000	3.500	4.7500	4.500	2.500	4.000	0.6250	1.6250

(Table 27)

Specifications

Nominal Shaft Diameter (in.)	Load Capacity		No. of Ball Circuits	H Mounting Hole	
	dyn. C (lbf)	stat. C _o (lbf)		Bolt	Hole
0.5000	115	176	4	#8	3/16
0.7500	194	308	5	#10	7/32
1.0000	221	353	6	1/4	9/32
1.2500	353	617	6	5/16	11/32
1.5000	491	905	6	5/16	11/32
2.0000	860	1787	6	3/8	13/32

(Table 28)

Notes:

- (1) Center line tolerance +/- .005"
- (2) Bolt hole location tolerance +/- .010"
- (3) Bolt hole location tolerance +/- .010"
- (4) Bushing insert length tolerance
Reference note 2 - page 19

Rexroth Linear Pillow Block Sets

Cast Iron Pillow Block Set, R1752

Adjustable type - for use on unsupported shaft

Structural design

- Rigid cast iron block
- Self-aligning sleeve
- Standard Bushing
- Fully sealed both ends
- Adjustable bore



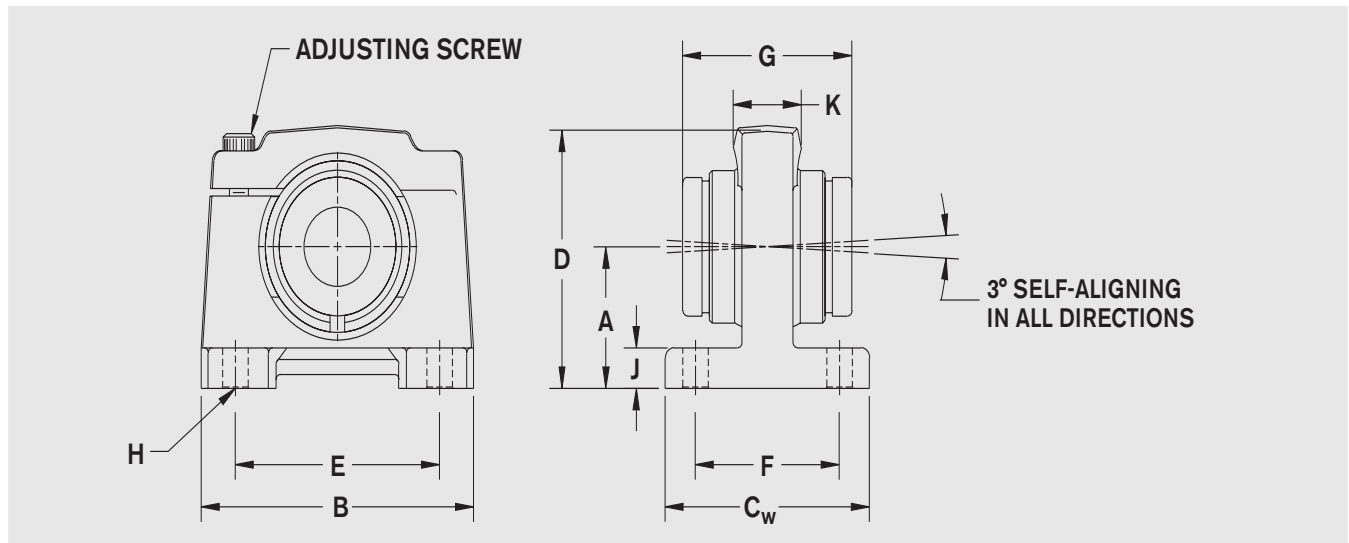
Ordering Data

Nominal Shaft Diameter (in.)	Part Number	Mass (lb)
	with two seals	
0.5000	R1752 208 00	0.50
0.7500	R1752 212 00	1.30
1.0000	R1752 216 00	2.10
1.2500	R1752 220 00	4.40
1.5000	R1752 224 00	5.70
2.0000	R1752 232 00	10.50

(Table 29)

Consult factory for details and availability:
No seal versions R0752 0..
Corrosion-resistant series R1752 .. 53

Dimensions and Specifications



(Figure 12)

Dimensions (inches)

Nominal Shaft Diameter	A ₍₁₎	B	C _w	D	E ₍₂₎	F ₍₃₎	G ₍₄₎	J	K
.5000	0.875	2.000	1.500	1.6250	1.500	1.000	1.250	0.2500	0.5000
.7500	1.125	2.750	2.000	2.1250	2.000	1.375	1.625	0.3125	0.6250
1.0000	1.375	3.250	2.250	2.5625	2.500	1.500	2.250	0.3750	1.0000
1.2500	1.750	4.000	2.750	3.2500	3.000	1.875	2.625	0.4375	1.2500
1.5000	2.000	4.750	3.000	3.7500	3.500	2.000	3.000	0.5000	1.4375
2.0000	2.500	6.000	3.500	4.7500	4.500	2.500	4.000	0.6250	1.6250

(Table 30)

Specifications

Nominal Shaft Diameter (in.)	Load Capacity		No. of circuits	H Mounting Hole	
	dyn. C (lbf)	stat. C _o (lbf)		Bolt	Hole
0.5000	115	176	4	#8	3/16
0.7500	194	308	5	#10	7/32
1.0000	221	353	6	1/4	9/32
1.2500	353	617	6	5/16	11/32
1.5000	491	905	6	5/16	11/32
2.0000	860	1787	6	3/8	13/32

(Table 31)

Notes:

- (1) Center line tolerance +/- .005"
- (2) Bolt hole location tolerance +/- .010"
- (3) Bolt hole location tolerance +/- .010"
- (4) Bushing insert length tolerance
Reference note 2 - page 19

Rexroth Linear Pillow Block Sets

Cast Iron Pillow Block Set, R1753

Open type - for use on supported shaft

Structural design

- Rigid cast iron block
- Self-aligning sleeve
- Standard Bushing
- Fully sealed both ends
- Adjustable open bore



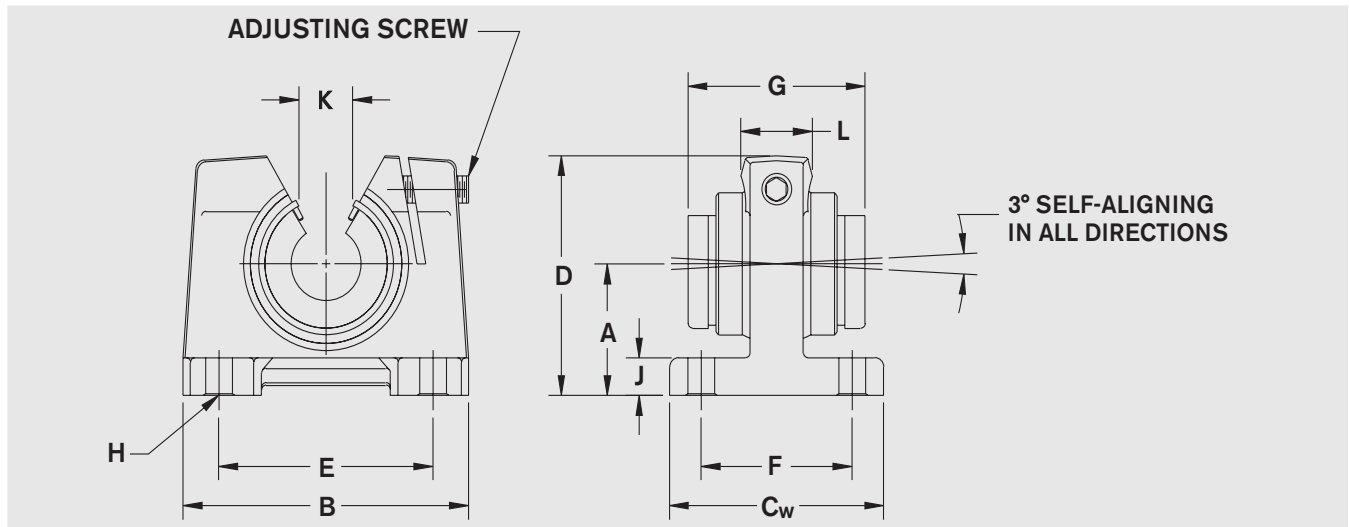
Ordering Data

Nominal Shaft Diameter (in.)	Part Number	Mass (lb)
	with two seals	
0.5000	R1753 208 00	0.50
0.7500	R1753 212 00	1.30
1.0000	R1753 216 00	2.10
1.5000	R1753 224 00	5.70
2.0000	R1753 232 00	10.50

(Table 32)

Consult factory for details and availability:
No seal versions R0753 0..
Corrosion-resistant series R1753 .. 53

Dimensions and Specifications



(Figure 13)

Dimensions (inches)

Nominal Shaft Diameter	A ₍₁₎	B	C _w	D	E ₍₂₎	F ₍₃₎	G ₍₄₎	J	K
.5000	0.875	2.000	1.500	1.5938	1.500	1.000	1.250	0.2500	0.3125
.7500	1.125	2.750	2.000	2.0938	2.000	1.375	1.625	0.3125	0.4375
1.0000	1.375	3.250	2.250	2.5313	2.500	1.500	2.250	0.3750	0.5625
1.2500	1.750	4.000	2.750	3.2188	3.000	1.875	2.625	0.4375	0.6250
1.5000	2.000	4.750	3.000	3.7188	3.500	2.000	3.000	0.5000	0.7500
2.0000	2.500	6.000	3.500	4.6563	4.500	2.500	4.000	0.6250	1.0000

(Table 33)

Specifications

Nominal Shaft Diameter (in.)	Load Capacity ⁽⁵⁾		No. of circuits	H Mounting Hole		L
	dyn. C (lbf)	stat. C _o (lbf)		Bolt	Hole	
0.5000	115	176	3	#8	3/16	15/32
0.7500	194	308	4	#10	7/32	19/32
1.0000	221	353	5	1/4	9/32	15/16
1.2500	353	617	5	5/16	11/32	1 5/32
1.5000	491	905	5	5/16	11/32	1 5/16
2.0000	860	1787	5	3/8	13/32	1 1/2

(Table 34)

Notes:

- (1) Center line tolerance +/- .005"
- (2) Bolt hole location tolerance +/- .010"
- (3) Bolt hole location tolerance +/- .010"
- (4) Bushing insert length tolerance
Reference note 2 - page 19
- (5) 50% derating required when load is applied through open side.

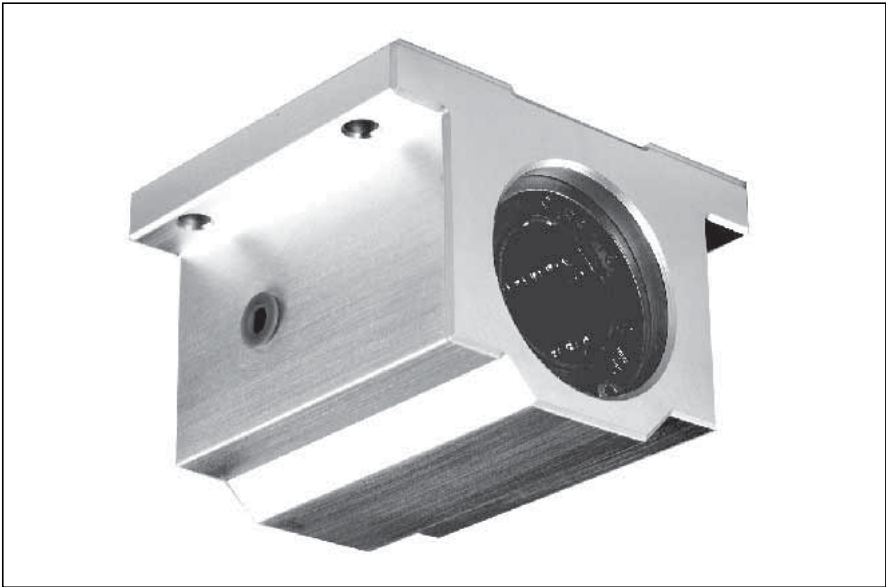
Rexroth Linear Pillow Block Sets

Aluminum Pillow Block Set, R1755

Closed type - for use on unsupported shaft

Structural design

- Precision, lightweight aluminum housing
- Super Linear Bushing
- Self-aligning feature
- Fully sealed both ends
- Access for lubrication



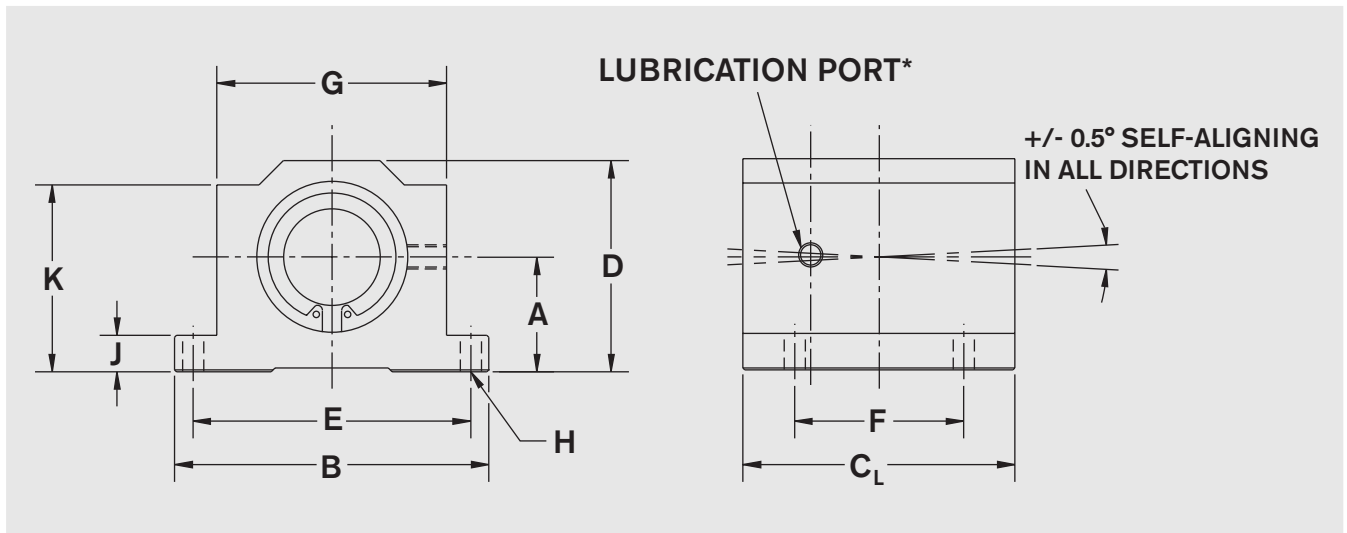
Ordering Data

Nominal Shaft Diameter (in.)	Part Number	Mass (lb)
	with two seals	
0.2500	R1755 704 00	0.09
0.3750	R1755 706 00	0.12
0.5000	R1755 708 00	0.24
0.6250	R1755 710 00	0.47
0.7500	R1755 712 00	0.57
1.0000	R1755 716 00	1.18
1.2500	R1755 720 00	2.40
1.5000	R1755 724 00	3.50
2.0000	R1755 732 00	6.90

(Table 35)

Consult factory for details and availability:
No seal versions R0755 0..

Dimensions and Specifications



(Figure 14)

Dimensions (inches)

Nominal Shaft Diameter	A ⁽¹⁾	B	C _L	D	E ⁽²⁾	F ⁽³⁾	G	J	K
0.2500	0.4370	1.625	1.188	0.813	1.312	0.750	1.000	0.188	0.750
0.3750	0.5000	1.750	1.313	0.938	1.437	0.875	1.125	0.188	0.875
0.5000	0.6870	2.000	1.688	1.250	1.688	1.000	1.375	0.250	1.125
0.6250	0.8750	2.500	1.938	1.625	2.125	1.125	1.750	0.281	1.437
0.7500	0.9370	2.750	2.063	1.750	2.375	1.250	1.875	0.313	1.563
1.0000	1.1870	3.250	2.813	2.188	2.875	1.750	2.375	0.375	1.938
1.2500	1.5000	4.000	3.625	2.813	3.500	2.000	3.000	0.438	2.500
1.5000	1.7500	4.750	4.000	3.250	4.125	2.500	3.500	0.500	2.875
2.0000	2.1250	6.000	5.000	4.063	5.250	3.250	4.500	0.625	3.625

(Table 36)

Specifications

Nominal Shaft Diameter (in.)	Load Capacity		No. of Ball Circuits	H Mounting Hole		L
	dyn. C (lbf)	stat. C _o (lbf)		Bolt	Hole	
0.2500	60	80	4	#6	5/32	0.394
0.3750	95	120	4	#6	5/32	0.433
0.5000	230	290	4	#6	5/32	0.591
0.6250	400	502	5	#8	3/16	0.709
0.7500	470	592	6	#8	3/16	0.717
1.0000	850	1062	6	#10	7/32	0.969
1.2500	1230	1532	6	#10	7/32	1.311
1.5000	1483	1852	6	1/4	9/32	1.378
2.0000	2430	3038	6	3/8	13/32	1.654

(Table 37)

Notes:

- (1) Center line tolerance +/- .0012"
- (2) Bolt hole location tolerance +/- .010"
- (3) Bolt hole location tolerance +/- .010"

* Provided with push-in lube fitting for sizes .2500" to .5000".
 Sizes .6250" to 2" offer a 1/4 - 28 tapped hole with plug.

Rexroth Linear Pillow Block Sets

Aluminum Pillow Block Set, R1756

Adjustable type - for use on unsupported shaft

Structural design

- Precision, lightweight aluminum housing
- Super Linear Bushing
- Self-aligning feature
- Fully sealed both ends
- Adjustable bore
- Access for lubrication



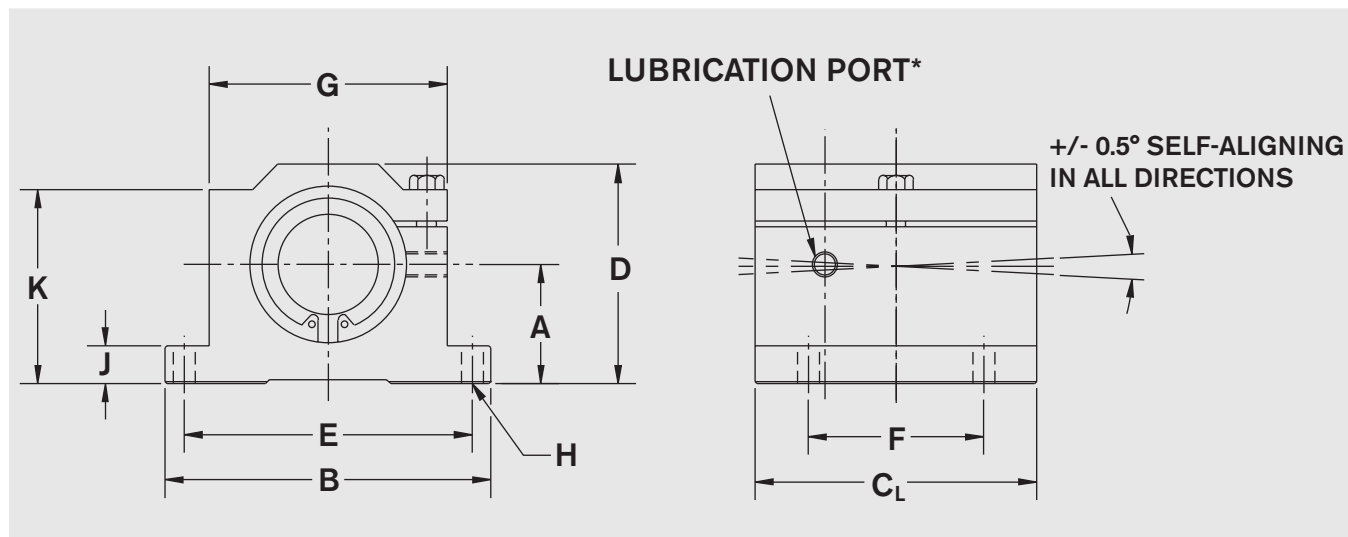
Ordering Data

Nominal Shaft Diameter (in.)	Part Numbers	Mass (lb)
	with two seals	
0.2500	R1756 704 00	0.09
0.3750	R1756 706 00	0.12
0.5000	R1756 708 00	0.24
0.6250	R1756 710 00	0.47
0.7500	R1756 712 00	0.57
1.0000	R1756 716 00	1.18
1.2500	R1756 720 00	2.40
1.5000	R1756 724 00	3.50
2.0000	R1756 732 00	6.90

(Table 38)

Consult factory for details and availability: No seal versions R1756 0..

Dimensions and Specifications



(Figure 15)

Dimensions (inches)

Nominal Shaft Diameter	A ⁽¹⁾	B	C _L	D	E ⁽²⁾	F ⁽³⁾	G	J	K
0.2500	0.4370	1.625	1.188	0.813	1.312	0.750	1.000	0.188	0.750
0.3750	0.5000	1.750	1.313	0.938	1.437	0.875	1.125	0.188	0.875
0.5000	0.6870	2.000	1.688	1.250	1.688	1.000	1.375	0.250	1.125
0.6250	0.8750	2.500	1.938	1.625	2.125	1.125	1.750	0.281	1.437
0.7500	0.9370	2.750	2.063	1.750	2.375	1.250	1.875	0.313	1.563
1.0000	1.1870	3.250	2.813	2.188	2.875	1.750	2.375	0.375	1.938
1.2500	1.5000	4.000	3.625	2.813	3.500	2.000	3.000	0.438	2.500
1.5000	1.7500	4.750	4.000	3.250	4.125	2.500	3.500	0.500	2.875
2.0000	2.1250	6.000	5.000	4.063	5.250	3.250	4.500	0.625	3.625

(Table 39)

Specifications

Nominal Shaft Diameter (in.)	Load Capacity		No. of Ball Circuits	H Mounting Hole		L
	dyn. C (lbf)	stat. C _o (lbf)		Bolt	Hole	
0.2500	60	80	4	#6	5/32	0.394
0.3750	95	120	4	#6	5/32	0.433
0.5000	230	290	4	#6	5/32	0.591
0.6250	400	502	5	#8	3/16	0.709
0.7500	470	592	6	#8	3/16	0.717
1.0000	850	1062	6	#10	7/32	0.969
1.2500	1230	1532	6	#10	7/32	1.311
1.5000	1483	1852	6	1/4	9/32	1.378
2.0000	2430	3038	6	3/8	13/32	1.654

(Table 40)

Notes:

- (1) Center line tolerance +/- .0012"
- (2) Bolt hole location tolerance +/- .010"
- (3) Bolt hole location tolerance +/- .010"

* Provided with push-in lube fitting for sizes .2500" to .5000".
 Sizes .6250" to 2" offer a 1/4 - 28 tapped hole with plug.

Rexroth Linear Pillow Block Sets

Aluminum Pillow Block Set, R1757

Open type - for use on supported shaft

Structural design

- Precision, lightweight aluminum housing
- Super Linear Bushing
- Self-aligning feature
- Fully sealed both ends
- Adjustable open bore
- Access for lubrication



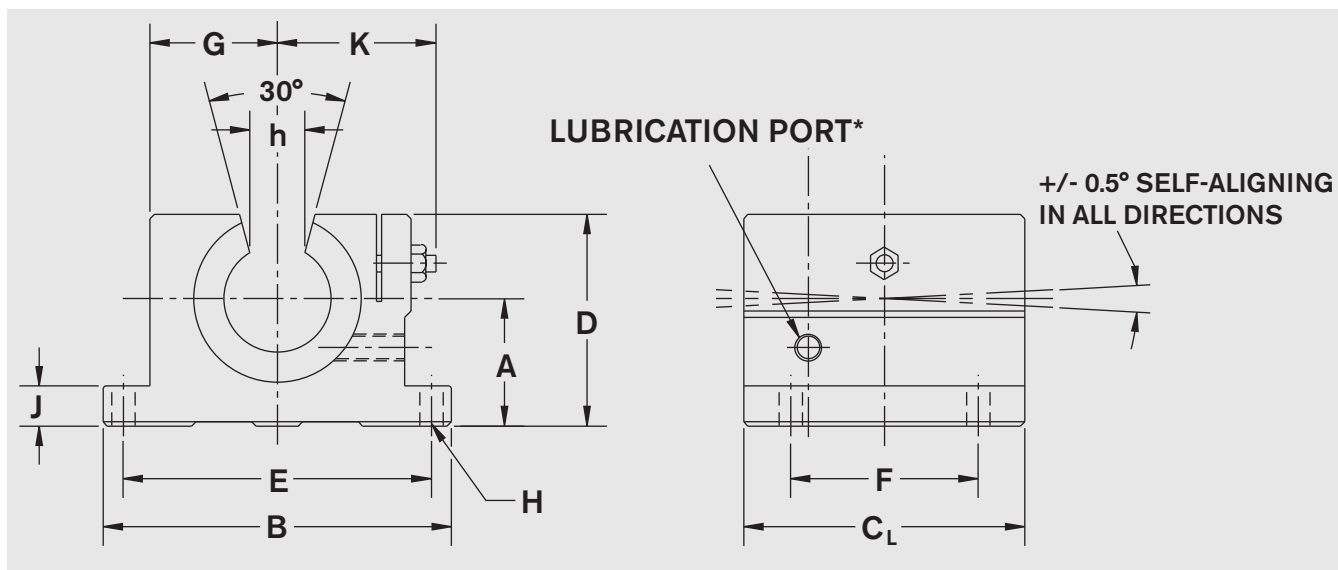
Ordering Data

Nominal Shaft Diameter (in.)	Part Number	Mass (lb)
	with two seals	
0.5000	R1757-708 00	0.19
0.6250	R1757 710 00	0.37
0.7500	R1757 712 00	0.50
1.0000	R1757 716 00	1.07
1.2500	R1757 720 00	2.04
1.5000	R1757 724 00	3.07
2.0000	R1757 732 00	5.92

(Table 41)

Consult factory for details and availability:No seal versions R1757 0..

Dimensions and Specifications



(Figure 16)

Dimensions (inches)

Nominal Shaft Diameter	A ₍₁₎	B	C _L	D	E ₍₂₎	F ₍₃₎	G	J	K	h
0.5000	0.6870	2.000	1.500	1.100	1.688	1.000	0.688	0.250	0.905	0.260
0.6250	0.8750	2.500	1.750	1.405	2.125	1.125	0.875	0.281	1.095	0.319
0.7500	0.9370	2.750	1.875	1.535	2.375	1.250	0.937	0.315	1.161	0.386
1.0000	1.1870	3.250	2.625	1.975	2.875	1.750	1.188	0.375	1.457	0.512
1.2500	1.5000	4.000	3.375	2.485	3.500	2.000	1.500	0.437	1.831	0.569
1.5000	1.7500	4.750	3.750	2.910	4.125	2.500	1.750	0.500	2.087	0.681
2.0000	2.1250	6.000	4.750	3.660	5.250	3.250	2.250	0.625	2.638	0.933

(Table 42)

Specifications

Nominal Shaft Diameter (in.)	Load Capacity		No. of Ball Circuits	H Mounting Hole		L
	dyn. C (lbf)	stat. C _o (lbf)		Bolt	Hole	
0.5000	230	290	3	#6	5/32	0.980
0.6250	400	502	4	#8	3/16	1.070
0.7500	470	592	5	#8	3/16	1.150
1.0000	850	1062	5	#10	7/32	1.750
1.2500	1230	1532	5	#10	7/32	2.180
1.5000	1483	1852	5	1/4	9/32	2.500
2.0000	2430	3038	5	3/8	13/32	3.150

(Table 43)

Notes:

- (1) Center line tolerance $\pm .0012''$
- (2) Bolt hole location tolerance $\pm .010''$
- (3) Bolt hole location tolerance $\pm .010''$

* Provided with push-in lube fitting for size .5000". Sizes .6250" to 2.000" offer a 1/4 - 28 tapped hole with plug.

Rexroth Linear Twin Pillow Block Sets

Aluminum Twin Pillow Block Set, R1760

Closed type - for use on unsupported shaft

Structural design

- Precision, lightweight aluminum housing
- Twin style housing
- Two Super Linear Bushings
- Self-aligning feature
- Fully sealed both ends
- Access for lubrication



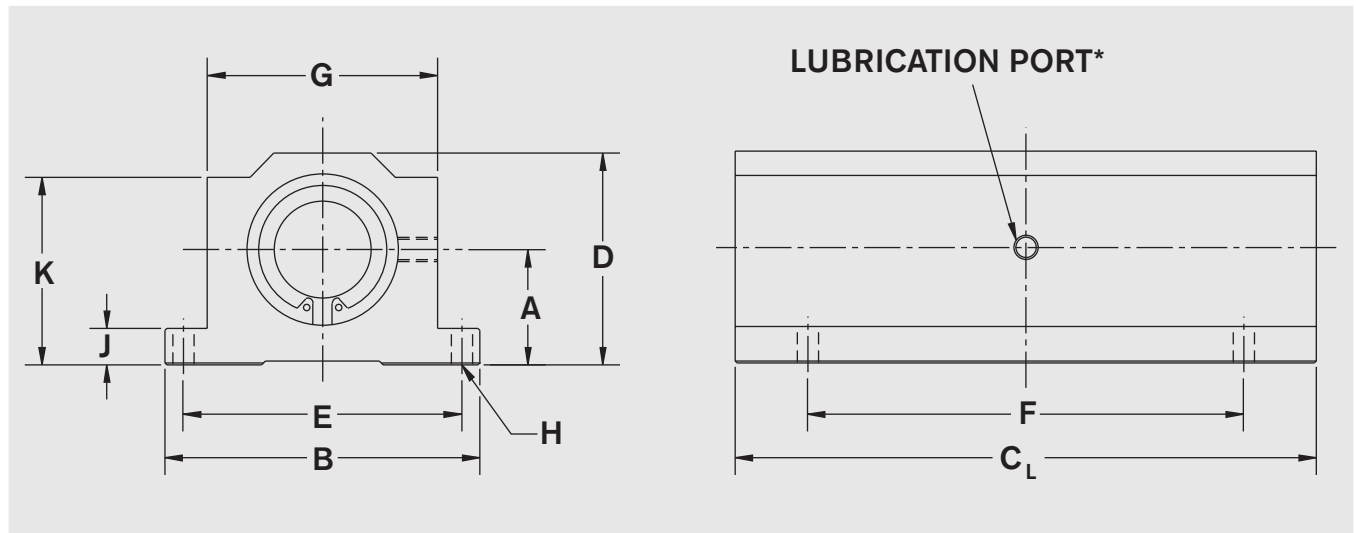
Ordering Data

Nominal Shaft Diameter (in.)	Part Number	Mass (lb)
	with two seals	
0.2500	R1760 704 00	0.19
0.3750	R1760 706 00	0.24
0.5000	R1760 708 00	0.49
0.6250	R1760 710 00	0.96
0.7500	R1760 712 00	1.25
1.0000	R1760 716 00	2.50
1.2500	R1760 720 00	5.00
1.5000	R1760 724 00	7.80

(Table 44)

Consult factory for details and availability:
No seal versions R1760 0..

Dimensions and Specifications



(Figure 17)

Dimensions (inches)

Nominal Shaft Diameter	A ₍₁₎	B	C _L	D	E ₍₂₎	F ₍₃₎	G	J	K
0.2500	0.4370	1.625	2.500	0.813	1.312	2.000	1.000	0.188	0.750
0.3750	0.5000	1.750	2.750	0.938	1.437	2.250	1.125	0.188	0.875
0.5000	0.6870	2.000	3.500	1.250	1.688	2.500	1.375	0.250	1.125
0.6250	0.8750	2.500	4.000	1.625	2.125	3.000	1.750	0.281	1.437
0.7500	0.9370	2.750	4.500	1.750	2.375	3.500	1.875	0.313	1.563
1.0000	1.1870	3.250	6.000	2.188	2.875	4.500	2.375	0.375	1.938
1.2500	1.5000	4.000	7.500	2.813	3.500	5.500	3.000	0.438	2.500
1.5000	1.7500	4.750	9.000	3.250	4.125	6.500	3.500	0.500	2.875

(Table 45)

Specifications

Nominal Shaft Diameter (in.)	Load Capacity		No. of Ball Circuits	H Mounting Hole	
	dyn. C (lbf)	stat. C _o (lbf)		Bolt	Hole
0.2500	96	160	8	#6	5/32
0.3750	150	240	8	#6	5/32
0.5000	370	580	8	#6	5/32
0.6250	640	1000	10	#8	3/16
0.7500	750	1184	12	#8	3/16
1.0000	1360	2124	12	#10	7/32
1.2500	1925	3064	12	#10	7/32
1.5000	2360	3685	12	1/4	9/32

(Table 46)

Notes:

- (1) Center line tolerance $\pm .0012''$
- (2) Bolt hole location tolerance $\pm .010''$
- (3) Bolt hole location tolerance $\pm .010''$

* Provided with push-in lube fitting for sizes .2500" to .5000". Sizes .6250" to 1.500" offer a 1/4 - 28 tapped hole with plug.

Rexroth Linear Twin Pillow Block Sets

Aluminum Twin Pillow Block Set, R1762

Adjustable type - for use on unsupported shaft

Structural design

- Precision, lightweight aluminum housing
- Twin style housing
- Two Super Linear Bushings
- Self-aligning feature
- Fully sealed both ends
- Adjustable bore
- Access for lubrication



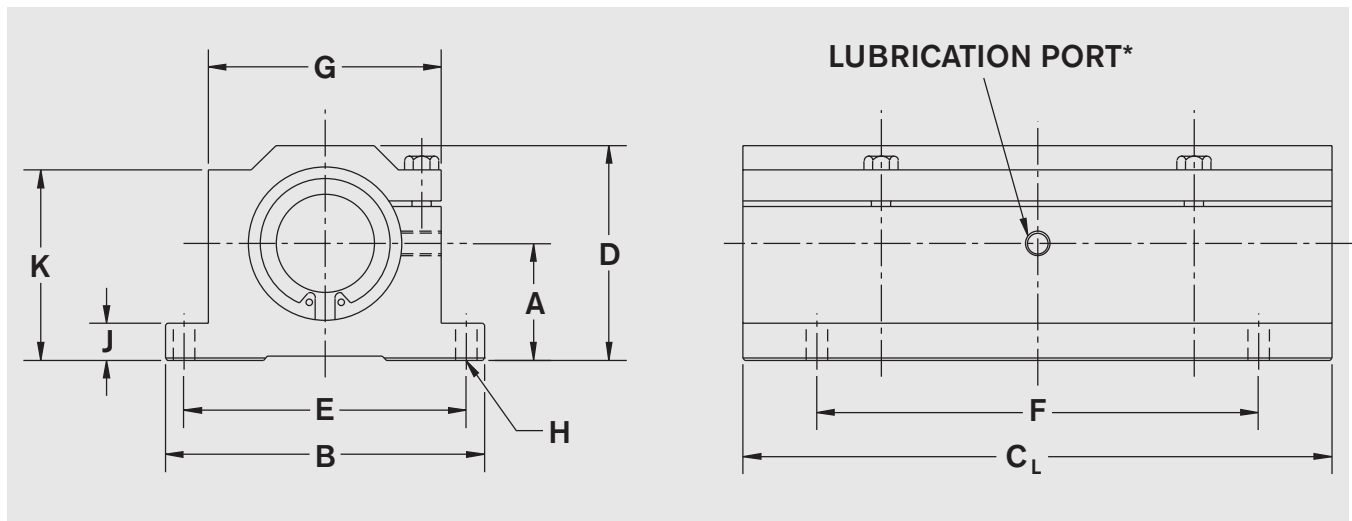
Ordering Data

Nominal Shaft Diameter (in.)	Part Number	Mass (lb)
	with two seals	
0.2500	R1762 704 00	0.19
0.3750	R1762 706 00	0.25
0.5000	R1762 708 00	0.50
0.6250	R1762 710 00	0.96
0.7500	R1762 712 00	1.25
1.0000	R1762 716 00	2.50
1.2500	R1762 720 00	5.00
1.5000	R1762 724 00	7.80

(Table 47)

Consult factory for details and availability:
No seal versions R1762 0..

Dimensions and Specifications



(Figure 18)

Dimensions (inches)

Nominal Shaft Diameter	A ₍₁₎	B	C _L	D	E ₍₂₎	F ₍₃₎	G	J	K
0.2500	0.4370	1.625	2.500	0.813	1.312	2.000	1.000	0.188	0.750
0.3750	0.5000	1.750	2.750	0.938	1.437	2.250	1.125	0.188	0.875
0.5000	0.6870	2.000	3.500	1.250	1.688	2.500	1.375	0.250	1.125
0.6250	0.8750	2.500	4.000	1.625	2.125	3.000	1.750	0.281	1.437
0.7500	0.9370	2.750	4.500	1.750	2.375	3.500	1.875	0.313	1.563
1.0000	1.1870	3.250	6.000	2.188	2.875	4.500	2.375	0.375	1.938
1.2500	1.5000	4.000	7.500	2.813	3.500	5.500	3.000	0.438	2.500
1.5000	1.7500	4.750	9.000	3.250	4.125	6.500	3.500	0.500	2.875

(Table 48)

Specifications

Nominal Shaft Diameter (in.)	Load Capacity		No. of Ball Circuits	H Mounting Hole	
	dyn. C (lbf)	stat. C _o (lbf)		Bolt	Hole
0.2500	96	160	8	#6	5/32
0.3750	150	240	8	#6	5/32
0.5000	370	580	8	#6	5/32
0.6250	640	1000	10	#8	3/16
0.7500	750	1184	12	#8	3/16
1.0000	1360	2124	12	#10	7/32
1.2500	1925	3064	12	#10	7/32
1.5000	2360	3685	12	1/4	9/32

(Table 49)

Notes:

- (1) Center line tolerance $\pm .0012''$
- (2) Bolt hole location tolerance $\pm .010''$
- (3) Bolt hole location tolerance $\pm .010''$

* Provided with push-in lube fitting for sizes .2500" to .5000".

Sizes .6250" to 1.500" offer a 1/4 - 28 tapped hole with plug.

Rexroth Linear Twin Pillow Block Sets

Aluminum Twin Pillow Block Set, R1763

Open type - for use on supported shaft

Structural design

- Precision, lightweight aluminum housing
- Twin style housing
- Two Super Linear Bushings
- Self-aligning feature
- Fully sealed both ends
- Adjustable open bore
- Access for lubrication



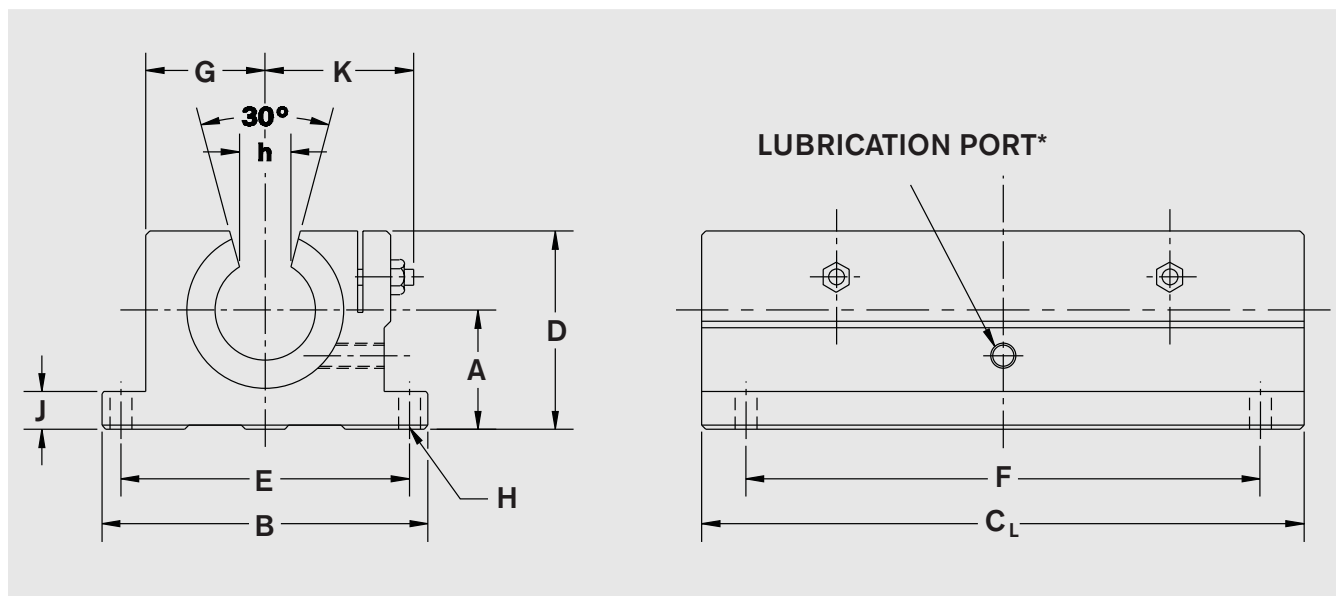
Ordering Data

Nominal Shaft Diameter (in.)	Part Number	Mass (lb)
	with two seals	
0.5000	R1763 708 00	0.40
0.6250	R1763 710 00	0.80
0.7500	R1763 712 00	1.00
1.0000	R1763 716 00	2.00
1.2500	R1763 720 00	4.20
1.5000	R1763 724 00	6.70

(Table 50)

Consult factory for details and availability:
No seal versions R1763 0..

Dimensions and Specifications



(Figure 19)

Dimensions (inches)

Nominal Shaft Diameter	A ₍₁₎	B	C _L	D	E ₍₂₎	F ₍₃₎	G	J	K	h
0.5000	0.6870	2.000	3.500	1.100	1.688	2.500	0.688	0.250	0.905	0.260
0.6250	0.8750	2.500	4.000	1.405	2.125	3.000	0.875	0.281	1.095	0.319
0.7500	0.9370	2.750	4.500	1.535	2.375	3.500	0.937	0.315	1.161	0.386
1.0000	1.1870	3.250	6.000	1.975	2.875	4.500	1.188	0.375	1.457	0.512
1.2500	1.5000	4.000	7.500	2.485	3.500	5.500	1.500	0.437	1.831	0.569
1.5000	1.7500	4.750	9.000	2.910	4.125	6.500	1.750	0.500	2.087	0.681

(Table 51)

Specifications

Nominal Shaft Diameter (in.)	Load Capacity		No. of Ball circuits	H Mounting Hole	
	dyn. C (lbf)	stat. C ₀ (lbf)		Bolt	Hole
0.5000	370	580	6	#6	5/32
0.6250	640	1000	8	#8	3/16
0.7500	750	1184	10	#8	3/16
1.0000	1360	2124	10	#10	7/32
1.2500	1924	3064	10	#10	7/32
1.5000	2360	3685	10	1/4	9/32

(Table 52)

Notes:

- (1) Center line tolerance $\pm .0012''$
- (2) Bolt hole location tolerance $\pm .010''$
- (3) Bolt hole location tolerance $\pm .010''$

* Provided with push-in lube fitting for sizes .5000". Sizes .6250" to 1.500" offer a 1/4 - 28 tapped hole with plug.

Rexroth Precision Steel Shafts

Shaft Products - Overview

Precision Shafts

R1700 ..

Case hardened polished and ground shaft.. Carbon or stainless material used in end supported Linear Assemblies.



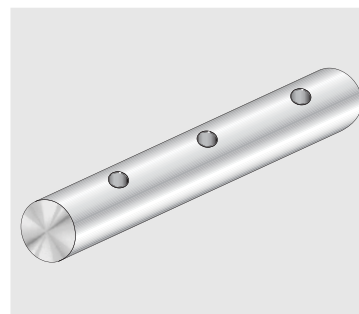
Page

55

Predrilled Shafts

R1771 ..

Case hardened polished and ground shaft. Carbon or stainless material. Pre-drilled radial taps provide mounting capability when used with shaft support rails.



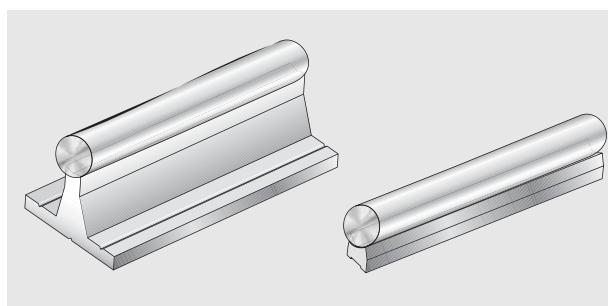
62

Shaft Support Rail

Assemblies

R1769 ../ R1770 ..

Combination of predrilled shaft mounted to predrilled shaft support rails. Available with carbon or stainless shaft and aluminum shaft support rails. Continuous support to shaft over length of assembly.



65

Precision Shaft

A critical component of the Linear Bushings Assembly is the shaft. Consideration for proper surface finish, hardness, and diameter is essential for performance of the assembly.

Rexroth Precision Steel Shafts are induction hardened and centerless ground to ensure quality fit and performance, complimenting the Linear Bushing line of Rexroth products.

In addition to the shaft acting as guideways with Linear Bushings, they also have a long and successful service in the following applications:

- Guide rods
- Control rods
- Rollers
- Pistons
- Axles
- Guide pins
- Tie rods
- Spindles
- Guide columns
- Mandrels and other similar applications

Precision Shafts offer the following features

- Diameter range between 1/4" to 4" nominal diameter
- Class L O.D. tolerances
- Carbon steel and stainless steel materials
- Random lengths up to 244" long
- Plain and predrilled shaft material
- Case hardened to R_c60-64

Technical Data

Dimensional accuracy and tolerance zones

The diameters of inch Precision Steel Shafts are accurate to within the tolerance zones of Classes L. Details on the dimensional accuracy of these shafts are compiled in the table on the right.

The tolerance for the diameter of soft-annealed shaft sections may be greater than the tolerance zones quoted.

For special diameter tolerances, please contact the factory.

Tolerances for inch-size steel shafts

Nominal diameter	(in)	over up to	0 1/4	1/4 3/8	3/8 5/8	5/8 1	1 2	2 3	3 4
Roundness	L	(in)	.00025	.00015	.00020	.00024	.00028	.00032	.00039
Taper,	L	(in)	.00020	.00024	.00032	.00035	.00043	.00051	.00059
Straightness		(in/ft)	.0015	.0015	.0015	.0015	.0015	.0015	.0015
Measured value $t_1^{1)}$		(in/ft)	.0047	.0047	.0047	.0047	.0047	.0047	.0047
Surface roughness maximum (RA) ²⁾		(μ in)	13	13	13	13	13	13	13

(Table 59)

¹⁾ Dial gauge reading during straightness measurement. For lengths of less than 303 ft., the lowest possible value is .0015in. This corresponds to a straightness tolerance of .0008 in.

²⁾ Applies to shafts made of heat-treatable or anti-friction bearing steel only. Please contact us for surface finish and surface roughness (RA) tolerances for corrosion-resistant steel shafts.

Straightness

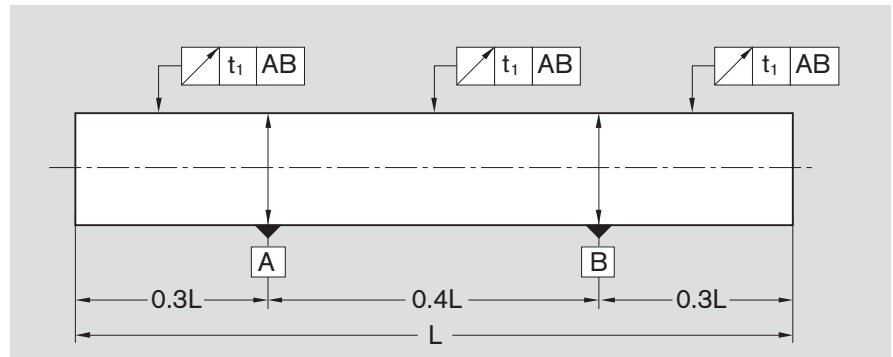
Because of the length of the shafts, it would be uneconomical to use the straightness measurement method specified in DIN ISO 1101 section 14.1. Instead of direct measurement for straightness, the shafts are tested for run out tolerance as described in DIN ISO 1101 section 14.13.1. See "Measurement of straightness".

Shaft Ø d		Class L	
(Inch)	(mm)	(Inch)	(mm)
1/4	6.35	−0.0005 −0.0010	−0.013 −0.025
3/8	9.525	−0.0005 −0.0010	−0.013 −0.025
1/2	12.70	−0.0005 −0.0010	−0.013 −0.025
5/8	15.875	−0.0005 −0.0010	−0.013 −0.025
3/4	19.05	−0.0005 −0.0010	−0.013 −0.025
1	25.40	−0.0005 −0.0010	−0.013 −0.025
1 1/4	31.75	−0.0005 −0.0010	−0.013 −0.025
1 1/2	38.1	−0.0006 −0.0011	−0.015 −0.028
2	50.8	−0.0006 −0.0013	−0.015 −0.033
3	76.2	−0.008 −0.0017	−0.020 −0.043
4	101.6	−0.0012 −0.0024	−0.030 −0.061

(Table 60)

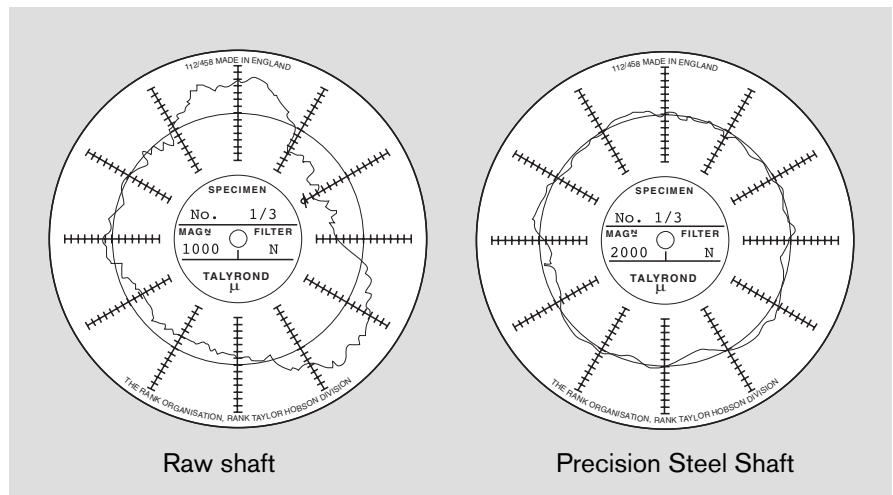
Measurement of straightness

Measurements are performed at points equidistant between the support points and the overhanging ends of the shaft. The measured values are then halved and the resulting value t_1 gives the straightness.



Measurement of roundness

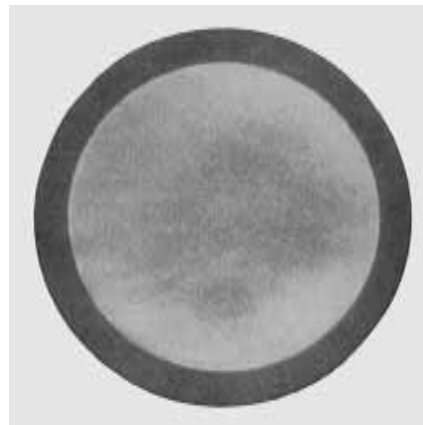
The figure shows the roundness of a raw shaft compared with that of a finished Precision Steel Shaft.



Shaft hardness

The surface of the shaft is induction-hardened to a depth of at least 0.015 up to 0.125 inches, depending on the shaft diameter. Surface hardness and depth of hardness are extremely uniform, both in the axial and in the circumferential direction. This is the reason for the excellent dimensional consistency and the long service life of Precision Steel Shafts.

The photographs opposite show a longitudinal and a transverse section through a hardened and ground Precision Steel Shaft. The hardened surface zone has been made visible by caustic etching.



Shaft Ø d	(in)	over up to	3/8	3/8 5/8	5/8 1	1 2	2 4
Depth of hardness ¹	(in)	min.	0.019	0.027	0.043	0.059	0.086

(Table 61)

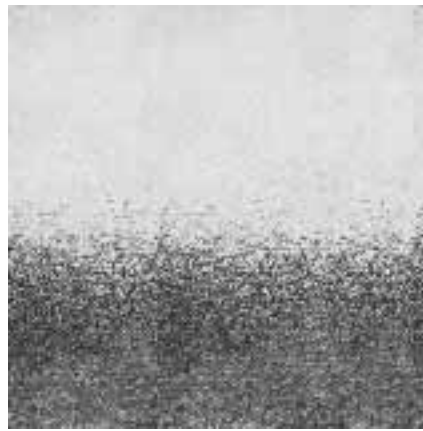
¹ Please contact us to obtain the depth of hardness for corrosion-resistant steel shafts.

Rexroth Precision Steel Shafts

Technical Data

Minimum hardness Solid and tubular shafts HRC 60 Corrosion-resistant steel shafts HRC 53 to DIN 17230 / EN 10088

The figure opposite shows the micro-structure in the surface zone of a shaft cross section (magnification approx. 10x). The hardened outer layer of martensite and the smooth transition to the tough inner core structure are clearly visible.



Induction-hardened surface zone
Structure: martensite
hardness • HRC 60 (Rockwell C)

Transitional structure:
martensite
troostite
pearlite

Core structure:
pearlite and ferrite

Shaft deflection

When steel shafts are used as linear motion guideways for linear bushings it is important that the shaft deflection occurring under load is kept within certain limits, as otherwise the proper functioning and the service life of the assembly could be impaired¹⁾. To facilitate the determination of shaft deflection by calculation, we have compiled the most common load cases together with the associated deflection equations in the table below. The equations for calculation of the inclination of the shaft in the linear bushing (tan α can also be taken from this table).

Case No.	Loading conditions	Deflection equation	Shaft inclination in linear bushings
1		$f_1 = \frac{F \cdot a^3}{6 \cdot E \cdot J} \cdot \left(2 - \frac{3 \cdot a}{l}\right)$ $f_{m1} = \frac{F \cdot a^2}{24 \cdot E \cdot J} \cdot (3l - 4a)$	$\tan \alpha_{(x=a)} = \frac{F \cdot a^2 \cdot b}{2 \cdot E \cdot J \cdot l}$
2		$f_2 = \frac{F \cdot l^3}{2 \cdot E \cdot J} \cdot \frac{a^2}{l^2} \cdot \left(1 - \frac{4}{3} \cdot \frac{a}{l}\right)$ $f_{m2} = \frac{F \cdot l^3}{8 \cdot E \cdot J} \cdot \frac{a}{l} \cdot \left(1 - \frac{4}{3} \cdot \frac{a^2}{l^2}\right)$	$\tan \alpha_{(x=a)} = \frac{F \cdot a \cdot b}{2 \cdot E \cdot J}$
3		$f_3 = \frac{F \cdot l^3}{3 \cdot E \cdot J} \cdot \frac{a^3 \cdot b^3}{l^3 \cdot l^3}$ $f_{m3} = \frac{2 \cdot F \cdot l^3}{3 \cdot E \cdot J} \cdot \frac{a^3}{l^3} \cdot \frac{b^2}{l^2} \cdot \left(\frac{l}{l+2a}\right)^2$	$\tan \alpha_{(x=b)} = \frac{F \cdot a^2 \cdot b^2}{2 \cdot E \cdot J \cdot l^2} \cdot \left(1 - \frac{2 \cdot b}{l}\right)$
4		$f_4 = \frac{F \cdot l^3}{3 \cdot E \cdot J} \cdot \frac{a^2 \cdot b^2}{l^2 \cdot l^2}$ $f_{m4} = f_4 \cdot \frac{l+b}{3 \cdot b} \cdot \sqrt{\frac{l+b}{3 \cdot a}}$	$\tan \alpha_{(x=b)} = \frac{F \cdot a}{6 \cdot E \cdot J \cdot l} \cdot (3b^2 - l^2 + a^2)$
5		$f_5 = \frac{5 \cdot F \cdot l^3}{384 \cdot E \cdot J}$	$\tan \alpha_{(x=0)} = \frac{F \cdot l^2}{24 \cdot E \cdot J}$

(Table 62)

¹⁾ There will be no loss of load-carrying capacity or service life in Super Linear Bushings provided the shaft deflection does not exceed 0.5° (tan 0.5° = 0.0087).

The tables below give the values for the maximum permissible shaft inclination ($\tan \alpha_{\max}$) for each size of Standard Linear Bushing.

At $\tan \alpha = \tan \alpha_{\max}$ the permissible static load capacity is approx. $0.4 C_O$.

Shaft Ø d (in.)	$\tan \alpha_{\max}$
1/4	$12.3 \cdot 10^{-4}$
3/8	$10.0 \cdot 10^{-4}$
1/2	$10.1 \cdot 10^{-4}$
5/8	$8.5 \cdot 10^{-4}$
3/4	$8.5 \cdot 10^{-4}$
1	$7.2 \cdot 10^{-4}$

(Table 63)

Shaft Ø d (in.)	$\tan \alpha_{\max}$
1 1/4	$6.4 \cdot 10^{-4}$
1 1/2	$7.3 \cdot 10^{-4}$
2	$6.3 \cdot 10^{-4}$
3	$5.7 \cdot 10^{-4}$
4	$5.7 \cdot 10^{-4}$

(Table 64)

Values for E x J and mass for steel shafts

Solid shafts			
Ø d		E x J	Mass
(Inches)	(mm)	(lb x in ²)	(lb/in)
1/4	6.35	1.16×10^5	0.014
3/8	9.525	5.85×10^5	0.031
1/2	12.7	1.85×10^6	0.056
5/8	15.875	4.51×10^6	0.087
3/4	19.05	9.38×10^6	0.125
1	25.4	2.96×10^7	0.223
1 1/4	31.75	7.25×10^7	0.348
1 1/2	38.1	1.50×10^8	0.501
2	50.8	4.74×10^8	0.890
2 1/2	63.5	1.16×10^9	1.391
3	76.2	2.40×10^9	2.003
4	101.6	7.59×10^9	3.560

(Table 65)

Rexroth Precision Steel Shafts

Machining

Examples of standard shaft machining services available are illustrated below. Many custom features can also be provided. A print or sketch must be provided to Bosch Rexroth indicating all dimensions, tolerances and the quantity required.

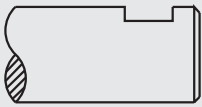
Standard Machining Options:

Standard Machining Options

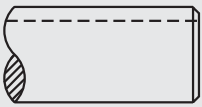
Three-place decimal
Two-place decimal
One-place decimal

Rexroth Tolerance

+0.005"
+0.010"
+0.020"



Flat



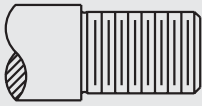
Keyway



Tapped Hole



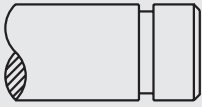
Radial Hole



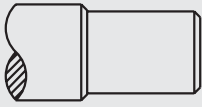
Threaded End



Coaxial Hole



Retaining Ring Groove



Reduced End

When no tolerances are specified, Bosch Rexroth will apply the following standard tolerances based upon the range of precision indicated by the blueprint.

Example	
<u>Blueprint Dimensions</u>	<u>Tolerance</u>
.XXX -three place decimal	+/- .005"
.XX -two place decimal	+/- .010"
.X -one place decimal	+/- .020"

Series R1700 0XX Precision Steel Shaft Specifications

Materials: --Ck55 or C55 carbon steel (similar to AISI C-1055), case hardened to min. $R_c 60$ to 64
Case depth shown in table 66.
--X46Cr13 stainless steel (similar to AISI 420C), case hardened to min. $R_c 53$.
Case depth shown in table 66.

Surface finish: 8 to 13 RA microinches

Length tolerances: +/- 1/32" for shafts up to 1.25" in diameter
+/- 1/16" for shafts up to 1.5" in diameter and over
* closer tolerances are available at additional costs

Straightness tolerance: .0015" per foot

End Conditions: Shaft ends are chamfered approximately 1/32" X 45° up to 1.25" diameter shaft and 1/16" X 45° to 1.5" diameter and up.
Other chamfers can be provided at additional costs.

Shaft Selection Table

Nominal Shaft Diameter (in.)	Part Numbers ⁽¹⁾ Class L -08	Actual Diameter	Weight lb/in	*Random Length (Avg.)	Case Depth (min.)
		Class L			
1/4	R1700 004 08	.2495/.2490	0.014	244"	0.019
3/8	R1700 006 08	.3745/.3740	0.031	244"	0.027
1/2	R1700 008 08	.4995/.4990	0.056	244"	0.031
5/8	R1700 010 08	.6245/.6240	0.087	244"	0.043
3/4	R1700 012 08	.7495/.7490	0.125	244"	0.047
1	R1700 016 08	.9995/.9990	0.223	244"	0.059
1 1/4	R1700 020 08	1.2495/1.2490	0.348	244"	0.059
1 1/2	R1700 024 08	1.4994/1.4989	0.501	244"	0.062
2	R1700 032 08	1.9994/1.9987	0.890	244"	0.086
2 1/2	R1700 040 08	2.4993/2.4985	1.391	244"	0.086
3	R1700 048 08	2.9992/2.9983	2.003	208"	0.086
4	R1700 064 08	3.9988/3.9976	3.560	208"	0.110

(Table 66)

*Consult Bosch Rexroth for details on longer lengths

(1)Stainless Steel Shaft: For Stainless Steel Shaft Class L use suffix -28. For plated, use suffix - 68

Order Example:

Part Number ---- R1700 004 08,48"

material ---- Standard carbon steel

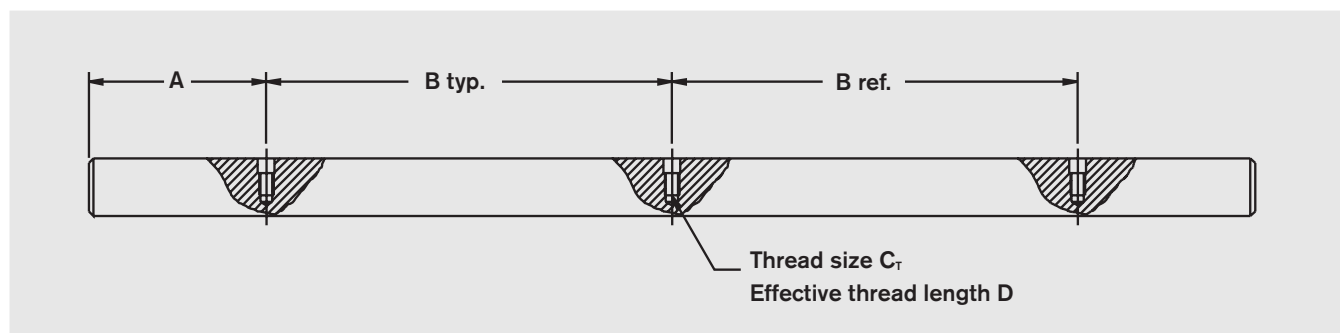
diameter ---- 1/4" nominal

Tolerance ---- Class L diameter

Length ---- 48" long

Rexroth Precision Steel Shafts

Series R1771 0XX Pre-drilled Shaft Specifications



(Figure 23)

Shaft Selection Table

(Old Series 1700 5..)

Nominal Shaft Diameter (in.)	Part Numbers ⁽¹⁾ Carbon Steel Ck-55 Class L	Stainless Steel X46 Class L	A +/- 0.005	B +/- 0.010	*Random Lengths (Avg.)	C _T Size	D Depth
1/2	R1771 008 08	R1771 008 28	2.00	4.00	200"	#6-32	0.250
5/8	R1771 010 08	R1771 010 28	2.00	4.00	200"	#8-32	0.320
3/4	R1771 012 08	R1771 012 28	3.00	6.00	200"	#10-32	0.380
1	R1771 016 08	R1771 016 28	3.00	6.00	200"	1/4-20	0.500
1 1/4	R1771 020 08	R1771 020 28	3.00	6.00	200"	5/16-18	0.630
1 1/2	R1771 024 08	R1771 024 28	4.00	8.00	200"	3/8-16	0.750
2	R1771 032 08	R1771 032 28	4.00	8.00	200"	1/2-13	1.000

(Table 67)

*Consult Bosch Rexroth for details on longer lengths

Materials:

Ck-55 carbon steel (similar to AISI C-1055), case hardened to R_c60 to 64
 X 46 Cr13 stainless steel (similar to AISI 420C), case hardened to R_c53 to 57.

Surface finish:

8 to 13 RA microinches

Length tolerances:

+/- 1/32" for shafts up to 1.25" in diameter
 +/- 1/16" for shafts up to 1.5" in diameter and over

Straightness tolerance:

.0015" per foot

Order Example:

Part Number ---- R1771 012 08,144"

material----Standard carbon steel

diameter----3/4" nominal

Tolerance----Class L diameter

Length----144" long

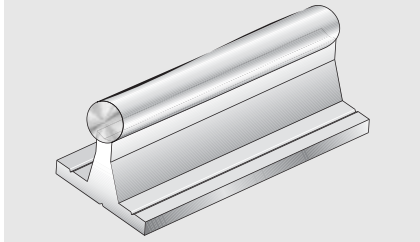
Rexroth Shaft Support Rail Assemblies

Shaft Support Rail Assemblies - Overview

Page

High Profile Assembly R1769 0..

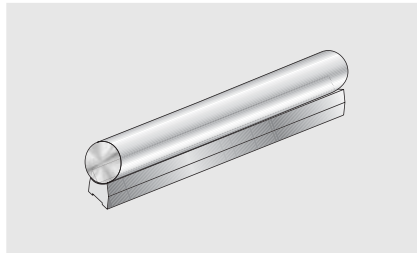
Flange style shaft support rail available plain or predrilled. Provides support to shaft assemblies where deflection is a concern.



60

Low Profile Assembly R1770 0..

Low profile shaft support rail available in plain or predrilled. Provide a rigid support and a lower center of gravity for shaft assemblies.



61

Shaft support assemblies are designed to provide a rigid structure and eliminate shafts bending under load. The Rexroth Shaft Support Rail Assemblies are delivered in ready mount from sections.

The basic design consists of Rexroth Precision Shaft and Support Rails. Various shaft diameters and materials are available for whatever design requirements are necessary.

Advantages

- Prevent shaft deflection
- Ensure efficient running of linear motion assemblies
- Eliminate the need for time consuming and costly designs

Continuous support of the shaft is possible by assembling individual supports end to end underneath the corresponding shaft. This ensures complete and uninterrupted support along the entire assembly.

Support assemblies are sized 1/2" nominal shaft diameter to 2" nominal shaft diameter in standard lengths up to 200" long.

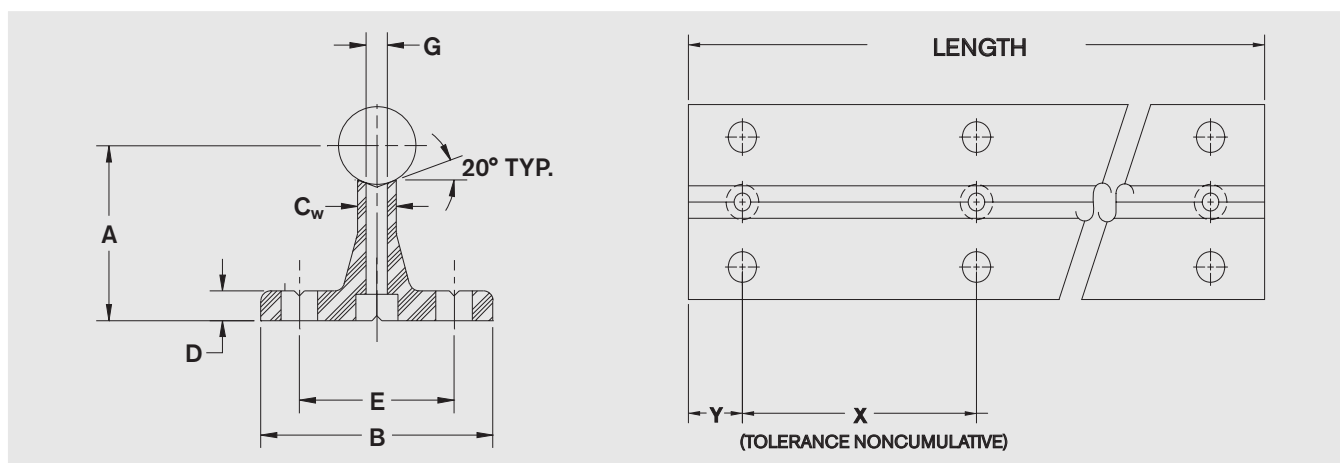
Other lengths and modifications may be made to the shaft/rail assemblies at additional costs. A print or sketch is required for quotation.

Rexroth shaft Support Assemblies

Series R1769 0XX High Profile Support Rail Assembly

Specifications:

Materials:	Support rails: 6061-T6 aluminum Shaft: Ck-55 carbon steel / X46 Cr13 stainless steel
Surface Finish:	Support rail: Aluminum mill finish Shaft: 8 to 13 RA microinc
Base hole location:	+/- .015" non-cummulative



(Figure 24)

Support Rail Assembly Selection Table

Nominal Shaft Diameter	Shaft Rail Assembly Part Number ⁽¹⁾ Carbon Steel Ck-55 Class L	A +/-0.002	B	C _w	D	E	G	X	Y	Part Number for Rail Support ⁽²⁾
1/2	R1769 008 08	1.125	1.50	0.25	0.19	1.000	0.19	4.00	2.00	R1767 108 00
5/8	R1769 010 08	1.125	1.62	0.31	0.25	1.125	0.25	4.00	2.00	R1767 110 00
3/4	R1769 012 08	1.500	1.75	0.38	0.25	1.250	0.31	6.00	3.00	R1767 112 00
1	R1769 016 08	1.750	2.12	0.50	0.25	1.500	0.25	6.00	3.00	R1767 116 00
1 1/4	R1769 020 08	2.125	2.50	0.56	0.31	1.875	0.31	6.00	3.00	R1767 120 00
1 1/2	R1769 024 08	2.500	3.00	0.69	0.38	2.250	0.31	8.00	4.00	R1767 124 00
2	R1769 032 08	3.250	3.72	0.88	0.50	2.750	0.38	8.00	4.00	R1767 132 00

(Table 68)

Order Example:

Part Number ---- R1769 016 08,120"

material----Standard carbon steel

diameter----1" nominal class L

Support Rail mounted to shaft

Length----120" long

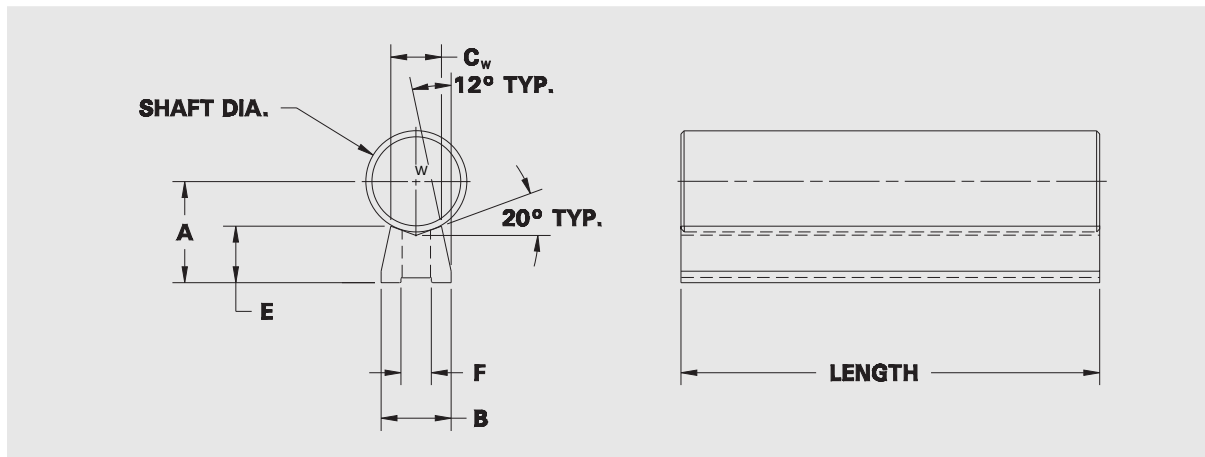
Note: 1. For Stainless Steel Shaft use suffix -2X 2. See page 63 for specification on Rail Supports

Rexroth Shaft Support Rail Assemblies

Series R1770 0XX Low Profile Shaft Support Assembly

Specifications:

Materials:	Support rails: AISI 1018 Steel Shaft: Ck-55 carbon steel / X46 Cr13 stainless steel
Surface Finish:	Support rail: Steel mill finish Shaft: 8 to 13 RA micro inches
Base hole location:	+/- .005" non-cumulative



(Figure 25)

Support Rail Assembly Selection Table

(Old Series R1700 6XX 37)

Nominal Shaft Diameter (in.)	Shaft/Rail Assembly Part Number ⁽¹⁾ Carbon Steel Ck-55 Class L	A +/-0.002	B +/-0.010	C _w +/-0.010	E Ref.	F Bolt	Hole	Part Number for Rail Support ⁽²⁾
1/2	R1770 008 08	0.562	0.370	0.250	0.341	6-32	0.169	R1768 108 00
3/4	R1770 012 08	0.750	0.510	0.375	0.420	10-32	0.221	R1768 112 00
1	R1770 016 08	1.000	0.690	0.500	0.560	1/4-20	0.281	R1768 116 00

(Table 69)

Order Example:

Part Number ---- R1770 016 08,120"

material----Standard carbon steel

diameter----1" nominal class L

Support Rail mounted to shaft

Length----120" long

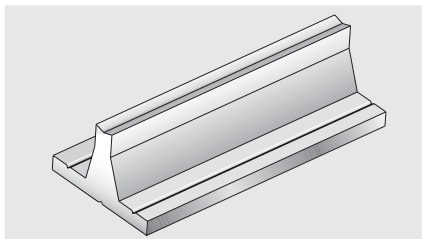
Note: 1. For Stainless Steel shaft use suffix -2X 2. See page 64 for specification on Rail Supports

Rexroth Shaft Support Rails

Shaft Support Rail Products Overview

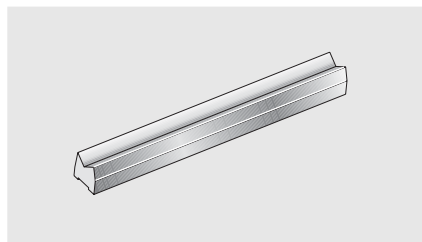
High Profile Rails R1767 1../ R1767 0..

Flange style shaft support rail available plain or predrilled. Provides support to shaft assemblies where deflection is a concern.

**Page****63**

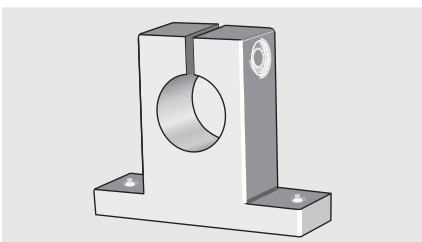
Low Profile Rails R1768 1../ R1768 0..

Low profile shaft support rail available in plain or predrilled. Provide a rigid support and a lower center of gravity for shaft assemblies.

**64**

Support Blocks R1759 00..

Provides a quick and effective way to support a shaft assembly where there is little or no concern for deflection.

**65**

Rexroth Support Rails

Series R1767 1XX 00 High Profile Support Rails

Rexroth Shaft support rails are available in three configurations: Plain, predrilled or special machined.

Support rails are available in shaft diameter sizes 1/2" to 2" as specified in the table below. For shaft sizes not listed, select the closest to that needed. If a shaft falls midway between specified diameters, use the next larger rail.

Standard rails are 24" long. To support longer shafts, several rails may be used in tandem. For shorter shafts, rails may be ordered pre-cut to fit. Also for user convenience, Rexroth support rails have pre-grooved centerlines for easy, accurate drilling of additional holes.

Specifications

Materials:

6061-T6 aluminum extrusion

Surface finish:

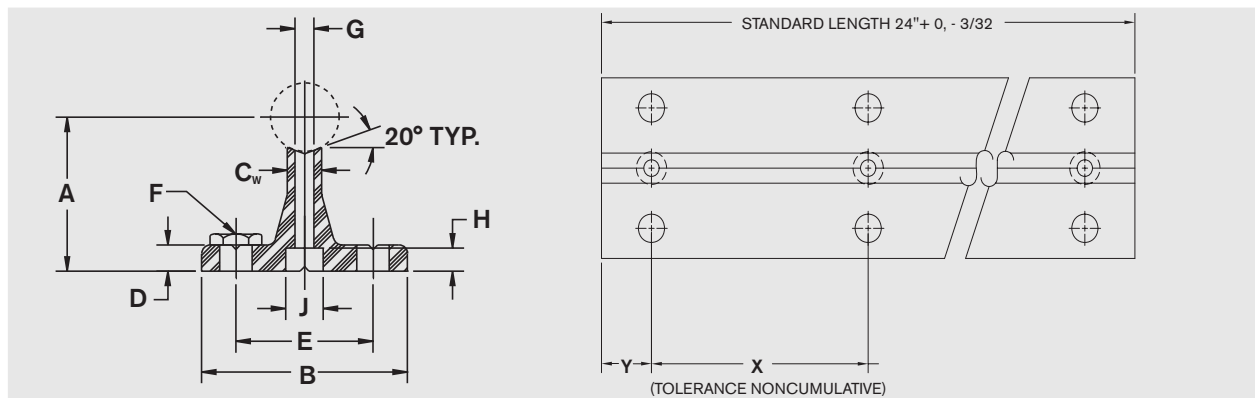
Aluminum mill finish

Length:

24" (tolerance +0, -3/32")

Base hole location:

+/- 0.015" noncumulative



(Figure 25)

Support Rail Selection Table

Nominal Shaft Diameter (in.)	Part Number ⁽¹⁾ Predrilled	A +/- 0.002	B	C _w	D	E	F	G Assembly Bolt	H	X	Y
1/2	R1767 108 00	1.125	1.50	0.25	0.19	1.000	#6	6-32x7/8	0.17	4.00	2.00
5/8	R1767 110 00	1.125	1.62	0.31	0.25	1.125	#8	8-32x7/8	0.19	4.00	2.00
3/4	R1767 112 00	1.500	1.75	0.38	0.25	1.250	#10	10-32x1-1/4	0.22	6.00	3.00
1	R1767 116 00	1.750	2.12	0.50	0.25	1.500	1/4	1/4-20x1-1 1/2	0.29	6.00	3.00
1 1/4	R1767 120 00	2.125	2.50	0.56	0.31	1.875	5/16	5/16-18x1-3/4	0.34	6.00	3.00
1 1/2	R1767 124 00	2.500	3.00	0.69	0.38	2.250	5/16	3/8-16x2	0.41	8.00	4.00
2	R1767 132 00	3.250	3.75	0.88	0.50	2.750	3/8	1/2-13x2-1/2	0.53	8.00	4.00

(Table 70)

Note: (1) Part number for non-drilled rail support is R1767 0XX 00.

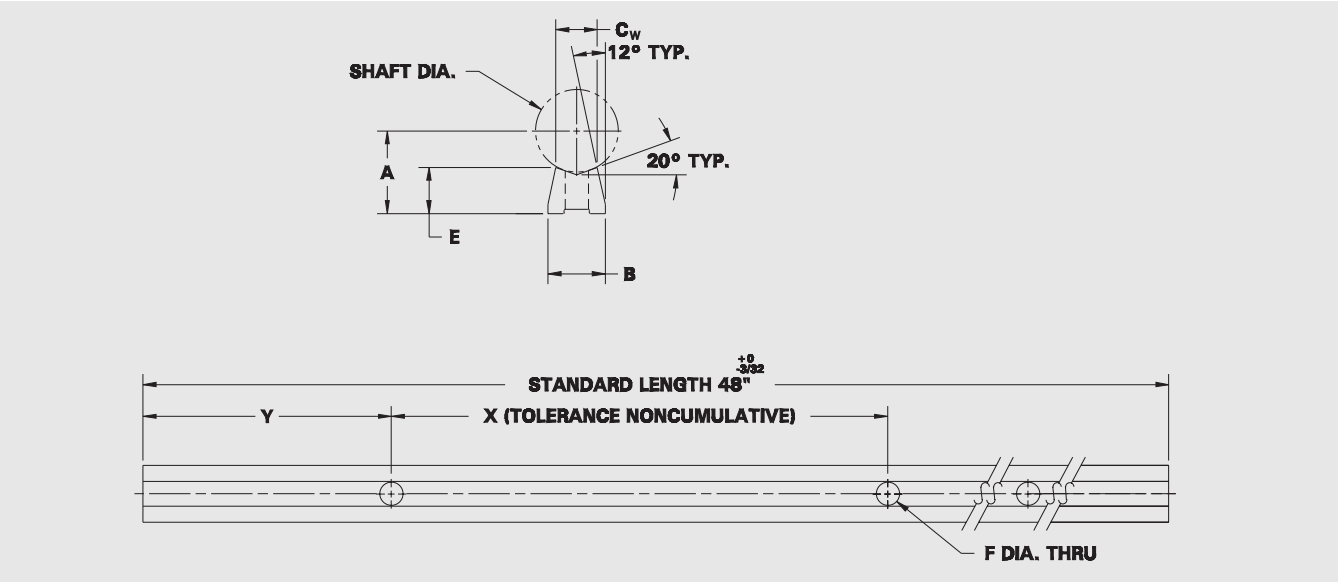
Rexroth Support Rails

Series R1768 1XX Low Profile Support Rails

Rexroth Low support rails provide for a very compact and rigid assembly, ideal for designs where the steel shaft can be mounted from below. This ensures a rigid structure by securing the mounting surface, low support rail and shaft together at each mounting point.

Each low support rail is available in standard lengths of 48".

Specifications	Materials:	AISI 1018 Steel
	Length:	48" (tolerance +0, -3/32")
	Base hole location:	+/- 0.005" noncumulative



(Figure 26)

Support Rail Selection Table

(Old Series R1767 XXX 37)

Nominal Shaft Diameter (in.)	Part Numbers Predrilled	A	B	C _w	E	F		X	Y
		+/-0.002	+/-0.010	+/-0.010	Ref.	Bolt	Hole	+/-0.005	+/-0.005
1/2	R1768 108 00	0.562	0.370	0.250	0.341	6-32	0.169	4.000	2.000
3/4	R1768 112 00	0.750	0.510	0.375	0.420	10-32	0.221	6.000	3.000
1	R1768 116 00	1.000	0.690	0.500	0.560	1/4-20	0.281	6.000	3.000

(Table 71)

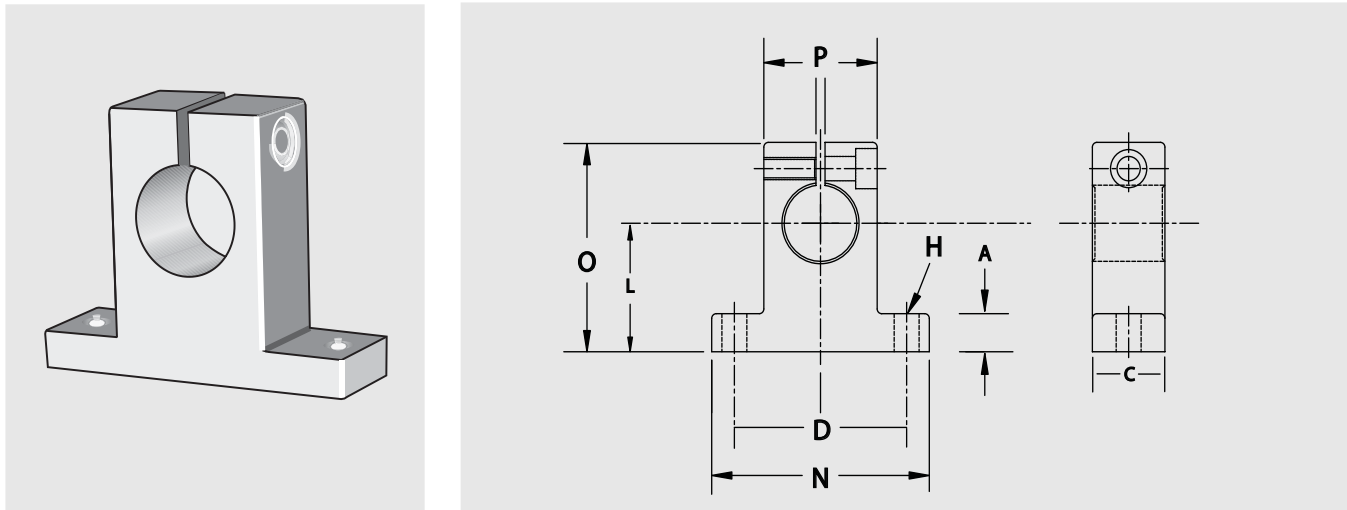
Note: (1) Part number for non-drilled rail support is R1768 0XX 00

Rexroth Support Blocks

Series R1759 XXX Support Blocks

Rexroth Series R1759 - Shaft Support Blocks may be used at end or intermediate positions on stationary shafts. They are ideal where loads are light and deflections between supports pose no problem.

Supports must not interfere with bushing or carriage travel. Shimming is suggested for high precision applications to eliminate the effect of variations in base flatness or support manufacturing tolerances. These blocks provide quick, firm clamping of shafts, reducing the need for specialized mountings and miscellaneous hardware.



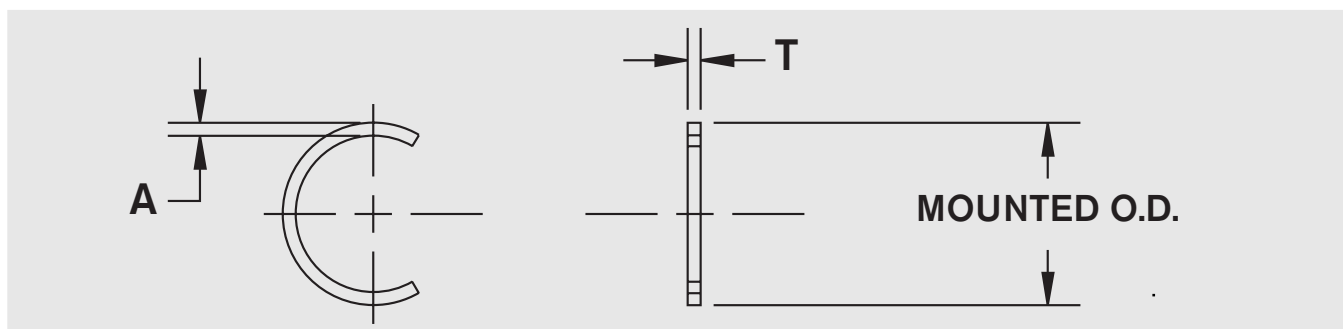
(Figure 27)

Support Block Selection Table

Nominal Shaft Diameter (in.)	Part Number	L	N	C	O	D	A	P	Weight (lbs)
1/2	R1759 008 01	1.00	2.00	0.63	1.63	1.50	0.25	0.88	0.20
3/4	R1759 012 01	1.25	2.50	0.75	2.13	2.00	0.31	1.25	0.41
1	R1759 016 01	1.50	3.06	1.00	2.56	2.50	0.38	1.50	0.76
1 1/4	R1759 020 01	1.75	3.75	1.13	3.00	3.00	0.44	2.00	1.30
1 1/2	R1759 024 01	2.00	4.38	1.25	3.50	3.50	0.50	2.25	1.87
2	R1759 032 01	2.50	5.50	1.50	4.50	4.50	0.63	3.00	3.74
Nominal Shaft Diameter (in.)	Part Number	H Mounting Hole Bolt Hole							
1/2	R1759 008 01	#8	3/16						
3/4	R1759 012 01	#10	7/32						
1	R1759 016 01	1/4	9/32						
1 1/4	R1759 020 01	5/16	11/32						
1 1/2	R1759 024 01	5/16	11/32						
2	R1759 032 01	3/8	13/32						

(Table 72)

Rexroth External Retaining Rings



(Figure 28)

External Ring Selection Table

New Part Number	Old Part Number	Free I.D.		Mounted O.D. ⁽¹⁾	A +/- .001	T +/- .001
		Ø	Tol.			
R987 145 915	XR-4A	0.469	+0.000	0.539	0.035	0.035
R987 146 891	**XRS-4A		- 0.020			
R987 145 916	XR-4A	0.588	+0.000	0.658	0.035	0.035
R987 146 892	**XRS-6A		- 0.025			
R987 145 917	XR-4A	0.821	+0.000	0.905	0.042	0.042
R987 146 893	**XRS-8A		- 0.035			
R987 145 918	XR-10A	1.059	+0.000	1.159	0.050	0.050
R987 146 888	**XRS-10A		- 0.040			
R987 145 916	XR-12A	1.176	+0.000	1.276	0.050	0.050
R987 146 889	**XRS-12A		- 0.045			
R987 145 911	XR-16A	1.468	+0.000	1.592	0.062	0.062
R987 146 890	**XRS-16A		- 0.055			
R987 145 919	XR-20A	1.886	+0.000	2.036	0.075 +/- .002	
R987 145 912	XR-24A	2.239	+0.000 - 0.080	2.395	0.078	0.078
R987 145 916	XR-32A	2.838	+0.000 - 0.100	3.024	0.093	0.093
call factory	XR-40 ₍₂₎	3.468	+ .0200 - .0300	4.310	-----	0.109 +/- .003
call factory	XR-48 ₍₂₎	4.223	+ .0200 - .0300	5.180	-----	0.109 +/- .003
call factory	XR-64 ₍₂₎	5.631	+ .0200 - .0400	6.910	-----	0.125 +/- .004

(Table 73)

(1) Reference dimension only

(2) Commercial type with end lugs

**Corrosion-resistant material

Note: XR-type made of Spring Steel, XRS-type made of Nickel Plated Spring Steel

Notes

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