

S Type Hole Alterations

Blind Joints which require this alteration

Pre-Assembly Insertion Double Joints
P671

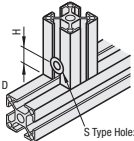
Drilling of S Holes for Pre Assy. Insertion Double Joint connections.
(Reference) Corners when using Pre Assy. Insertion Double Joints

Horizontal on Left End LSH
Vertical on Left End LSV
Horizontal on Right End RSH
Vertical on Right End RSV

S Hole is added on every slot for multiple slotted extrusions.

Hole Position and Size		S Hole	
Extrusion Series	H(mm)	ØD ₁ (mm)	ØD ₂ (mm)
HFS6	15	16.5	11.1
HFS8	20	20	13.1
HFS8-45	22.5	20	15.1

Pre-Assembly Insertion Double Joint Drilling



Ordering Example

HFS6-3030-2000-LSH-RSV

Days to Ship

[Configure Online](#)

M Type Hole Alterations

Blind Joints which require this alteration

Post-Assembly Insertion Double Joints
P665 Center Joint
P663

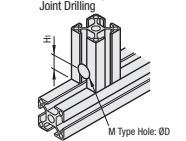
Drilling of M Holes for Center Joint and Post Assy. Insertion Double Joint connections.
(Reference) Corners when using Center Jointing

Horizontal on Left End LMH
Vertical on Left End LMV
Horizontal on Right End RMH
Vertical on Right End RMV

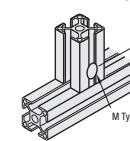
M Hole is added on every slot for multiple slotted extrusions, except for the middle slot of 3-slotted extrusion.

Hole Position and Size		M Hole
Extrusion Series	H ₁ (mm)	ØD(mm)
HFS5	10	7.1
HFS5 (25 Square)	10	7.1
HFS6	15	11.1
HFS8	20	13.1
HFS8-45	*(20.5)	13.1

Post-Assembly Insertion Double Joint Drilling



Center Joint Drilling



Ordering Example

HFS6-3030-2000-LMH-RMH

Days to Ship

[Configure Online](#)

*Only for 45 Square Light Type (HFS8-45) Series, H₁ dimension is 20.5.

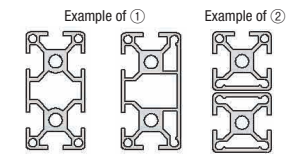
Alterations	Code	No.	Page	S Hole Dia.	S Hole			
					Left Side Horizontally/Vertically	Right Side Horizontally/Vertically	Left Side Horizontally/Vertically	Right Side Horizontally/Vertically
4-Side Slots	HFS6	3030	P545	D ₁ Ø16.5 D ₂ Ø11.1				
	GF56	3060	P547					
	EF56	3090	P549					
	NFS6	30120	P550					
	NEFS6	5050	P553					
	NEFS6	50700	P552					
	CAF6	100100	P553					
	CAF6	6060	P549					
	HFSY6	6090	P551					
	NEFS6	60120	P551					
	NEFS6	60600	P552					
	NEFS6	30300	P550					
	3-Side Slot 1-Side Flat	HFS6	3030		P546	D ₁ Ø16.5 D ₂ Ø11.1		
HFSF6		3060	P548					
NEFSF6		5050	P553					
2-Side Slots 2 Flats	HFSF6	3030	P546	D ₁ Ø16.5 D ₂ Ø11.1				
	EFST6	3060	P548					
	NFSF6	5050	P553					
2 Slots on Opposite Sides	HFSH6	3030	P546	D ₁ Ø16.5 D ₂ Ø11.1				
	EF5H6	3060	P548					
1-Side Slot 3 Flats	HFS6	3030	P546	D ₁ Ø16.5 D ₂ Ø11.1				
	EFSC6	3030	P546					
Light Type	HFSL6	3030	P545	D ₁ Ø16.5 D ₂ Ø11.1				
	NFSL6	5050	P553					
Heavy Type	HFSG6	6060	P549	D ₁ Ø16.5 D ₂ Ø11.1				
	HFS30A6	3060	P552					
Angled	HFS4A6	30	P552	D ₁ Ø16.5 D ₂ Ø11.1				
	NFS4A6	30	P552					
	HFS60A6	30	P552					
Black Anodize	HFSB6	3030	P546	D ₁ Ø16.5 D ₂ Ø11.1				
	EF5B6	3060	P547					
	NEFSB6	5050	P553					
	EF5B6	6060	P549					
	EF5B6	3030	P546					
	EF5B6	3030	P546					
	EF5B6	3030	P546					
	EF5B6	3030	P546					
4-Side Slots	HFS8	4040	P587	D ₁ Ø20 D ₂ Ø13.1				
	GF58	4080	P589					
	EF58	40120	P592					
	NFS8	40160	P593					
	NEFS8	8080	P591					
	CAF8	80160	P592					
	HFSY8	808040	P594					
	HFSH8	8080	P591					
	EF5H8	4040	P588					
	GF5H8	4080	P589					
	NEFSH8	8080	P591					
3-Side Slot 1-Side Flat	HFS6	4040	P588	D ₁ Ø20 D ₂ Ø13.1				
	GF5F6	4080	P589					
	NEFSF6	8080	P591					
2-Side Slots 2 Flats	HFSF8	4040	P588	D ₁ Ø20 D ₂ Ø13.1				
	EF5F8	4080	P589					
	NFSF8	8080	P591					
2 Slots on Opposite Sides	HFSH8	4040	P588	D ₁ Ø20 D ₂ Ø13.1				
	EF5H8	4080	P589					
1-Side Slot 3 Flats	HFS6	4040	P588	D ₁ Ø20 D ₂ Ø13.1				
	EFSC8	4040	P588					
Light Type	HFSL8	4040	P587	D ₁ Ø20 D ₂ Ø13.1				
	NFSL8	4080	P589					
Angled	HFS30A8	40	P593	D ₁ Ø20 D ₂ Ø13.1				
	HFS45A8	40	P593					
	HFS60A8	40	P593					
Black Anodize	HFSB8	4040	P587	D ₁ Ø20 D ₂ Ø13.1				
	EF5B8	4080	P589					
	NEFSB8	80160	P592					
	HFSB8	4040	P587					
	HFSB8	4040	P587					
	HFSB8	4040	P587					
Curved	HFSR8	4040	P594	D ₁ Ø20 D ₂ Ø13.1				
	NFSR8	808040	P594					
	HFSR8	808040	P594					

Alterations	Code	No.	Page	S Hole Dia.	S Hole			
					Left Side Horizontally/Vertically	Right Side Horizontally/Vertically	Left Side Horizontally/Vertically	Right Side Horizontally/Vertically
4-Side Slots	HFS5	4545	P625	D ₁ Ø20 D ₂ Ø15.1				
	GF55	4590	P628					
	EF55	45180	P629					
	NFS5	5050	P631					
	NEFS5	50100	P632					
	CAF5	909045	P629					
	CAF5	90180	P629					
	HFSY5	909045	P629					
	NEFS5	3090	P629					
	NEFS5	100100	P632					
	NEFS5	100200	P632					
	NEFS5	4060	P513					
	3-Side Slot 1-Side Flat	HFS5	4545		P626	D ₁ Ø20 D ₂ Ø15.1		
GF5F5		4590	P628					
NEFSF5		5050	P631					
2-Side Slots 2 Flats	HFSF5	4545	P627	D ₁ Ø20 D ₂ Ø15.1				
	EF5F5	4590	P628					
	NEFSF5	5050	P631					
2 Slots on Opposite Sides	HFSH5	4545	P627	D ₁ Ø20 D ₂ Ø15.1				
	EF5H5	4590	P628					
1-Side Slot 3 Flats	HFS5	4545	P627	D ₁ Ø20 D ₂ Ø15.1				
	EFSC5	4545	P627					
Light Type	HFSL5	4545	P625	D ₁ Ø20 D ₂ Ø15.1				
	NFSL5	4590	P628					
Angled	HFS45A5	45	P630	D ₁ Ø20 D ₂ Ø15.1				
	HFS45A5	45	P630					
	HFS60A5	45	P630					
Black Anodize	HFSB5	4545	P625	D ₁ Ø20 D ₂ Ø15.1				
	EF5B5	4590	P628					
	NEFSB5	50100	P632					
Curved	HFSR5	4545	P627	D ₁ Ø20 D ₂ Ø15.1				
	NFSR5	909045	P630					

Standard of Extrusion Position

Placing method of the extrusion, which is a basis to determine right and left is shown as follows.

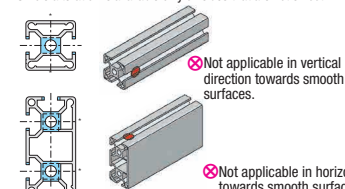
- On the vertical length
- Flat side down



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

Notes on Extrusions with Flat (smooth) Sides

S Hole alteration is available only on sides that are not smooth.



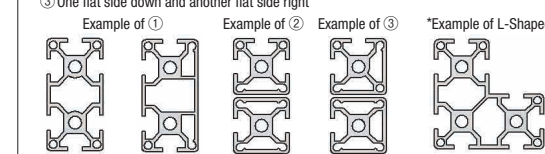
Notes on Large Extrusions and L-sectioned Extrusions

Maximum length available for S Holes is 100mm. Not available in the direction over 100mm for large extrusions such as 30120. S Hole alteration on L-sectioned extrusions is not possible, irrespective of directions.

Standard of Extrusion Position

Placing method of the extrusion, which is a basis to determine right and left is shown as follows.

- On the vertical length
- Flat side down
- One flat side down and another flat side right



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

Notes on Extrusions with three slots, M holes cannot be drilled on the center slot.

