

# RECOMMENDED VELMEX XSLIDE™ CLEAT PLACEMENT



*XSlide mounted to a flat metal surface using the XMC-2 standard cleat adds support and stability while operating.*

The XSlide™ Assembly base should be mounted with Velmex XMC-2 cleats to a reasonably flat surface. Inaccuracies and binding can result if mounted to non-flat surfaces. Mounting surface should be metal and have 6-32 UNC threaded holes with a minimum thread depth of 0.15”

Refer to the XSlide User’s Manual and the chart below for cleat placement. Use cleats in pairs with a pair 0.6” from each end to first mounting hole. All other cleats should be equally spaced between them. Use more cleats for heavy off-center (cantilever) loads and for more rigidity.

Attach cleats with Velmex XMB-1 bolts or equal grade 8 bolts. Start with bolts finger tight and then tighten bolts, progressively alternating sides and diagonals. Finish by tightening bolts to 17 in-lbs.

*Thread locking compound (Loctite ) is recommended for all mounting bolts.*



*Four XSlide cleats are available: standard, sandwich, cross cleat and an optical cleat. Pictured is the standard cleat used to mount an XSlide to a base or to another XSlide carriage. Each pair has 190 lbs. of holding capability.*

## Recommended Cleats for Velmex Single-Axis XSlide™ Assembly

Design				Lighter Loads			Heavier Loads		
Travel	Travel	Length	Length	# Cleat*	Spacing	Spacing	# Cleat*	Spacing	Spacing
(inches)	(cm)	(inches)	(cm)		(inches)	(cm)		(inches)	(cm)
2	5.08	4.5	11.43	4	2.57	6.528	4	2.57	6.528
4	10.16	6.5	16.51	4	4.57	11.608	6	2.285	5.804
6	15.24	8.5	21.59	4	6.57	16.688	6	3.285	8.344
8	20.32	10.5	26.67	6	4.285	10.884	8	2.857	7.256
12	30.48	14.5	36.83	6	6.285	15.964	10	3.143	7.982
18	45.72	20.5	52.07	6	9.285	23.584	12	3.714	9.434
24	60.96	26.5	67.31	8	8.19	20.803	14	4.095	10.401
30	76.2	32.5	82.55	10	7.643	19.412	16	4.367	11.093

\* Total number of cleats. (Cleats are used in pairs; one each side of the slide.)