

# Alterations for Aluminum Extrusions - Overview / Labeling Service / Chamfering Alterations

(Applicable Extrusion: P.529 ~ P.690)

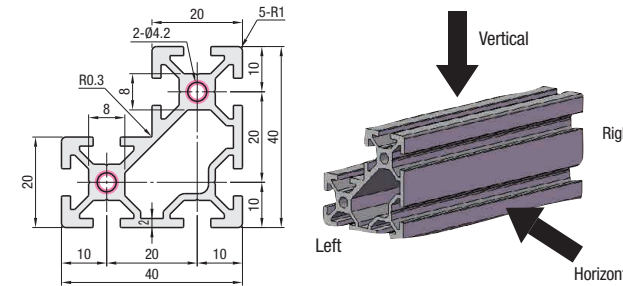
MISUMI Aluminum Extrusion products can be utilized for structure building with highly enhanced design flexibility when available alteration options are applied. Some alterations are not applicable depending on extrusion types and sizes. Check for the available alterations on each product page price lists. The hyphens (-) in the price lists denote the unavailable items.

Type	Alterations	Page	Alteration Codes	App. Example	Contents
End Tapping	End Tapping (Center Hole)	P.757	LTP/RTP/TPW LHP/RHP/HPW		Adds tapped holes on extrusion ends. Blind Joints which require this alteration • Screw Joints P.552, 603, 660, 706 • Simple Joints P.604
	End Tapping (4 Side Holes)	P.768	LSP/RSP/SPW		Adds tapped holes on extrusion corner ends.
Cutting Method Change	High Precision Cut	P.758	SC		Applies High Precision Cut with an overall length tolerance of (Standard=L±0.5)→L±0.2 * Only applicable to L≤1500
	45-Degree Cut	P.758	L□T45/R□T45		Cuts with 45-degree angle.
Drill Wrench Hole	Wrench Hole in Fixed Position	P.759	LWP/RWP		Wrench access hole(s) for Blind Joints are drilled. The hole location will be aligned with the mating extrusion's tapped hole location. Blind Joints which require this alteration • Screw Joints P.552, 603, 660, 706 • Single Joints P.609, 661, 707 • Tapping Joints P.552, 602, 660
	Hole Position Change for Extrusion End Cap Thickness	P.760	FL/FR		Offsets the wrench access hole for the thickness of Extrusion End Cap (3mm). The extrusion end cap will be flat with the adjacent extrusion surface.
	Wrench Hole in Specified Position	P.761	AH/BH/AV/BV		Adds a wrench hole in a desired position from the left end. Use for Blind Jointing in beam sections, etc.
Counterboring	Counterbores in Specified Position	P.763	Z6/XA100		Adds a counterbored hole in a desired position from the left end. Can be used for connecting extrusions or installing tables, etc.
Blind Joint Dedicated Holes	D Hole	P.764	LDH/RDH		Adds required holes for Single Joint connections. (Single Joints P.609, 661, 707)
	S Hole	P.765	LSH		Adds required holes for Pre-Assembly, Insertion Double Joint connections. (Pre-Assembly Insertion Double Joints P.611, 663, 709)
	M Hole	P.766	LMH		Adds required holes for Post-Assembly Insertion Double Joints, Center Joint connections. (Post-Assembly Insertion Double Joints P.554, 607, 664, 710)
	L Hole	P.767	JLP		Adds required holes for Parallel Joint connections. (Parallel Joints P.554, 613, 664)

Type	Alterations	Page	Alteration Codes	App. Example	Contents
Special Extrusions End Plates Mounting	GFS Series End Tapping	P.768	LTS/RTS/TSW		Adds tapped holes on extrusion ends. Blind Joints which require this alteration • Screw Joints P.552, 603, 660, 706 • Simple Joints P.604
	HFSR End Tapping	P.768	LTS/RTS/TSW		Necessary alteration to use Ends Protection Plates for HFSR series on P.555, 568, 615, 628.
Chamfering	End Face C Chamfering	See Below	CW		Adds C Chamfering on extrusion ends.
Labeling	Labeling	See Below	ZZZ		Adds a sticker with catalog No. etc. on the aluminum extrusions. Although number of characters are limited, customer's own serial number or unit number can be labeled.

## Standard of Extrusion Position and Indications

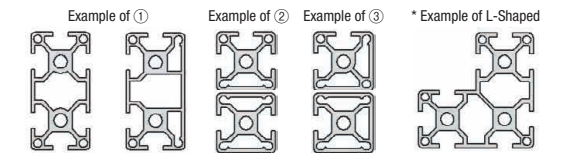
For some hole alterations, specifying of "Which end (L or R) to apply the alterations" and "Which direction (horizontal or vertical) to apply the alterations" will be required. Using our standard specifying method for orientation, then L/R and H/V are determined as shown below.



## 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.

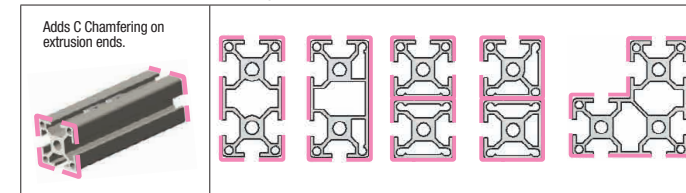
## LR (Left and Right of Extrusions):

Place extrusions properly, then determine the right and left. Since most extrusion cross sections are symmetrical and can be used in any orientation. However, please specify the L/R parameters in your orders for administrative purposes. Extrusions ① with different alterations applied on left and right ends, and ② with non-symmetrical cross sections are not reversible therefore the L/R specifications will become critically important.

## HVP (Horizontal / Vertical / Cross):

Specify the hole alterations with the extrusion properly oriented, and according to the connection method with the mating extrusion.

## End Face C Chamfering



\* Not applicable to Aluminum Extrusions with Parallel Surfacing, Aluminum Extrusions 15mm Square

Alteration	Code	Spec.
End Face C Chamfering	CW	Adds C Chamfering on both extrusion ends. (Thread Chamfering C0.2 ~ 0.3)

Ordering Example: Part Number HFS6 - 3030 - 500 - CW

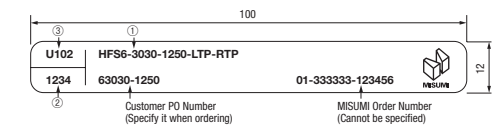
## Labeling on Aluminum Extrusions

Adds a sticker with catalog No. etc. on the aluminum extrusion. (Free of Charge)  
When placing an order, please add:

- a serial number of four digits beginning with -ZZZ
- Specify a unit number of 3 digits or less beginning with -U.

(Ex.) HFS6-3030-1250-LTP-RTP-ZZZ1234-U102

① Part Number      ② Serial Number      ③ Unit Number



## Detailed Specs

Please specify the serial number by 1 digit or more.  
Make ③ blank if the unit number is not specified.  
If Part Number exceeds 41 digits, "... " follows from the 42nd digit.  
If Customer PO Number exceeds 21 digits, "... " follows from the 22nd digit.

