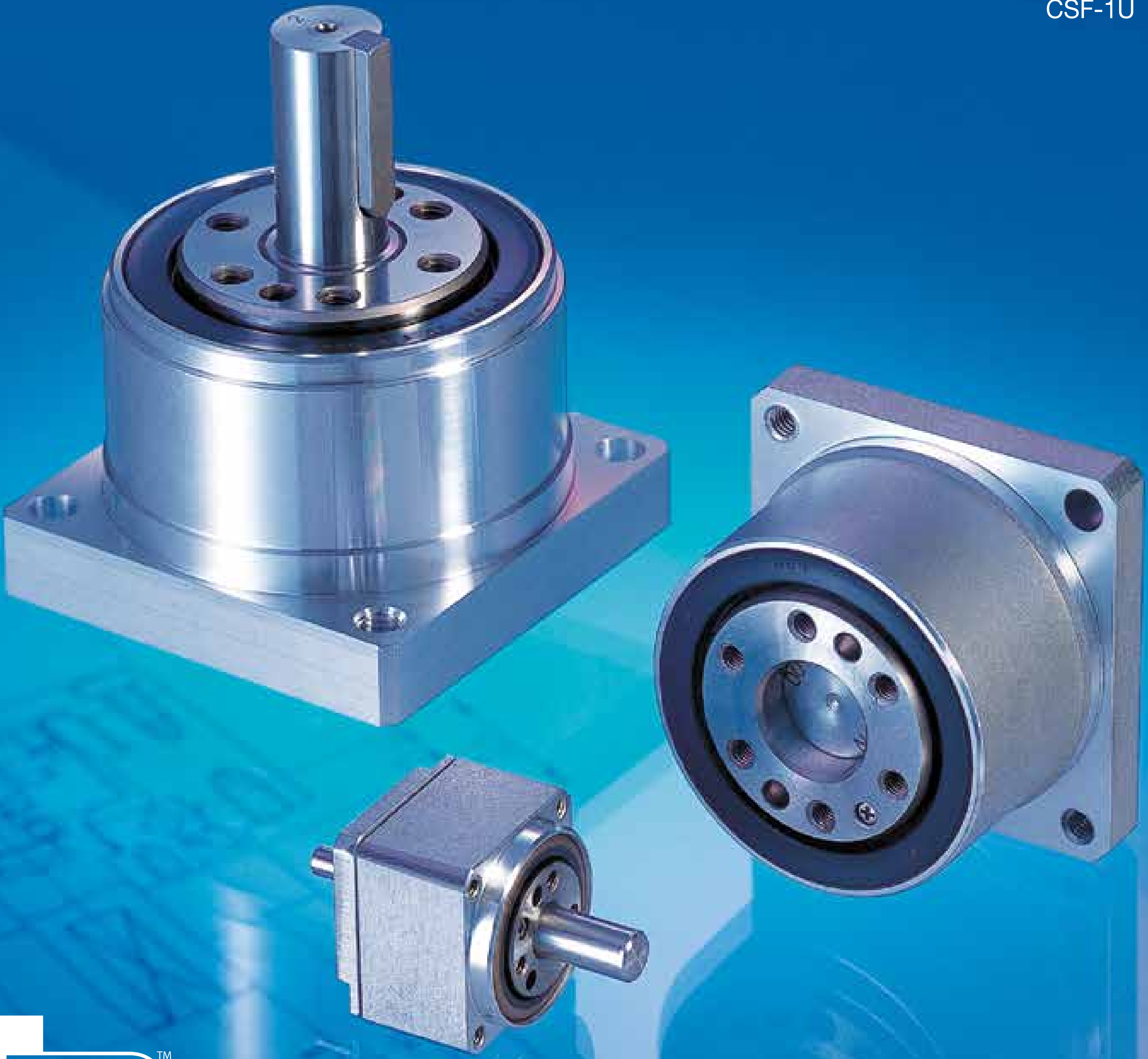
Miniature Gearheads

Harmonic Drive® Gearheads
CSF Mini Series

CSF-2XH-F
CSF-2XH-J
CSF-1U

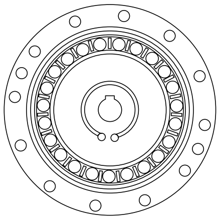


HARMONIC DRIVE

Total Motion Control

Harmonic Drive® gear

Precision Gearing and Motion Control



Harmonic Drive® precision gear is the next generation in precision motion control.

Harmonic Drive® Precision Control Speed Reducers for compact models
are available in this CSF Mini Series.

Future

Zero-Backlash, High Positional Accuracy, High Repeatability

The innovative design of Harmonic Drive® precision gear allows consistently high performance over the life of the gear.

Compact, Lightweight, High Torque Capacity

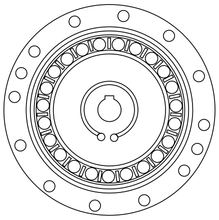
Harmonic Drive LLC' patented "S" gear tooth profile achieves twice the torque, life and torsional stiffness as compared to gears of the same size by allowing up to 30% of the gear teeth to be engaged at all times.

Compact 4-Point Contact Ball Bearing Mounted In Main Shaft

A high performance 4-point contact output bearing supports the output flange/shaft. This bearing has excellent run-out characteristics and can support high radial, axial and moment loads.

Wide Range Of Gear Ratios And Input/Output Configurations In Each Size

Gear Ratios 30:1, 50:1, and 100:1 are available in each size. This allows servomotor and gearhead combinations to operate over a wide speed range. In addition, each size has 3 input/output shaft/flange configurations allowing convenient methods for attaching loads, motors, and pulleys.



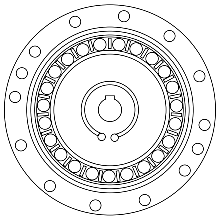
CONTENTS

About Harmonic Drive® Gear
Principle and Structure 04
Driving Configuration 05
Application Example 06
Ordering Information Model and Code 06
Rating Table 07
Definition of Ratings 07
Strength and Life 08
Selection Procedure 09
Selection Example 10

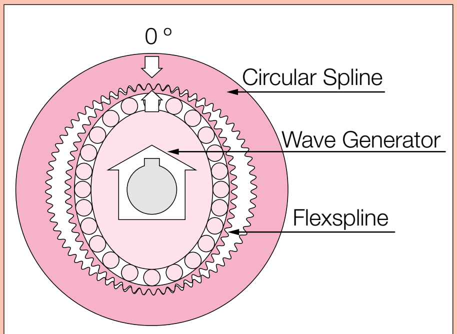
Unit Type CSF-mini
External Dimensions 11
Specification for Cross Roller Bearing 12
Output Bearing Ratings 13
Specifications of Output Bearings 14

Engineering Data
Efficiency 15
No Load Running Torque 17
Starting Torque and Backdriving Torque 19
Positioning Accuracy 19
Torsional Stiffness 20
Recommended Tolerance for Assembly 22
Performance Data for Input Bearing 23
Installation of Case Side 24
Tolerances for Assembly 25

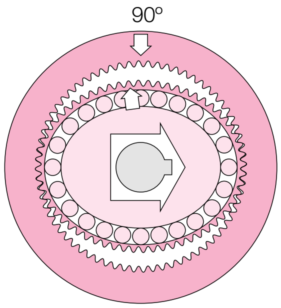
Warranty and Safety
Warranty 25
Safety Guide 26



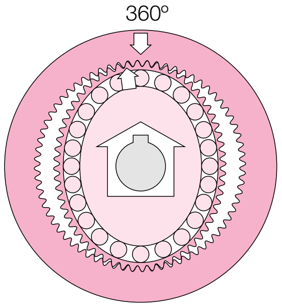
About Harmonic Drive® strain wave gear principle and structure



The Flexspline is elliptically shaped by The Wave Generator and engaged with the Circular Spline at the major elliptical axis. The teeth completely disengage on the minor axis.



When the Circular Spline is fixed and the Wave generator rotates clockwise, the Flexspline is elastically deformed and rotates counterclockwise relative to the Circular Spline.



For each 360 degrees clockwise movement of the Wave Generator,the Flexspline moves counterclockwise by two teeth relative to the Circular Spline.

System Components

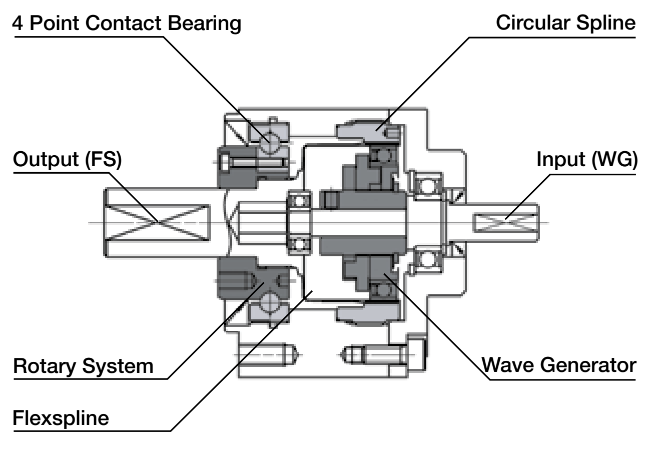
The Wave Generator: A thin raced ball bearing fitted onto an elliptical plug serving as a high efficiency torque converter.

The Flexspline: A non-rigid, thin cylindrical cup with external teeth on a slightly smaller pitch diameter than the Circular Spline. It fits over and is held in an elliptical shape by the Wave Generator.

The Circular Spline: A rigid ring with internal teeth, engaging the teeth of the Flexspline across the major axis of the Wave Generator.

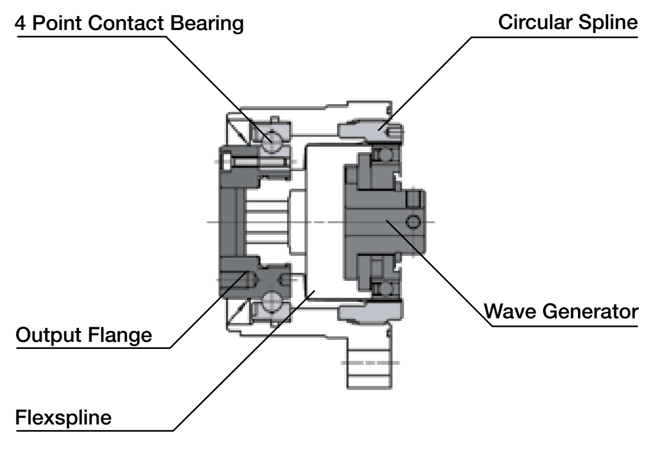
GEARHEAD TYPE (IU)

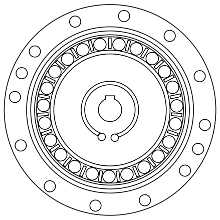
This gearhead is easy to use and has both an input and output shaft. It also allows for pulleys to be used for the input and output to the gearhead.



GEARHEAD TYPE (2XH)

This gearhead is designed to be coupled directly to a servo-motor. It is available in 2 models. 2XH-F:Direct input coupling/ output Flange. 2XH-J: Direct input coupling/output Shaft.



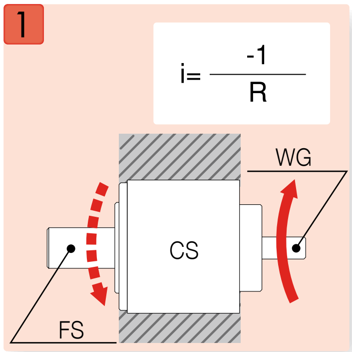


DRIVING CONFIGURATIONS

Driving Configurations

A variety of different driving configurations are possible, as shown below. The reduction ratio given in the tables on page 10 and 11 correspond to arrangement 1, in which the Wave Generator acts as the input element, the Circular Spline is fixed and the Flexspline acts as the output element.

$$\text{Ratio} = \frac{\text{input speed}}{\text{output speed}}$$



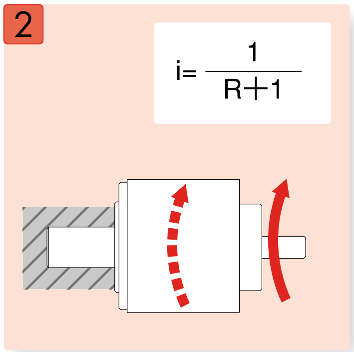
$$i = \frac{-1}{R}$$

1. Reduction Gearing

CS	Fixed
WG	Input
FS	Output

$$\text{Ratio} = -\frac{R}{1} \qquad \text{[Equation 1]}$$

Input and output in opposite direction.



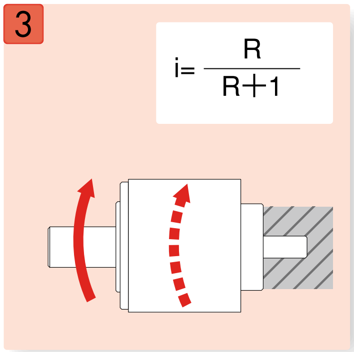
$$i = \frac{1}{R+1}$$

2. Reduction Gearing

FS	Fixed
WG	Input
CS	Output

$$\text{Ratio} = \frac{R+1}{1} \qquad \text{[Equation 2]}$$

Input and output in same direction.



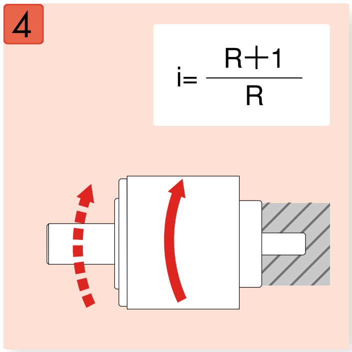
$$i = \frac{R}{R+1}$$

3. Reduction Gearing

WG	Fixed
FS	Input
CS	Output

$$\text{Ratio} = \frac{R+1}{R} \qquad \text{[Equation 3]}$$

Input and output in same direction.



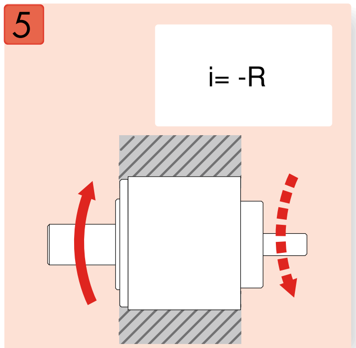
$$i = \frac{R+1}{R}$$

4. Speed Increaser Gearing

WG	Fixed
CS	Input
FS	Output

$$\text{Ratio} = \frac{R}{R+1} \qquad \text{[Equation 4]}$$

Input and output in same direction.



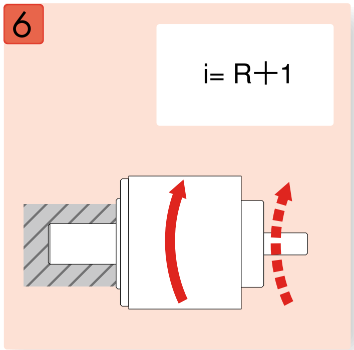
$$i = -R$$

5. Speed Increaser Gearing

CS	Fixed
FS	Input
WG	Output

$$\text{Ratio} = -\frac{1}{R} \qquad \text{[Equation 5]}$$

Input and output in opposite direction.



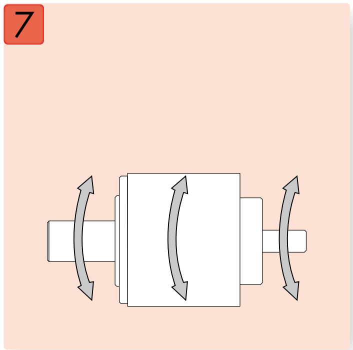
$$i = R+1$$

6. Speed Increaser Gearing

FS	Fixed
CS	Input
WG	Output

$$\text{Ratio} = \frac{1}{R+1} \qquad \text{[Equation 6]}$$

Input and output in same direction.



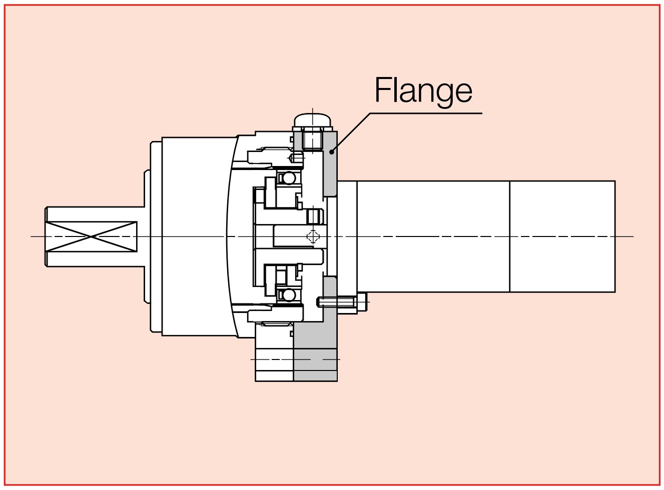
7. Differential Gearing

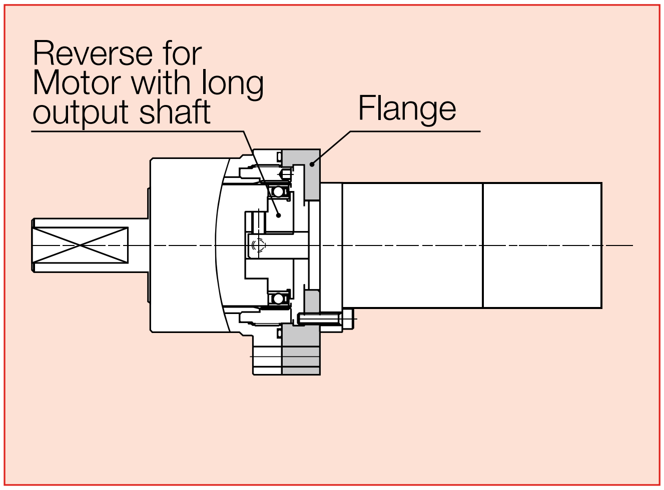
WG	Control Input
CS	Main Drive-Input
FS	Main Drive-Output

Numerous differential functions can be obtained by combinations of the speed and rotational direction of the three basic elements. [Equation 7]

APPLICATION EXAMPLE

Application for 2XH





Motor Matching Table

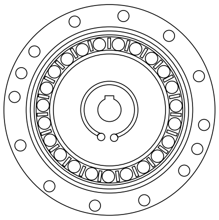
Table 1

Manufacturer	Yaskawa / ΣMini-Series				Mitsubishi / HC-AQ Series			Matsushita minas
Motor Capacity	3W-5W	10W	20W	30W	10W	20W	30W	30W
CSF-5-2X	●							
CSF-8-2XH		●			●			
CSF-11-2XH			●	●		●	●	●
CSF-14-2XH				●			●	●

ORDERING INFORMATION

CSF	-	14	-	100	-	2XH - F	-	SP
Name of Model		Size		Gear Ratio		Model		SP

Name	Size	Gear Ratio	Model	SP
CSF	5	30, 50, 100	1U 2XH-F 2XH-J	Customized specification (special) shape and performance
	8	30, 50, 100		
	11	30, 50, 100		
	14	30, 50, 80, 100		

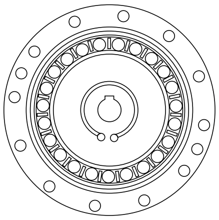


RATING TABLE

Rating Table

Table 2

Size	Gear Ratio	Rated Torque at 2000rpm		Repeated peak torque		Max. average load torque		Max. momentary torque		Max. Input Speed	Avg. Input Speed	Moment of Inertia(1/4 GD)^2	
		Nm	in.lb	Nm	in.lb	Nm	in.lb	Nm	in.lb	rpm	rpm	1U kgcm^2	2XH kgcm^2
5	30	0.25	2	0.5	4	0.38	3	0.9	8	10,000	6,500	$2.5x10^{-4}$	$2.5x10^{-4}$
	50	0.4	4	0.9	8	0.53	5	1.8	16				
	100	0.6	5	1.4	12	0.94	8	2.7	24				
8	30	0.9	8	1.8	16	1.4	12	3.3	29	8,500	3,500	$3.0x10^{-3}$	$3.2x10^{-3}$
	50	1.8	16	3.3	29	2.3	20	6.6	58				
	100	2.4	21	4.8	42	3.3	29	9.0	80				
11	30	2.2	19	4.5	40	3.4	30	8.5	75	8,500	3,500	$1.2x10^{-2}$	$1.4x10^{-2}$
	50	3.5	31	8.3	73	5.5	49	17	150				
	100	5.0	44	11	97	8.9	79	25	221				
14	30	4.0	35	9.0	80	6.8	60	17	150	8,500	3,500	$3.3x10^{-2}$	$3.4x10^{-2}$
	50	5.4	48	18	159	6.9	61	35	310				
	80	7.8	69	23	204	11	97	47	416				
	100	7.8	69	28	248	11	97	54	478				



TECHNICAL TERMS

Definition of Ratings

Rated Torque (Tr)

Rated torque indicates allowable continuous load torque at 2000 rpm input speed.

Limit for Repeated Peak Torque (figure 1)

During acceleration a deceleration the Harmonic Drive® gear experiences a peak torque as a result of the moment of inertia of the output load.

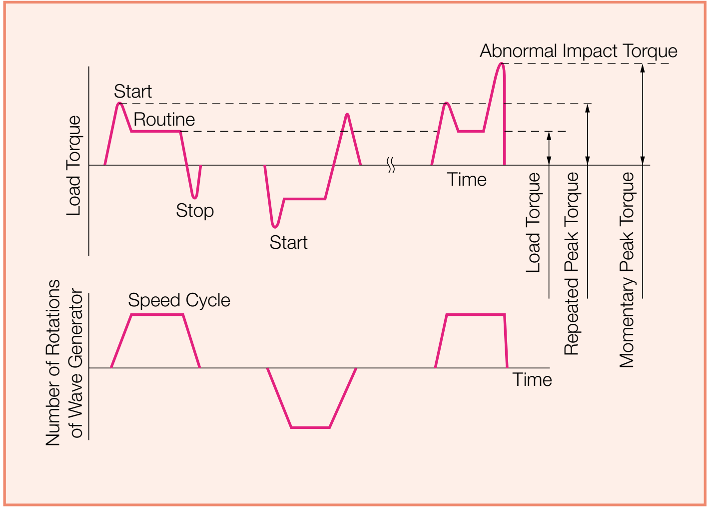
Limit for Average Torque

In cases where load torque and input speed vary, it is necessary to calculate an average value of load torque. The table indicates the limit for average torque. The average torque calculated must not exceed this limit.

Limit for Momentary Peak Torque (figure 1)

The gear may be subjected to momentary peak torques in the event of a collision or emergency stop. The magnitude and frequency of occurrence of such peak torques must be kept to a minimum and they should, under no circumstance, occur during normal operating cycle. The allowable number of occurrences of the momentary peak torque may be calculated by using equation 8 on page 8.
Also see section “strength and life”.

Figure 1

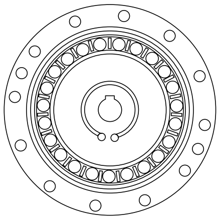


Maximum Input Speed, Limit for average input speed

Do not exceed the allowable rating.

Moment of Inertia

The rating indicates the moment of inertia reflected to the wave generator (gear input).



STRENGTH AND LIFE

Strength and Life

The non-rigid Flexspline is subjected to repeated deflections, and its strength determines the torque capacity of the Harmonic Drive® gear. The values given for Rated Torque at Rated Speed and for the allowable Repeated Peak Torque are based on an infinite fatigue life for the Flexspline.

The torque that occurs during a collision must be below the momentary peak torque (impact torque). The maximum number of occurrences is given by the equation below.

[Equation 8]

$$N = \frac{1.0 \text{ X } 10^4}{2 \text{ X} \frac{n}{60} \text{X } t}$$

n: Input speed before collision

t: Time interval during collision

Please note:
If this number is exceeded, the Flexspline may experience a fatigue failure.

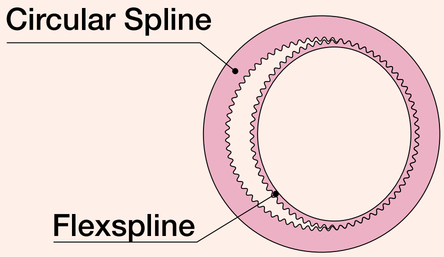
Ratcheting phenomenon

When excessive torque is applied while the gear is in motion, the teeth between the Circular Spline and Flexspline may not engage properly. This phenomenon is called ratcheting and the torque at which this occurs is called ratcheting torque. Ratcheting may cause the Flexspline to become non-concentric with the Circular Spline.
(See figure 2 and 3 on page 8) Operating in this condition may result in shortened life and a Flexspline fatigue failure.

Note!

When ratcheting occurs, the teeth mesh abnormally as shown above. Vibration and Flexspline damage may occur. Once ratcheting occurs, the teeth wear excessively and the ratcheting torque may be lowered.

Figure 2



This condition is called “dedoidal”.

Table 3 Ratcheting Torque Nm

Size	Gear Ratio			
	30	50	80	100
5	2.7	3.2	–	3.5
8	11	12	–	14
11	29	34	–	43
14	59	88	110	84

Buckling Torque Nm

Size	All Ratio
5	9.8
8	35
11	90
14	190

The Life of a Wave Generator

The normal life of a gear is determined by the life of the wave generator bearing. The life may be calculated by using the input speed and the output load torque.

Rated Lifetime

Ln : (n = 10 or 50)

L10	CSF : 7,000	CSG: 10,000
L50	CSF : 35,000	CSG : 50,000

Equation for the expected life of the wave generator under normal operating conditions is given by the equation below.

[Equation 9]

$$Lh = Ln \bullet \left(\frac{Tr}{Tav}\right)^3 \bullet \left(\frac{Nr}{Nav}\right)$$

Lh : Expected Life, hours

Ln : Rated Lifetime at L10 or L50

Tr : Rated Torque (Table 2)

Nr : Rated input speed (2000 rpm)

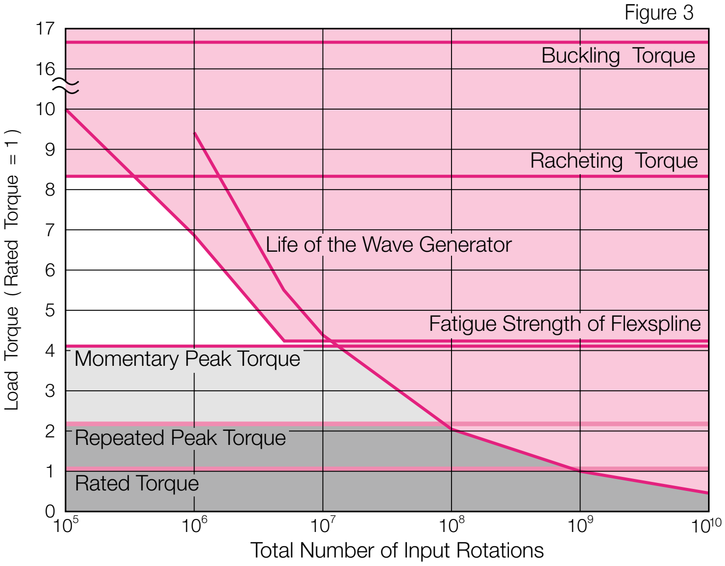
Tav : Average load torque on output side (page 9)

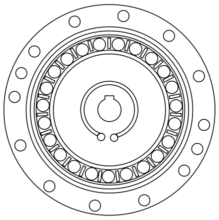
Nav : Average input speed (page 9)

Relative Torque Rating

The chart below shows the various torque specifications relative to rated torque. Rated Torque has been normalized to 1 for comparison.

Figure 3





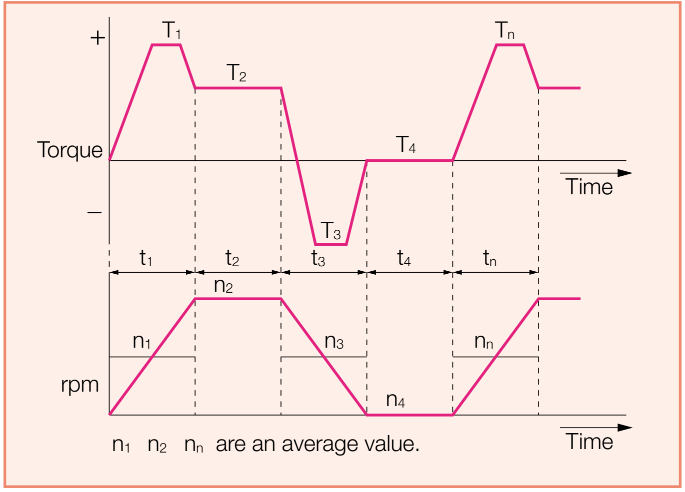
Size Selection

Generally, the operating conditions consist of fluctuating torques and output speeds. Also, an unexpected impact output torque must be considered.

The proper size can be determined by converting fluctuating load torque into average load torque and equivalent load torque. This procedure involves selecting the size based on load torque for component sets.

This procedure does not consider the life of the output bearing for housed units. Determining the life of the output bearing for various axial, radial, and moment loads is outlined on page 12.

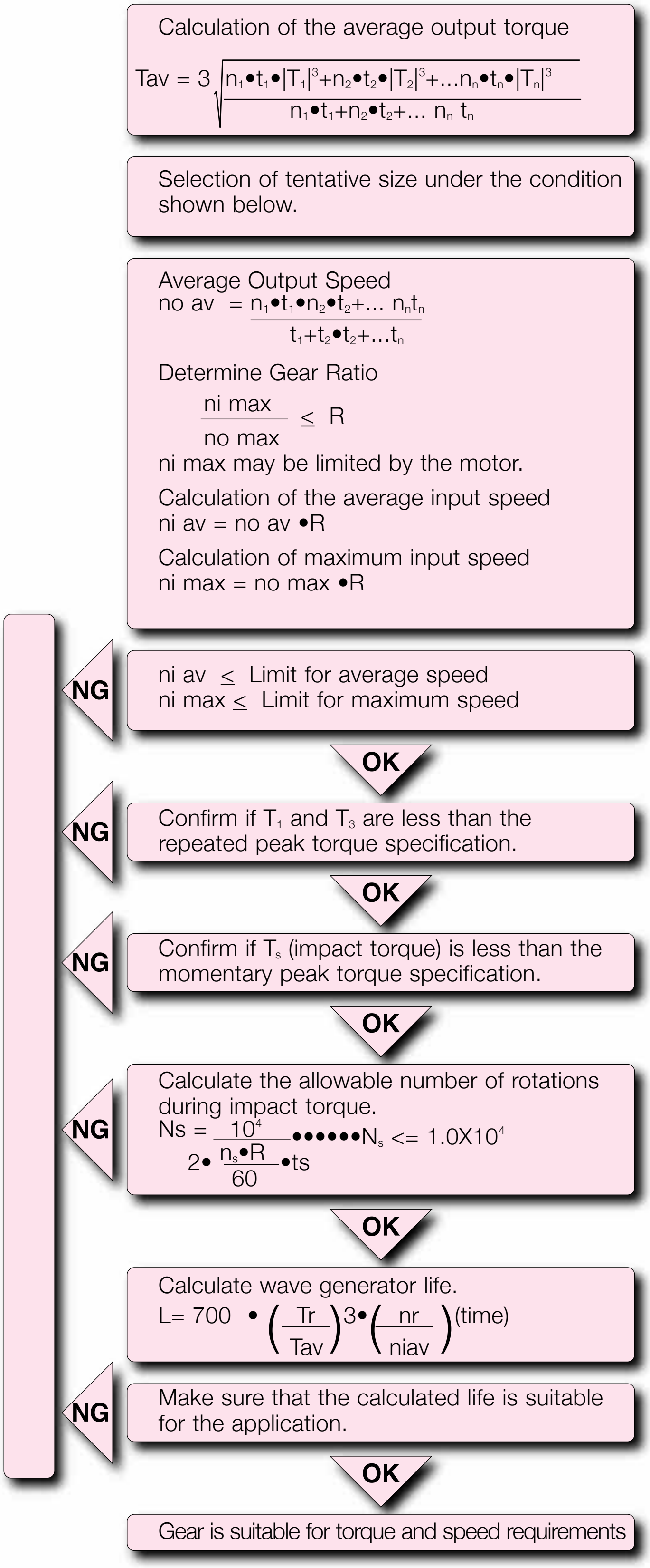
Figure 4



Parameters	
Load Torque	Tn (Nm)
Time	tn (sec)
Output Speed	nn (rpm)
Normal Operating Pattern	
Acceleration	T_1,t_1, n_1
Regular Operation	T_2,t_2, n_2
Deceleration	T_3,t_3, n_3
Dwell	T_4,t_4, n_4
Maximum RPM	
Max output speed	no maximum
Max input speed	ni maximum
Impact Torque	T_s,t_s, n_s
Ratings	
Rated Torque	Tr
Rated Speed	nr =2000 rpm
Life	L_{10}=L(hrs)

Flow Chart for Selecting a Size

Please use the flowchart shown below for selecting a size. Operating conditions must not exceed the performance ratings as described on page 7.



Calculation of the average output torque

$$Tav = \sqrt[3]{\frac{n_1 \bullet t_1 \bullet |T_1|^3 + n_2 \bullet t_2 \bullet |T_2|^3 + \ldots n_n \bullet t_n \bullet |T_n|^3}{n_1 \bullet t_1 + n_2 \bullet t_2 + \ldots\ n_n\ t_n}}$$

Selection of tentative size under the condition shown below.

Average Output Speed

$$no\ av = \frac{n_1 \bullet t_1 \bullet n_2 \bullet t_2 + \ldots\ n_n t_n}{t_1 + t_2 \bullet t_2 + \ldots t_n}$$

Determine Gear Ratio

$$\frac{ni\ max}{no\ max} \leq R$$

ni max may be limited by the motor.

Calculation of the average input speed
ni av = no av •R

Calculation of maximum input speed
ni max = no max •R

ni av $\leq$ Limit for average speed
ni max $\leq$ Limit for maximum speed

Confirm if T_1 and T_3 are less than the repeated peak torque specification.

Confirm if T_s (impact torque) is less than the momentary peak torque specification.

Calculate the allowable number of rotations during impact torque.

$$Ns = \frac{10^4}{2 \bullet \frac{n_s \bullet R}{60} \bullet ts} \bullet\bullet\bullet\bullet\bullet\bullet N_s <= 1.0X10^4$$

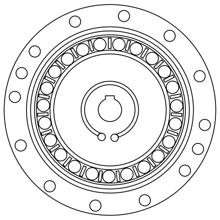
Calculate wave generator life.

$$L = 700 \bullet \left(\frac{Tr}{Tav}\right)^3 \bullet \left(\frac{nr}{niav}\right)(time)$$

Make sure that the calculated life is suitable for the application.

Gear is suitable for torque and speed requirements

Also consider output bearing, environment, etc.



SELECTION EXAMPLE

Values of an each Load Torque Pattern

Load Torque	T_n (Nm)
Time	t_n (sec)
Output Speed	n_n (rpm)

Maximum Speed

output max speed no max = 16 rpm

input max speed ni max = 1800 rpm
(limited by motor)

Normal Operating Pattern

Acceleration	T_1 = 19 Nm,	t_1 = 0.4 sec,	n_1 = 8 rpm
Regular Operation Stop	T_2 = 2 Nm,	t_2 = 4 sec,	n_2 = 16 rpm
Deceleration	T_3 = 19 Nm,	t_3 = 0.4 sec,	n_3 = 8 rpm
Dwell	T_4 = 0 Nm,	t_4 = 0.2 sec,	n_4 = 0 rpm

Impact Torque

T_s = 50 Nm, ts = 0.15 sec, n_s = 12 rpm

Life Required

L_{10} = 7000 hrs.

Tav (Nm)

$$Tav = \sqrt[3]{\frac{8rpm \cdot 0.4sec \cdot |19Nm|^3 + 16rpm \cdot 4sec \cdot |2Nm|^3 + 8rpm \cdot 0.4sec \cdot |19Nm|^3}{8rpm \cdot 0.4sec + 16rpm \cdot 4sec + 8rpm \cdot 0.4sec}}$$

Tav =8.6Nm ≤ 11Nm (for CSF-14-100-2XH)

no av (rpm)

$$no\ av = \frac{8rpm \cdot 0.4sec + 16rpm \cdot 4sec + 8rpm \cdot 0.4sec}{0.3sec + 3sec + 0.4sec + 0.2sec} = 14rpm$$

(R)

$$\frac{1800\ rpm}{14\ rpm} = 129 \geq 100$$

n_i av = 14 rpm •100 = 1400 rpm

n_o max ni max (rpm)

n_i max = 16 rpm •100 = 1600 rpm

n_i av =1000rpm ≤ 3500 rpm (for CSF-14-100-2XH)

n_i max=1600rpm ≤ 8500 rpm (for CSF-14-100-2XH)

OK

Confirm that T1 and T3 are within a

T_1 ,T_3 (Nm)

T_1 =19Nm ≤ 28Nm (for CSF-14-100-2XH)

T_3 =19Nm ≤ 28Nm (for CSF-14-100-2XH)

OK

T_s (Nm)

T_s = 500Nm ≤ 54Nm (for CSF-14-100-2XH)

OK

(N_s) Calculate an allowable number of rotation(Ns) and confirm ≤ 1.0 x 10^4

$$N_S = \frac{10^4}{2 \cdot \frac{16rpm \cdot 100}{60} \cdot 0.15sec} = 1250 \leq 1.0X10^4$$

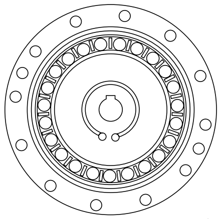
OK

$$L_{10} = 7000 \cdot \left(\frac{7.8\ Nm}{8.6\ Nm}\right)^3 \cdot \left(\frac{2000\ rpm}{1400\ rpm}\right)$$

L_{10} =7460≥7000 (L_{B10})

OK

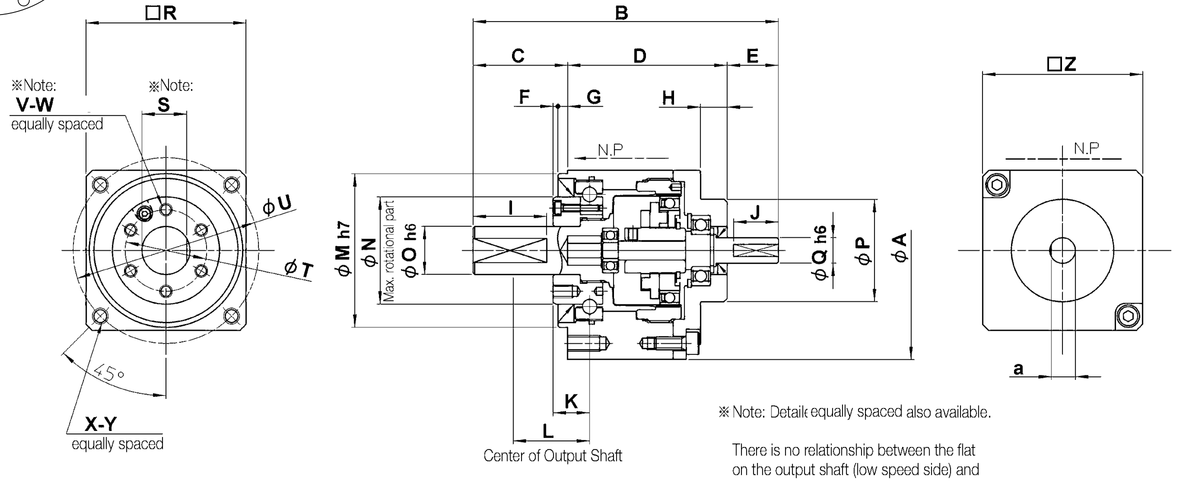
CSF-14-100-2XH



EXTERNAL DIMENSIONS

Compact Double Shaft Type 1U

This gearhead is easy to use and has both an input and output shaft.



※Note: Detail equally spaced also available.

There is no relationship between the flat on the output shaft (low speed side) and the location of V-W tapped holes.

Table 4

Symbol \ Size	5	8	11	14
øA	26.5	40	54	68
B	37	65.5	82.5	95.4
C	13	23	29.5	29.5
D	16	29.5	37	49.9
E	8	13	16	16
F	0.5	0.5	0.5	1.5
G	2.5	2.5	3	3
H	0.8	2.6	3.9	8.4
I	9	18	21.5	23
J	7	11	14	14

Table 5

Symbol \ Size	5	8	11	14
K	4.85	7.3	9	11.4
L	9.85	17.3	22	23.9
øM h7	19.5	29	39	48
øN	13	20	26.5	33.5
øO h6	5	9	12	15
øP	9	16	24	32
øQ h6	3	5	6	8
□R	20.4±0.42	30.7±0.46	40.9±0.50	51.1±0.50
S	4.6	8	10.5	14
øT	9.8	15.5	20.5	25.5

Table 6 m

Symbol \ Size	5	8	11	14
øU	23	35	46	58
V	3	4	6	6
W	M2X3	M3X4	M3X5	M4X6
X	4	4	4	4
Y	M2X3	M3X6	M4X8	M5X10
□Z	20±0.42	30±0.46	40±0.50	50±0.50
a	2.6	4.5	5.5	7.5
weight(g)	35	130	240	440

Gearhead Type 2XH-F

This gearhead is designed to be coupled directly to a servomotor. The motor shaft is attached directly to the gearhead input element. The output of the gearhead is a flange.

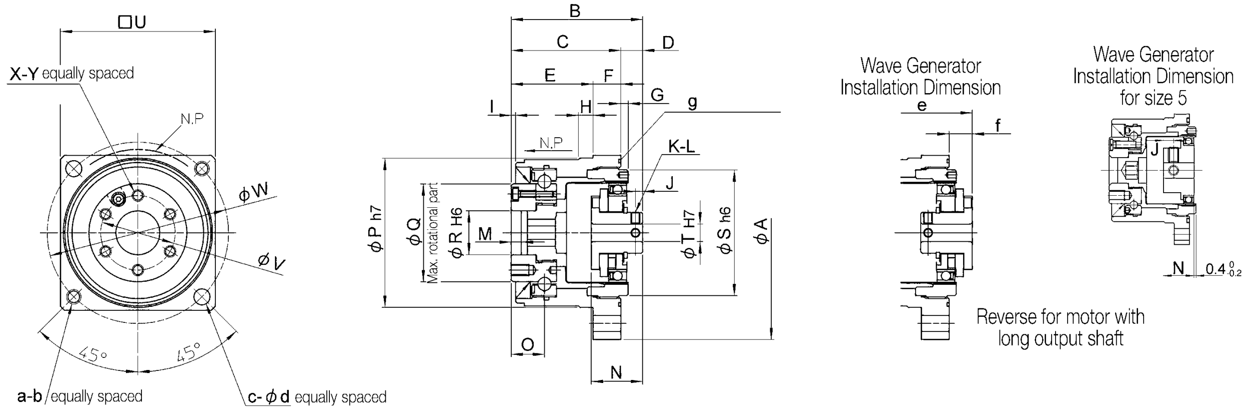


Table 7

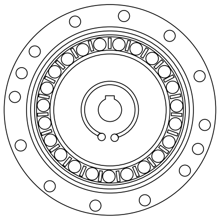
Symbol \ Size	5	8	11	14
øA	29	43.5	58	73
B	17	31	38.3	45
C	15.7	24.5	30	37.5
D	–	$6.5^{0}_{-0.3}$	$8.3^{0}_{-0.7}$	$7.5^{0}_{-0.8}$
E	12.7	19	23.5	28
F	3	5.5	6.5	9.5
G	1.3	1.5	2	2.5
H	2	3	3	5
I	0.5	0.5	0.5	1.5
J	2	2	3	2.5
K	2	2	2	2

Table 8

Symbol \ Size	5	8	11	14
L	M2X3	M2X3	M3X4	M3X4
M	1.7	2.2	2.5	3.5
N	6	12	16	17.6
O	4.85	7.3	9	11.4
øP h7	20.5	31	40.5	51
øQ	13	20	26.5	33.5
øR H6	5	9	12	15
øS h6	17	26	35	43
øT H7	3	3	5	6
□øU	22±0.42	30±0.46	43±0.50	53±0.50
øV	9.8	15.5	20.5	25.5

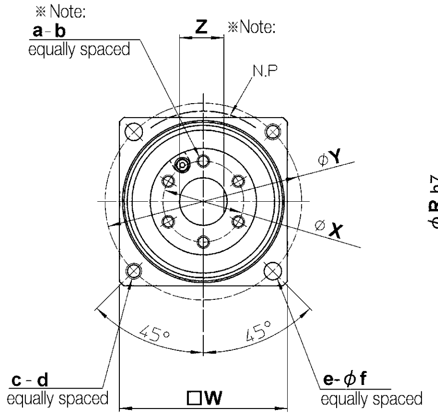
Table 9 mm

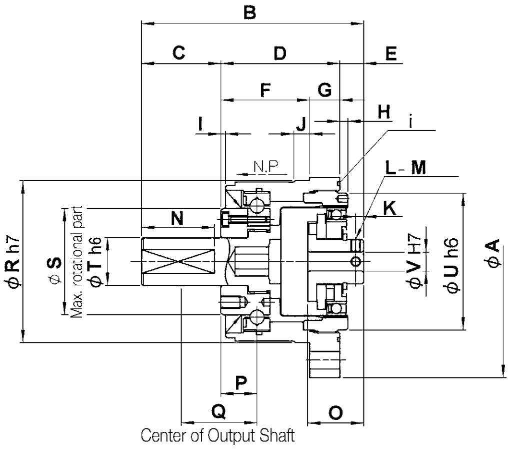
Symbol \ Size	5	8	11	14
øW	25	37.5	50	62
X	3	4	6	6
Y	M2X3	M3X4	M3X5	M4X6
a	2	2	2	2
b	M2	M3	M4	M5
c	2	2	2	2
ød	2.3	3.4	4.5	5.5
e	–	28.7	36.1	45.4
f	–	$4.2^{0}_{-0.3}$	$6.1^{0}_{-0.7}$	$7.9^{0}_{-0.8}$
g	18.90±0.70	28.20±1.00	38.00±1.50	48±1.00
weight(g)	25	100	150	295



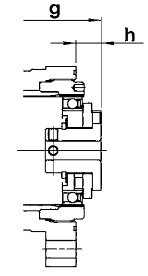
EXTERNAL DIMENSIONS & OUTPUT BEARING RATINGS

Gearhead Type 2XH-J This gearhead is designed to be coupled directly to a servomotor. The motor shaft is attached directly to the gearhead input element. The output of the gearhead is a shaft.



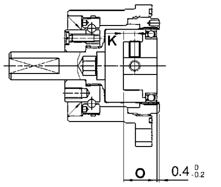


Wave Generator Installation Dimension



Wave generator reverse installation

Wave Generator Installation Dimension for size 5



※ Note: Detailed drawings are also available.

Table 10

Symbol \ Size	5	8	11	14
øA	29	43.5	58	73
B	25.7	51	64.3	70
C	10	20	26	25
D	15.7	24.5	30	37.5
E	–	$6.5^{\ 0}_{-0.3}$	$8.3^{\ 0}_{-0.7}$	$7.5^{\ 0}_{-0.8}$
F	12.7	19	23.5	28
G	3	5.5	6.5	9.5
H	1.3	1.5	2	2.5
I	0.5	0.5	0.5	1.5
J	2	3	3	5
K	2	2	2	2.5
L	2	2	2	2

Table 11

Symbol \ Size	5	8	11	14
M	M2X3	M2X3	M3X4	M3X4
N	9	18	21.5	23
O	6	12	16	17.6
P	4.85	7.3	9	11.4
Q	9.85	17.3	22	23.9
øR h7	20.5	31	40.5	51
øS	13	20	26.5	33.5
øT h6	5	9	12	15
øU h6	17	26	35	43
øV H7	3	3	5	6
☐ W	22±0.42	32±0.46	43±0.50	53±0.50
øX	9.8	15.5	20.5	25.5

Table 12 m

Symbol \ Size	5	8	11	14
øY	25	37.5	50	62
Z	4.6	8	10.5	14
a	3	4	6	6
b	M2X3	M3X4	M3X5	M4X6
c	2	2	2	2
d	M2	M3	M4	M5
e	2	2	2	2
øf	2.3	3.4	4.5	5.5
(g)	–	48.7	62.1	70.4
h	–	$4.2^{\ 0}_{-0.3}$	$6.1^{\ 0}_{-0.7}$	$7.9^{\ 0}_{-0.8}$
i	18.90X0.70	28.20X1.00	38.00X1.50	48.00X1.00
weight(g)	27	111	176	335

Specification for Output Bearing

CSF-Mini Series incorporate a precise 4-point contact bearing to directly support a load. The inner race of the bearing forms the output flange. Please calculate maximum load moment, life of cross roller bearing, and static safety factor to fully maximize the performance of the CSF-Mini Series.

Calculation Procedure

1. Maximum Load Moment (Mmax)

Calculate maximum load moment → Maximum load moment (Mmax)< Allowable moment (Mc)

2. Output Bearing Life

Calculate average radial load (Frav) and average axial load (Faav) → Calculate radial load coefficient (X) and axial load coefficient (Y) → Calculate lifetime

3. Static Safety Factor

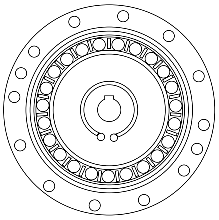
Calculate static equal radial load (Po) → Confirm static safety factor (fs)

Specification for Output Bearing

Table 13

Size	Pitch Circle dp	Offset R	Basic Dynamic Rated Load C		Basic Static Rated Load Co		Allowable Moment Load Mc		Moment Rigidity Km		Allowable Radial Load		Allowable Thrust Load	
	mm	mm	$x10^2N$	lb	$x10^2N$	lb	Nm	in-lb	Nm/rad	in-lb arc-min	N	lb	N	lb
5	13.5	4.85	9.14	205	7.63	171	0.89	8	$7.41X10^2$	1.9	90	20.2	270	60.6
8	20.5	7.3	21.6	485	19.0	427	3.46	31	$2.76X10^3$	7.09	200	44.9	630	141
11	27.5	9	38.9	874	35.4	795	6.6	58	$7.41X10^3$	19	300	67.4	1,150	258
14	35	11.4	61.2	1,376	58.5	1,315	13.2	117	$1.34X10^4$	34.4	550	123	1,800	404

Allowable Radial Load is based on load acting at the middle of the output shaft 1U and gearhead type 2XH-J



Output Bearing Ratings

How to Calculate the Maximum Load Moment

How to calculate the Maximum load moment is shown below. Please be sure that Mc is equal or greater than M max.

Mmax = Frmax • (Lr+R) + Famax • La

Frmax	Max. radial load	N	Figure 6
Famax	Max. axial load	N	Figure 6
Lr, La	Moment arm	m	Figure 5
R	amount of offset	m	Table 13

How to Calculate an Average Load

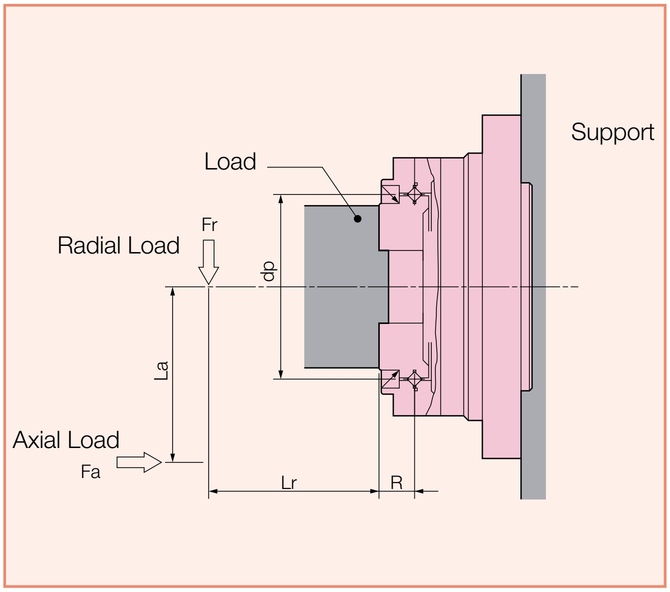
To calculate average radial load, average axial load or average output speed, follow steps below.

When the radial load and axial load vary, the life of cross roller bearing can be determined by converting to an average load. (see figure 6)

Equation (10) Calculate Average Radial Load

$$Frav = \sqrt[10/3]{\frac{n_1t_1|Fr_1|^{10/3}+ n_2t_2|Fr_2|^{10/3}\cdots + n_nt_n|Fr_n|^{10/3}}{n_1t_1+ n_2t_2\cdots + n_nt_n}}$$

However Max. radial load in t1 is Fr1, Max. radial load in t3 is Fr3.



Equation (11) Calculate Average Axial Load(Faav)

$$Faav = \sqrt[10/3]{\frac{n_1t_1|Fa_1|^{10/3}+ n_2t_2|Fa_2|^{10/3}\cdots + n_nt_n|Fa_n|^{10/3}}{n_1t_1+ n_2t_2\cdots + n_nt_n}}$$

However, an axial load in t1 is Fa1, Max. axial load in t3 is Fa3.

Equation (12) Calculate Average Output Speed

$$Nav = \frac{n_1t_1 + n_2t_2 \ldots + n_nt_n}{t_1t_2 \ldots + t_n}$$

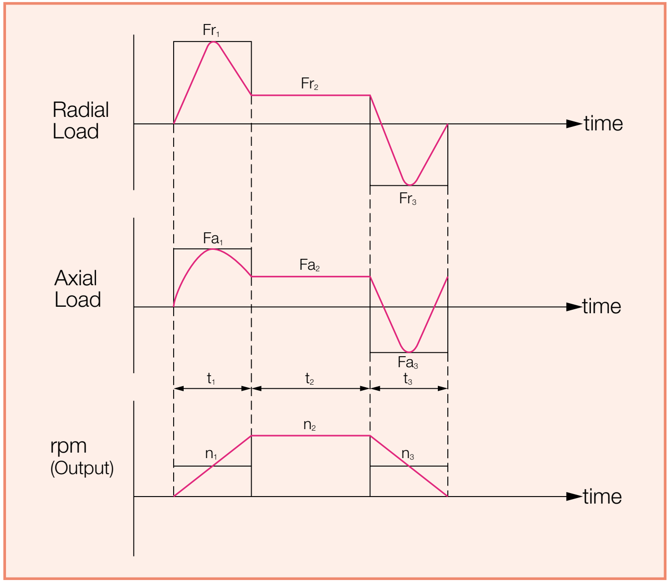
How to calculate radial load coefficient (X) axial load (Y)

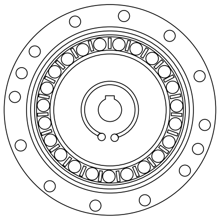
list 2

		X	Y
$\frac{Faav}{Frav+2 (Frav (Lr+R) + Faav.La) /dp}$	≤ 1.5	1	0.45
$\frac{Faav}{Frav+2 (Frav (Lr+R) + Faav.La) /dp}$	> 1.5	0.67	0.67

Frmax	Max. radial load	N	Figure 6
Famax	Max. axial load	N	Figure 6
Lr, La	Moment arm	m	Figure 5
R	amount of offset	m	Table 13
dp	pitch circle	m	Table 13

Figure 6





SPECIFICATIONS OF CROSS ROLLER BEARING

How to Calculate Life of the Output Bearing

The life of a cross roller bearing can be calculated by equation (13).

Equation 15

$$L\,10 = \frac{10^6}{60xNav} \text{ x } \left(\frac{C}{fw.Pc} \right)^{10/3} \qquad \text{equation (13)}$$

L_{10}	Life	Hour	————
Nav	Average Output Speed	rpm	equation 12
C	Basic Dynamic Rated Load	N	table 13
Pc	Dynamic Equivalent	N	equation 14
fw	Load Coefficient	———	list 3

List 3

Load Coefficient, fw	
Steady operation without impact and vibration	1~1.2
Normal operation	1.2~1.5
Operation with impact and vibration	1.5~3

Dynamic Equivalent Radial Load

equation (14)

$$Pc = X\,.\left(\frac{2\,(Frav\,(\,Lr + R\,) + Faav\,.\,La)}{dp} \right) + Y\,.\,Faav$$

Symbol of equation

Frav	Average radial load	N	equation 10
Faav	Average axial load	N	equation 11
dp	Pitch diameter	m	table 13
X	Radial load coefficient	———	list 2
Y	Axial load coefficient	————	list 2
Lr, La	Moment Arm	m	figure 5
R	Offset	m	figure 7 and table 13

How to Calculate Static Safety Coefficient

Basic static rated load is an allowable limit for static load, but its limit is determined by usage. In this case, static safety coefficient of the cross roller bearing can be calculated by equation (15). Reference values under general conditions are shown on list 4. Static equivalent radial load can be calculated by equation (15)

$$fs = \frac{Co}{Po} \qquad \text{equation (15)}$$

Symbols for equation (17)			
Co	Basic static rated load	N	table 13
Po	Static equivalent radial load	N	refer to equation (17)

list 4

Rotating Conditions	Load Conditions	Lower Limit Value for f_s
Normally not rotating	Slight oscillations Impact loads	≥ 2 ≥ 3
Normally rotating	Normal loads Impact loads	≥1.5 ≥ 3
Static Safety Coefficient	High Accuracy Required	≥ 3
	Oscillations, Impact Loads	≥ 2
	Normal Loads	≥1.5

How to Calculate Life for Oscillating Motion

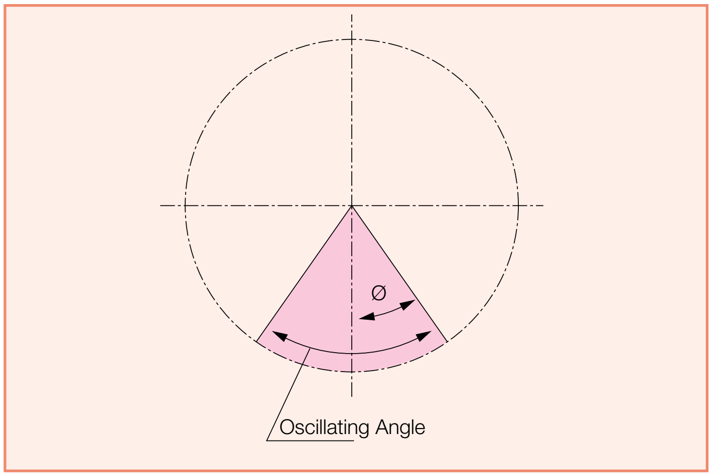
The Life of a cross roller bearing in a oscillating operation can be calculated by equation 9

equation (16)

$$Loc = \frac{106}{60xn1} \text{ x } \frac{90}{Ø} \text{ x } \left(\frac{C}{fw.Pc} \right)^{10/3}$$

Symbol of equation

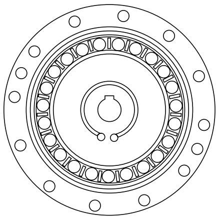
Loc	Rated life for oscillating motion	Hour	————
n1	Round trip oscillation each minute	rpm	————
C	Basic dynamic rated load	N	————
Pc	Dynamic equivalent radial load	N	equation 14
fw	Load Coefficient	———	list 3
Ø	Angle of oscillation/2		degrees refer to figure



A small angle of oscillation (less than 5 degrees) may cause fretting corrosion to occur since lubrication may not circulate properly.

$$Po = Frmax + \frac{2Mmax}{dp} + 0.44.\,Famax \qquad \text{equation (17)}$$

Symbols for Equation (17)		
Frmax	Max. radial load	N
Famax	Max. axial load	N
Mmax	Max. moment load	Nm
dp	Pitch diameter	m



EFFICIENCY

Efficiency The efficiency depends on the conditions shown below. Efficiency depends on gear ratio, input speed, load torque, temperature, quantity of lubricant and type of lubricant.
Efficiency values shown are for rated torque. If load torque is below rated torque, a compensation factor must be employed.
Load Torque≥Rated Torque: Efficiency = Efficiency from Graph
Load Torque<Rated Torque: Efficiency = Efficiency from Graph x Compensation Coefficient from figure 9.

Measurement Condition
Installation : Based on recommended tolerance
Load torque : Rated torque
Lubricant : Harmonic Grease SK-2 only
Grease quantity : Recommended quantity
Please contact us for details pertaining to recommended oil lubricant.

Size 5

1U-2XH

Figure 1 Ratio 30

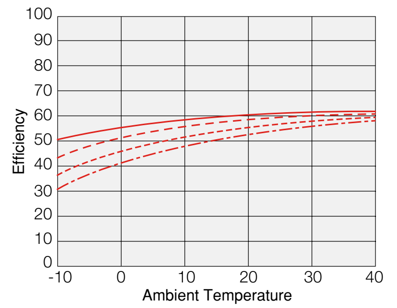


Figure 2 Ratio 50

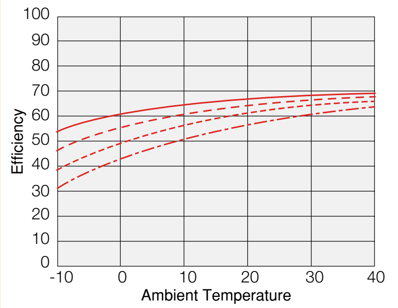
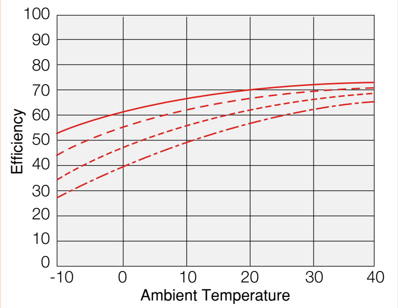


Figure 3 Ratio 100



Input Speed —— 500r/min - - - - - 1000r/min ------- 2000r/min —·—·— 3500r/min

Size 8

1U

Figure 4 Ratio 30

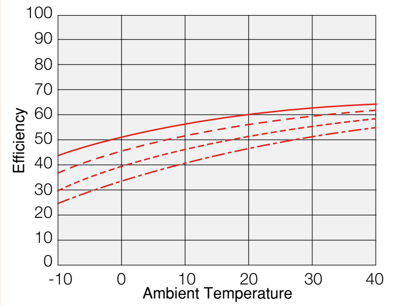


Figure 5 Ratio 50

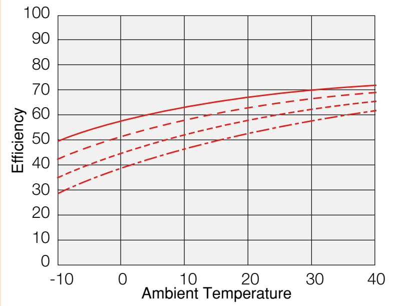
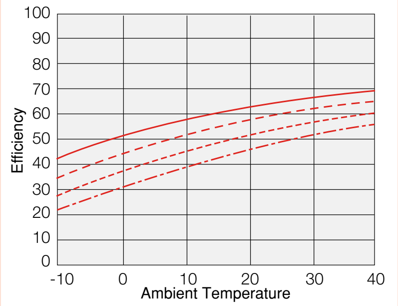


Figure 6 Ratio 100



2XH

Figure 7 Ratio 30

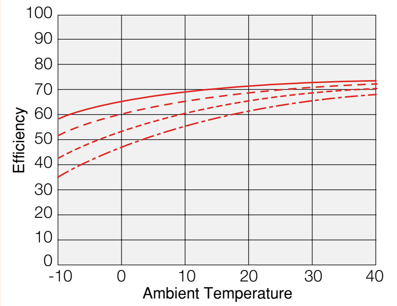


Figure 8 Ratio 50

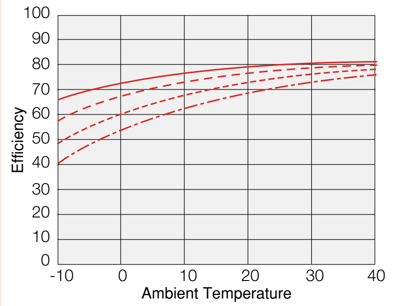
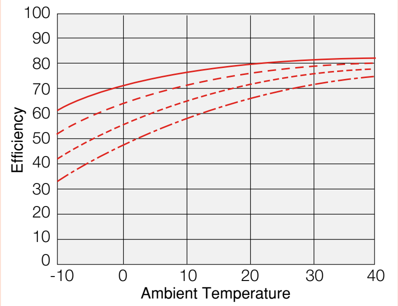


Figure 9 Ratio 100



Input Speed —— 500r/min - - - - - 1000r/min ------- 2000r/min —·—·— 3500r/min

Efficiency Compensation Coefficient

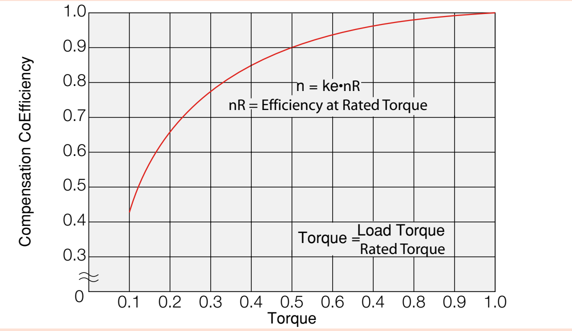
Find the Compensation Coefficient (Ke) from graph (a) and calculate the Efficiency.

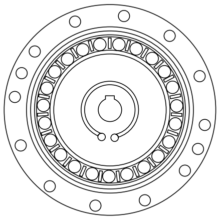
*For example Find the Efficiency n (%) on following condition that using model CSF-8-100-2XH
Input speed :1000 r/min
Load torque : 2.0N.m
Type of lubricant : grease
Temperature :20ºC

Size 8—ratio 100, rated torque= 2.4N.m (see rated table, page 07)
Torque a = 2.0/2 .4≠0.83
Efficiency Compensation Coefficient Ke = 0.99
Load torque =2.0Nm
Efficiency n =Ke·NR = 0.99 x 77 = 76%

*The load torque is greater than the rated torque :The Efficiency Compensation Coefficient Ke=1

Graph (a)





EFFICIENCY

Size 11

1U

Figure 10 Ratio 30

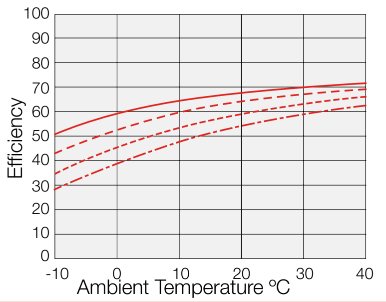


Figure 11 Ratio 50

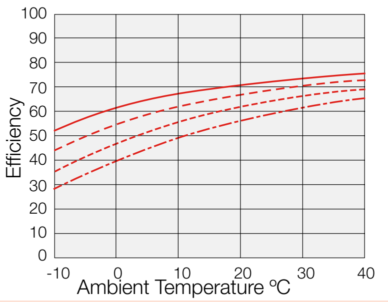
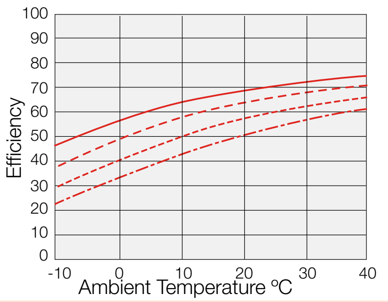


Figure 12 Ratio 100



2XH

Figure 13 Ratio 30

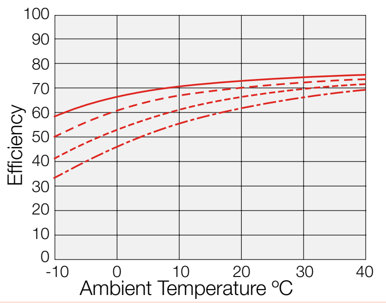


Figure 14 Ratio 50

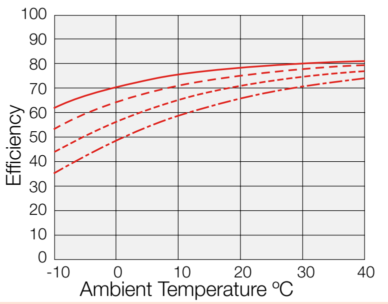
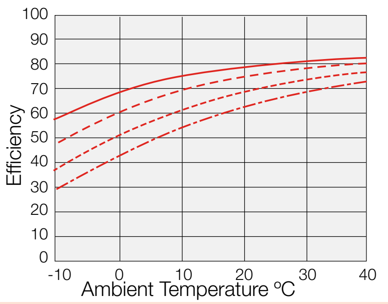


Figure 15 Ratio 100



Input ——— 500r/min - - - - - - 1000r/min -------- 2000r/min —·—·—·— 3500r/min

Size 14

1U

Figure 16 Ratio 30

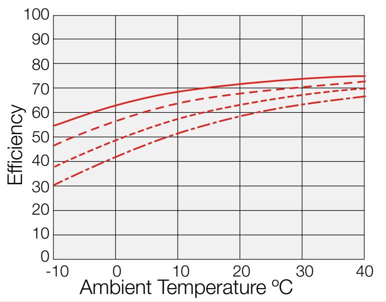


Figure 17 Ratio 50

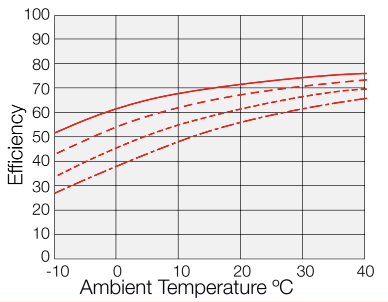
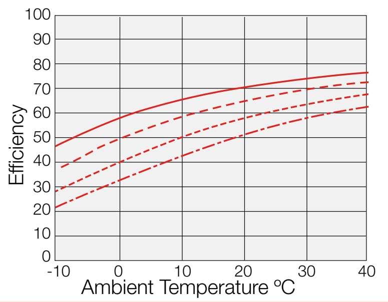


Figure 18 Ratio 80, 100



2XH

Figure 19 Ratio 30

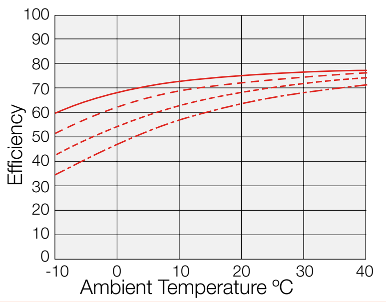


Figure 20 Ratio 50

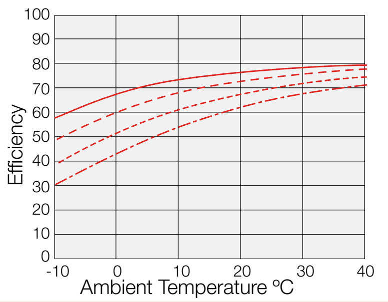
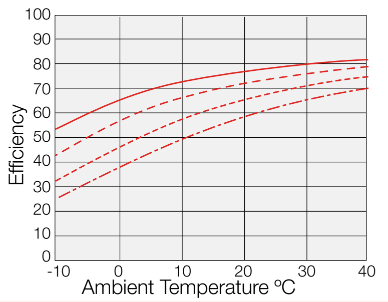
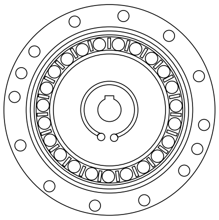


Figure 21 Ratio 80, 100



Input ——— 500r/min - - - - - - 1000r/min -------- 2000r/min —·—·—·— 3500r/min



No Load Running Torque

No Load Running Torque

No load running torque indicates the torque which is needed to rotate input of the gear, "Wave Generator", with no load on the output side (low speed side). Please contact us regarding details."

Compensation Value in Each Ratio (Component Set)

No load running torque of the gear varies with ratio.The graphs indicate a value for ratio 100.
For other gear ratios, add the compensation values from table 34.

Measurement condition

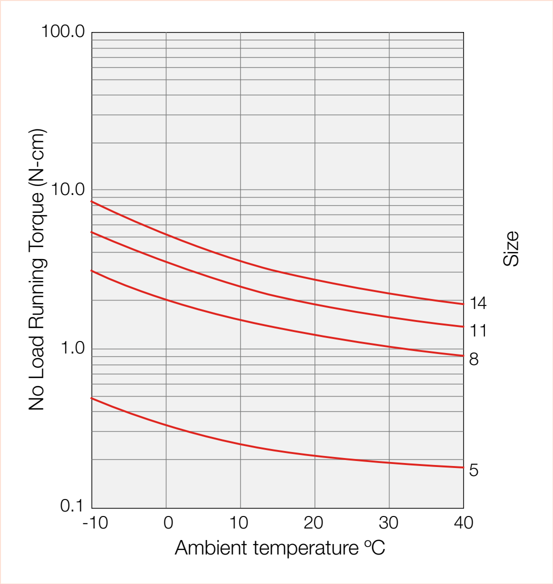
Ratio : 1/100
Lubricant : Harmonic Grease SK-2
Quantity : Recommended quantity
see page 19

Torque value is measured after 2 hours at 2000rpm input.

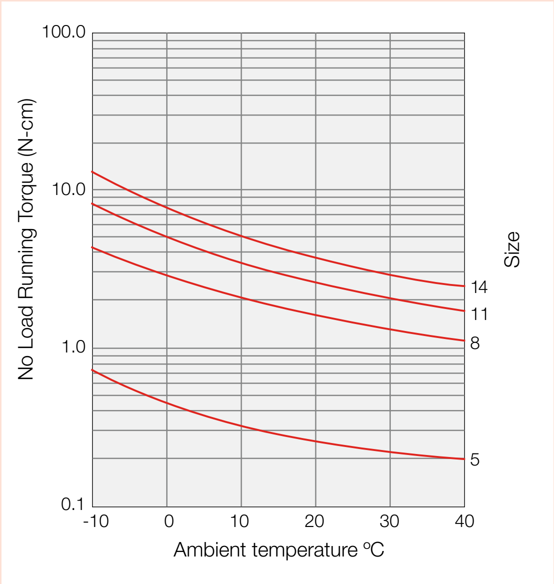
In case of oil lubricant, please contact us.

1U

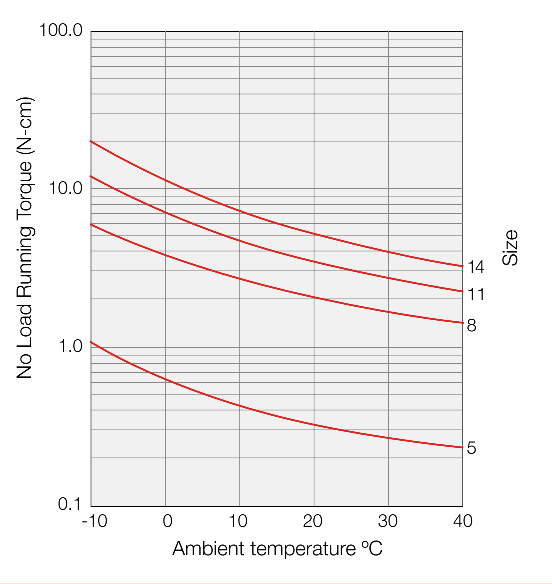
Input Speed 500r/min



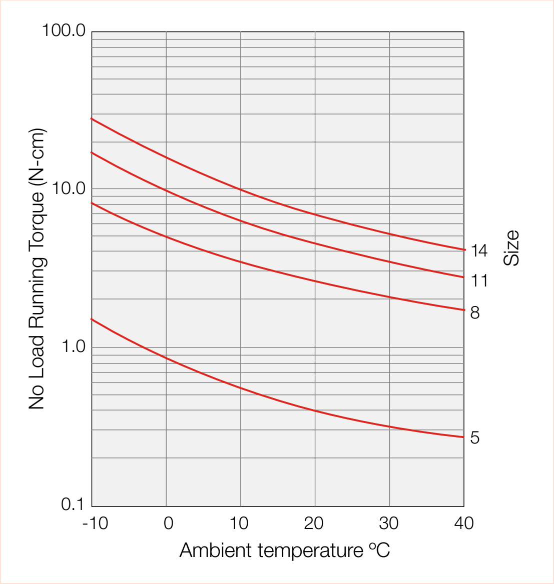
Input Speed 1000r/min

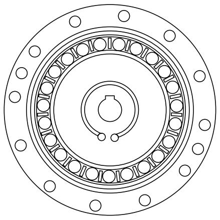


Input Speed 2000r/min



Input Speed 3500r/min





NO LOAD RUNNING TORQUE

Compensation Value in Each Ratio

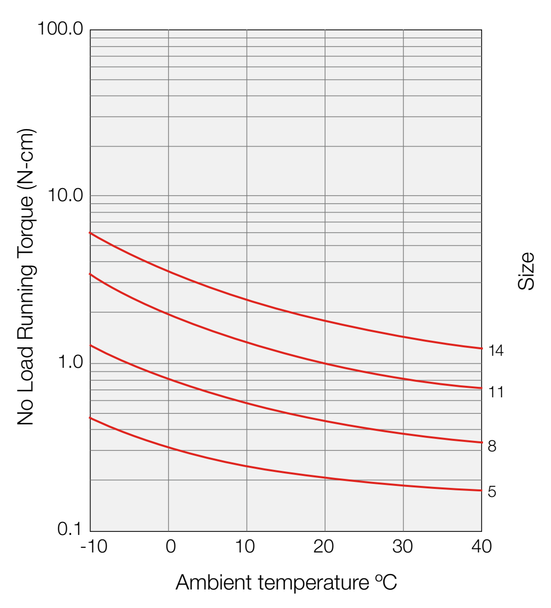
No load running torque of the gear varies with ratio. The graphs indicate a value for ratio 100. For other gear ratios, add the compensation values from table at right.

No load Running Torque Compensation Value Ncm

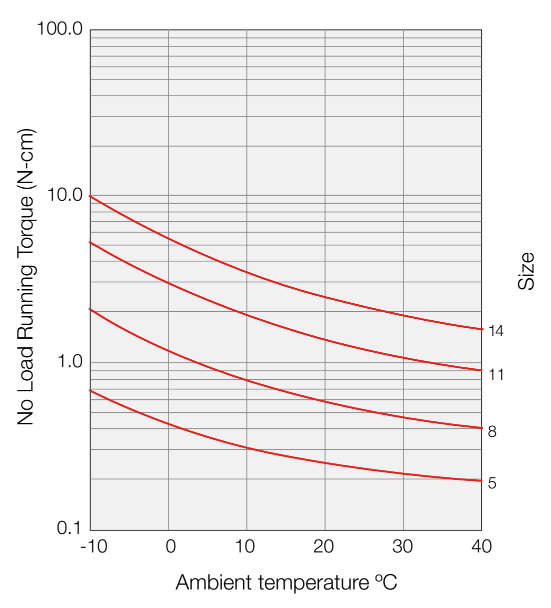
Size	Ratio		
	30	50	80
5	0.26	0.11	–
8	0.44	0.19	–
11	0.81	0.36	–
14	1.33	0.58	0.1

2XH

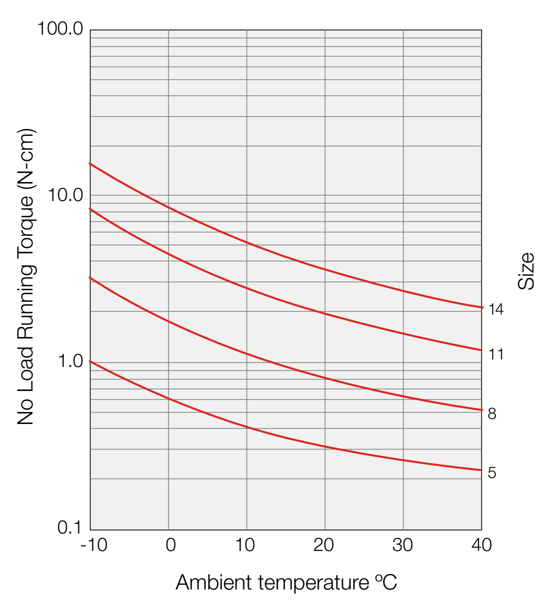
Input Speed 500r/min



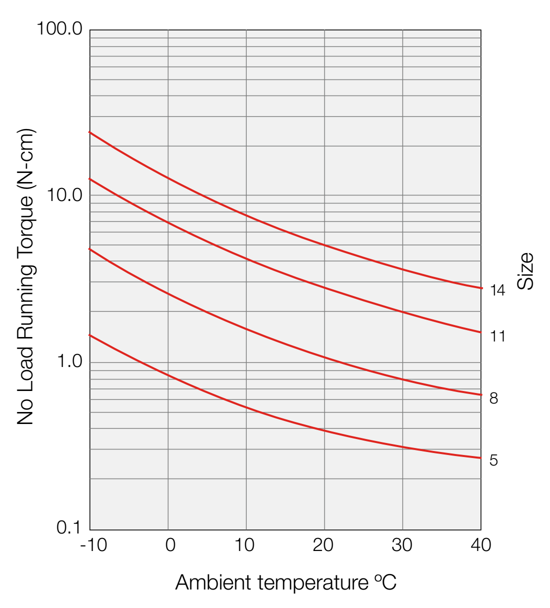
Input Speed 000r/min

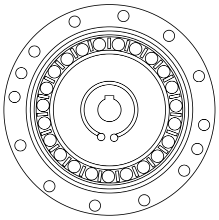


Input Speed 2000r/min



Input Speed 3500r/min





STARTING TORQUE AND BACKDRIVING TORQUE

Starting Torque

Starting torque is the torque required to commence rotation of the input element (high speed side), with no load being applied to the output. The table below indicates the maximum values. The lower values are approximately 1/2 to 1/3 of the maximum values. Temperature is at 20 degree C.

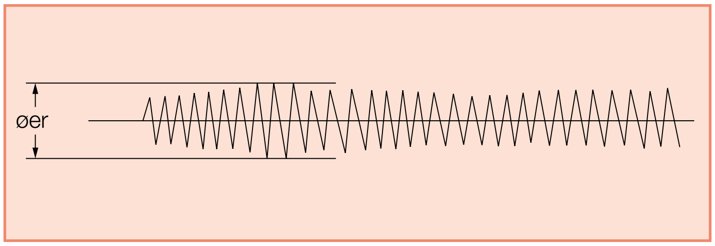
Starting Torque Ncm

Size	Ratio			
	30	50	80	100
5	0.53	0.40	–	0.30
8	1.3	0.80	–	0.59
11	3.4	2.0	–	1.5
14	6.4	4.1	2.8	2.5

Positioning Accuracy

The positioning accuracy of the gear represents a linearity error between the input and output angle. The position error is the difference between theoretical and actual output rotation angle.

The positioning accuracy is measured for one complete output revolution using a high resolution measurement system. The measurements are carried out without reversing direction.



Positioning Accuracy arc-min

Ratio	Size			
	5	8	11	14
30	4	2	2	2
50+	3	2	1.5	1.5

Component Type Backdriving Torque

Backdriving torque is the torque required to commence rotation of input element (high speed side) when torque is applied on the output side (low speed side). The table below indicates the maximum values. The typical values are approximately 1/2 to 1/3 of the maximum values. The backdriving torque should not be relied upon to provide a holding torque to prevent the output from backdriving. A failsafe brake should be used for this purpose.

Measurement condition: Ambient temperature 20ºC

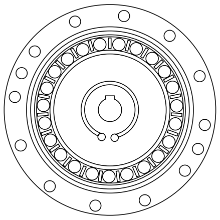
Values shown below vary depending on condition. Please use values as a reference.

θer.......................................Positioning Accuracy
θ1..Input Angle
θ2..Actual Output Angle
R...Gear Ratio (i=l;R)

$$\theta er = \theta_2 - \frac{\theta_1}{R}$$ equation [18]

Back Driving Torque Nm

Size	Ratio			
	30	50	80	100
5	0.29	0.21	–	0.27
8	0.70	0.55	–	0.75
11	1.7	1.2	–	1.5
14	2.4	1.6	1.6	1.8



TORSIONAL STIFFNESS

Torsional Stiffness

Torsional stiffness is determined by applying a load to the output of the gear, with the input rotationally locked. The angular rotation is measured as the load is increased. The typical curve (shown in the figure 11) is non-linear. The stiffness is determined the slope of this curve. For simplicity, the curve is approximated by 3 straight lines having stiffness of K1, K2, and K3. Stiffness K1 applies for output torque of 0 to T1. Stiffness K3 applies for output torque greater than T2. Stiffness K2 applies for output torque between T1 and T2.Typical stiffness values are shown in tables 14, 15, 16.

Figure 8

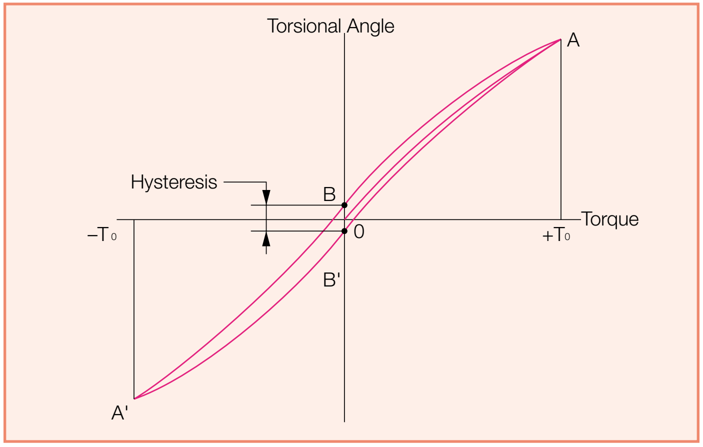
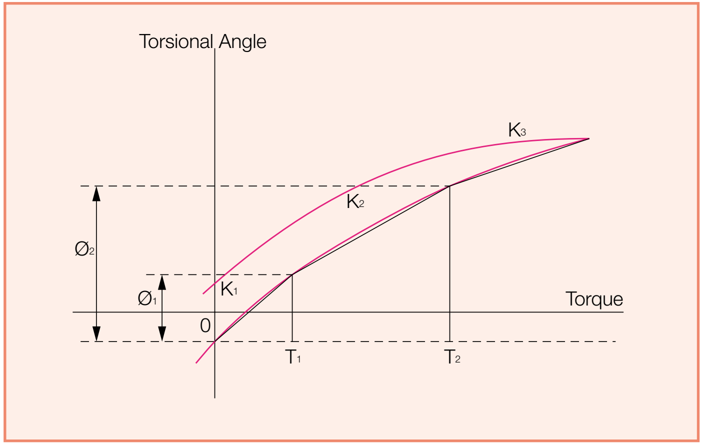


Figure 9



Torsional Stiffness for Ratio 30:1

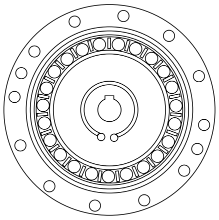
Table 14

Size		5			8			11			14		
Model		2XH-F	2XH-J	1U	2XH-F	2XH-J	1U	2XH-F	2XH-J	1U	2XH-F	2XH-J	1U
T_1	Nm	0.075			0.29			0.80			2.0		
	In-lb	0.66			2.57			7.08			17.70		
K_1	X 10^4Nm/rad	0.010	0.009	0.009	0.034	0.031	0.031	0.084	0.077	0.077	0.188	0.172	0.172
	In-lb/arc-min	0.258	0.232	0.232	0.876	0.798	0.798	2.163	1.983	1.983	4.841	4.429	4.429
$Ø_1$	X 10^{-4} rad	7.5	8.7	8.7	8.6	9.5	9.5	9.5	10	10	11	12	12
	arc-min	2.6	3.0	3.0	3.0	3.2	3.2	3.3	3.6	3.6	3.6	4.0	4.0
T_2	Nm	0.22			0.75			2.0			6.9		
	In-lb	1.95			6.64			17.70			61.07		
K_2	X 10^4Nm/rad	0.013	0.011	0.011	0.044	0.039	0.039	0.124	0.109	0.109	0.235	0.210	0.210
	In-lb/arc-min	0.335	0.283	0.283	1.133	1.004	1.004	3.193	2.807	2.807	6.051	5.408	5.408
$Ø_2$	X 10^{-4} rad	19	22	22	19	21	21	19	21	21	31	35	35
	arc-min	6.4	7.5	7.5	6.6	7.3	7.3	6.6	7.4	7.4	11	12	12
K_3	X 10^4Nm/rad	0.016	0.012	0.012	0.054	0.046	0.046	0.158	0.134	0.134	0.335	0.286	0.286
	In-lb/arc-min	0.412	0.309	0.309	1.391	1.185	1.185	4.069	3.451	3.451	8.626	7.365	7.365

Torsional Stiffness for Ratio 50:1

Table 15

Size		5			8			11			14		
Model		2XH-F	2XH-J	1U	2XH-F	2XH-J	1U	2XH-F	2XH-J	1U	2XH-F	2XH-J	1U
T_1	Nm	0.075			0.29			0.80			2.0		
	In-lb	0.66			2.57			7.08			17.70		
K_1	X 10^4Nm/rad	0.013	0.011	0.011	0.044	0.039	0.039	0.221	0.177	0.177	0.335	0.286	0.286
	In-lb/arc-min	0.335	0.283	0.283	1.133	1.004	1.004	5.691	4.558	4.588	8.626	7.365	7.365
$Ø_1$	X 10^{-4} rad	5.6	6.9	6.9	6.6	7.5	7.5	3.6	4.5	4.5	6.0	7.0	7.0
	arc-min	2.0	2.4	2.4	2.3	2.6	2.6	1.2	1.6	1.6	2.0	2.4	2.4
T_2	Nm	0.22			0.75			2.0			6.9		
	In-lb	1.95			6.64			17.70			61.07		
K_2	X 10^4Nm/rad	0.018	0.014	0.014	0.067	0.056	0.056	0.300	0.225	0.225	0.468	0.378	0.378
	In-lb/arc-min	0.464	0.361	0.361	1.725	1.442	1.442	7.725	5.794	5.794	12.051	9.734	9.734
$Ø_2$	X 10^{-4} rad	14	18	18	14	16	16	7.6	9.9	9.9	16	20	20
	arc-min	4.8	6.0	6.0	4.7	5.4	5.4	2.6	3.4	3.4	5.6	6.8	6.8
K_3	X 10^4Nm/rad	0.025	0.017	0.017	0.084	0.067	0.067	0.320	0.236	0.236	0.568	0.440	0.440
	In-lb/arc-min	0.644	0.438	0.438	2.163	1.725	1.725	8.240	6.077	6.077	14.626	11.330	11.330



TORSIONAL STIFFNESS

Torsional Stiffness for Ratio 80:1

Table 16

Size		5			8			11			14		
Model		2XH-F	2XH-J	1U	2XH-F	2XH-J	1U	2XH-F	2XH-J	1U	2XH-F	2XH-J	1U
T_1	Nm	0.075			0.29			0.80			2.0		
	In-lb	0.66			2.57			7.08			17.70		
K_1	X 10^4Nm/rad	0.020	0.015	0.015	0.09	0.072	0.072	0.267	0.206	0.206	0.468	0.378	0.378
	In-lb/arc-min	0.515	0.386	0.386	2.318	1.854	1.854	6.875	5.305	5.305	12.051	9.734	9.734
$Ø_1$	X 10^{-4} rad	3.7	5.0	5.0	3.2	4.1	4.1	3.0	3.9	3.9	4.3	5.3	5.3
	arc-min	1.3	1.7	1.7	1.1	1.4	1.4	1.0	1.3	1.3	1.5	1.8	1.8
T_2	Nm	0.22			0.75			2			6.9		
	In-lb	1.95			6.64			17.70			61.07		
K_2	X 10^4Nm/rad	0.027	0.018	0.018	0.104	0.08	0.08	0.333	0.243	0.243	0.601	0.46	0.46
	In-lb/arc-min	0.695	0.464	0.464	2.678	2.060	2.060	8.575	6.257	6.257	15.476	11.845	11.845
$Ø_2$	X 10^{-4} rad	9.2	13	13	7.7	9.8	9.8	6.6	8.8	8.8	12	16	16
	arc-min	3.1	4.4	4.4	2.6	3.4	3.4	2.3	3.0	3.0	4.2	5.4	5.4
K_3	X 10^4Nm/rad	0.030	0.020	0.020	0.120	0.089	0.089	0.432	0.291	0.291	0.700	0.516	0.516
	In-lb/arc-min	0.773	0.515	0.515	3.090	2.292	2.292	11.124	7.493	7.493	18.025	13.287	13.287

Hysteresis Loss

A typical hysteresis curve is shown in figure 8. With the input locked, a torque is applied from 0 to ± Rated Torque. Hysteresis measurement is shown in the figure.

The following table shows typical hysteresis values.

Table 17 Hysteresis Loss

Ratio		Size			
		5	8	11	14
30	X10^{-4}rad	8.7	8.7	8.7	8.7
	arc-min	3	3	3	3
50	X10^{-4}rad	8.7	5.8	5.8	2.9
	arc-min	3	2	2	1
80 and up	X10^{-4}rad	8.7	5.8	5.8	2.9
	arc-min	3	2	2	1

Calculate Torsion Angle

1. For $T<T_1$: $Ø = T/K_1$
2. For $T_1<T<T_2$: $Ø = T_1/K_1 + (T-T_2)/K_2$
3. For $T_2<T$: $Ø = T_1/K_1 + (T_2-T_1)/K_2^2 + (T-T_2)/K_3$

Note: Units for T, T_1, T_2, K, K_1, K_2, K_3, and Ø must be consistent.

1. T_{L1} =0.5Nm ($T<T_1$)

$$Ø_{L1} = T_{L1}K_1$$
$$= 0.50/0.286X10^4$$
$$= 1.75X10^4 \text{ rad (0.6 arc min)}$$

2. T_{L2} =4Nm ($T_1<T<T_2$)

$$Ø_{L2} = Ø_1 + (T_{L2}-T_1)K_2$$
$$= 7.0X10^{-4} +(4-2)/0.378X10^4$$
$$= 12.3X10^{-4} \text{ rad (4.2 arc min)}$$

*Note: Units for T, T_1, T_2, K_3, K_1, K_2, K_3, and Ø must be consistent.

Table 18 Maximum Backlash

Ratio		Size		
		8	11	14
30	X10^{-5}rad	28.6	23.8	29.1
	arc-sec	59	49	60
50	X10^{-5}rad	17	14.1	17.5
	arc-sec	35	24	36
80	X10^{-5}rad	–	–	11.2
	arc-sec	–	–	23
100	X10^{-5}rad	8.7	7.3	8.7
	arc-sec	18	15	18

Backlash from Oldham Coupling

The gear element has zero backlash. However, an Oldham coupling is included as standard with all gearing components and gearheads. The Oldham coupling compensates for motor shaft concentricity errors. Unfortunately, the Oldham coupling does add a small amount of backlash to the system. Backlash values are shown in table 18. This amount of backlash is usually negligible. Component sets and gearheads can be supplied without an Oldham coupling. This is called a “Direct Drive” version.

Surface Treatment

Corrosion resistant surface treatments are available for exposed areas of the gear. Additionally some components can be manufactured using corrosion resistant steels.

RECOMMENDED TOLERANCES FOR ASSEMBLY

Recommended Tolerances for Assembly

For peak performance of the CSF-mini, Gearhead Type 2XH it is essential that the following tolerances be observed when assembly is complete.

Recommended Tolerances for Assembly Figure 10

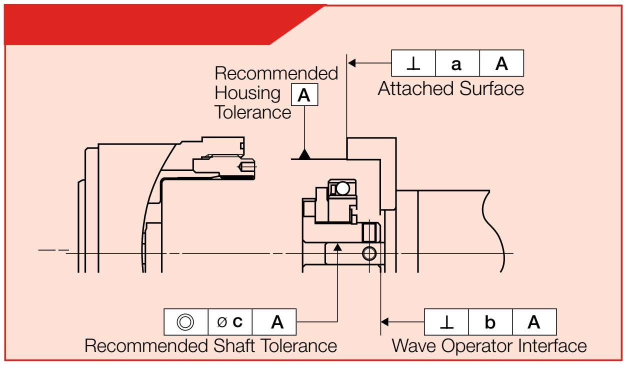


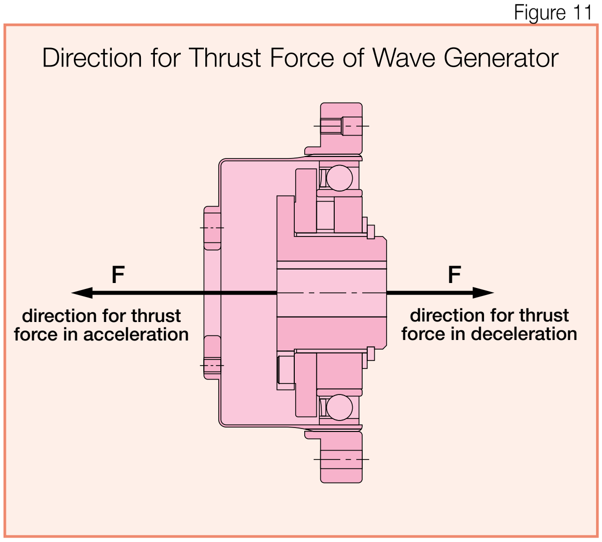
Table 19 Recommended Tolerances for Assembly Nm

Symbol		Size			
		5	8	11	14
a	Attached Surface	0.008	0.010	0.011	0.011
b	Wave Generator Interface	0.005	0.012 (0.006)	0.012 (0.007)	0.017 (0.008)
c	Concentricity	0.005	0.015 (0.006)	0.015 (0.007)	0.030 (0.016)

* The values in parenthesis indicate that the wave generator does not have an Oldham coupling.

AXIAL FORCE

Figure 11



Equation for axial force

Gear Ratio	equation
i=1/30	$F=2x\frac{T}{D}\ x\ 0.07\ x\ \tan 32^\circ$
i=1/50	$F=2x\frac{T}{D}\ x\ 0.07\ x\ \tan 30^\circ$
i=1/80 and up	$F=2x\frac{T}{D}\ x\ 0.07\ x\ \tan 20^\circ$

Symbols for equation

F	axial force	N
D	Gear Size x 0.00254	m
T	output torque	Nm

Axial Force of Wave Generator

When a CSF gear is used to accelerate a load, the deflection of the Flexspline leads to an axial force acting on the Wave Generator. This axial force, which acts in the direction of the closed end of the Flexspline, must be supported by the bearings of the input shaft (motor shaft).

When a CSF gear is used to decelerate a load, an axial force acts to push the Wave Generator out of the Flexspline cup. Maximum axial force of the Wave Generator can be calculated by the equation shown below. The axial force may vary depending on its operating condition. The value of axial force tends to be a larger number when using high torque, extreme low speed and constant operation. The force is calculated (approximately) by the equation. In all cases, the Wave Generator must be axially (in both directions), as well as torsionally, fixed to the input shaft.

Note: Please contact us when you fix the Wave Generator hub and input shaft using bolts.

Calculation Example

size	:	11
Ratio	:	i=1/50
Output Torque	:	3.5 Nm

$F=2x\frac{3.5}{(11x0.00254)}x\ 0.07x\tan 30^\circ$

F=10N

Sealing structure

A seal structure is needed to maintain the high durability of gearing and prevent grease leakage.

Key Points to Verify

- Rotating parts should have an oil seal (with spring), surface should be smooth (no scratches)
- Mating flanges should have an O Ring, seal adhesive
- Screws should have a thread lock (Loctite 242 recommended) or seal adhesive.

PERFORMANCE DATA FOR INPUT BEARING

Performance Data for the Input Bearing

The Input Shaft incorporated in the CSF-1U unit is supported by two deep groove single row ball bearings.
Please calculate Input load to fully maximize the performance of CSF-1U gearhead.

Fig.12 shows the points of application of forces, which determine the maximum permissible radial and axial loads as indicated in Fig.13.

The maximum values, as given in Figures 13, are valid for an average input speed of 2000 rpm and a mean bearing life of L10=7000h.

Example: If the input shaft of a CSF-14-1U unit is subjected to an axial load (Fa) of 8N, then the maximum permissible radial face will be 20N, Fig. 13.

Specification for Input Bearing

Table 20

Size	Bearing A					Bearing B								
	Bearing A	Basic Dynamic Rated Load		Basic Static Rated Load		Bearing B0-	Basic Dynamic Rated Load		Basic Statica Rated Load		b (mm)	(mm)	(N)	lb
		Cr (N)	lb	Cor (N)	lb		Cr (N)	lb	Cor (N)	lb				
5	SSLF-630DD	196	44	59	13	L-520WO2	176	40	54	12	10.8	9.25	8	2
8	MR126	715	161	292	66	MR83	560	126	170	38	16.65	18	10	2
11	689	1330	299	665	149	624	1300	292	485	109	20.6	21.9	20	4
14	6900ZZ	2700	607	1270	285	605ZZ	1330	299	505	114	28.25	24.25	30	7

Point of Shaft

Figure 12

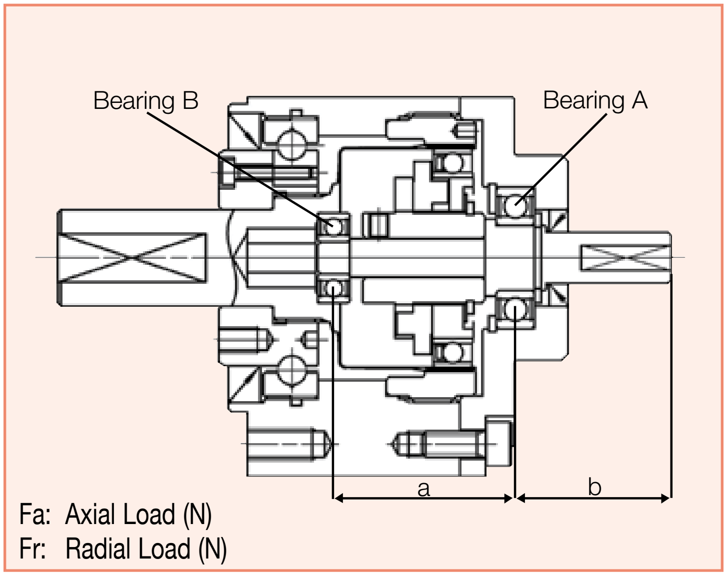
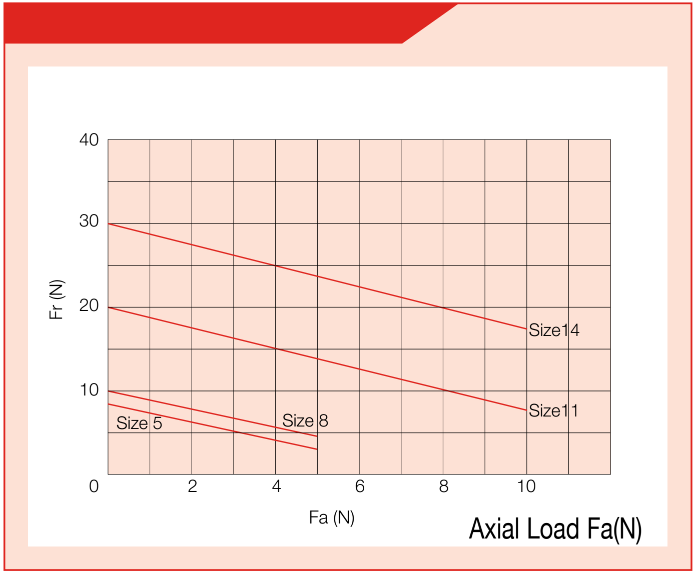
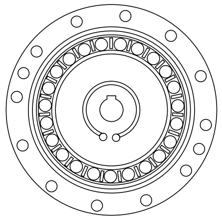


Figure 13





INSTALLATION OF CASE SIDE

Ensure that surface used for installation is flat and does not have any burr.
Please fasten bolt with the proper torque for each size as indicated.

IU

Table 21

Size		5	8	11	14
Number of Bolts		4	4	4	4
Size of Bolt		M2	M3	M4	M5
Pitch Circle Diameter	mm	23	35	46	58
Clamp Torque	Nm	0.25	0.85	2	3.96
	In.lb	0.03	0.09	17.70	35.05
Length of Bolt	mm	2.4	3.6	4.8	60
Torque Transmission Capacity	Nm	3.5	12	29	57
	In.lb	31	106	257	504

Recommended Bolt: JISB1176 socket head cap, screw strength range: JISB1051 over 12.9

2XH

Table 22

Size		5	8	11	14
Number of Bolts		2	2	2	2
Size of Bolt		M2	M3	M4	M5
Pitch Circle Diameter	mm	25	37.5	50	62
Clamp torque	Nm	0.25	0.85	2	4
	In.lb	2.21	7.52	17.70	35.40
Length of Bolt	mm	2.4	3.6	4.8	6
Torque Transmission Capacity	Nm	2	7	16	31
	In.lb	18	62	142	274

Recommended Bolt: JISB1176 socket head cap, screw strength range: JISB1051 over 12.9

Installation of Output Flange

Please refer to “Specification for a Cross Roller Bearing”. page 12-14

2XH (Output Flange)

Table 23

Size		5	8	11	14
Number of Bolts		3	4	6	6
Size of Bolt		M2	M3	M3	M4
Pitch Circle Diameter	mm	9.8	15.5	20.5	25.5
Clamp torque	Nm	0.54	2	2	4.6
	In.lb	4.8	17.7	17.7	40.7
Torque Transmission Capacity	Nm	2	13	26	55
	In.lb	18	115	230	487

***Output Flange is prevented for grease leakage, re-sealing is not necessary.

1U, 2XH-J (Output Shaft)

Avoid impact to output shaft during assembly of pulley or pinion, loss of accuracy and speed may occur.

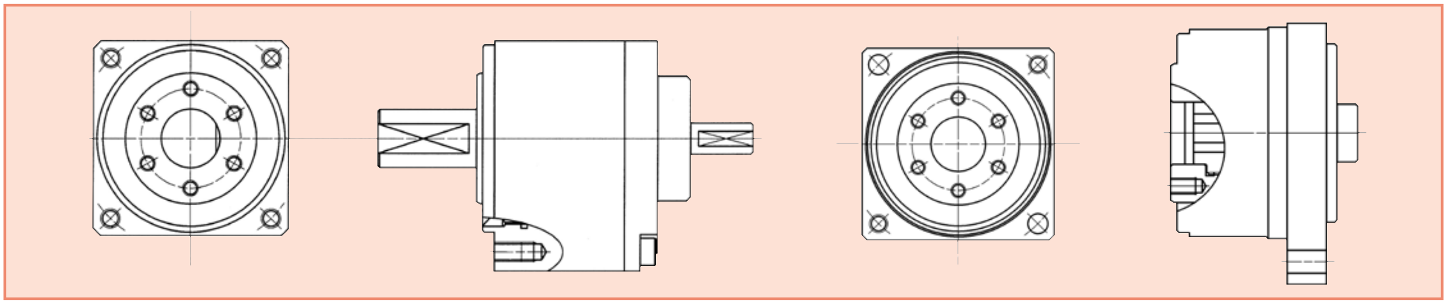


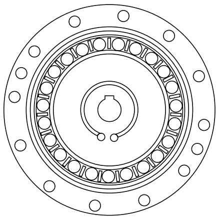
Figure 14

Lubrication

Harmonic Drive® CSF-mini series are delivered ready for use. They are supplied with lifetime lubricant, which is high performance grease that meets the specific requirements of the gears. It guarantees constant accuracy of the gears over their entire service life.

Recommended Grease

Lubricant	Speed reducers	Cross Roller Bearing
Name of Lubricant	Harmonic Grease SK-2	Multemp HL-D
Manufacturer	Harmonic Drive Systems	Kyodo Yushi
Base Oil	Refined Mineral Hydrocarbon base oil	Hydrocarbon type synthetic oil and polymer
Thickening Agent	lithium soap thickener	Lithium soap thickener
Viscosity (25º)	295	280
Melting Point	198ºC	210ºC
Color	Green	White

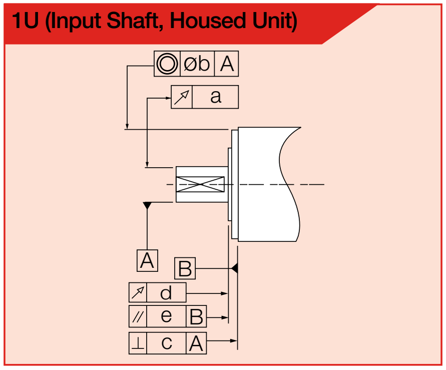


Tolerances for Assembly

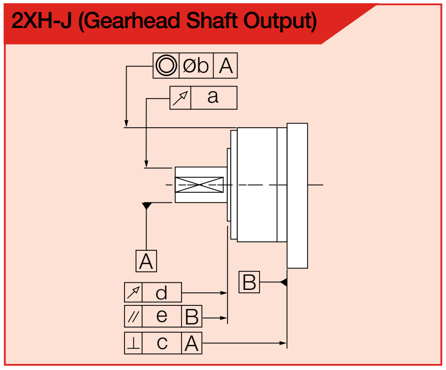
This innovative gearhead combines precision Harmonic Drive® gear and a high capacity 4-point contact bearing for output flange/shaft support.

Recommended Tolerances for Assembly

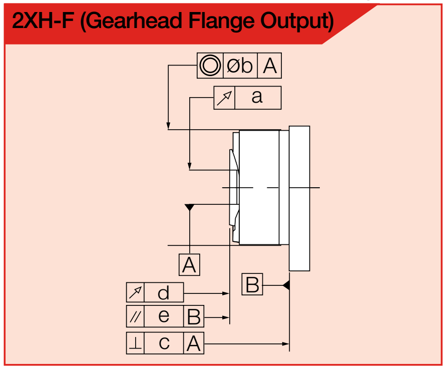
1U (Double Shaft Type)



2XH-J(Output Shaft)



2XH-F (Output Flange)



Torsional Stiffness for Ratio 1/80

Table 24

Size	Tolerances Item	Configuration							
		5		8		11		14	
		1U, 2XH-J	2XH-F	1U, 2XH-J	2XH-F	1U, 2XH-J	2XH-F	1U, 2XH-J	2XH-F
a	1U, 2XH-J Run Out	0.020	–	0.020	–	0.020	–	0.020	–
	2XH-F Run Out	–	0.005	–	0.005	–	0.005	–	0.005
b	Concentricity	0.020		0.020		0.030		0.030	
c	Perpendicularity	0.020		0.020		0.025		0.025	
d	Run Out	0.005		0.005		0.005		0.005	
e	Parallelism	0.015		0.020		0.030		0.030	

Note:

Warranty Period and Terms

The Product is warranted as follows:

- Warranty period

Under the condition that the product is handled, used and maintained and conforms to each item of the documents and the manuals, the product is warranted against defects in workmanship and materials for the period of either one year after delivery or 2,000 hours of operation time, whichever is shorter.

- Warranty terms

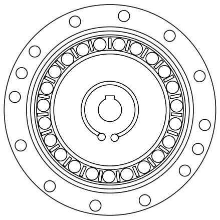
All products are warranted against defects in workmanship and materials for the warranted period. This limited warranty does not apply to any product that has been subject to:

1. User's misapplication, improper installation, inadequate maintenance, or misuse.
2. Disassembling modification or repair by others than Harmonic Drive LLC.
3. Imperfection caused by something other than the product.
4. Disaster or other occurrences that does not belong to the responsibility of Harmonic Drive LLC.

Our liability shall be limited exclusively to repairing or replacing the product as found by Harmonic Drive LLC. to be defective. Harmonic Drive® Systems, Inc. shall not be liable for consequential damages of other equipment caused by the defective product, and shall not be liable for the incidental and consequential expenses and the labor coast associated with disassembly and installation to the driven equipment.

- Trademark

The academic and general nomenclature for Harmonic Drive® gear "Strain Wave Gearing". " Harmonic Drive" is a trademark that can be used only on products, which are manufactured and sold by Harmonic Drive LLC.



CSF-MINI

SAFETY GUIDE

- For actuators, motors, control units and drivers manufactured by Harmonic Drive LLC.
- Read the manual thoroughly before designing the application, installation, maintenance or inspection of the actuator.
- WARNING: Indicates a potentially hazardous situation, which, if not avoided, could result in death or serious personal injury.
- CAUTION: Indicates a potentially hazardous situation, which, if not avoided, may result in minor or moderate personal injury and/or damage to the equipment.

LIMITATION OF APPLICATIONS:

The equipment listed in this document may not be used for the following applications:

- Space equipment
- Aircraft, aeronautic equipment
- Nuclear equipment
- Household apparatus
- Vacuum equipment
- Automobile, automotive parts
- Amusement equipment, sport equipment, game machines
- Machine or devices acting directly on the human body
- Instruments or devices to transport or carry people
- Apparatus or devices used in special environments

Please consult us, if you intend to use our products in one of the areas mentioned above.

Safety measures are essential to prevent accidents resulting in death, injury or damage of the equipment due to malfunction or faulty operation.

Precautions When Using An Actuator and/or Driver

CAUTIONS FOR ACTUATORS IN APPLICATION DESIGN

The product must only be used indoors, where the following conditions are provided:

- Ambient temperature: 0ºC to 40ºC
- Ambient humidity: 20% to 80%RH (Non-condensating)
- Vibration: Max 24.5 m/S^2
- No contamination by water, oil or foreign matters
- No corrosive, inflammable or explosive gas

Follow exactly the instructions in the relating manuals to install the product in the equipment.

- Ensure exact alignment of motor shaft center and corresponding center in the application.
- Failure to observe this caution may lead to vibration, resulting in damage of output elements.

CAUTIONS FOR ACTUATORS IN OPERATIONS

Do not exceed the allowable torque of the actuator.

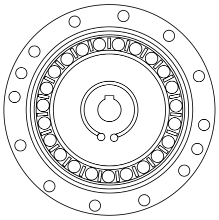
- Be aware, that if a load arm attached to the output hits by accident an obstacle, the output shaft may become uncontrollable.

Never connect cables directly to a power supply socket.

- An actuator must not be operated without a corresponding driver.
- Failure to observe this caution may lead to injury, fire or damage of the actuator.

Protect the actuator from impact and shocks

- Do not use a hammer to position the actuator during installation
- Failure to observe this caution could damage the encoder and may cause uncontrollable operation.
- Avoid handling of the actuator by its cables.
- Failure to observe this caution may damage the wiring, causing uncontrollable or faulty operation.



SAFETY GUIDE

CAUTIONS FOR DRIVERS IN APPLICATION DESIGN

Always use drivers under the following conditions:

- Mount in a vertical position keeping sufficient distance to other devices to let heat generated by the driver radiate freely.
- Ambient temperature: 0° to 50°
- Ambient humidity: less than 95% RH (Non condensation)
- No contamination by water, oil or foreign matters
- No corrosive, inflammable or explosive gas Use sufficient noise suppressing means and safe grounding.
- Keep signal and power leads separated.
- Keep leads as short as possible.
- Ground actuator and driver at one single point, minimum ground resistance class: D (less than 100 ohms)
- Do not use a power line filter in the motor circuit. Pay attention to negative torque by inverse load.
  –Inverse load may cause damages of drivers.
- Please consult our sales office, if you intent to apply products for inverse load. Use a fast-response type ground-fault detector designed for PWM inverters.
- Do not use a time-delay-type ground-fault detector.

CAUTIONS FOR DRIVERS IN OPERATIONS

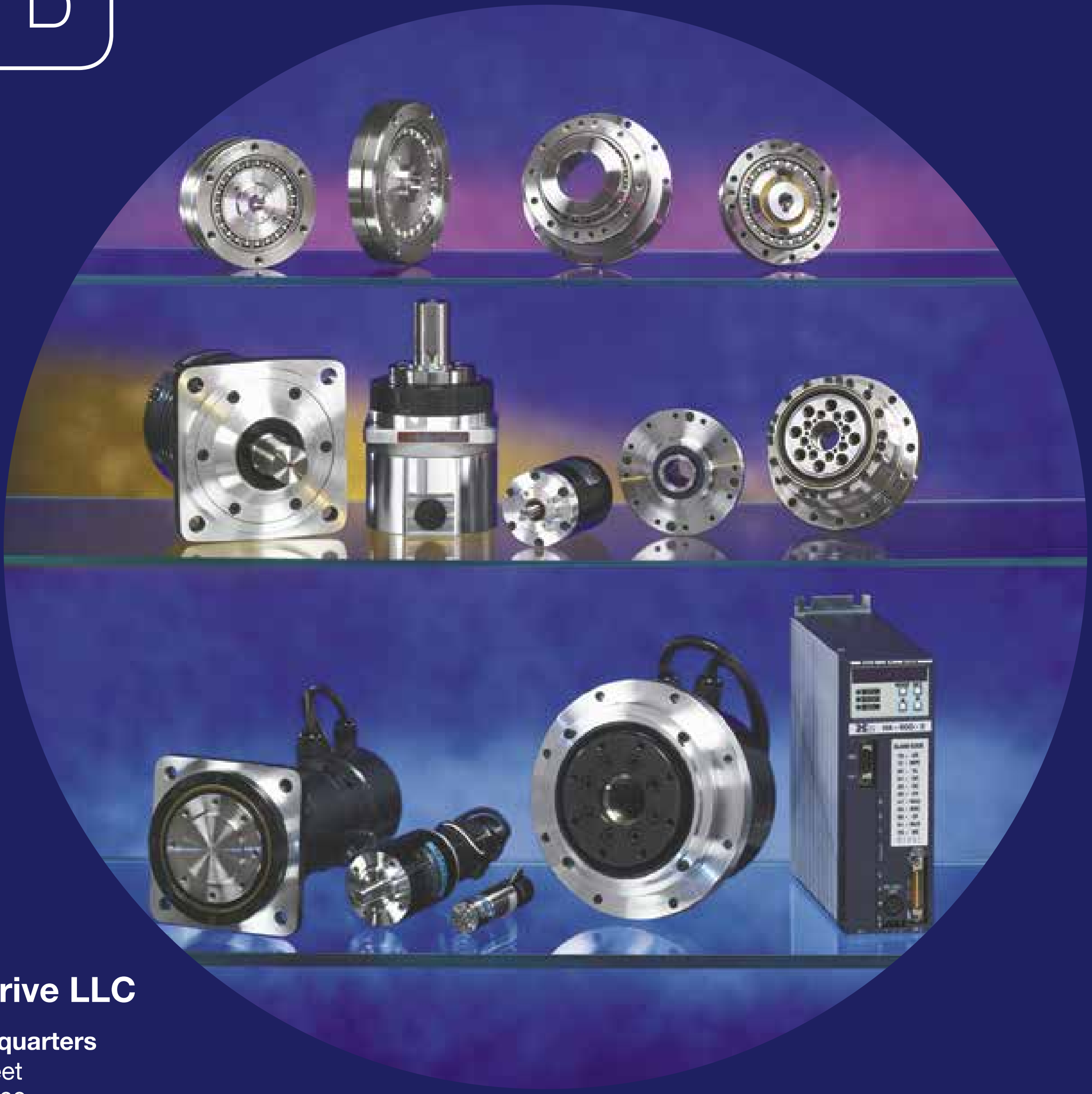
Never change wiring while power is active:

- Make sure of power non-active before servicing the products.
- Failure to observe this caution may result in electric shock or personal injury.
  Do not touch terminals or inspect products at least 5 minutes after turning OFF power.
- Otherwise residual electric charges may result in electric shock.
- Make installation of products not easy to touch their inner electric components. Do not make a voltage resistance test.
- Failure to observe this caution may result in damage of the control unit.
- Please consult our sales office, if you intent to make a voltage resistance test.
- Do not operate control units by means of power ON/OFF switching.
- Start/stop operation should be performed via input signals.
- Failure to observe this caution may result in deterioration of electronic parts.

DISPOSAL OF AN ACTUATOR, A MOTOR, A CONTROL UNIT AND/OR THEIR PARTS

- All products or parts have to be disposed of as industrial waste.
- Since the case or the box of drivers have a material indication, classify parts and dispose them separately.

All products are warranted to be free from design or manufacturing defects for a period of one year from the date of shipment. Such items will be repaired or replaced at the discretion of Harmonic Drive LLC. The seller makes no warranty, expressed or implied, concerning the material to be furnished other than it shall be of the quality and specifications stated. The seller's liability for any breach is limited to the purchase price of the product. All efforts have been made to assure that the information in this catalog is complete and accurate. However, Harmonic Drive LLC is not liable for any errors, omissions or inaccuracies in the reported data. Harmonic Drive LLC reserves the right to change the product specifications, for any reason, without prior notice.



Harmonic Drive LLC

Boston US Headquarters
247 Lynnfield Street
Peabody, MA 01960

New York Sales Office
100 Motor Parkway
Suite 116
Hauppauge, NY 11788

California Sales Office
333 W. San Carlos Street
Suite 1070
San Jose, CA 95110

Chicago Sales Office
137 N. Oak Park Ave., Suite 410
Oak Park, IL 60301

T: 800.921.3332
T: 978.532.1800
F: 978.532.9406

www.HarmonicDrive.net

Group Companies
Harmonic Drive Systems, Inc.
6-25-3 Minami-Ohi, Shinagawa-ku
Tokyo 141-0013, Japan

Harmonic Drive AG
Hoenbergstrasse, 14, D-6555
Limburg/Lahn Germany

Rev 10-16