**Metric table**

1 d₁	2 Side thrust force F ≈	3 Type KA / KB			d₂	l₂	l₃	s	w	Part number installation tool	Dimensions in: millimeters / inches					
		l₁ - 2	Type SA / KA	Type SB / KB												
5 0.20	20 N 4.50 lbf	50 N 11.24 lbf	100 N 22.48 lbf	20 N 4.50 lbf	11.5 0.45	19 0.75	26.5 1.04	M 12	6.4 0.25	6 0.24	3.9 0.15	3.5 0.14	10 0.39	1.6 0.06	0.8 0.03	GN 713.1-5.6
6 0.24	40 N 8.99 lbf	75 N 16.86 lbf	100 N 22.48 lbf	40 N 8.99 lbf	11.5 0.45	19 0.75	26.5 1.04	M 12	10.4 0.41	10 0.39	7.4 0.29	7 0.28	10 0.39	2 0.08	1 0.04	GN 713.1-5.6
10 0.39	100 N 22.48 lbf	150 N 33.72 lbf	205 N 46.09 lbf	100 N 22.48 lbf	18 0.71	31.5 1.24	45 1.77	M 18 x 1.5	16.9 0.67	16 0.63	11.9 0.47	11 0.43	16 0.63	3.2 0.13	1.6 0.06	GN 713.1-10

Specification**Housing**

Steel, zinc plated, blue passivated finish

Thrust pin

- Steel for Type SA / SB
 - Hardened
 - Zinc plated, blue passivated finish
- Plastic, Polyacetal (POM) for Type KA / KB

Thrust spring

- Side thrust force light
Stainless steel AISI 301
- Side thrust force medium
Spring steel, blackened finish
- Side thrust force heavy
Spring steel, zinc plated, blue passivated finish

Seal

Chloroprene rubber (CR)

RoHS

Spring loaded side thrust pins GN 713 are versatile and practical elements for holding, positioning and clamping workpieces.

They eliminate costly alternatives, are space saving and simple to install. The protruding height of the thrust pin can be adjusted with the threaded body.

For mounting the side thrust pins a suitable mounting tool GN 713.1 is available (see table).

see also...**GN 715 Press-Fit Side Thrust Pins**

3.8

QVX

GN 714 Press-Fit Side Thrust Pins (without Pressure Pin)

QVX

Technical Information

Technical and Assembly Instructions

QVX

Plastic Characteristics

QVX

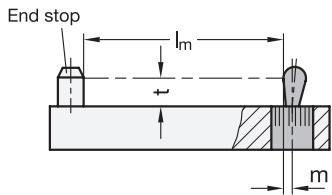
Accessory**GN 713.1 Mounting Tools (Part Number, see Table)****How to order**

1	Diameter d₁
2	Side thrust force F
3	Thread engagement l₁
4	Type

GN 713-6-75-11.5-SB

Side Thrust Pins

Technical and Assembly Instructions GN 713 | GN 714 | GN 715

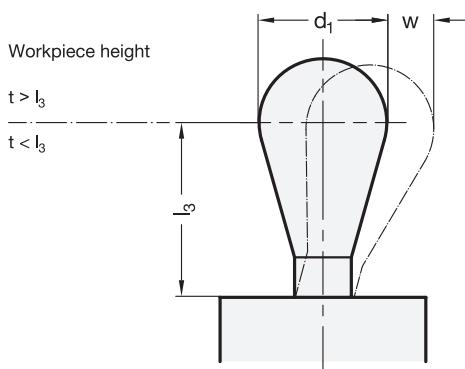


The position of the mounting hole results from the workpiece length l_m plus the hole offset m , which is calculated as shown below:

w = Maximum movement range of the thrust pin

t = Workpiece height

m = Hole offset



Case 1:

The workpiece height t is greater than the cone height l_3

$$m = \frac{d_1}{2} - \frac{w}{2}$$

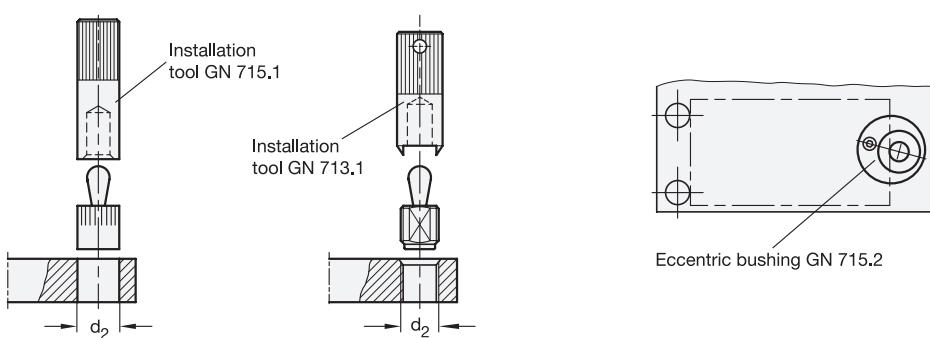
Case 2:

The workpiece height t is smaller than the cone height l_3

$$m = \frac{d_1}{2} - (l_3 - t) \times 0.123$$

If the position of the mounting hole is determined as specified, the full movement of the side thrust pin will be available to cover the tolerance of the workpiece.

In case 1, the lateral clamping force is coupled with a downward pull that presses the workpiece against the contact surface.



The use of a installation tool GN 715.1 or installation tool GN 713.1 is recommended for installation.

Eccentric bushings GN 715.2 are an assembly aid for side thrust pins GN 714 / GN 715. They enable adjustment of the side thrust pins to the most favorable clamping position, e.g. to bridge larger tolerance ranges of a workpiece.

