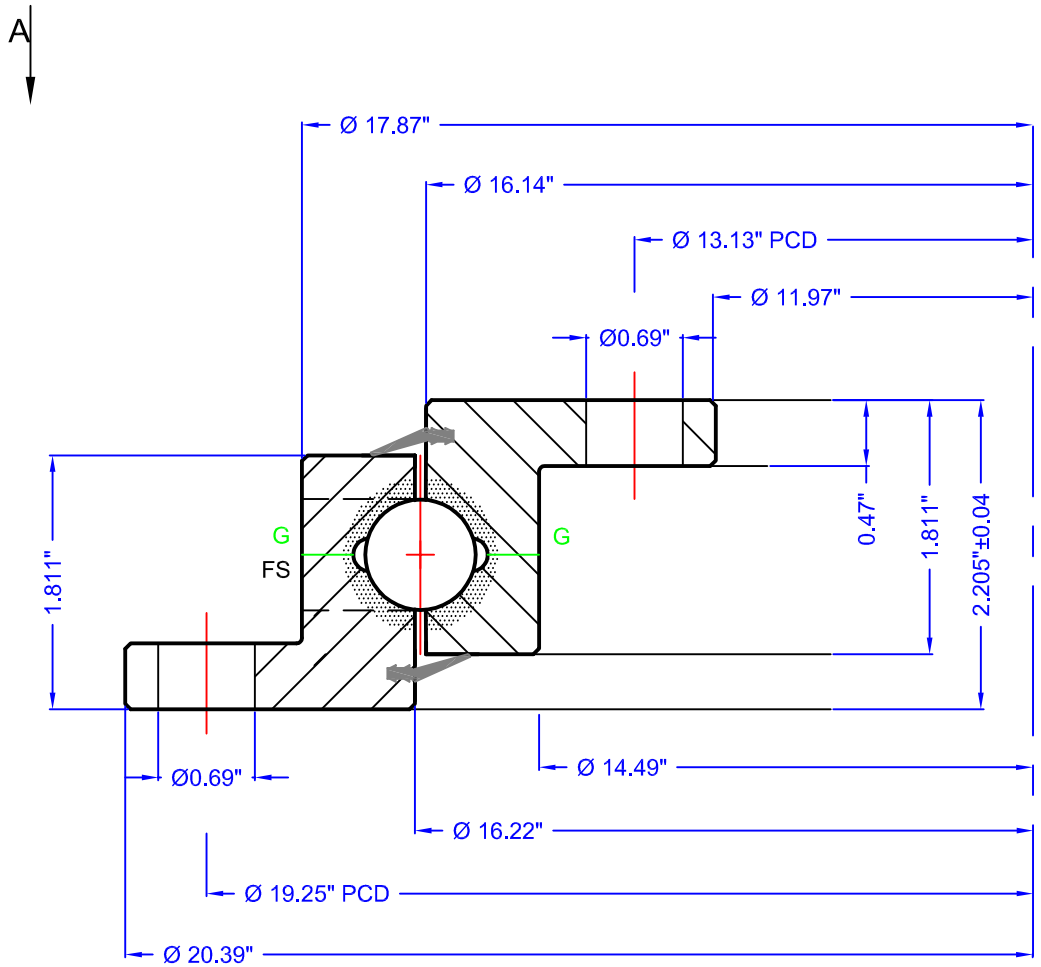
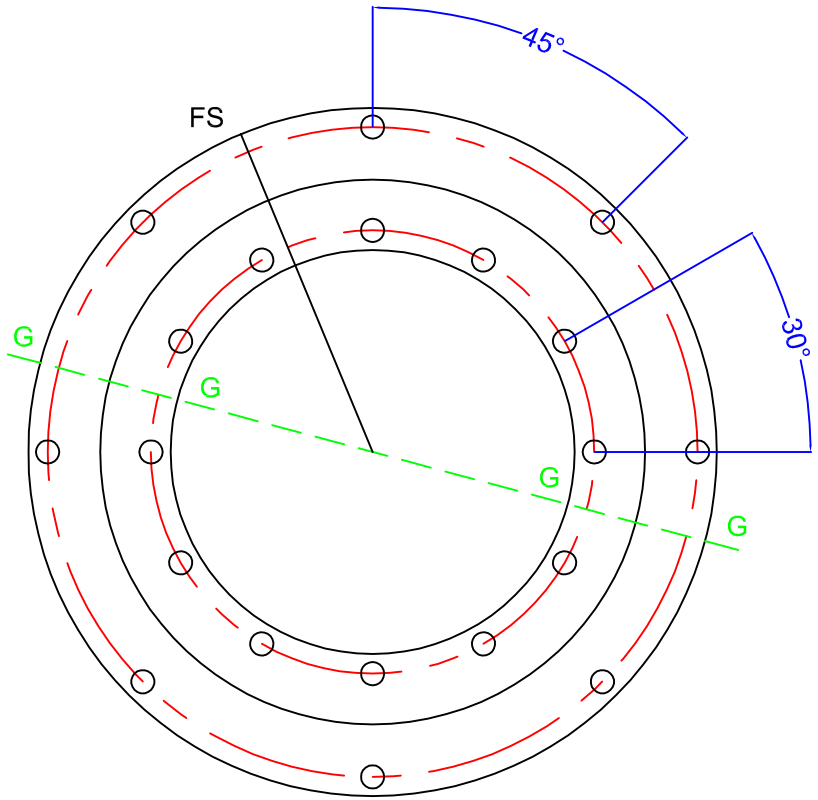
GEN. TOLERANCES	0.5 - 6	±0.1	6 - 30	±0.2	30 - 120	±0.3	120 - 315	±0.5	315 - 1000	±0.8	1000 - 2000	±1.2	2000 - 4000	±2	4000 - 8000	±3
GEN. MACHINING	√ 0.4		√ 1.6		√ 3.2		√ 6.3		√ 12.6		√ 25 ROUGH		√		√	



VIEW ON 'A' SHOWING DRILLING PATTERN AND OTHER DETAILS



GEAR DATA				
HARDENED GEAR				
NUMBER OF TEETH (z)		MODULE (m)		
PRESSURE ANGLE (∝)		DP		
ADDENDUM COEFFICIENT (x)				
PROFILE CORRECTION (xm)		CALCULATED GEAR STRENGTH		
TRUNCATION (km)		Fz (Normal)	KN	
PITCH CIRCLE DIAMETER		Fz (Max)	KN	
MEASUREMENT ON K TEETH	mm	Pin Diameter	mm	
RUNOUT NOT HARDENED/HARDENED				

Designed in accordance with designated QCB SLEWING RING STANDARDS
Non toleranced dimensions to ISO 2768-1 m
All burrs and sharp edges to be removed; Standard corner chamfer 1mm x 45°
Internal radial and axial clearance figures to QCB standard 2014 or revisions thereof
The HARDNESS GAP is to be indicated by stamped letter R or a PAINT mark on the exterior surface
The high point of gear eccentricity to be indicated by GREEN or BLUE paint on 3 teeth

BOLT DATA					
INNER	12 =	MOUNTING HOLES	Ø 0.69"	AXIAL PLAY	0.07-0.17 mm
OUTER	8 =	MOUNTING HOLES	Ø 0.69"	RADIAL PLAY	0.07-0.17 mm
GREASE HOLES	'G'		(2 + 2) 1/4"-28 UNF	TURNING TORQUE	Nm
LOADING PLUG	'FS'	SOFT ZONE	'R'	MATERIAL	50Mn
		SEAL SIZE	TBA	WEIGHT	27 kg (est)
				DEPTH OF HARDENING (55-60HRc)	mm

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REV	DATE	MODIFICATION	REVISED BY
1			

QCB Bearings — SLEWING RINGS & DRIVES

imported by NBC Group Ltd
Orleton Lane, Wellington, Telford, TF1 2BG, UK
P: 01952 222300 F: 01952 242938
www.nbcgroup.co.uk

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QCB or NBC DRAWING NUMBER

FUN 518 20 61 CC LM

QCB RS 11/2016

DRAWN:	LW
DATE:	13/05/2016
CHECKED:	LJM