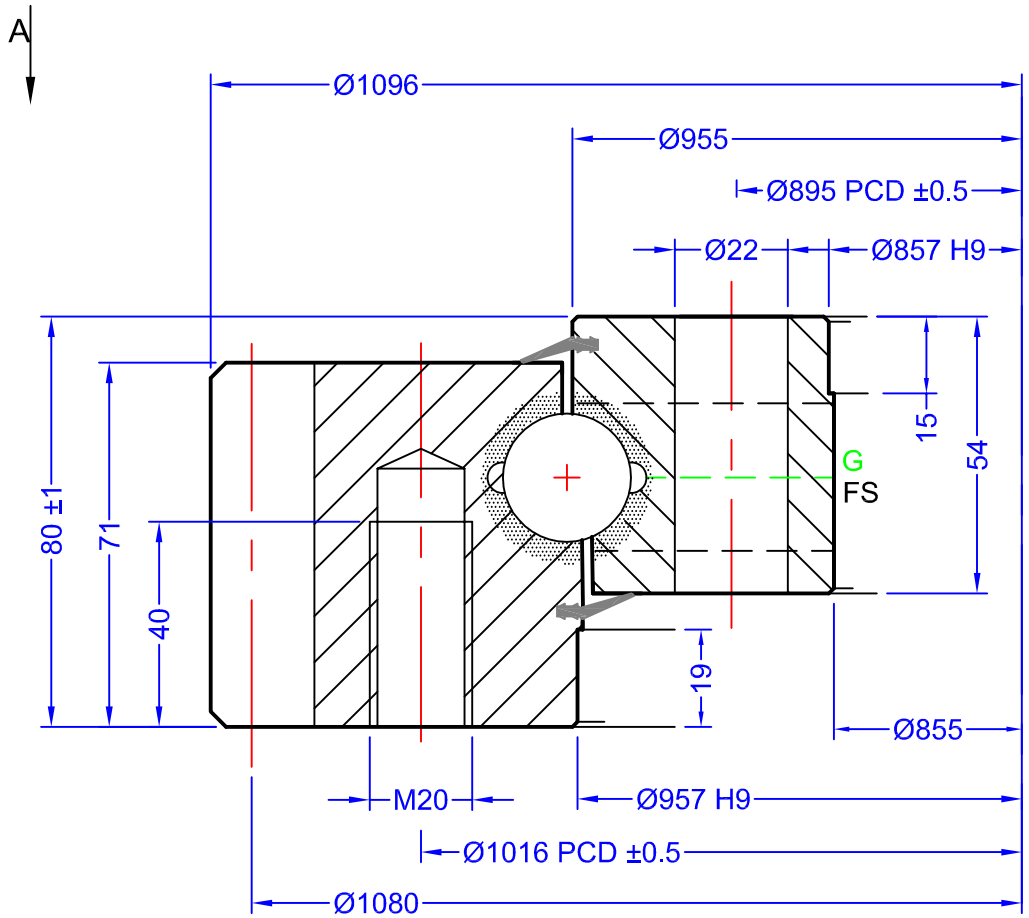
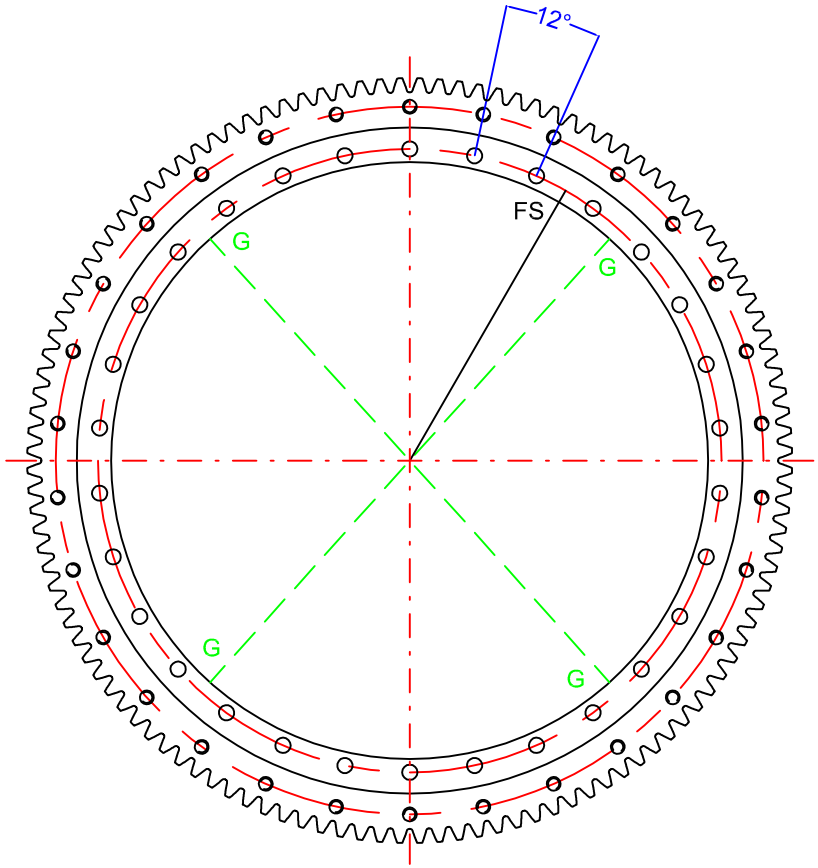
GEN. TOLERANCES	0.5 - 6	±0.1	6 - 30	±0.2	30 - 120	±0.3	120 - 315	±0.5	315 - 1000	±0.8	1000 - 2000	±1.2	2000 - 4000	±2	4000 - 8000	±3
GEN. MACHINING	0.4		1.6		3.2		6.3		12.6		25 ROUGH					



VIEW ON 'A' SHOWING DRILLING PATTERN AND OTHER DETAILS



GEAR DATA	SPUR		
HARDENED GEAR	NO		
NUMBER OF TEETH (z)	120	MODULE (m)	9
PRESSURE ANGLE (∝)	20°	DP	
ADDENDUM COEFFICIENT (x)	0		
PROFILE CORRECTION (xm)	0	CALCULATED GEAR STRENGTH	
TRUNCATION (km)	-1 mm	Fz (Normal)	KN
PITCH CIRCLE DIAMETER	1080 mm	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	30 =	MOUNTING HOLES	Ø 22	AXIAL PLAY	0.12-0.28 mm
OUTER	30 =	MOUNTING HOLES	M20	RADIAL PLAY	0.12-0.28 mm
GREASE HOLES	'G'		4 x M10	TURNING TORQUE	Nm
LOADING PLUG	'FS'	SOFT ZONE	'R'	MATERIAL	42CrMo4 Q&T
		SEAL SIZE	TBA	WEIGHT	155 kg (est)
				DEPTH OF HARDENING (55-60HRc)	mm

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

QCB or NBC DRAWING NUMBER

SEG 1100 25 01 AA LM

QCB RS 11/2016

DRAWN:	LW
DATE:	04/01/2016
CHECKED:	LJM