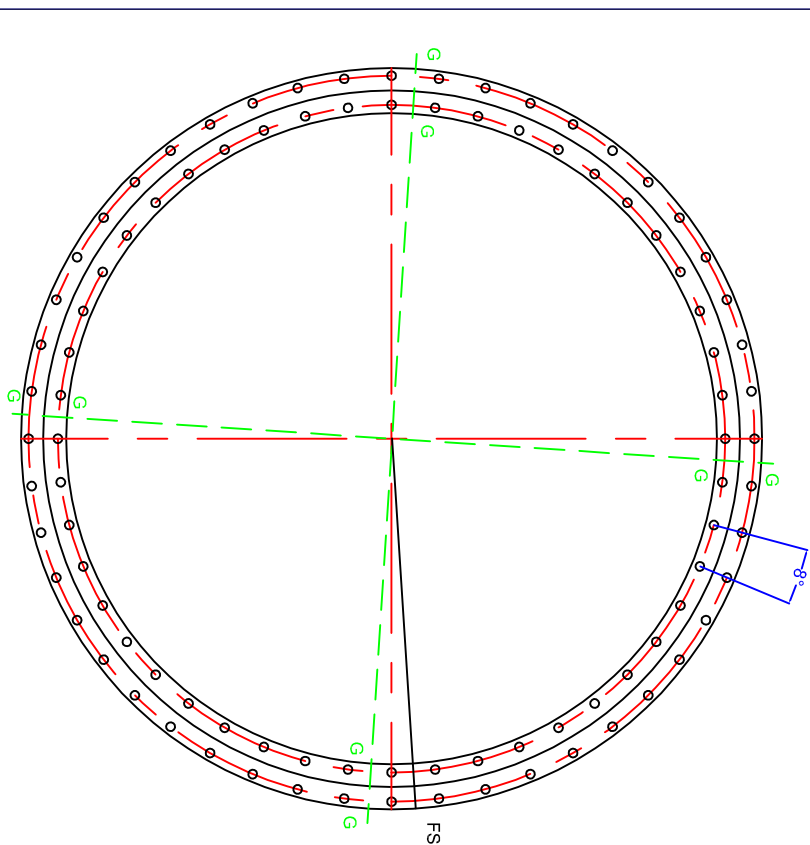
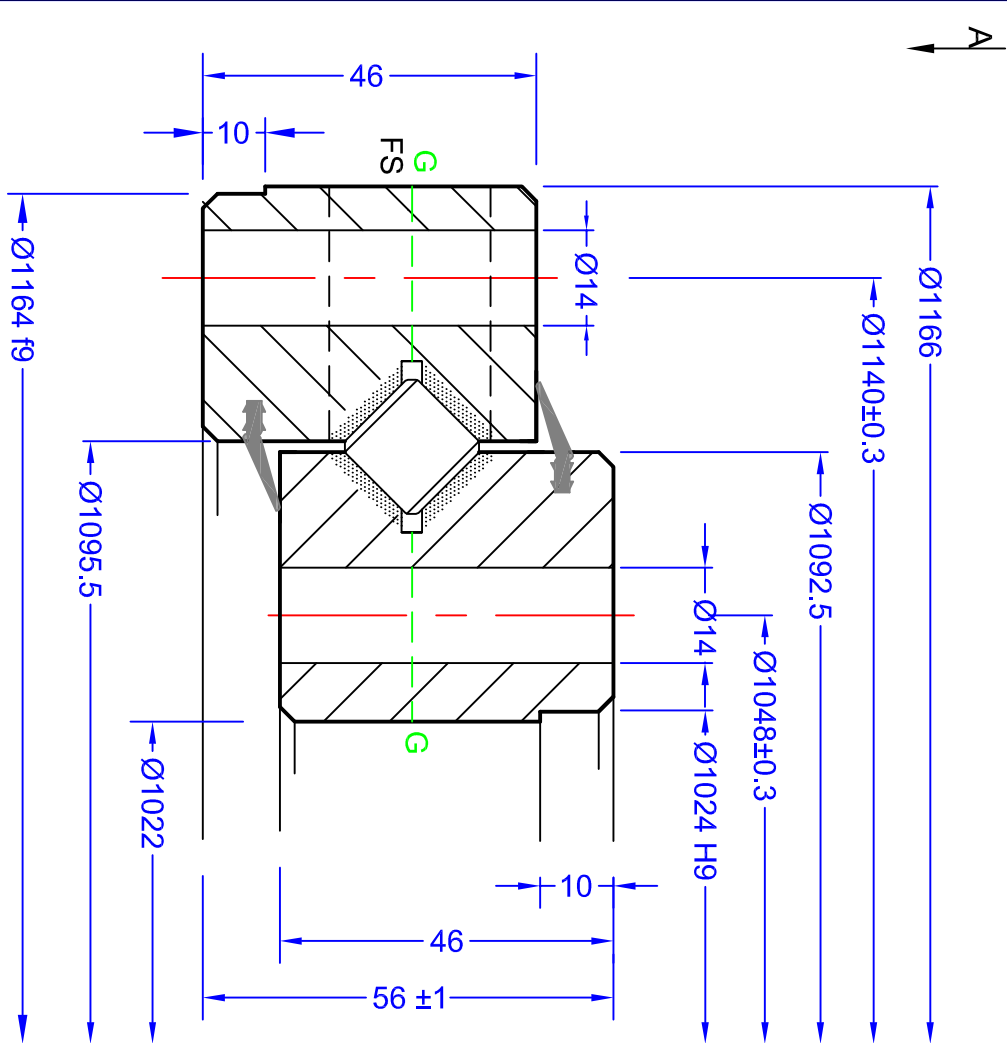


GEN. TOLERANCES	0.5 - 6	±0.1	6 - 30	±0.2	30 - 120	±0.3	120 - 315	±0.5	315 - 1000	±0.8	1000 - 2000	±1.2	2000 - 4000	±2	4000 - 8000	±3
GEN. MACHINING	✓	0.4	✓	1.6	✓	3.2	✓	6.3	✓	12.6	✓	25 ROUGH	✓			



VIEW ON 'A' SHOWING DRILLING PATTERN AND OTHER DETAILS

GEAR DATA		Designed in accordance with designated QCB SLEWING RING STANDARDS													
HARDENED GEAR		Non toleranced dimensions to ISO 2768-1 m													
NUMBER OF TEETH (z)	MODULE (m)	All burrs and sharp edges to be removed; Standard corner chamfer 1mm x 45°													
PRESSURE ANGLE (α)	DP	Internal radial and axial clearance figures to QCB standard 2014 or revisions thereof													
ADDENDUM COEFFICIENT (x)		The HARDNESS GAP is to be indicated by stamped letter R or a PAINT mark on the exterior surface													
PROFILE CORRECTION (y)		The high point of gear eccentricity to be indicated by GREEN or BLUE paint on 3 teeth													
CALCULATED GEAR STRENGTH		BOLT DATA													
TRUNCATION (mm)	Fz (Normal)	KN	INNER	48 =	MOUNTING HOLES	Ø 14	TURNING TORQUE		AXIAL PLAY	0.12-0.28 mm					
PITCH CIRCLE DIAMETER	Fz (Max)	KN	OUTER	48 =	MOUNTING HOLES	Ø 14	MATERIAL	42CrMo4 Q&T	RADIAL PLAY	0.12-0.28 mm					
MEASUREMENT ON K TEETH	Pin Diameter	mm	GREASE HOLES	G'	2 X 4 X M8	WEIGHT	77 kg (SB)								
RUNOUT NOT HARDENED/HARDENED			LOADING PLUG	'FS'	SOFT ZONE	'R'									
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DATE

MODIFICATION

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QCB

Bearings

SLEWING

RINGS &

DRIVES

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QCB RS 11/2016