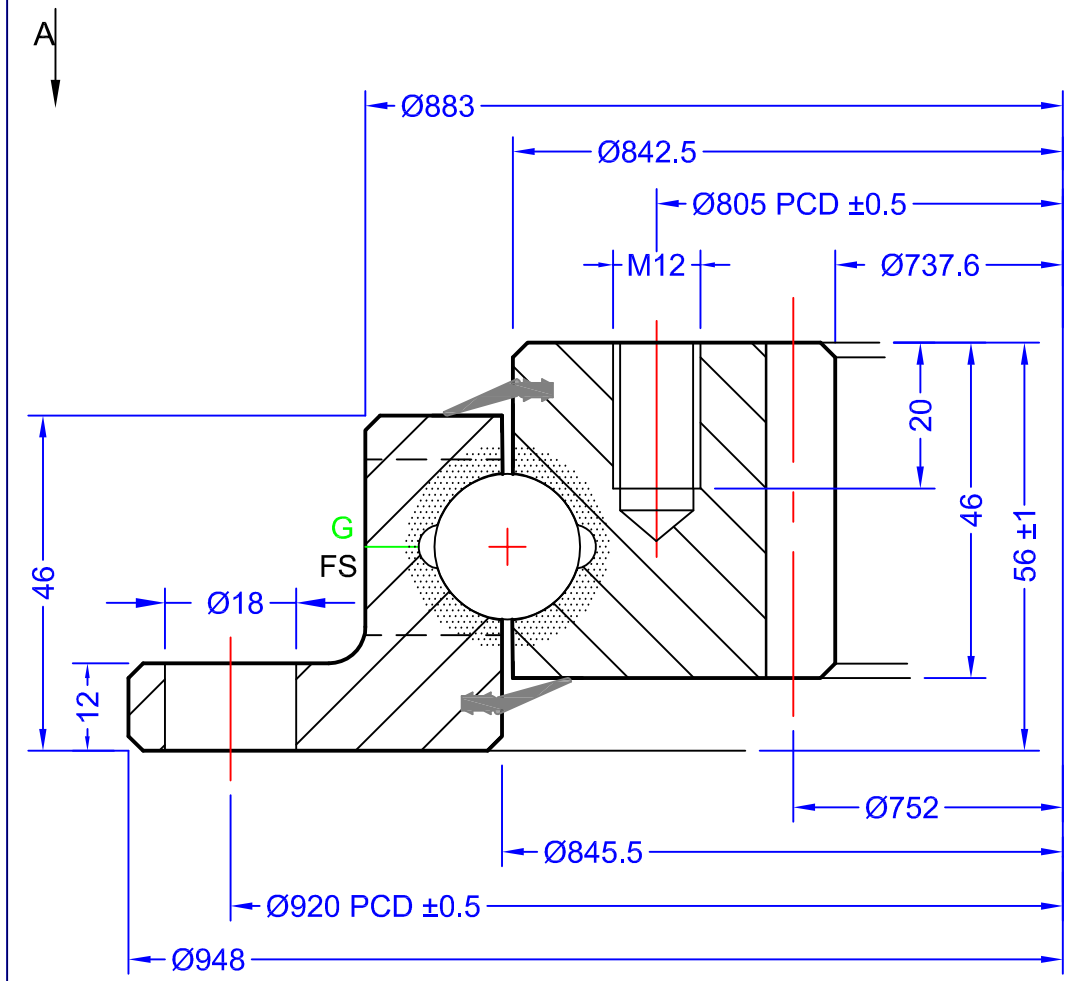
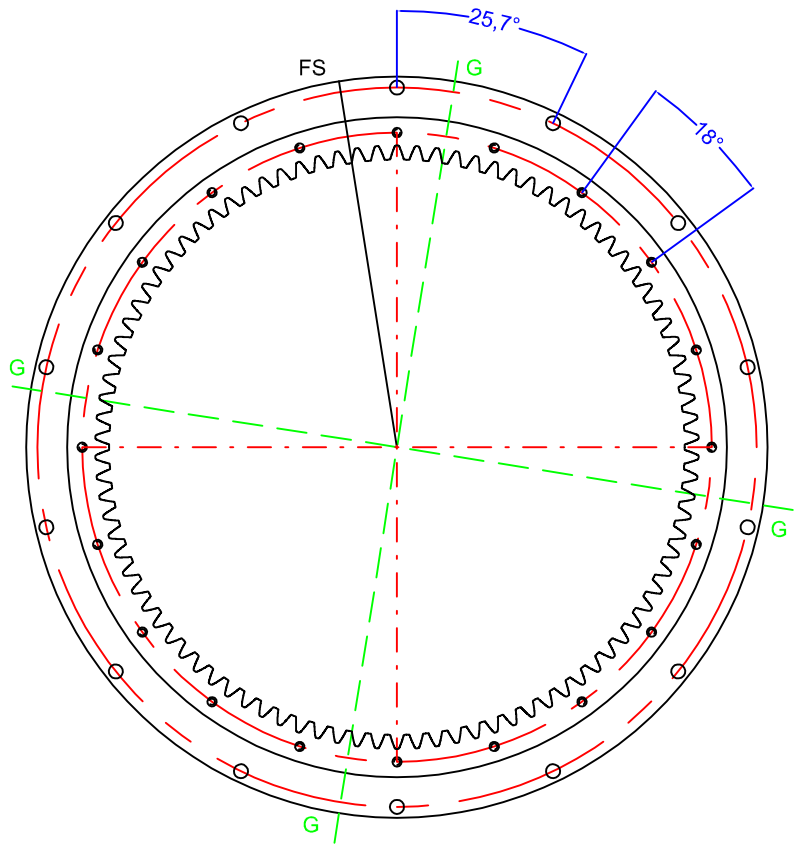
GEN. TOLERANCES	0.5 - 6	±0.1	6 - 30	±0.2	30 - 120	±0.3	120 - 315	±0.5	315 - 1000	±0.8	1000 - 2000	±1.2	2000 - 4000	±2	4000 - 8000	±3
GEN. MACHINING	0.4		1.6		3.2		6.3		12.6		25 ROUGH					



VIEW ON 'A' SHOWING DRILLING PATTERN AND OTHER DETAILS



GEAR DATA	SPUR		
HARDENED GEAR	NO		
NUMBER OF TEETH (z)	94	MODULE (m)	8
PRESSURE ANGLE (∝)	20°	DP	
ADDENDUM COEFFICIENT (x)	0		
PROFILE CORRECTION (xm)	0	CALCULATED GEAR STRENGTH	
TRUNCATION (km)	-0.8 mm	Fz (Normal)	KN
PITCH CIRCLE DIAMETER	752 mm	Fz (Max)	KN
MEASUREMENT ON K TEETH		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	20 =	MOUNTING HOLES	M12	AXIAL PLAY	0.12-0.28 mm
OUTER	14 =	MOUNTING HOLES	Ø 18	RADIAL PLAY	0.12-0.28 mm
GREASE HOLES	'G'		4 x M8	TURNING TORQUE	Nm
LOADING PLUG	'FS'	SOFT ZONE	'R'	MATERIAL	42CrMo4 Q&T
		SEAL SIZE	TBA	WEIGHT	61 kg (est)
				DEPTH OF HARDENING (55-58HRc)	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

FIG 950 20 00 AA LM

DRAWN:	LJM
DATE:	2/12/2015
CHECKED:	LJM

QCB RS 11/2016