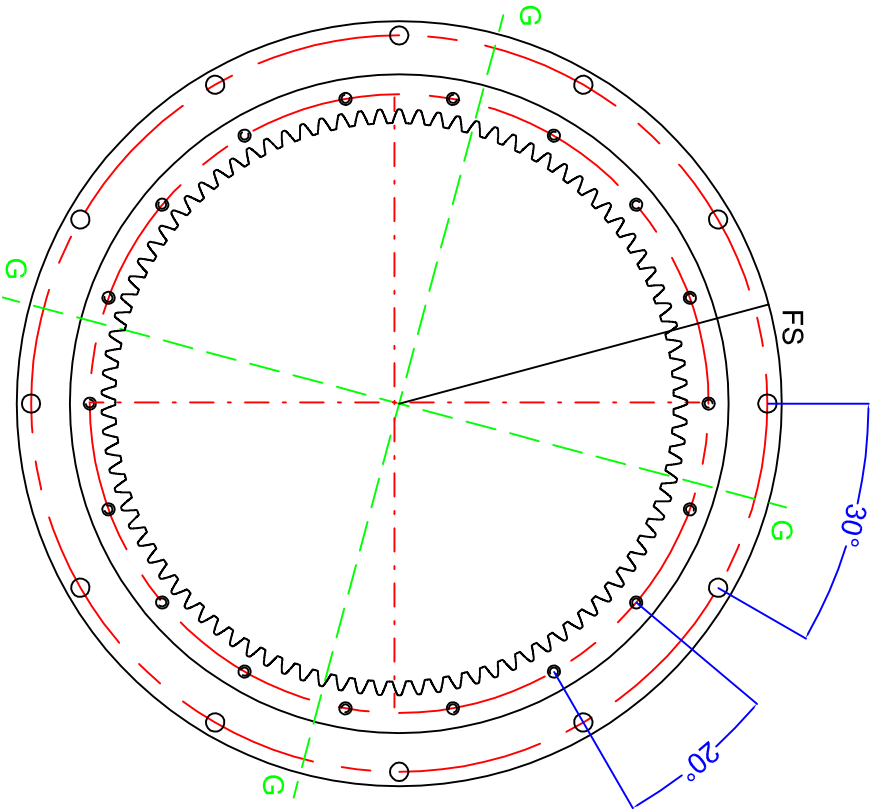
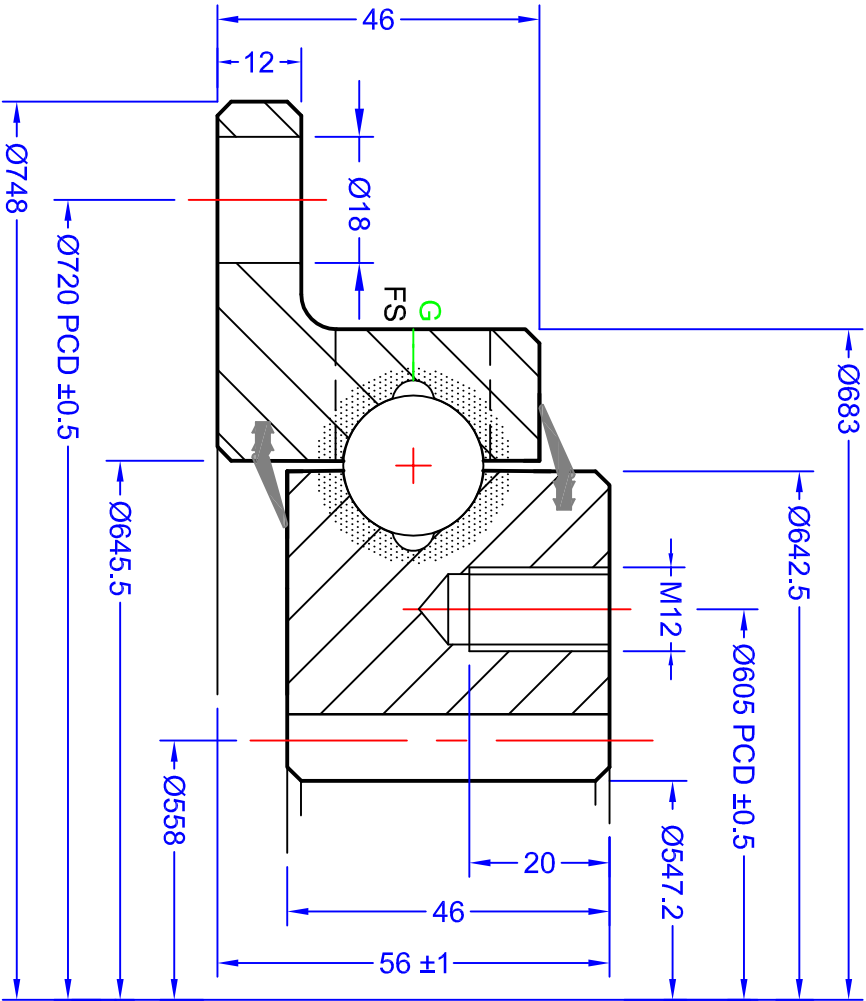
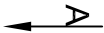


GEN. TOLERANCES	0.5 - 6	±0.1	6 - 30	±0.2	30 - 120	±0.3	120 - 315	±0.5	315 - 1000	±0.8	1000 - 2000	±1.2	2000 - 4000	±2	4000 - 8000	±3
GEN. MACHINING	✓	0.4	✓	1.6	✓	3.2	✓	6.3	✓	12.6	✓	25 ROUGH	✓			



VIEW ON 'A' SHOWING DRILLING PATTERN AND OTHER DETAILS

GEAR DATA		SPUR		Designed in accordance with designated QCB SLEWING RING STANDARDS											
HARDED GEAR	NO	Non tolerated dimensions to ISO 2768-1 m													
NUMBER OF TEETH (Z)	93	MODULE (m)		All burrs and sharp edges to be removed; Standard corner chamfer 1mm x 45°											
PRESSURE ANGLE (α)	20°	DP		Internal radial and axial clearance figures to QCB standard 2014 or revisions thereof											
ADDENDUM COEFFICIENT (x)	0	CALCULATED GEAR STRENGTH		The HARDNESS GAP is to be indicated by stamped letter R or a PAINT mark on the exterior surface											
PROFILE CORRECTION (mm)	0	CALCULATED GEAR STRENGTH		The high point of gear eccentricity to be indicated by GREEN or BLUE paint on 3 teeth											
TRUNCATION (mm)	-0.6 mm	Fz (Internal)		BOLT DATA											
PITCH CIRCLE DIAMETER	558 mm	Fz (Max)		INNER	18 =	MOUNTING HOLES	M 12	TURNING TORQUE	Nm						
MEASUREMENT ON K TEETH	mm	Pin Diameter		OUTER	12 =	MOUNTING HOLES	Ø 18	MATERIAL	42CrMo4 Q&T						
RUNOUT NOT HARDENED/HARDED				GREASE HOLES	G'		4 X M8	WEIGHT	47,5 kg (est)						
				LOADING PLUG	FS'	SOFT ZONE	'R	DEPTH OF HARDENING (Scale 0)	mm						
				SEAL SIZE	TBA										
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REV	DATE	MODIFICATION	REVISED BY

QCB
Bearings

SLEWING
RINGS &
DRIVES

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FIG 750 20 00 AA LM

QCB RS 11/2016