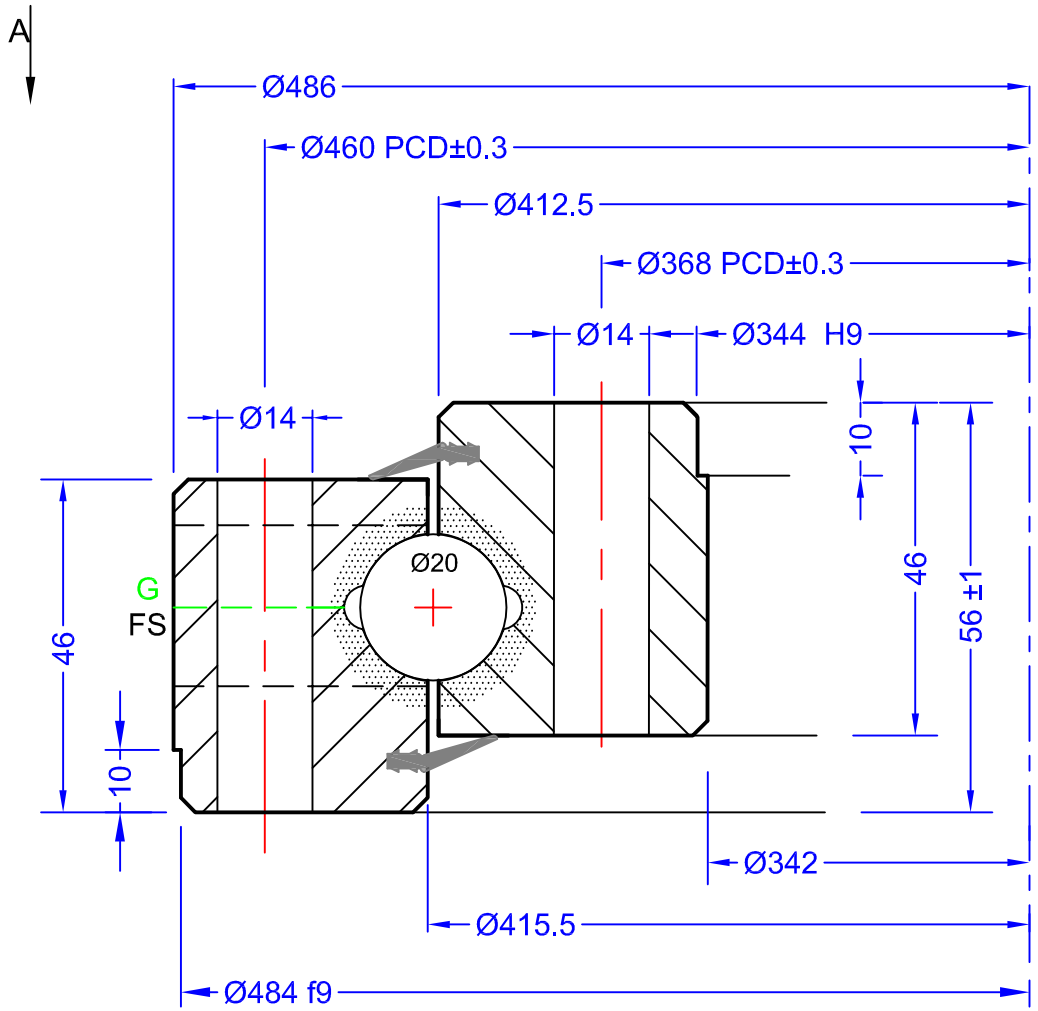
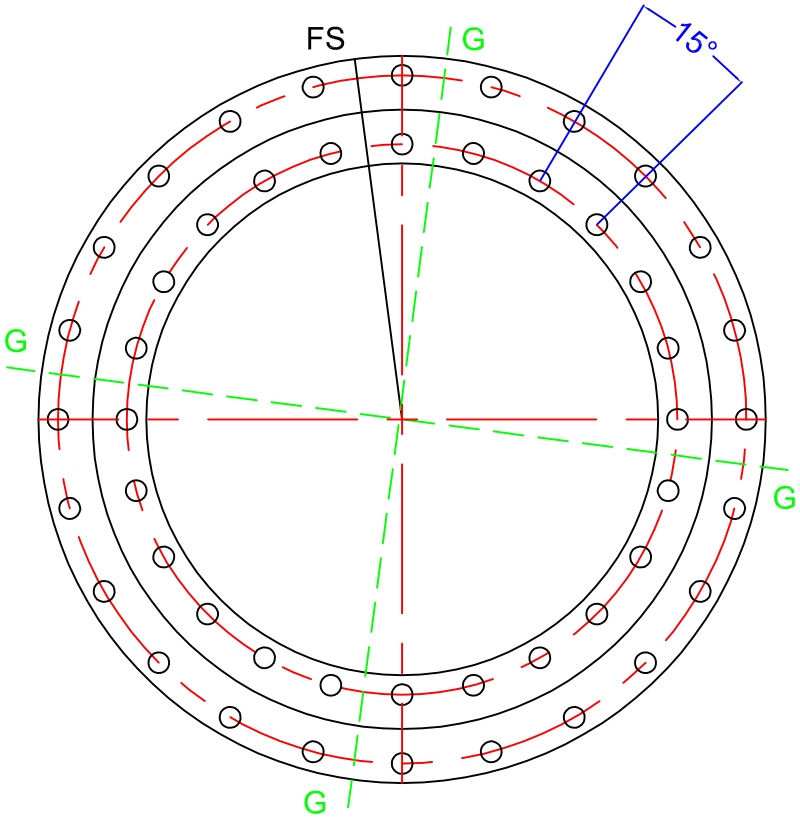
GEN. TOLERANCES	0.5 - 6	±0.1	6 - 30	±0.2	30 - 120	±0.3	120 - 315	±0.5	315 - 1000	±0.8	1000 - 2000	±1.2	2000 - 4000	±2	4000 - 8000	±3
GEN. MACHINING	0.4		1.6		3.2		6.3		12.6		25 ROUGH					



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		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	24 =	MOUNTING HOLES	Ø 14	AXIAL PLAY	0.07-0.17 mm
OUTER	24 =	MOUNTING HOLES	Ø 14	RADIAL PLAY	0.07-0.17 mm
GREASE HOLES	'G'		4 x M8	TURNING TORQUE	Nm
LOADING PLUG	'FS'	SOFT ZONE	'R'	MATERIAL	50Mn
		SEAL SIZE	TBA	WEIGHT	30 kg (est)
				DEPTH OF HARDENING (55-60HRc)	mm

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REV	DATE	MODIFICATION	REVISED BY
1			

QCB Bearings — SLEWING RINGS & DRIVES

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QCB or NBC DRAWING NUMBER

SUN 486 20 01 CC LM

QCB RS 11/2016

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