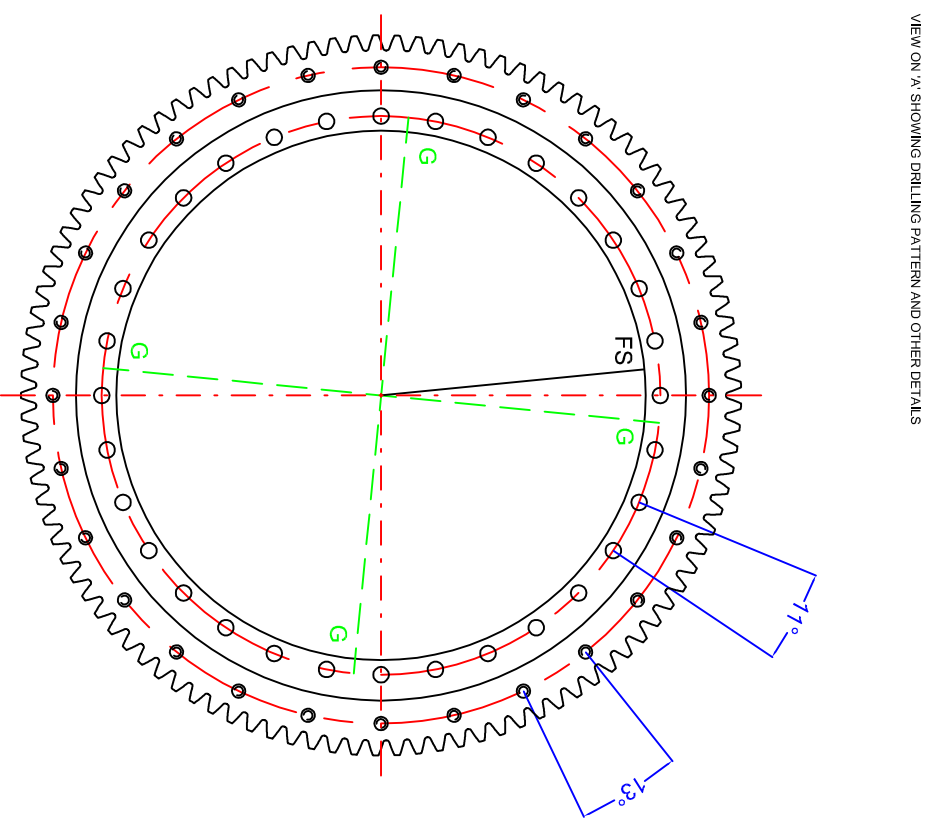
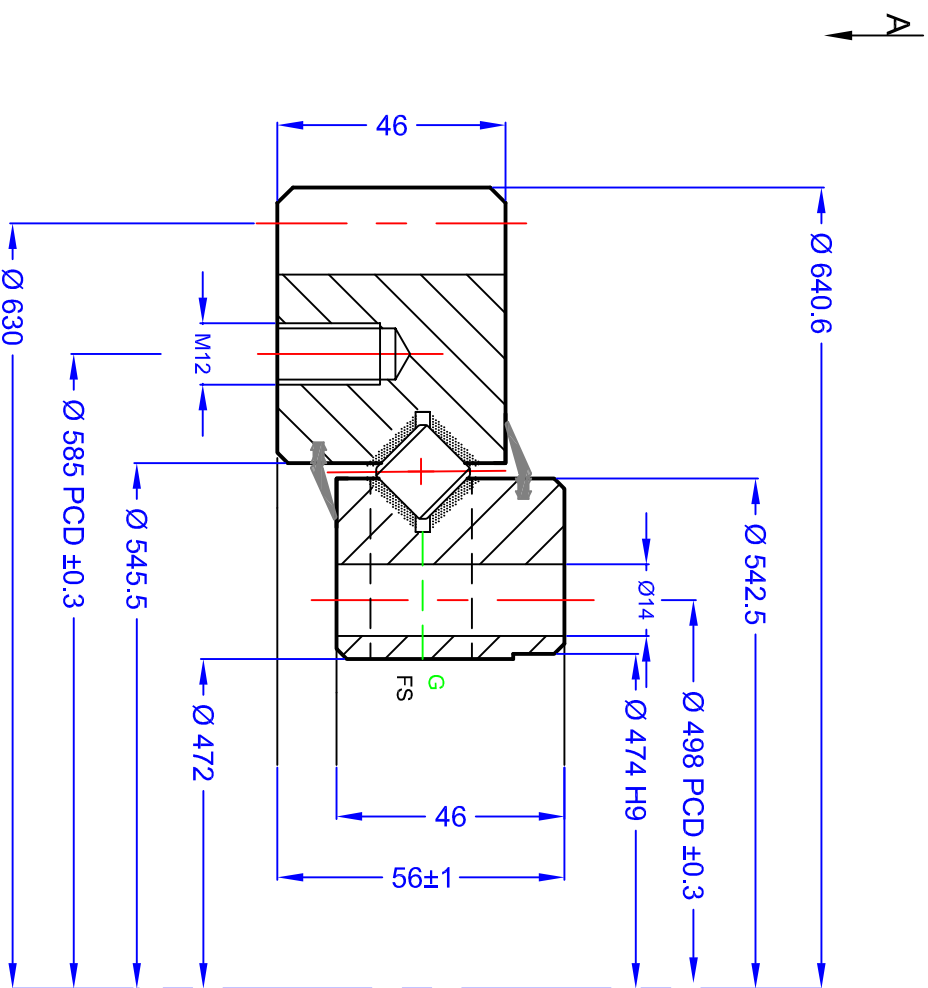


GEN. TOLERANCES								
	0.5 - 6	±0.1	6 - 30	±0.2	30 - 120	±0.3	120 - 315	±0.5
GEN. MACHINING	✓	0.4	1.6	✓	3.2	✓	6.3	✓
							12.6	✓
							25 ROUGH	✓
								✓
								±2
								4000 - 8000
								±3



BLACK OXIDE TREATMENT			YES / NO	
GEAR DATA		SPUR	WORM	HELICAL
HARDENED GEAR		NO		
NUMBER OF TEETH (Z)		105		
PRESSURE ANGLE (α)		20°		
ADDENDUM COEFFICIENT (α)		0		
PROFILE CORRECTION (xm)		0		
TROCHICATION (mm)		-0.7 mm		
PITCH CIRCLE DIAMETER		630 mm		
MEASUREMENT ON K TEETH		mm		
RUNOUT NOT HARDENED/HARDENED		Pn Diameter mm		
LEADING PLUG		LOADING PLUG		
SEAL SIZE		TBA		
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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 radii and axial clearance figures to QCB standard 2014 or revisions thereof				
The HARDNESS GAP is to be indicated by stamped letter R or a PLAIN mark on the exterior surface				
The high point of gear eccentricity to be indicated by GREEN or BLUE paint on 3 teeth				

BOLT DATA				AXIAL PLAY		RADIAL PLAY	
INNER				32 =		MOUNTING HOLES Ø14	
OUTER				28 =		MOUNTING HOLES M12	
GREASE HOLES				G*		4 x M8	
SOFT ZONE				F5S		R*	
SEAL SIZE				TBA			

QCB		SLEWING RINGS & DRIVES		QCB® is a registered trademark of NBC Group Ltd	
Bearings					

1	DATE	MODIFICATION	REVISED BY
REV	DATE	MODIFICATION	REVISED BY

QCB 650 X14 01 AA LM		Orleton Lane, Wellington, Telford, TF1 2BG, UK	
SEG 650 X14 01 AA LM		P: 01952 222300 F: 01952 242938	
QCB RS 11/2016		www.nbcgroup.co.uk	

QCB or NBC DRAWING NUMBER		DRAWN: LW	
DATE: 15/12/2016		CHECKED: LM	