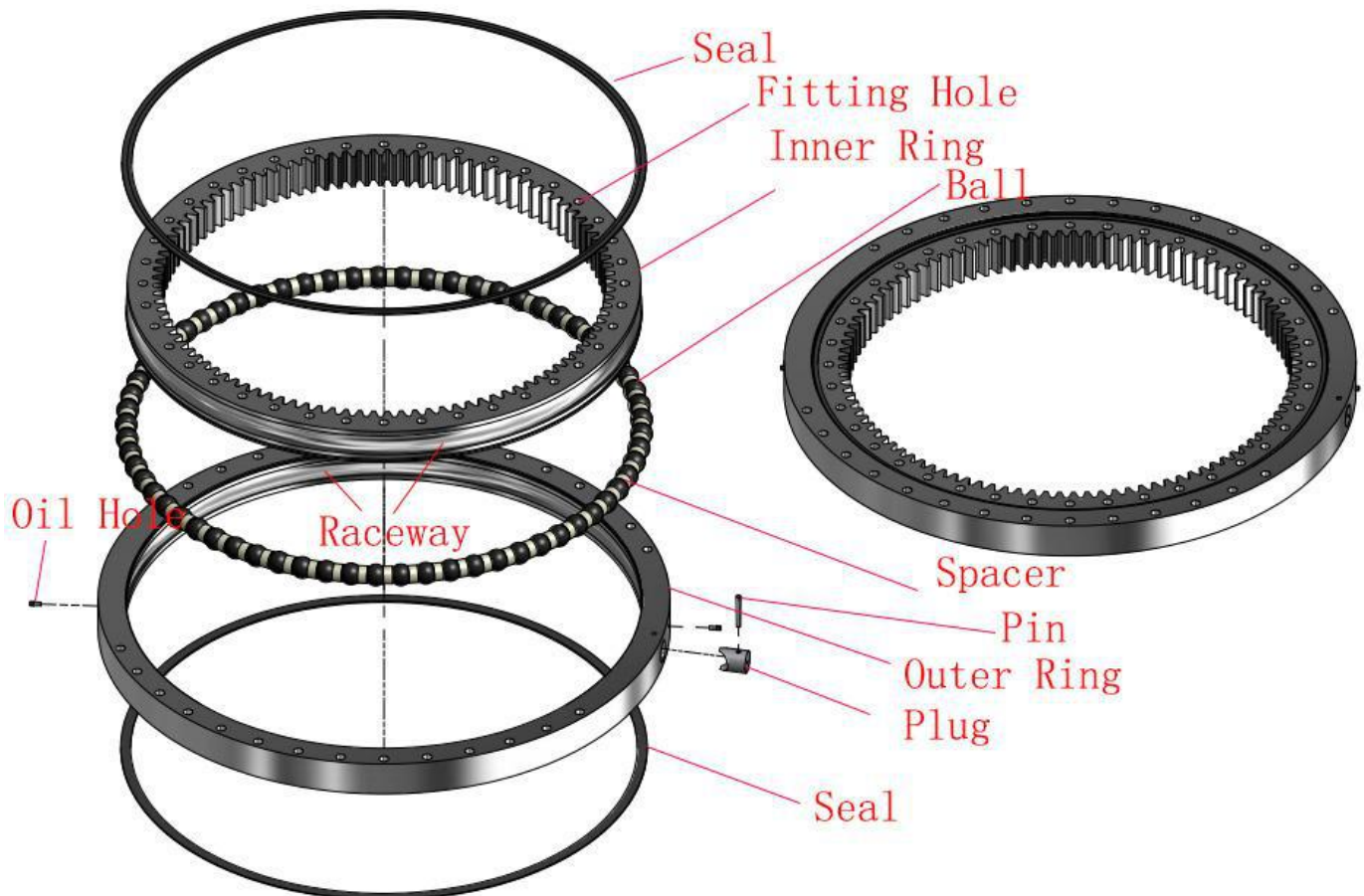


INSTALLATION & MAINTENANCE

1. Structure of Slewing Rings



2. Installation

A, Flatness requirement of the mounting surface

In order to avoid localized overload and make sure the slewing rings can be turned smoothly, the flatness of the mounting surface should be clean, flat and controlled as the following table:

Race way center diameter	Flatness Deviation		
	Four Point Contact Ball Type	Double Row Type	Roller Type
≤1000mm	0.15	0.20	0.10
1000-1500	0.19	0.25	0.12
1500-2000	0.22	0.30	0.15
2000-2500	0.25	0.35	0.17
2500-4000	0.30	0.40	0.20

B, The soft zone (marked by the letter "S") and the loading plug should be located at non-loading area or light-loading area.

C, The strength grade of mounting bolt must be no less than 8.8 grade. The bolt must have enough pre-tightening force and

the pre-tightening force must be in the range of 0.6-0.7 times of the bolt material yield strength.

D,The pinion must be installed from the gear which painted green.

3.Maintenance

A,The slewing rings can not been cleaned with water directly,prevent water and any other objects into the raceway.

B,The slewing rings had been filled with a little EP2 based grease in the raceway before delivery.Make sure to fill the slewing rings with enough grease before installation and fill the grease again every 50-60 working hours(except bad environment).Also,In order to make sure the grease evenly lubricated,the slewing rings must be rotate smoothly when filling.

C, In order to prevent any objects falling into the raceway,please check the seals often to make sure it is ok.

D, If there is any abnormal phenomenon,such as noise, shock, and suddenly increasing driving force, Please stop working, find out the problem and remove it.

E,If the slewing rings stocked in the warehouse for more than 6 months,please filling the grease again and do rust prevention with anti-rust oil.

F,If there is noise when turning the slewing rings,please try to check the gear clearance is ok between the slewing rings and pinion or try to fill more grease or check the flatness of the mounting table or check the load capacity of the slewing rings is enough or check the uneven pre-tension force of the mounting bole.

G,We don't advise non-professionals person to disassemble the slewing rings and mixed assemble the slewing ring with different outer ring and inner ring due to clearance problem.

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