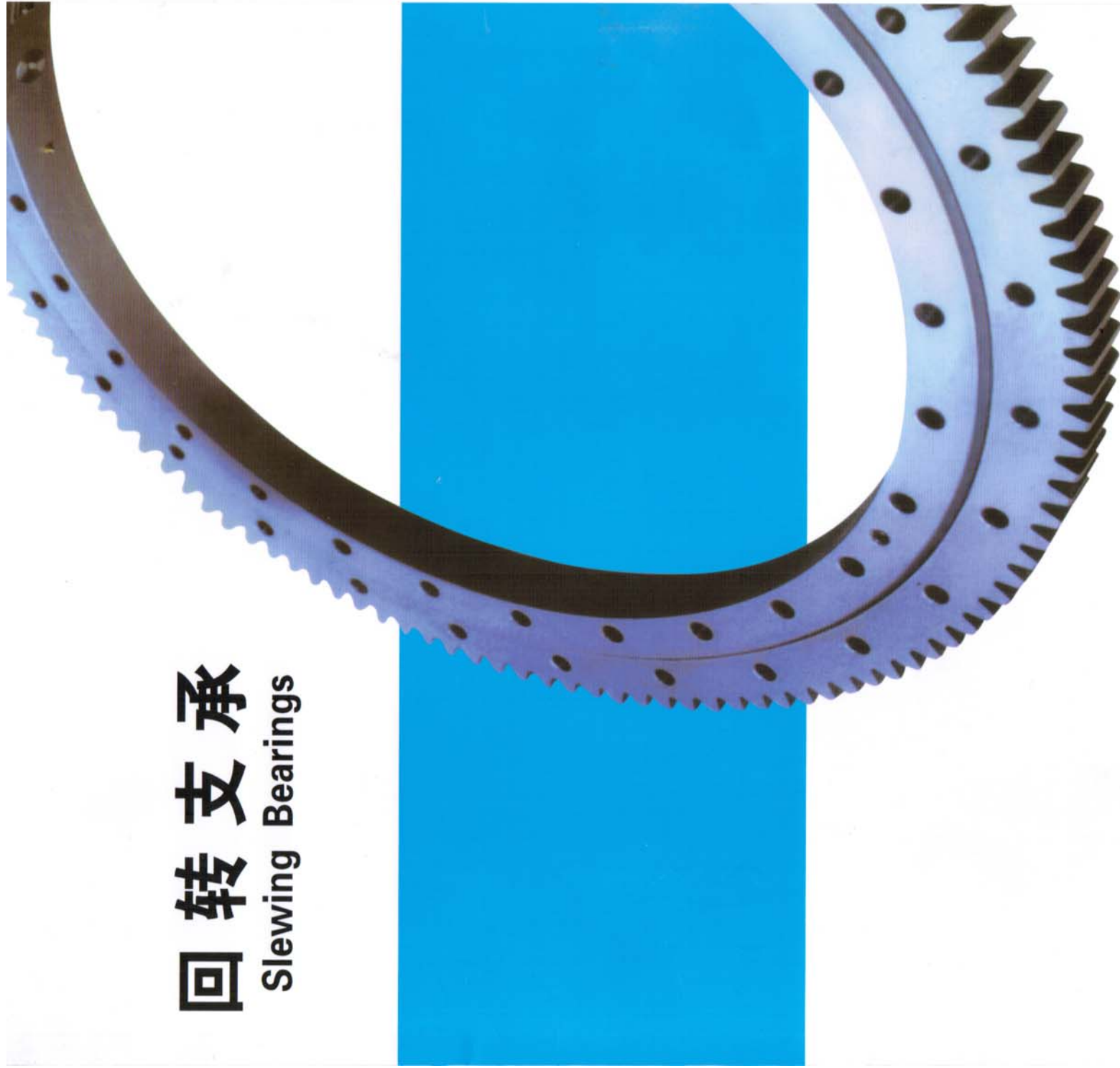


回转支承

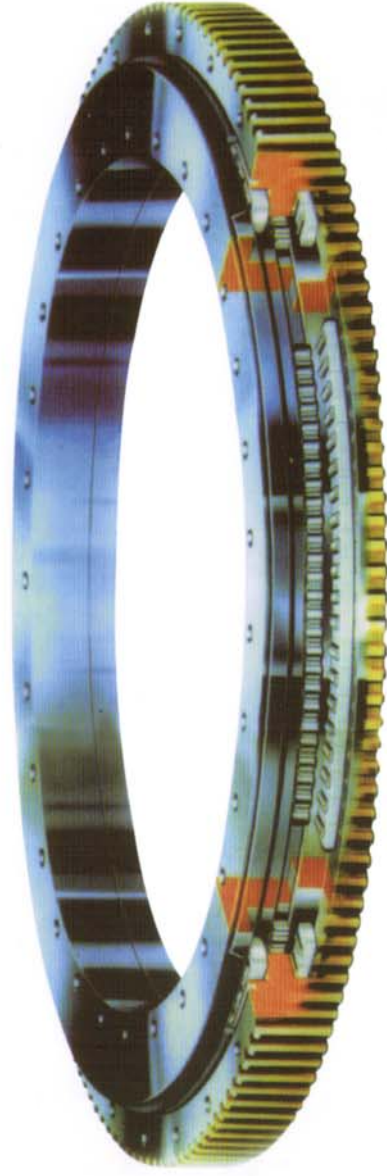
Slewing Bearings



徐州天龙回转支承有限公司

XUZHOU TIANLONG SLEWING RING BEARINGS CO.,LTD

用/心/打/造/精/品



徐州天龙回转支承有限公司

XUZHOU TIANLONG SLEWING RING BEARINGS CO.,LTD

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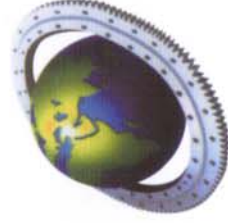
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1 企业简介 About us

徐州天龙回转支承公司坐落于经济发达、风景秀丽、交通便利的徐州南城区—工业园，是一家从事回转支承制造与开发的厂家。

本公司生产的回转支承具有结构紧凑、重量轻、刚性好、运转平稳、精度高、安全可靠等优点；可同时承受轴向力、径向力、倾覆力矩，是承受重负荷、低转速的理想部件；该产品广泛应用于工程、矿山、冶金、船舶、港口、石油、化工、食品、航空、军工、仪器、仪表等行业。

本公司已通过 ISO9001 质量体系认证。我们将以一贯的经营作风—信守承诺，一如既往的向广大新老客户提供高质量的产品、及时有效的服务。

欢迎八方宾客来人、来函洽谈业务。

Xuzhou Tianlong slewing bearings CO.,LTD is located in the industrial park in southern new zone known as a place has developed economy, beautiful scenery and convenient transportation.it is a factory where slewing bearings are built.

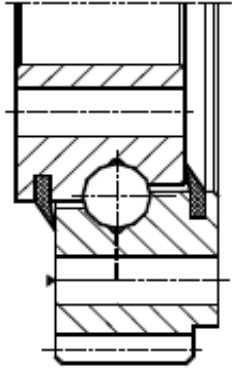
The slewing bearings produced by our company has many advantages,such as ,compact structure,light, weight,good rigidity of structure,smooth operation,high accuracy and reliable safety,etc.Meanwhile,they can bear axial force,radiial force and overturning movement, they are the ideal components which can bear heavy loading and low speed. Our products have widely applied to construction, mine, metallurgy, shipment, harbor, chemical,industry,food,aviation,military industry,instrument,meter,ect.

Our company has been certified by the ISO9001-quality system.We will offer high quality products and efficiency service for our old and new clients as our old managing fashion—keep our promise.

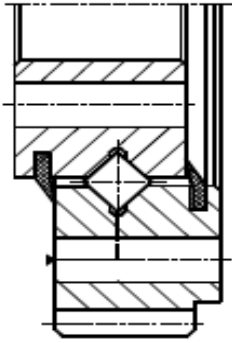
Welcome guests from different places to discuss our cooperation.

2、回转支承结构型式 *Structural types of the slewing bearings*

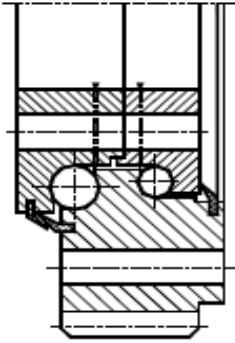
单排四点接触球式 Single-row four-point contact ball



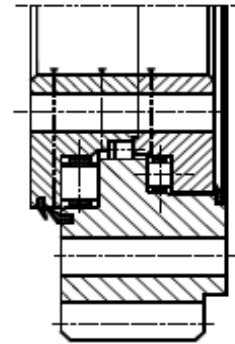
单排交叉滚柱式 Single-row cross roller



双排异径球式 Double-row ball



三排滚柱式 Triple-row roller



3 回转支承编号方法 Nubering of slewing bearings

3.回转支承编号方法 <i>JB/T2300-2011</i>		<i>The numbering of the slewing bearings JB2300-2011</i>	
(1)回转支承类型及系列		(1) types and series of slewing bearings	
0-球类回转支承		0-ball slewing bearings	
1-滚柱类回转支承		1-roller slewing bearings	
(2) 滚道结构形式		(2) types of raceway's structure	
单排交叉滚柱式、单排四点接触球式		single-row cross roller 、 single-row four-point contact ball	
双排异径球式		double-row different diameter ball	
三排滚柱式		triple-row roller	
(3)传动方式		(3) the types of transmission	
0-无齿		0-gearless	
1-圆柱齿轮外啮合小模数		1- cylindrical gear external gearing minor modulus	
1-圆柱齿轮外啮合大模数		2- cylindrical gear external gearing large module	
1-圆柱齿轮内啮合小模数		3- cylindrical gear internal gearing minor module	
1-圆柱齿轮外啮合小模数		4- cylindrical gear internal gearing large module	
(4)滚动体（钢球或滚柱）直径		(4) rolling element's(steel ball or roller) diameter	
(5) 滚道中心直径		raceway centre's diameter	

基本型号规格举例说明

Illustration of the basic type's specification

0	1	2	40	1000	·	xxx	·	xx	·	xx
公司内部编号		Company's internal number		滚道中心直径		Raceway centre's diameter		滚动体直径		Rolling element's diameter
齿轮啮合方式		Fashion of gearing		滚道结构型式		Type of raceway		回转支承类型		Types of slewing bearings

因此：此回转支承为单排球外齿式、钢球直径 40mm、滚道中心直径 1000mm
Conclusion: this slewing bearing is single-row ball external gearing, and its steel ball's diameter is 40mm, the raceway center's diameter is 1000mm.

说明：Introduction:

- 1、样本中回转支承为标准产品，如有以下情况请在合同中注明或附图
- (1) 有止口配合要求

(2) 安装孔非均布

(3) 安装孔螺紋孔

(4) 齿轮热处理方式（齿面淬火、齿根齿面淬火、全齿淬火）
- 2、用户若需其它异型回转支承请与本公司联系
- 3、回转支承选型计算请参考 4.4
- 4、回转支承安装时请参考安装说明书
1. this sample is the standard product of slewing bearing, please mark out or attach pictures to our contract if meeting the circumstances as follows:
- (1). the fitting size requirements;

(2). the installation holes are not equi spaced;

4 回转支承选型计算 Seiection calculation of slewing bearings

- (3). the installation holes are threaded holes;
- (4). heat treatment method of the gears(HQ on the gear's suface, root and whole part).
2. Please contact us if you need other different types of slewing bearing.
3. Selection calculation of slewing bearings, please refer to 4.4.
4. Please refer to the instruction of installation and usage when installing the slewing bearing.

4. 回转支承选型计算 selection calculation of slewing bearings

4.1 回转支承受载情况:

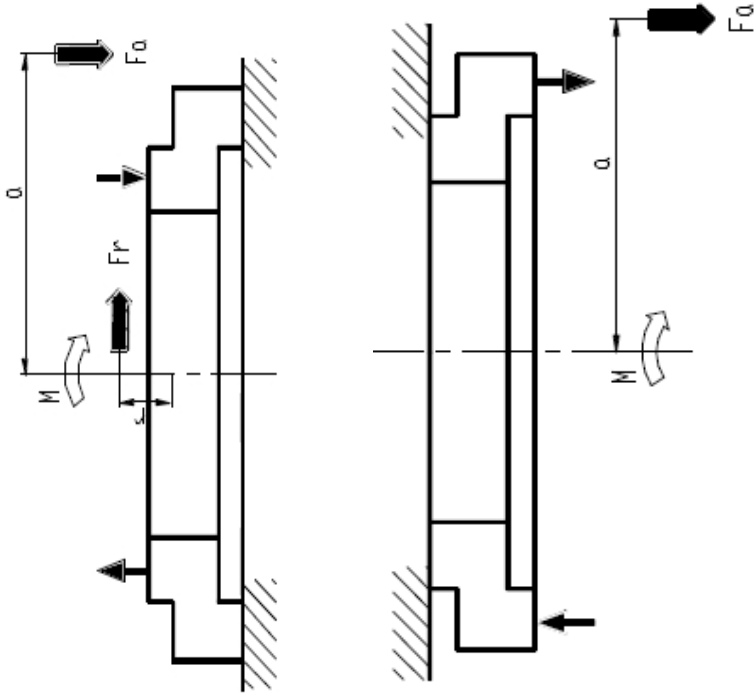
回转支承在使用过程中一般承受轴向力 Fa、径向力 Fr、倾覆力矩 M 的共同作用，对不同的应用场合，由于主机的工作方式及结构型式不同，上述三各载荷的作用组合情况将有所变化，有时可能是两载荷的共同作用，有时也有可能仅仅是一个载荷的单独作用。

通常，回转支承的安装方式有以下两种型式，座式安装和悬挂安装两种安装形式，支承承受的载荷示意如下：

4.1 load condition of slewing bearing

During the process of working, the slewing bearing generally endures the interaction of bearing axial force, radial force and overturning movement. At different circumstances, the above three loads' interaction may change because of the different working methods and structures of the main engine. Sometimes it may be the interaction of two loads, or may be just affected by one load.

Normally, there are two installation methods of slewing bearing, horizontal installation and suspended installation. These two installation's supported load conditions are shown as follows:



4 回转支承选型计算 Seiection calculation of slewing bearings

4.2 回转支承选型所需的技术参数

- 1、回转支承承受的载荷
- 2、每种载荷及其作业时间百分比
- 3、在每种载荷作用下，回转支承的转速或转数
- 4、作用在齿轮上圆周力

- 5、回转支承的结构尺寸
- 6、其它的运转条件

4.2 Technical parameters of selecting slewing bearing's type

- 1.The load of slewing bearing
- 2.Every load and the percent of each load's working hours
- 3.The slewing bearing's revolving speed or revolution under each load's effect.
- 4.Peripheral force affected on gears
- 5.The slewing bearing's size
- 6.Other working conditions

主机厂可根据产品样本所提供的信息，利用静态承载曲线图（详见 5.3），按回转支承选型计算方法初步选择回转支承，然后，与我公司技术部共同确认。也可向我公司提供回转支承相关信息，由我公司进行设计选型。

由我公司进行设计选型时，请索取《回转支承选型技术参数表》（包括参数表中的附录 A 及附录 B），并详细填写，以便我们能尽快提交准确而经济实用的回转支承选型方案。

The main engine factory can refer to the provided information by the product samples,and make use of static load graph(details see this chapter 5.3),and select the slewing bearing primarily according to the selection calculation of slewing bearing.Then,Please confirm the information with our company's department of technology.Besides,please offer the related information about slewing bearing for our company so as to we can choose to design.

If you choose to let us design,please ask for the technological parameters of slewing bearing's selection(includes the appendix A and appendix B of the parameter),fill the form in details so that we can submit accurate and economical and practice selection plans of slewing bearing as soon as possible.

4.3 回转支承承载曲线

产品样本中每一型号回转支承都对应一个承载能力曲线图，曲线图可帮助用户初步选择所需回转支承。

曲线图中有二种曲线，一类为静态承载曲线（1）线，表示回转支承保持静止时所能承受的最大负荷。另一类为螺栓极限负荷曲线（8.8、10.9 线），它是在在螺栓夹持长度为螺栓直径 5 倍、预紧力为螺栓材料屈服极限的 70%时确定的。

The bearing capacity curve of slewing bearing

every type of the product sample corresponds to a bearing capacity curve,which can help the users choose the slewing bearing preliminarily.

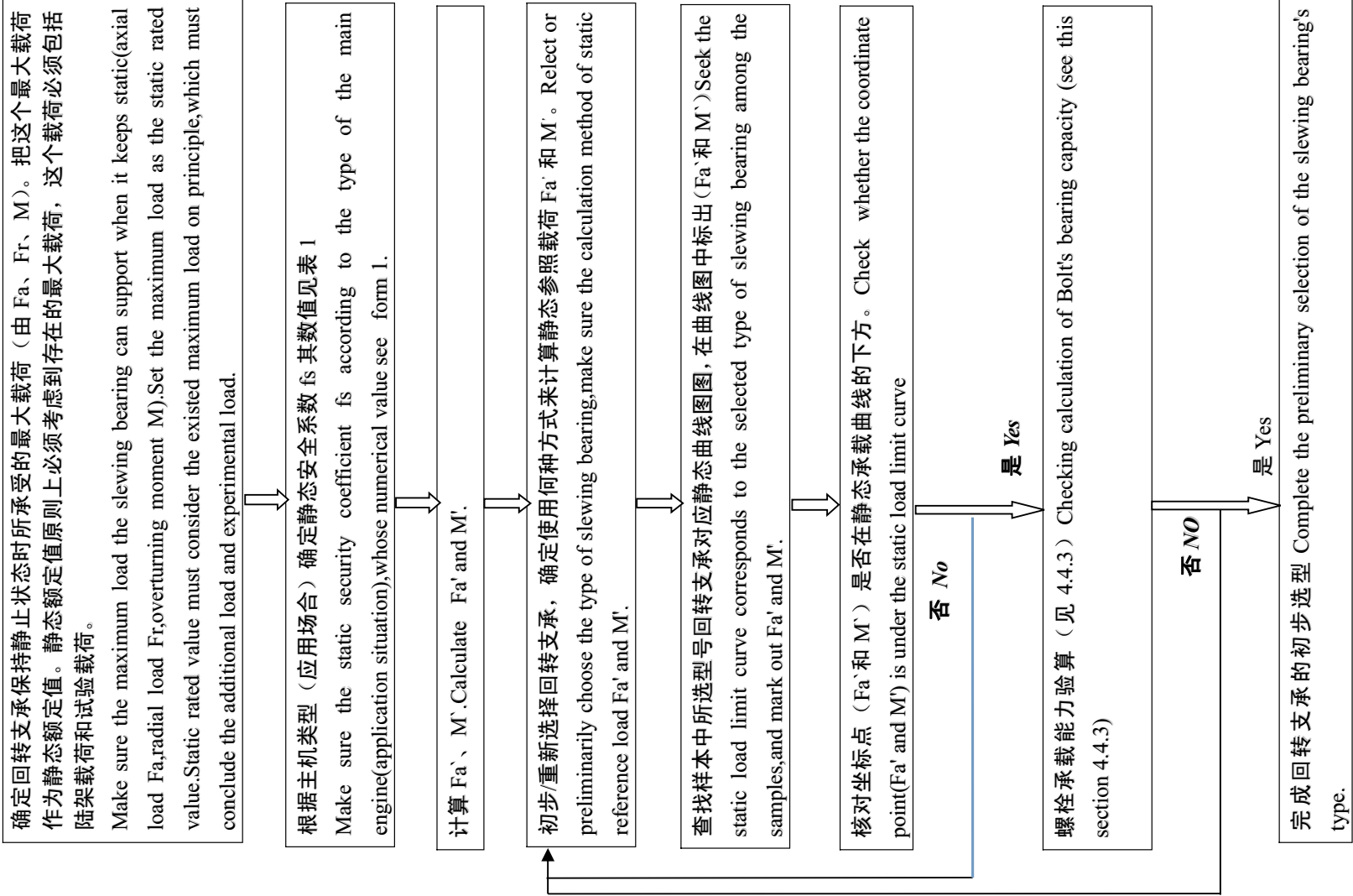
There are two Types of curves,one is static load limit curve, the maximum load the slewing bearing can bear when it keeps static.The other one is bolt load limit curve(curve 8.8,10.9),it is decided when the bolt's fixture length is 5 times as the bolt's nominal diameter, and the preload is 70% of the bolt material's yield limit.

4.4 回转支承选型计算方法 selection calculation method of slewing bearings

4 回转支承选型计算 Seiection calculation of slewing bearings

4.4.1 按静态曲线选型 4.4.1 Selection of static type

1) 选型计算流程图 1)flow diagram of selection calculation:



4 回转支承选型计算 Seiection calculation of slewing bearings

2) 静态参照载荷 Fa` 和 M` 的计算方法:

the calculation method of static reference load Fa` and M`:

单排四点接触球式 Single-row four-point contact ball

单排四点接触球式回转支承的选型计算分别按压力角 45° 和 60° 两种情况进行

The selection calculation of the single-row four-point contact ball slewing bearing processes by load support angle 45° and 60° respectively.

I、a=45°

II、a=60°

Fa`=(1.225*Fa+2.686*Fr)*fs

Fa`=(Fa+5.046*Fr)*fs

M`=1.225M*fs

M`=M*fs

在曲线上图找出以上两点，其中一点在曲线下方即可。

Then find out the above point on the curve,one of which is under the curve is enough.

单排交叉滚柱式 Single- row cross roller

Fa`=(Fa+2.05*Fr)*fs

M`=M*fs

双排异径球式 Double-row ball

Fa`=Fa*fs

M`=M*fs

对于双排异径球式回转支承选型计算，当 Fr<=10%Fa 时，Fr 忽略不计，当 Fr>=10%Fa 时，必须考虑滚动压力角的变化，其计算请与我们联系

The selection calculation of the double-row different diameter ball slewing bearing,when Fr<=10%Fa,ignore Fr;when Fr>10%Fa,the change of the pressure angle inside raceway must be accounted,please contact us about its calculation.

三排滚柱式 Triple-row roller

三排滚柱式回转支承选型时，仅对轴向滚道负荷和倾覆力矩的作用进行计算。

When select the triple-row roller slewing bearing,only calculate the interaction of the axial raceway load and overturning moment.

Fa`=Fa*fs

M`=M*fs

4.4.2 动态选型计算 *Selection of Dynamic type*

对于连续运转、高速回转和其它对回转支承寿命有要求的应用场合，请与我们公司技术部联系。

To the application situation which has specific requirements for the slewing bearing's service life,or needs to continuously revolve or high-speed rotating,please contact our company's department of technology.

4.4.3 螺栓承载能力验算 *Checking calculation of the bolt's bearing capacity*

1) 把回转支承所承受的最大载荷（没有乘静态安全系数 fs）作为选择螺栓的载荷;

2) 查对载荷是否落在所需等级螺栓极限负荷曲线以下;

3) 若螺栓承载能力不够，可重新选择回转支承，或与我公司技术部联系。

1)Set the maximum load the slewing bearing can support (without multiply the static security coefficient fs)as the selected bolt's load;

2)checking out whether the load is under the required grade bolt' limit load curve;

3)If the bolt's bearing capacity is not enough,you can reelect slewing bearing or contact our company's department of technology.

4 回转支承选型计算 Seiection calculation of slewing bearings

表一 form 1

应用场合 Application situation.	fs	fL	原则上，必须以作用在支承上的最大载荷做为静态值，这个载荷必须包括附加载荷和试验载荷。 没有被列入表中的应用场合，可以参考表中与其相似的工作条件和应用，选取安全系数 fs *)上回转式塔机 Mf=空载时的反向倾覆力矩 M=幅度最大时的倾覆力矩 **) 对于静态安全系数 fs 取 1.45 的应用场合，因平均负载较高和繁重的工作条件，就优先选择多排滚道支承 On principle,the static calculation value must be the maximum load , That the bearing supported,this load must include the additional load and experimental load. The application situations which are not mentioned in the list,please refer to the similar situation and choose he static security coefficient fs. *) Rotation upward crane Mf= reverse overturning moment when M=overturning moment when maximum range **)To the situation when these curity coefficient fs is 1.45, better choose multi-row raceway slewing bearing because of high average load and heavy working
浮式起重 Floating crane(cargo). 汽车起重机 Mobile crane(cargo). 船用甲板起重机 Ship deck crane(grab bucket). 焊接设备 Welding equipment.	1.10	1.0	
工作台(连续运转)Turntable (continuously revolve).			
塔式回转式起重机的回转部分 Mf<=0.5M		1.0	
0.5M<=Mf=0.8M		1.15	
Mf>=0.8M		1.25	
下回转 Rotation at base.	1.25	1.0	
回转式起重机 Rotation crane(cargo).		1.15	
造船厂起重机 Shipyard crane.			
装船机/卸船机 Ship loader/ship unloader.			
冶金起重机 Steel mill crane		1.5	
汽车起重机 Mobile crane(grab bucket or deal with heavy work)		1.7	
回转式起重机 Rotation crane(grab bucket or sucker)			
桥式起重机 Bridge crane (grab bucket or sucker)			
浮式起重机 Floating crane(grab bucket or sucker)	1.45**		
斗轮式挖掘机 Bucket-wheel excavator 堆料机 Stackler-reclaimer 悬臂式输送机 boom conveyor		2.15	
近海起重机 Offshore crane.	特殊标准	special standard	
铁路起重机 Railway crane.	1.0		在这些应用场合，工作条件变化相当大，比如对于不经常回转的情况使用的回转支承，只要求进行静态校核。对于连续运转和间歇式回转情况下使用的回转支承，将需要进行动态寿命计算 On these application situations,the working conditions change a lot.For example,facing with the working slewing bearing which often does not rotate,only need to check in static;for the working slewing bearing which are under the situation of continuously rotate or intermittently rotate.
甲板起重机 Deck crane(carrying goods).			
堆料机 Stacker	1.0		
输送车 Delivery wagon			
小于等于 1.5M³ 液压挖掘机 <=1.5m3 hydraulic excavator	1.45		
大于等于 1.5M³ 液压挖掘机 >1.5m3 hydraulic excavator	特殊标准	special standard	
钢包回转台 Ladle turret	1.75		

注：fL 为动态安全系数，它必须结合动态承载曲线使用（动态承载曲线不在此样本中）。它来源于经验和试验，是基于最大工作载荷情况下的一个参照值。若需根据寿命选择回转支承时，请与我公司技术部联系。

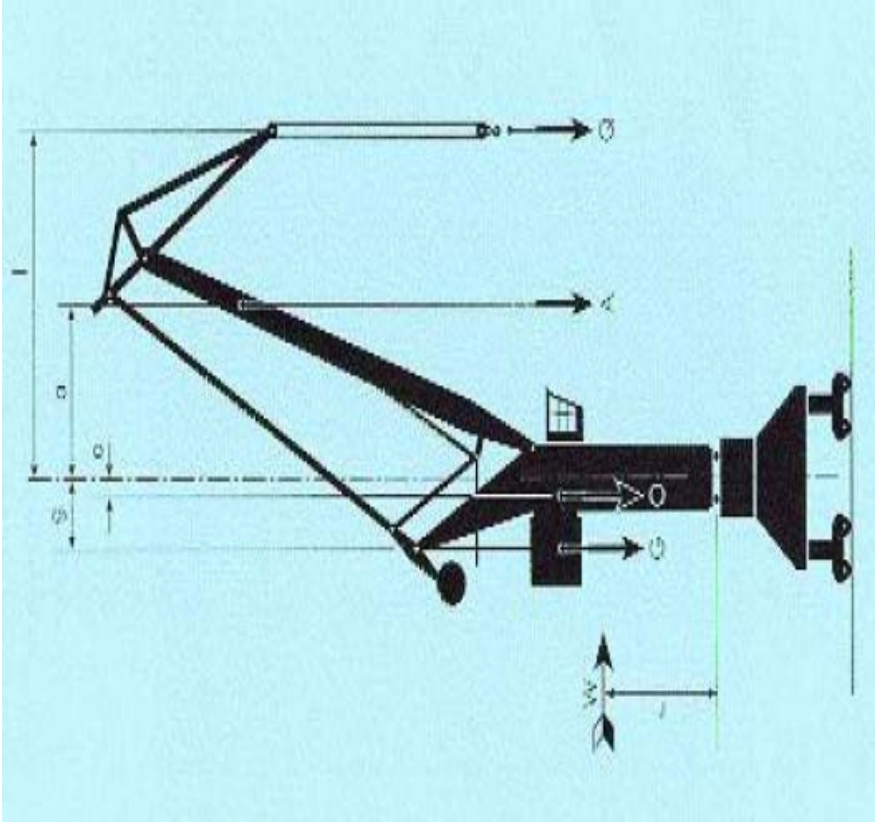
Notes: fL is the dynamic security coefficient,it must combine the dynamic load limit curve to use(the

4 回转支承选型计算 Seiection calculation of slewing bearings

dynamic load limit curve is not in this sample).It comes from experiences and experiments,and based on a reference value under the maximum working load.If you need to select slewing bearing according to the service life,please contact our department of technology.

4.5 选型计算举例-门座式起重机（抓斗）Example of selection calculation--gantry crane(grab bucket)

门座式起重机示意图 Schematic of gantry crane



采用承载曲线选型时，最大的负荷的计算方法介绍如下：

在选择回转支承前，首先确定对该主机应考虑的静态安全系数 fs,可由表 1 查得。

门座式起重机（抓斗）： fs=1.45

已知最大静载荷出现在幅度最大时，其载荷计算公式如下；

When adopting the bearing capacity curve to select,the calculation method of the maximum load is suggested as follows.

Before selecting the slewing bearing,ensure the static security coefficient fs of the main engine,which can refer to form 1.

Gantry crane(grab bucket):fs=1.45

When the given maximum static load reaches to the maximum range,it's load calculation formulas are as follows:

1）考虑八级风时最大工作载荷 the maximum working load when the wind force is eight

轴向力 Axial force Fa=Q+A+O+G

倾覆力矩 Overturning moment M=Q•Lmax+A•amax+W•r-O•o-G*g

4 回转支承选型计算 Seiection calculation of slewing bearings

2)不计风力，考虑 25%试验负荷的载荷 consider the load of 25%experimental load without the wind force

轴向力 Axial force Fa=1.25Q+A+O+G

倾覆力矩 Overturning momentM= 1.25Q•Lmax+A•amax -O•o-G*g

例：已知一抓斗式港口吊最大幅度的工作负荷和幅值为：

Eg:given that a grab bucket port crane's working load and range value of maximum range.

Q=260kN lmax=23m

A=75kN amax=11m

O=450kN o=0.75m

G=900kN g=3m

W=27kN r=6.5m

1)八级风力时的最大工作载荷 the maximum working load when the wind force Is eight.

Fa=Q+A+O+G

=260+75+450+900

=1685kN

M=Q* lmax+A* amax+W*r-O*o-G*g

=260*23+75*11+27*6.5-450*0.75-900*6.5

=3943Nm

2)不计风力考虑 25%试验负载时的最大工作载荷 consider the load of 25%experimental load without the

wind force

Fa=1.25Q+A+O+G

=275+75+450+900

=1750kN

M=1.25Q* lmax+A* amax+W*r-O*o-G*g

=275*23+75*11+27*6.5-450*0.75-900*6.5

=5566.3Nm

3)不计风力时的最大工作载荷 the maximum working load without wind force

Fa=1685kN

M=Q* lmax+A* amax-O*o-G*g

=260*23+75*11-450*0.75-900*6.5

=3767.5Nm

选用负荷情况 2 工作为静态计算的工作载荷

Choose the load situation 2 as the static calculation 's working load.

按表 1 要求，门座式起重机(抓斗)应采用三排滚柱式回转支承

Under the requirement of form 1, gantry crane should adopt the triple-row roller slewing bearing:

回转支承静态参照载荷为

The slewing bearing 's static reference load is:

Fa=1750*1.45=2537.5kN

M=5566.3*1.45=8071.1Nm

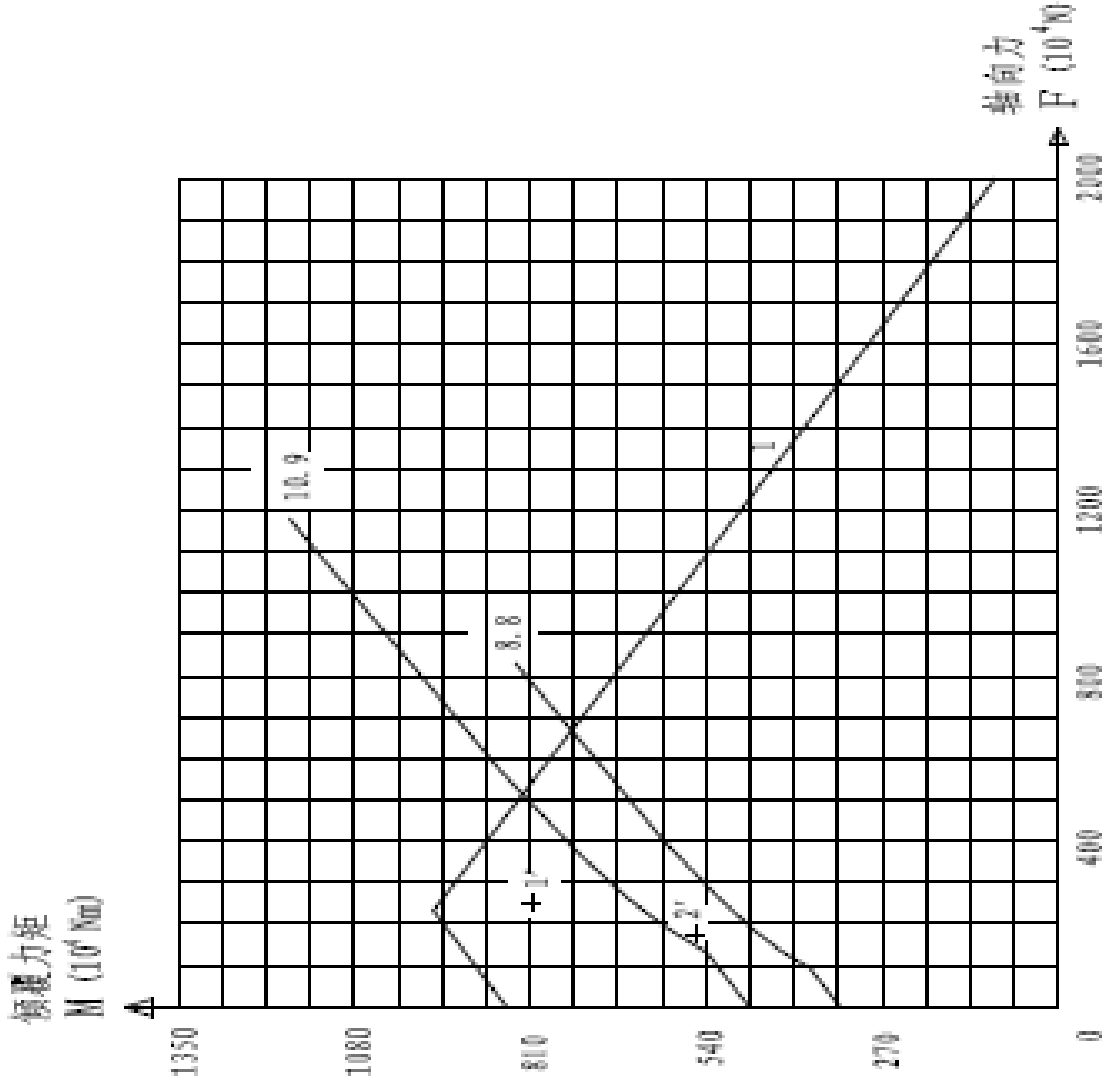
而螺栓的计算载荷为： While the bolt's calculation load is:

Fa=1750kN

M=5566.3Nm

4 回转支承选型计算 Selection calculation of slewing bearings

按上述计算结果，在承载曲线中选择，可确定选用 13* .45.2000.002 回转支承；
As the above calculation result,make the choice in the static load limit curve,therefore make sure select the 13* .45.2000.002 slewing bearing.



线 1 为滚道静态承载曲线 Line 1 is the static load limit curve
线 8.8、10.9 为螺栓承载曲线 8.8、10.9 is the bolt load limit curve
1'- 静态载荷点 static load point
2'-螺栓载荷点 bolt load point
点 1'在滚道静态曲线 1 下,因此满足要求 Point 1' is under the raceway static load limit curve,thus it meets the requirement
点 2'在 10.9 级螺栓承载曲线 10.9 下, 因此满足使用要求 Point 2' is under the grade 10.9 bolt load limit curve,thus choose grade 10.9 bolt can meet the requirement.

4 回转支承的安装及维护 Installation and maintenance of slewing bearings

5.1 装卸与贮运

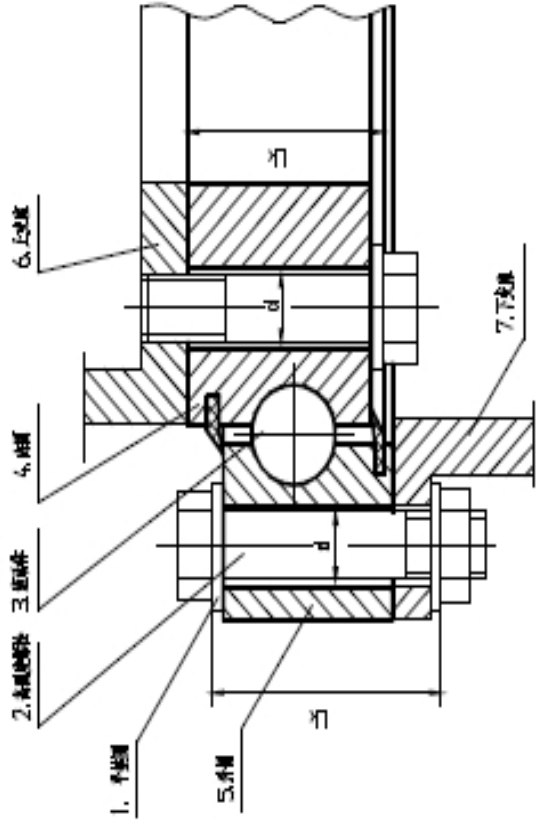
回转支承必须小心装卸
运输和贮存以水平放置为宜，贮存必须放在干燥的室内
吊装宜用吊环螺钉，以水平方式进行切勿碰撞，特别是径向方向的碰撞
回转支承外表面涂有防锈剂，其防锈期一般为六个月，存放期超过六个月的应重新进行防锈包装或采取其它贮存措施

handling and shipping

Slewing bearing must be handled with care。
The transportation and storage of the slewing bearing is suitable to be held horizontally,and the storage must be put into the dry room.
For hoisting,lifting bolt is suitable ,and please move it horizontally,do not hit anything,especially the the direct collision.
The slewing bearing's surface is covered with antirust agent,whose rust proof life is 6 months mostly.For those whose storage life has over 6 month (like accessories) should take the antirust package or other storage measures again.

5.2 安装支架的要求

安装配合支架一般筒形结构，筒壁与滚道中心对齐；
Requirements of installing the support Generally, install matching support adopts tubular structure,the cylinder's wall is aligned at the center of the raceway is suitable.



安装示意图。installation schematic

- | | | |
|-------------------|----------------------------|-----------------------|
| 1 平垫圈 flat washer | 2 高强度螺栓 high strength bolt | 3 滚动体 rolling element |
| 4 内圈 inner ring | 5 外圈 outer ring | 6 上支座 upper bracket |
| 7 下支座 subframe | | |

为了防止回转支承局部过载，保证其灵活运转，安装支架应在所有焊接工序后进行消除内应力外理，安装平面进行机械加工，其平面度（包括水平面的角偏差）应控制在一定范围内。见表 2
In order to Prevent the slewing bearing' partly overload , and ensure its flexible revolve,the installation of the support should be removed its inner stress after all the welding operations have finished,and the installation surface must be processed,its flatness(include its angular deviation) should be controlled within limits.

4 回转支承的安装及维护 Installation and maintenance of slewing bearings

See form 2

表 2 包含角偏差在内的平面度许可值 *The flatness' allowed value includes angular deviation*

滚道中心直径 Diameter of the raceway center.	安装支架平面偏差 P（mm） The plane deviation of installation support		
	单排四点接触球式支承 Single-row ball bearing	双排球式支承 Double-row ball bearing.	滚柱式支承 Roller bearing
DL			
~1000	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
>4000~6000	0.40	0.50	0.30
>6000~8000	0.50	0.60	0.40

注 Notes:

表 2 中的数值为最大值，在 180° 的扇形区内，只允许有一次波峰达到该值，并在 0° -90° -180° 区域内平衡上升或下降。不允许忽升忽降，以避免峰值负荷。

The value in form 2 is the maximum value,among the 180° fan section,only one one crest can reach this value and it will rise or drop alowly between 0° -180° .Do not rise or drop rapidly to avoid peak load.

安装支架还应有良好的刚性。在最大允许负荷下，挠曲变形量应控制在表 3 规定的范围内 The installation should also has high rigidity.Under the maximum load,flexural deflection value should be controlled within the range given by form 3.

表 3 最大允许负荷下的挠曲变形量 The flexural deflection value under the maximum allowed load

滚道中心直径 DL（mm） The diameter of raceway center	≤100	>100~1500	<1500~2000	>2000~2500	>2500~3000	>3000~3500	>3500~4000	>4000~4500	>4500~5000	>5000~5500	>5500~6000	>6000~7000	>7000~8000
支架平面最大挠 Amax (mm) The maximum deflection of the Support's plane	0.05	0.08	0.10	0.15	0.20	0.25	0.30	0.36	0.42	0.48	0.55	0.60	0.70

安装支架的螺栓孔按 GB/T5277-1985 中级精度加工 The installation support's bolt's hole should be intermediate accuracy processed by GB/T5277-1985

5.3 安装螺栓副

回转支承所用螺栓尺寸应符合 GB/T5782-2000 或 GB/T5783-2000 的规定，其强度不低于 GB/T3098.1-2000 规定的指标，并根据支承受力情况选择合适的强度等级。

螺母尺寸应 GB/6170-2000 和 GB/T6175-2000 规定，其机械性能 GB/T3098.2-2000 规定。

垫圈尺寸应符合 GB/T97.1-1985 和 GB/T97.2-1985，淬火处理；不得使用弹簧垫圈。

螺栓拧紧方式按主机设计规定，应保证一定预紧力，除非特殊规定，一般预紧力为螺栓屈服极限的 0.7 倍。拧紧时允许在螺纹处涂少许油。预紧扭矩或预紧力见表 4

4 回转支承的安装及维护 Installation and maintenance of slewing bearings

螺栓夹持长度 L_K≥5d

5.3 the installation of screw pair

The bolt's size of slewing bearing should be in line with the regulation of GB/T5782-2000 or GB.T5783-2000.Its strength grade is not less than grade 8.8 given by grade 8.8.

The nut's size should accord with the regulation of GB/T6170-2000 or GB/T6175-2000,it's mechanical property should be accord with the regulation of GB3098.2-2000

Washer's size should accord with GB/T97.1-1985 and GB/97.2-1985,it needs tempering treatment.Do not use spring washer.

The bolt tightening method should be regulated by the main engine's design,and ensure certain preload.Unless special regulation,the regular preload should be the 0.7 times as the bolt's yield limit.When fastening,some lube is allowed on the thread.Pre-tightening torque or preload see form 4

The bolt's clamped length L_K≥5d (d-bolt's diameter)

表 4 预紧力矩和预紧力 form 4 pre-tightening torque or preload

螺 栓 规 格 Bolt specificat (GB/5782-2000 GB/5783-2000)	安装孔直径 Mounting hole's diameter (mm)	螺栓强度等级 (GB3098.1)		Bolt's strength grade	
		8.8		10.9	
		螺栓材料屈服极限σmin (N/mm²)			Yield strength limit of bolt
		640		900	
		预紧力矩 pre-tightening torque MA (N.M)			
M10	11	44		62	
M12	13.5	77.5		110	
M14	15.5	120		170	
M16	18	190		265	
M18	20	260		365	
M20	22	370		520	
M22	24	500		700	
M24	26	640		900	
M27	30	950		1350	
M30	33	1300		1800	
预紧力 preload KN					
M33	36	293		412	
M36	39	344		484	
M39	42	414		581	
M42	45	473		665	
M45	48	553		777	
M48	52	623		876	
M52	56	749		1054	
M56	62	863		1214	
M60	66	1008		1418	

注：Notes:

4 回转支承的安装及维护 Installation and maintenance of slewing bearings

- (1) 当螺栓尺寸不符合相应标准时，表值需另行计算。
- (2) 螺栓头部与被夹紧面间的总摩擦系数按 $\mu=0.14$ ，螺纹涂少许润滑油。

(1) When the bolt's size is not in line with GB/T5782-2000 or GB/T5738-2000, the number of the form should be recounted.

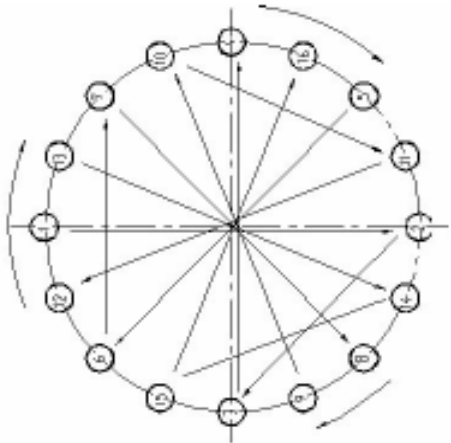
(2)The total friction coefficient between the bolt's head and the champering side $\mu=0.14$;put some lube on the thread.

5.4 安装

- 安装前，回转支承安装基面和支架安装平面必须清理干净，去除油污、行刺、油漆以及其它异物。
- 回转支承滚道淬火软带（外部标记“S”或堵塞处）应置于非经常负荷区或非负荷区
- 回转支承吊装到位后，应用塞尺检查接合平面的平面度。如有间隙应重新进行机械加工，安装平面无法加工的，采取过填塑或局部垫片填充，以防螺栓拧紧后支承变形，影响回转支承性能
- 安装螺栓拧紧前，根据齿轮节圆径向跳动最高点（三个涂有绿漆标记的齿）调节齿侧间隙并于螺栓拧紧后，在全部齿圈上进行一次齿侧间隙的检查。
- 拧紧螺栓应在 180° 方向对称地连续进行，最后再拧紧一遍，保证圆周上的螺栓预紧力相同。

installation

- Before be cleaned and removed the oil dirt, burr, paint and other foreign matters. installation, the slewing bearing's installation datum plane and the support installation plane must
- The HQ soft zone of the slewing bearing's raceway (marked by S outside or at the clogging hole) should be put between incidental loading zone and non-loading zone.
- When the slewing bearing is lifted at the right place, please use the feeler gauge to check the fraying surface's flatness. Restart mechanical process if there is clearness and install the plane ;If not, please adopt tamping or gasket to depletion partly to prevent the bearing getting out of shape after tightening the bolts which may affect the slewing bearing's function.
- Before tightening the installation bolt, please adjust the gear teeth's clearness by the maximum point (three marked gear teeth with green paint) that gear pitch run out radially. And after tightening the bolt, check the gear teeth's clearness once more around the whole teeth ring.
- Tighten the bolt should be continuously and symmetrically processed on 180° direction. At last, tighten again to ensure the bolts on the circle have the same preload.



4 回转支承的安装及维护 Installation and maintenance of slewing bearings

回转支承在家出厂前，滚道内注入少量的 2 号极压锂基润滑油（GB7324-1994），启用时用户应根据不同的工作条件，重新充满新的润滑。

回转支承滚道应定期加注润滑油。一般球在支承每运转 100 小时加油一次，滚柱类支承运转 50 小时加注一次，特殊工作环境，如热带、湿度大、灰尘多、温度变化大以及连续工作时，应缩短加油周期。机器长期停止运转的前后必须加足新的润滑油。每次润滑必须将滚道注满润滑油，直到从密封处渗出为止。注润滑油时，要慢慢转支回转支承，使润滑油填充均匀。

齿面应经常清除杂物，并涂以相应的润滑油。

因为综合工作因素较多，用户也可根据具体要求自行选择最佳润滑油。如滚道可采用少量 MOBILUXEP2 Shell Alvania Ep(LF)2 润滑油。

回转支承首次运转 100 小时后，应检查螺栓的预紧力。以后每运转 500 小时检查一次，必须保持足够的预紧力。

使用中注意回转支承的运转情况，如发现噪声、冲击、功率突然增大，应立即停机检查，排除故障，必要时进行拆检。

使用中禁止用水直接冲刷回转支承，以防进入滚道。严防硬物接近或进入齿轮啮合区。

经常检查密封完好情况，如果发现密封带破损应及时更换、如脱落应及时复位。

The slewing bearing's raceway is covered with a little No.2 extreme pressure lubrication (GB7324-1994) inside when leaving factory. Users should start it according to different working condition and refill new lubrication.

the slewing bearing's raceway should be refueled regularly. Mostly ball bearing should be refueled every 100h it rotates; roller bearing should be refueled every 50h. The lubrication cycle should be shortened when at special working environment, such as tropic, high temperature, dusty place, large temperature difference and continually working. Besides, before or after the machine stopped working for a long time, enough new lubrication must be added. Each lubrication must fulfill the raceway until it spilled out of the sealing part. When refueling lubrication, turn the slewing bearing slowly to make the lubrication packing uniformly.

Tooth surface should be cleaned frequently, and daubed with relevant lubrication.

Because of many integrated working factors, users can also select the best lubrication by oneself. For example, raceway can adopt some Mobilux EP2, Shell Alvania EP(LF)2 lubrication.

After the first operation, check the bolt's preload. After then, check the preload every 500h it rotates to ensure the enough preload.

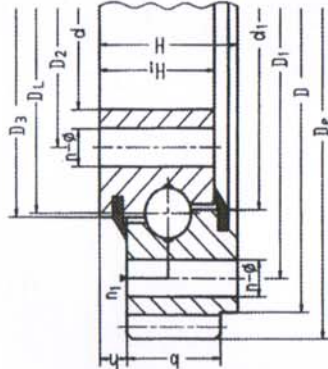
Attention to the slewing bearing's operation circumstances when working, if you find noise, impact, or rapid increase of power, please switch off the machine to check and rule out stoppage, or take apart to check if necessary.

Never use water to wash the slewing bearing when working to prevent water getting into the raceway. Do not let hard thing approach or get inside tooth engage position.

frequently check the sealing's sound condition. If you find the sealing strip broken, change it in time; if you find it drop, reset it in time.

6单排四点接触球式回转支承（01系列）结构参数—外齿式
Single-row four-point contact ball slewing bearings (series 01) structural parameters

机械行业标准 Machinery industry standard (JB/T2300 -2011)



011,012

Table with 10 columns: 承载曲线号 (Load diagram No.), 型号 Type (DL mm), 外型尺寸 Configuration size (De, D, d, H, mm), 安装尺寸 Mounting size (D1, D2, n, phi, M, mm), and 重量 weight (kg). It lists 17 different bearing models and their specifications.

6单排四点接触球式回转支承（01系列）结构参数—外齿式
Single-row four-point contact ball slewing bearings (series 01) structural parameters

注: ● m为润滑油孔数。油杯M10×1JB/T7940. 1-JB/T7940. 2。根据应用情况用户可指定油孔位置。

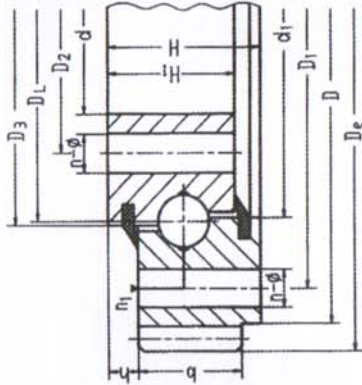
- n-φ可改为螺纹孔，螺纹直径M，螺纹深度2M。
- 表内齿圆周力为最大圆周力，额定圆周力取其1/2。
- “K”为消顶系数。
- 本样本中的规格为标准产品，内外径均为自由公差。若主机与回转支承有配合要求，请在合同或合同附件（如技术协议）中注明配合尺寸和精度。
- 表中所列为我公司常规产品，若有其它特殊要求，请与我公司联系。

Table with 13 columns: 结构尺寸 Structural size (n1, D3, d1, H1, h, mm), 齿轮参数 Gear data (b, m, z, x, k), 齿圆周力 Tangential tooth load (正火 KN, 调质 KN), and 重量 weight (kg). It lists 24 different bearing models and their specifications.

6单排四点接触球式回转支承（01系列）结构参数—外齿式

Single-row four-point contact ball slewing bearings (series 01) structural parameters

机械行业标准 Machinery industry standard (JB/T2300-2011)



011, 012

承载曲线号 Load diagram No	型号 Type	外型尺寸 Configuration size		安装尺寸 Mounting size			
		De mm	D mm	d mm	H mm	D1 mm	D2 mm
18	011.35.1000.001	1160	1120	876	90	1074	926
	012.35.1000.001	1170					
19	011.40.1000.001	1188	1122	878	100	1078	922
	012.40.1000.001	1185.6					
20	011.25.1120.001	1278		1013	79	1183	1057
21	011.35.1120.001	1300	1240	996	90	1194	1046
	012.35.1120.001	1308					
22	011.40.1120.001	1298	1242	998	100	1198	1042
	012.40.1120.001	1305.6					
23	011.30.1180.001	1338		1068	79	1248	1112
24	011.25.1250.001	1408		1143	79	1313	1187
25	011.35.1250.001	1430	1370	1126	90	1324	1176
	012.35.1250.001	1440					
26	011.40.1250.001	1450	1390	1108	102	1336	1164
	012.40.1250.001	1452					
27	011.45.1250.001	1449.6	1390	1110	110	1337	1163
	012.45.1250.001	1453.2					
28	011.30.1320.001	1497.6		1208	89	1388	1252
29	011.35.1400.001	1584	1520	1276	90	1474	1326
	012.35.1400.001	1596					
30	011.40.1400.001	1608	1540	1258	102	1486	1314
	012.40.1400.001	1610					
31	011.45.1400.001	1605.6	1540	1260	110	1487	1313
	012.45.1400.001	1607.2					
32	011.30.1500.001	1677.6		1388	89	1568	1432

6单排四点接触球式回转支承（01系列）结构参数—外齿式

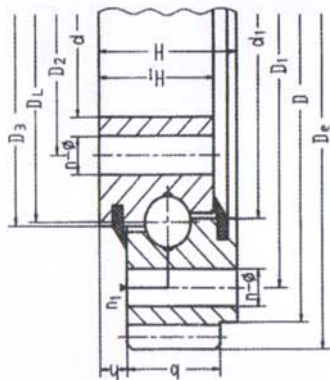
Single-row four-point contact ball slewing bearings (series 01) structural parameters

notes: n is the number of lubrication holes, oil cup M*1JB/T7940.1-JB/T7940.2, users can appoint the oil hole's position according to application circumstances.
n-Φ can be replaced by threaded hole, the diameter is M, the depth is 2M.
the tooth gear's peripheral force in the firm is the maximum peripheral force, the rated peripheral force is half of it.
'k' indicates cut-top coefficient.
this sample's specification is the standard product, both the inner diameter and outside diameter are all the free to tolerance, if the main engine and the slewing bearings have matching requirement, please note the matching size and accuracy on the contract or the appendix of the contract (like technology agreement).
these are the standard products of our company listed in the form. if you have any other requirements, please contact us.

结构尺寸 Structural size					齿轮参数 Gear data				齿轮圆周力 Tangential tooth load		重量 weight kg	
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
4	1001	998	80	10	70	8	144	-0.5	0			227
						10	116					232
6	1001	998	90	10	80	10	116	+0.5	0.1	100	140	294
						12	96			120	167	284
5	1121	1119	54	9	70	10	125	+0.5	0.1	88	135	182
4	1121	1118	80	10	70	10	129	-0.5	0			272
						12	108					272
6	1121	1118	90	10	80	10	127	+0.5	0.1	100	140	318
						12	106			120	167	318
6	1181	1178	63	9	70	10	131	+0.5	0.1	88	129	227
6	1251	1249	54	9	70	10	138	+0.5	0.1	88	135	221
4	1251	1248	80	10	70	10	142	-0.5	0			302
						12	119					309
4	1251	1248	90	12	80	10	144	-0.5	0			396
						12	120					392
5	1252	1248	100	10	90	12	118	+0.5	0.1	135	188	438
						14	101			158	219	438
6	1321	1318	63	9	80	12	122	+0.5	0.1	121	176	298
6	1401	1398	80	10	70	12	131	-0.5	0			337
						14	113					347
6	1401	1398	90	12	80	12	133	-0.5	0			448
						14	114					443
5	1402	1398	100	10	90	12	131	+0.5	0.1	135	188	501
6	1501	1498	63	9	80	12	137	+0.5	0.1	121	176	338

6单排四点接触球式回转支承（O1系列）结构参数—外齿式
Single-row four-point contact ball slewing bearings (series O1) structural parameters

机械行业标准 Machinery industry standard (JB/T2300-2011)



O11.O12

Table with 10 columns: Load diagram No, 型号 Type, 外型尺寸 Configuration, 安装尺寸 Mounting size, 重量 weight. Rows 33-47.

6单排四点接触球式回转支承（O1系列）结构参数—外齿式
Single-row four-point contact ball slewing bearings (series O1) structural parameters

注：● n为润滑油孔数。油杯M10×1JB/T7940.1-JB/T7940.2。根据应用情况用户可指定油孔位置。

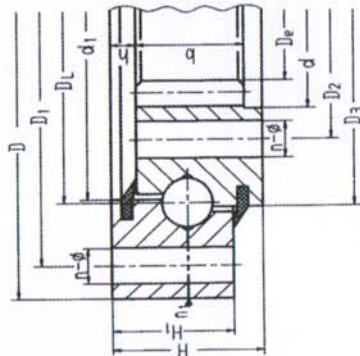
- n-φ 可改为螺纹孔，螺纹直径M，螺纹深度2M。
- 表内齿轮圆周力为最大圆周力，额定圆周力取其1/2。
- “K” 为消顶系数。
- 本样本中的规格为标准产品，内外径均为自由公差。若主机与回转支承有配合要求，请在合同或合同附件（如技术协议）中注明配合尺寸和精度。
- 表中所列为我公司常规产品，若有其它特殊要求，请与我公司联系。

Table with 13 columns: 结构尺寸 Structural size, 齿轮参数 Gear data, 齿轮圆周力 Targential tooth load, 重量 weight. Rows 5-8.

6单排四点接触球式回转支承（01系列）结构参数—内齿式

Single-row four-point contact ball slewing bearings (series 01) structural parameters

机械行业标准 Machinery industry standard (JB/T2300-2011)



013,014

承载曲线号 Load diagram No	型号 Type DL mm	外型尺寸 Configuration				安装尺寸 Mounting size				
		De mm	D mm	d mm	H mm	D1 mm	D2 mm	n	Φ mm	M mm
1	013.20.400.001	300	475		55	448	352	16	13.5	12
2	013.20.450.001	345	531		55	500	400	16	15.5	14
3	013.30.500.001	367	602	398	80	566	434	20	18	16
	014.30.500.001	368.4								
4	013.20.560.001	450	641		55	610	510	20	15.5	14
5	013.30.560.001	427	662	458	80	626	494	20	18	16
	014.30.560.001	428.4								
7	013.30.630.001	494.4	732	528	80	696	564	24	18	16
	014.30.630.001	491.2								
8	013.20.710.001	594	797		55	762	658	24	18	16
9	013.30.710.001	572.4	812	608	80	776	644	24	18	16
	014.30.710.001	571.2								
13	013.40.800.001	635.2	922	678	100	878	772	30	22	20
	014.40.800.001	634								
48	013.25.886.001	752	980		63	944	827	36	18	16
15	013.40.900.001	739.2	1022	778	100	978	822	30	22	20
	014.40.900.001	734								
19	013.40.1000.001	824	1122	878	100	1078	922	36	22	20
	014.40.1000.001	820.8								
49	013.25.1077.001	930	1169		63	1134	1017	36	18	16
50	013.30.1120.001	960	1232		79	1188	1052	36	22	20
22	013.40.1120.001	944	1242	998	100	1198	1042	36	22	20
	014.40.1120.001	940.8								
51	013.30.1250.001	1090	1362		79	1318	1182	40	22	20

6单排四点接触球式回转支承（01系列）结构参数—内齿式

Single-row four-point contact ball slewing bearings (series 01) structural parameters

notes: n is the number of lubrication holes, oil cup M*1JB/T7940.1-JB/T7940.2, users can appoint the oil hole's position according to application circumstances.

n- Φ can be replaced by threaded hole, the diameter is M, the depth is 2M.

the tooth gear's peripheral force in the firm is the maximum peripheral force, the rated peripheral force is half of it.

'k' indicates cut-top coefficient.

this sample's specification is the standard product, both the inner diameter and outside diameter are all the free to tolerance, if the main engine and the slewing bearings have matching requirement, please note the matching size and accuracy on the contract or the appendix of the contract (like technology agreement).

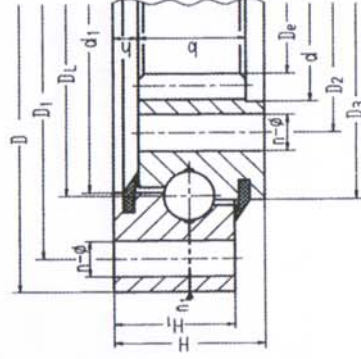
these are the standard products of our company listed in the form. if you have any other requirements, please contact us.

结构尺寸 Structural size						齿轮参数 Gear data				齿轮圆周力 Tangential tooth load		重量 weight kg
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
2	401	339	46	9	46	5	61	+0.5	0	29	44	33
2	451	449	46	9	46	5	70	+0.5	0	29	44	38
4	501	498	70	10	60	5	74	+0.5	0.2	37	52	90
						6	62					
4	561	559	46	9	46	6	76	+0.5	0	35	53	51
4	561	558	70	10	60	5	86	+0.5	0.2	37	52	102
						6	72					
4	631	628	70	10	60	6	83	+0.5	0.2	45	62	116
						8	62					
4	711	709	46	9	46	6	100	+0.5	0	35	53	68
4	711	708	70	10	60	6	96	+0.5	0.2	45	62	132
						8	72					
6	801	798	90	10	80	8	80	+0.5	0.2	80	111	224
						10	64					
4	887	885	54	9	54	8	95	+0.5	0	54	83	111
6	901	898	90	10	80	8	93	+0.5	0.2	80	111	252
						10	74					
6	1001	998	90	10	80	10	83	+0.5	0.2	100	140	252
						12	69					
6	1078	1076	54	9	54	10	94	+0.5	0	68	104	140
6	1121	1118	63	9	70	10	97	+0.5	0	88	135	206
6	1121	1118	90	10	80	10	95	+0.5	0.2	100	140	333
						12	79					
8	1251	1248	63	9	70	10	110	+0.5	0	88	135	231

6单排四点接触球式回转支承(O1系列) 结构参数—内齿式

Single-row four-point contact ball slewing bearings (series 01) structural parameters

机械行业标准 Machinery industry standard (JB/T2300-2011)



013.014

承载曲线号	Load diagram No	型号 type DL mm	外型尺寸 Configuration				安装尺寸 Mounting size				
			De mm	D mm	d mm	H mm	D1 mm	D2 mm	n	Φ mm	M mm
27		013.45.1250.001	1048.8	1390	1110	110	1337	1163	40	26	24
		014.45.1250.001	1041.6								
52		013.30.1400.001	1224	1512		89	1468	1332	44	22	20
31		013.45.1400.001	1192.8	1540	1260	110	1487	1313	40	26	24
		014.45.1400.001	1195.6								
53		013.40.1500.001	1308	1634		94	1582	1418	40	26	24
54		013.30.1600.001	1428	1712		89	1668	1532	48	22	20
34		013.45.1600.001	1391.6	1740	1460	110	1687	1513	45	26	24
		014.45.1600.001	1382.4								
55		013.40.1700.001	1498	1834		94	1782	1618	44	26	24
37		013.45.1800.001	1573.6	1940	1660	110	1887	1713	45	26	24
		014.45.1800.001	1574.4								
56		013.50.1800.001	1554	1971		109	1905	1695	36	33	30
57		013.50.2000.001	1764	2171		109	2105	1895	40	33	30
40		013.60.2000.001	1734.4	2178	1825	144	2110	1891	48	33	30
		014.60.2000.001	1735.2								
58		013.50.2240.001	1984	2411		109	2345	2135	48	33	30
42		013.60.2240.001	1990.4	2418	2065	144	2350	2131	48	33	30
		014.60.2240.001	1987.2								
59		013.50.2490.001	2240	2661		109	2595	2385	54	33	30
44		013.60.2500.001	2239.2	2678	2325	144	2610	2391	56	33	30
		014.60.2500.001	2228								
60		013.50.2800.001	2544	2971		109	2905	2652	60	33	30
46		013.60.2800.001	2527.2	2978	2625	144	2910	2691	56	33	30
		014.60.2800.001	2528								
47		013.75.3150.001	2828	3376	2922	174	3286	3014	56	45	42
		014.75.3150.001	2824.8								

6单排四点接触球式回转支承(01系列)结构参数—内齿式

Single-row four-point contact ball slewing bearings (series 01) structural parameters

注: ● n为润滑油孔数。油杯M10×1JB/T7940.1-JB/T7940.2。根据应用情况用户可指定油孔位置。

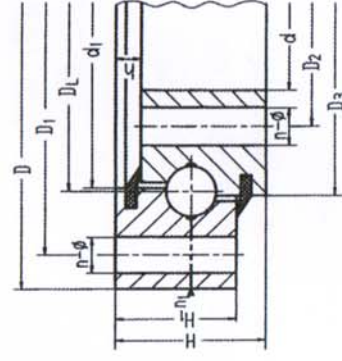
- $n-\phi$ 可改为螺纹孔，螺纹直径M，螺纹深度2M。
- 表内齿轮圆周力为最大圆周力，额定圆周力取其1/2。
- “K”为消顶系数。
- 本样本中的规格为标准产品，内外径均为自由公差。若主机与回转支承有配合要求，请在合同或合同附件（如技术协议）中注明配合尺寸和精度。
- 表中所列为我公司常规产品，若有其它特殊要求，请与我公司联系。

结构尺寸					齿轮参数					Sear data		齿轮周力		重量 kg
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	Tangential tooth load		
5	1252	1248	100	10	90	12 14	88 75	+0.5	0.2	135 158	188 219	467 467		
11	1401	1398	63	9	80	12	103	+0.5	0	121	176	296		
5	1402	1398	100	10	90	12 14	100 86	+0.5	0.2	135 158	188 219	529 529		
8	1501	1498	81	9	85	12	110	+0.5	0	128	187	410		
8	1601	1598	63	9	80	12	120	+0.5	0	121	176	334		
5	1602	1598	100	10	90	14 16	100 87	+0.5	0.2	158 181	219 250	607 620		
11	1701	1698	81	9	85	14	108	+0.5	0	149	218	475		
5	1802	1798	100	10	90	14 16	113 99	+0.5	0.2	158 181	219 250	721 721		
9	1802	1798	99	9	100	14	112	+0.5	0	257	276	762		
8	2002	1998	99	9	100	14	127	+0.5	0	257	827	827		
8	2002	1998	132	12	120	16	109	+0.5	0.2	241	333	1265		
8	2242	2238	99	9	100	18	97	+0.5	0	271	375	1265		
8	2242	2238	99	9	100	16	125	+0.5	0	294	961	961		
8	2242	2238	132	12	120	16 18	125 111	+0.5	0.2	241 271	333 375	1393 1393		
9	2492	2488	99	9	100	16	141	+0.5	0	294	1053	1053		
8	2502	2498	132	12	120	18 20	125 112	+0.5	0.2	271 301	375 418	1580 1580		
12	2802	2798	99	9	100	16	160	+0.5	0	294	1205	1205		
8	2802	2798	132	12	120	18 20	141 127	+0.5	0.2	271 301	375 418	1800 1800		
8	3152	3147	162	12	150	20 22	142 129	+0.5	0.2	377 415	522 574	2840 2840		

6单排四点接触球式回转支承(O1系列) 结构参数—无齿式

Single-row four-point contact ball slewing bearings (series 01) structural parameters

机械行业标准 Machinery industry standard (JB/T2300-2011)



010

Load diagram No 承载曲线号	型号 Type DL mm	外型尺寸 Configuration size				安装尺寸 Mounting size				
		De mm	D mm	d mm	H mm	D1 mm	D2 mm	n	Φ mm	M mm
3	010.30.500.001		602	398	80	566	434	20	18	16
5	010.30.560.001		662	458	80	626	494	20	18	16
7	010.30.630.001		732	528	80	696	564	24	18	16
9	010.30.710.001		812	608	80	776	644	24	18	16
12	010.40.800.001		922	678	100	878	722	30	22	20
15	010.40.900.001		1022	778	100	978	822	30	22	20
17	010.40.1000.001		1122	878	100	1078	922	36	22	20
22	010.40.1120.001		1242	998	100	1198	1042	36	22	20
27	010.45.1250.001		1390	1110	110	1337	1163	40	26	24
31	010.45.1400.001		1540	1260	110	1487	1313	40	26	24
34	010.45.1600.001		1740	1460	110	1687	1513	45	26	24
37	010.45.1800.001		1940	1660	110	1887	1713	45	26	24
40	010.60.2000.001		2178	1825	144	2110	1891	48	23	30
42	010.60.2240.001		2418	2065	144	2350	2131	48/	33	30
44	010.60.2500.001		2678	2325	144	2610	2391	56	33	30
46	010.60.2800.001		2978	2625	144	2910	2691	56	33	30
47	010.75.3150.001		3376	2922	174	3286	3014	56	45	42

6单排四点接触球式回转支承(01系列) 结构参数—无齿式

Single-row four-point contact ball slewing bearings (series 01) structural parameters

notes: n1 is the number of lubrication holes.oil cup M*1JB/T7940.1-JB/T7940.2, users can appoint the oil hole's position according to application circumstances.

n - Φ can be replaced by threaded hole, the diameter is M , the depth is $2M$.

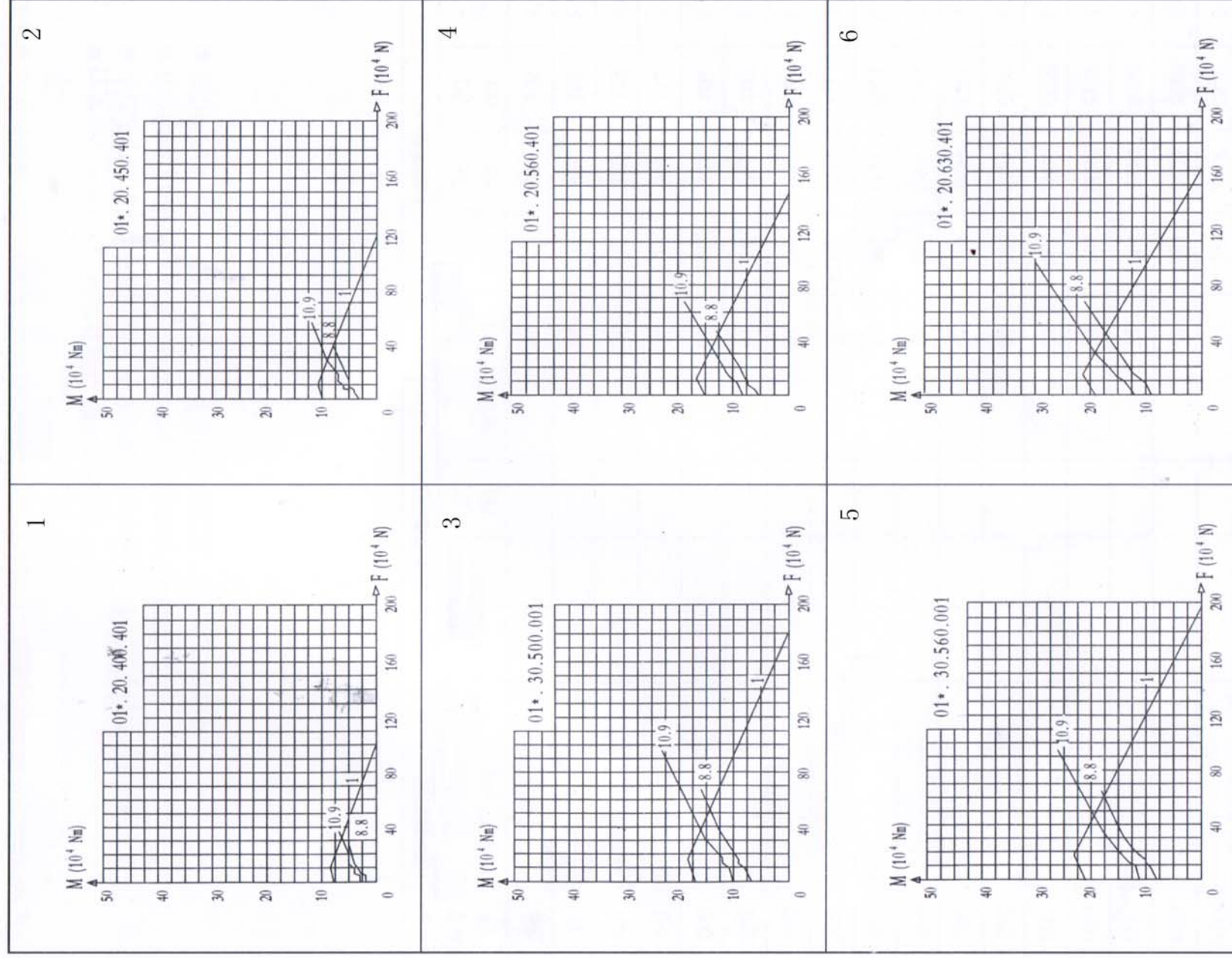
the tooth gear's peripheral force in the firm is the maximum peripheral force, the rated peripheral force is half of it. 'k' indicates cut-top coefficient.

this sample's specification is the standard product, both the inner diameter and outside diameter are all the free to tolerance, if the main engine and the slewing bearings have matching requirement, please note the matching size and accuracy on the contract or the appendix of the contract (like technology agreement). these are the standard products of our company listed in the form. if you have any other requirements, please contact us.

结构尺寸						齿轮参数				齿轮周力		重量
Structural size						Gear data				Tangential tooth load		weight
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	kg
4	501	498	70	10								84
4	561	558	70	10								92
4	631	628	70	10								104
4	711	708	70	10								121
6	801	798	90	10								200
6	901	898	90	10								225
6	1001	998	90	10								263
6	1121	1118	90	10								281
5	1252	1248	100	10								399
5	1402	1398	100	10								446
5	1602	1598	100	10								507
5	1802	1798	100	10								575
8	2002	1998	132	12								1047
8	2242	2238	132	12								1181
8	2502	2498	132	12								1315
8	2802	2798	132	12								1484
8	3152	3147	162	12								2618

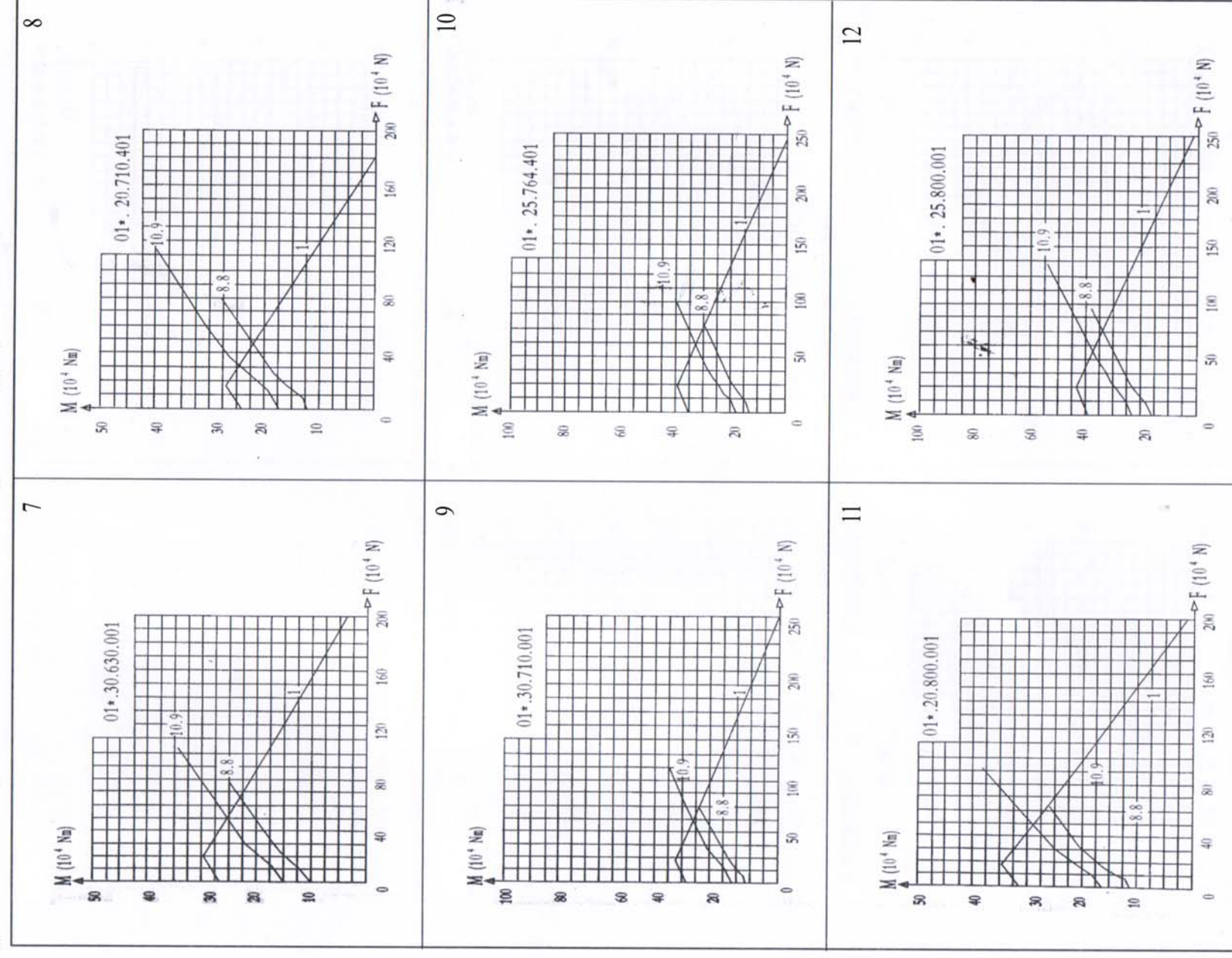
6单排四点接触球式回转支承(O1系列)承载曲线

Single-row four-point contact ball slewing bearings (series O1) static load limit curve



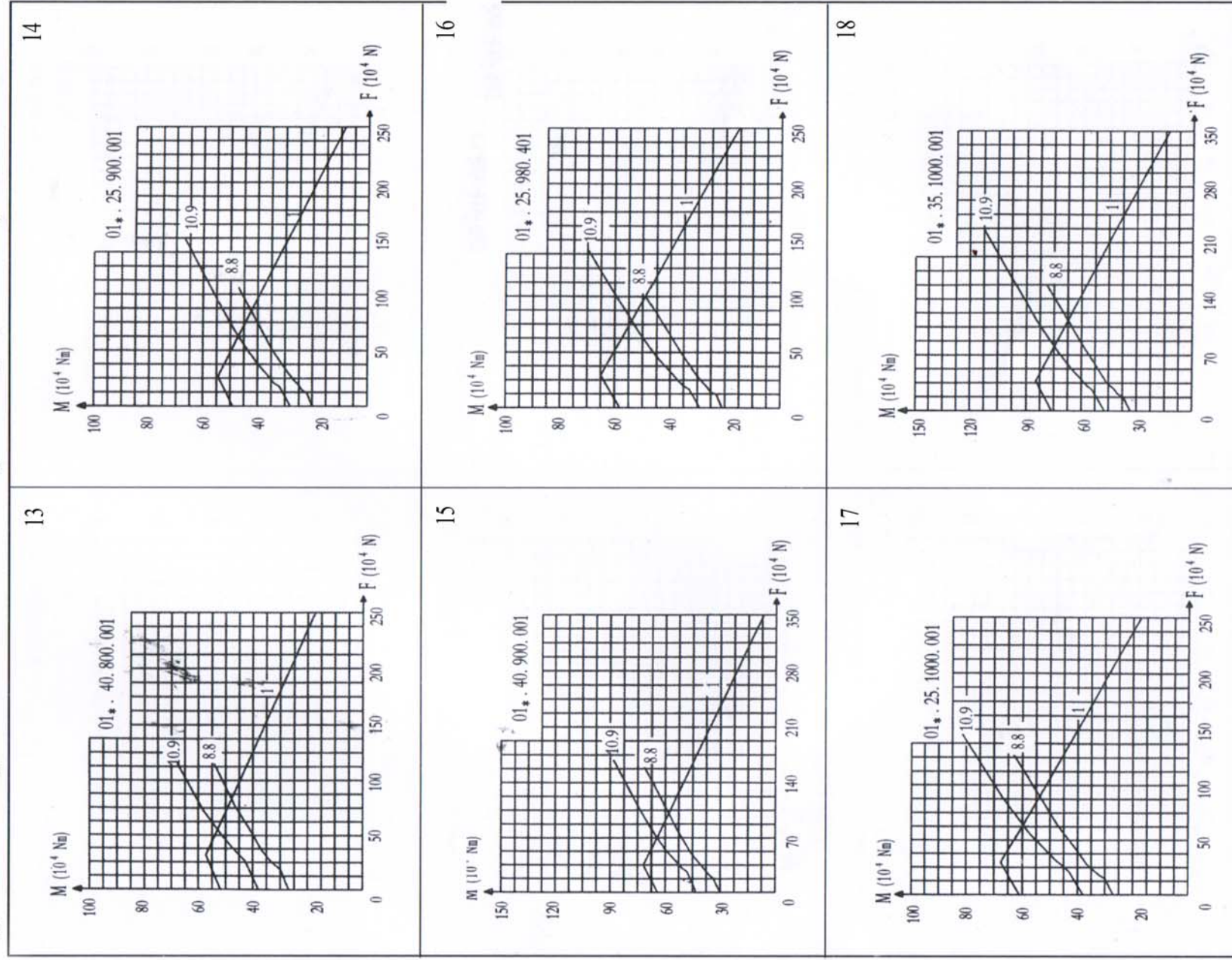
6单排四点接触球式回转支承(O1系列)承载曲线

Single-row four-point contact ball slewing bearings (series O1) static load limit curve



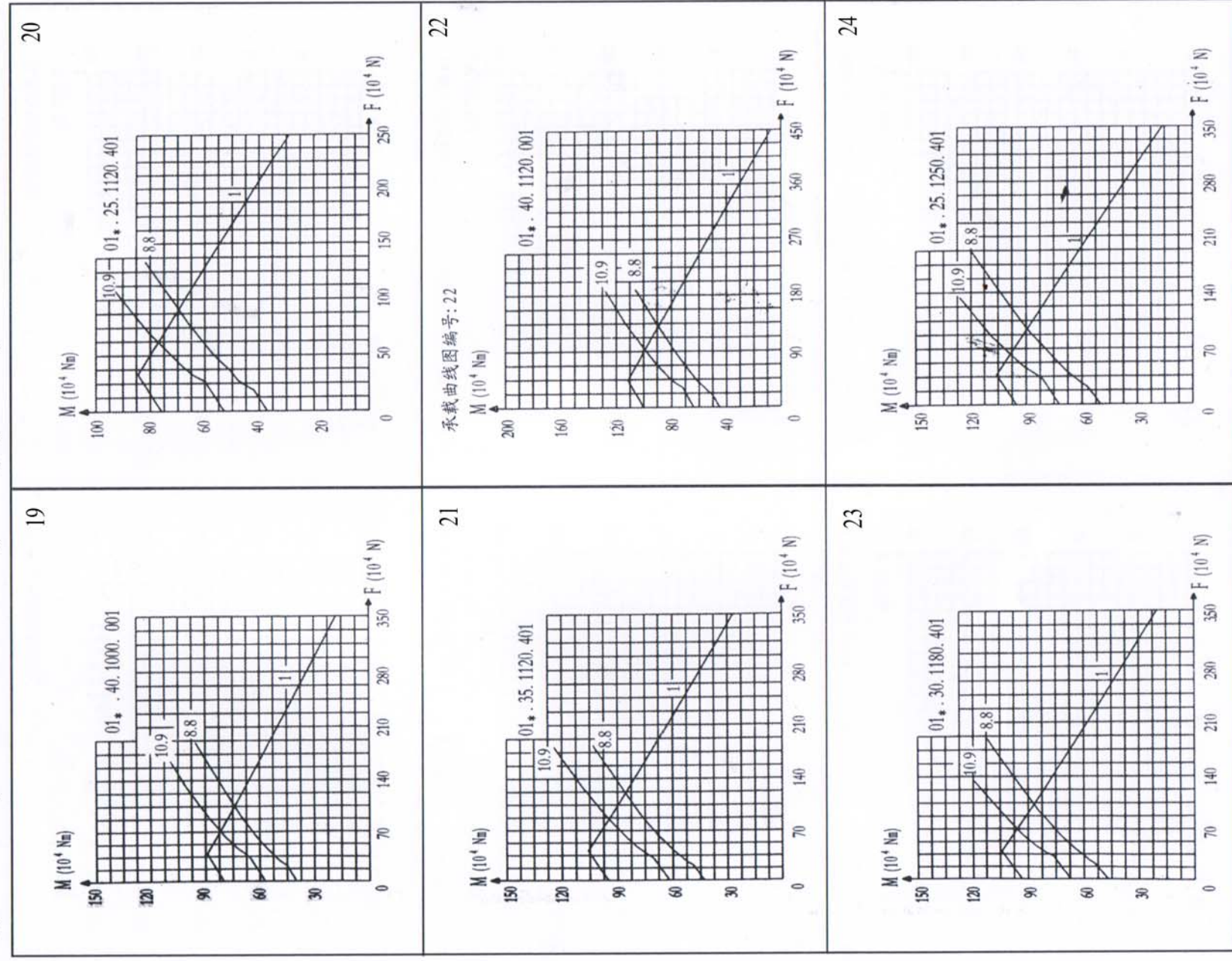
6单排四点接触球式回转支承(O1系列)承载曲线

Single-row four-point contact ball slewing bearings (series O1) static load limit curve



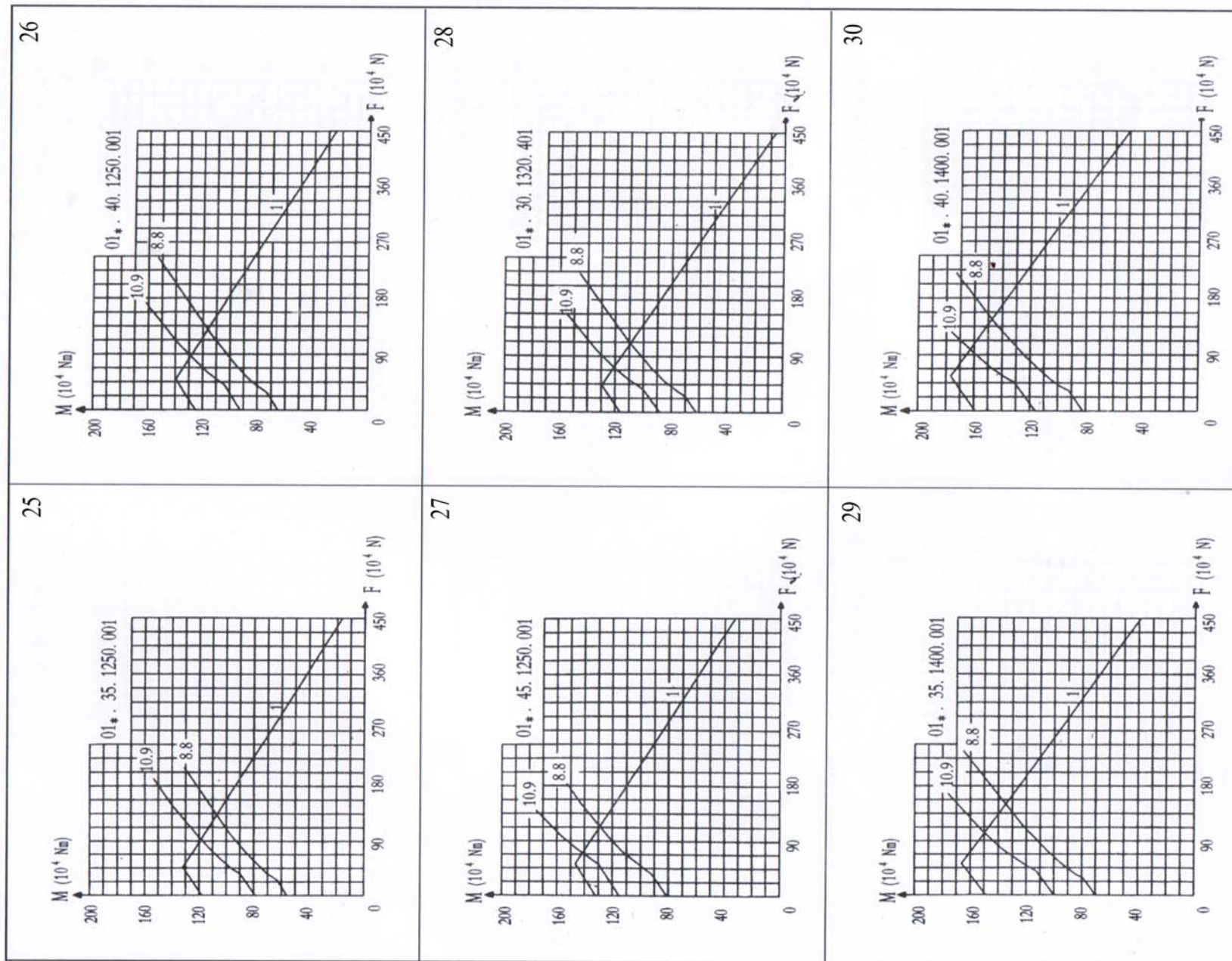
6单排四点接触球式回转支承(O1系列)承载曲线

Single-row four-point contact ball slewing bearings (series O1) static load limit curve



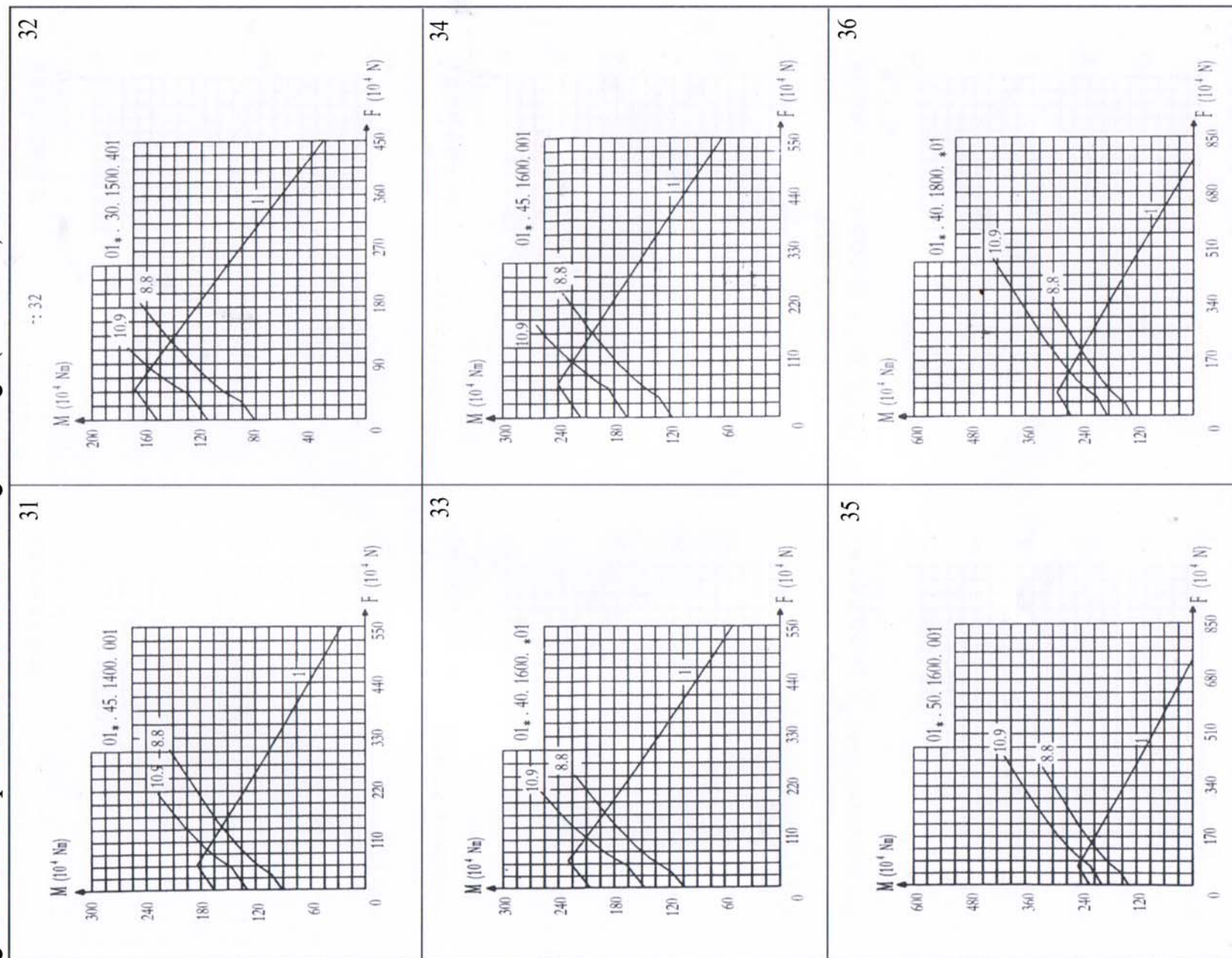
6单排四点接触球式回转支承(O1系列)承载曲线

Single-row four-point contact ball slewing bearings (series O1) static load limit curve



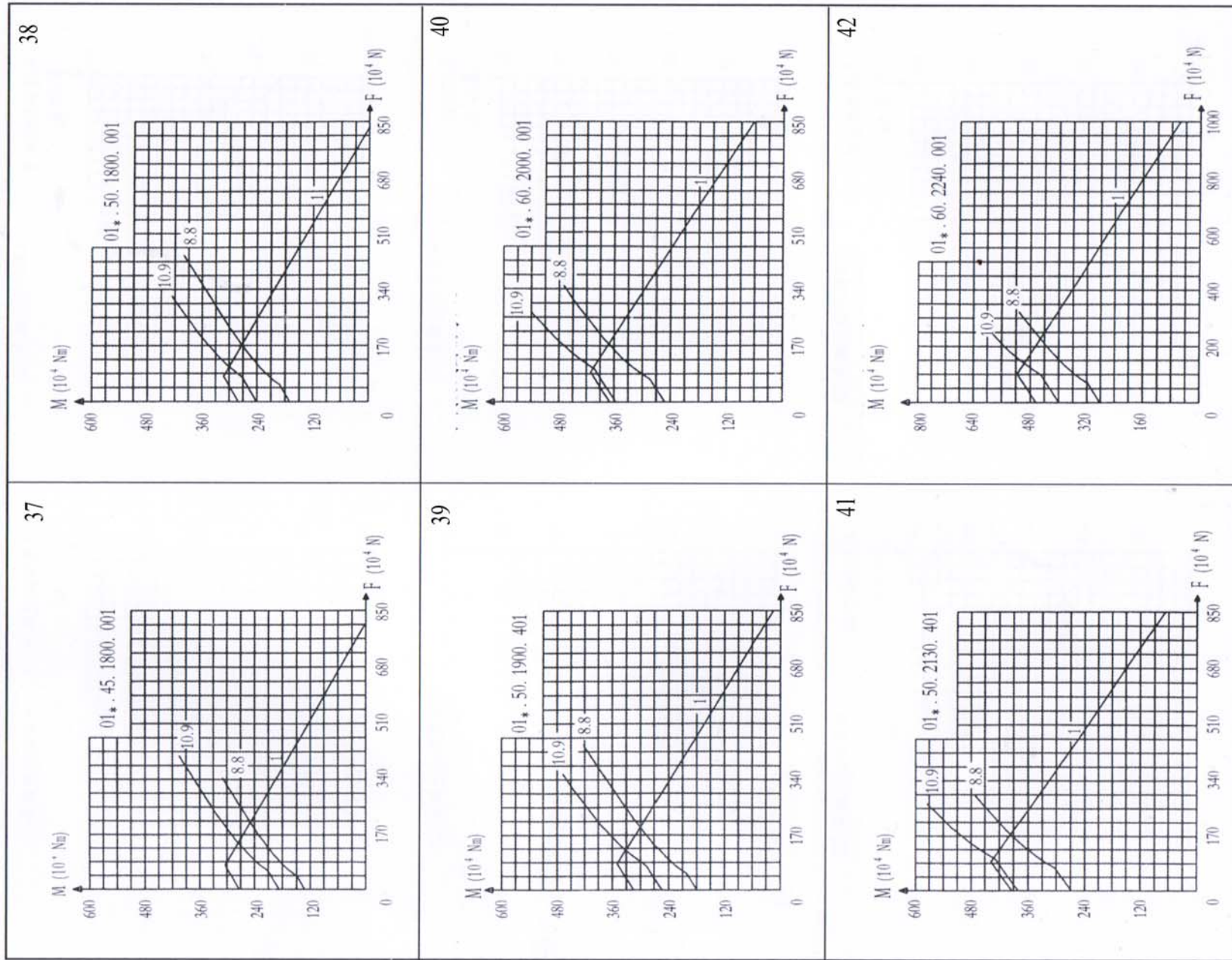
6单排四点接触球式回转支承(O1系列)承载曲线

Single-row four-point contact ball slewing bearings (series O1) static load limit curve



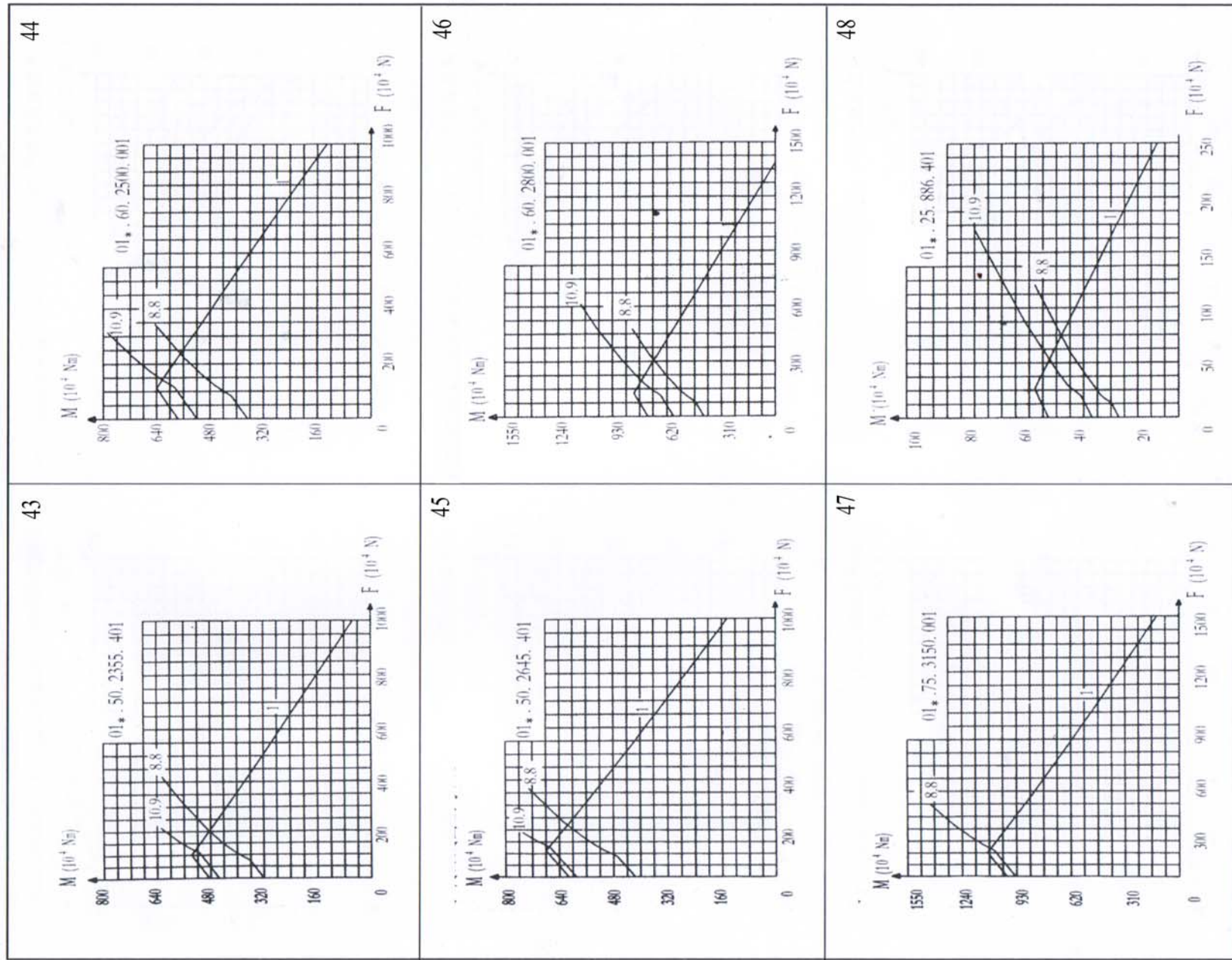
6单排四点接触球式回转支承(O1系列)承载曲线

Single-row four-point contact ball slewing bearings (series O1) static load limit curve



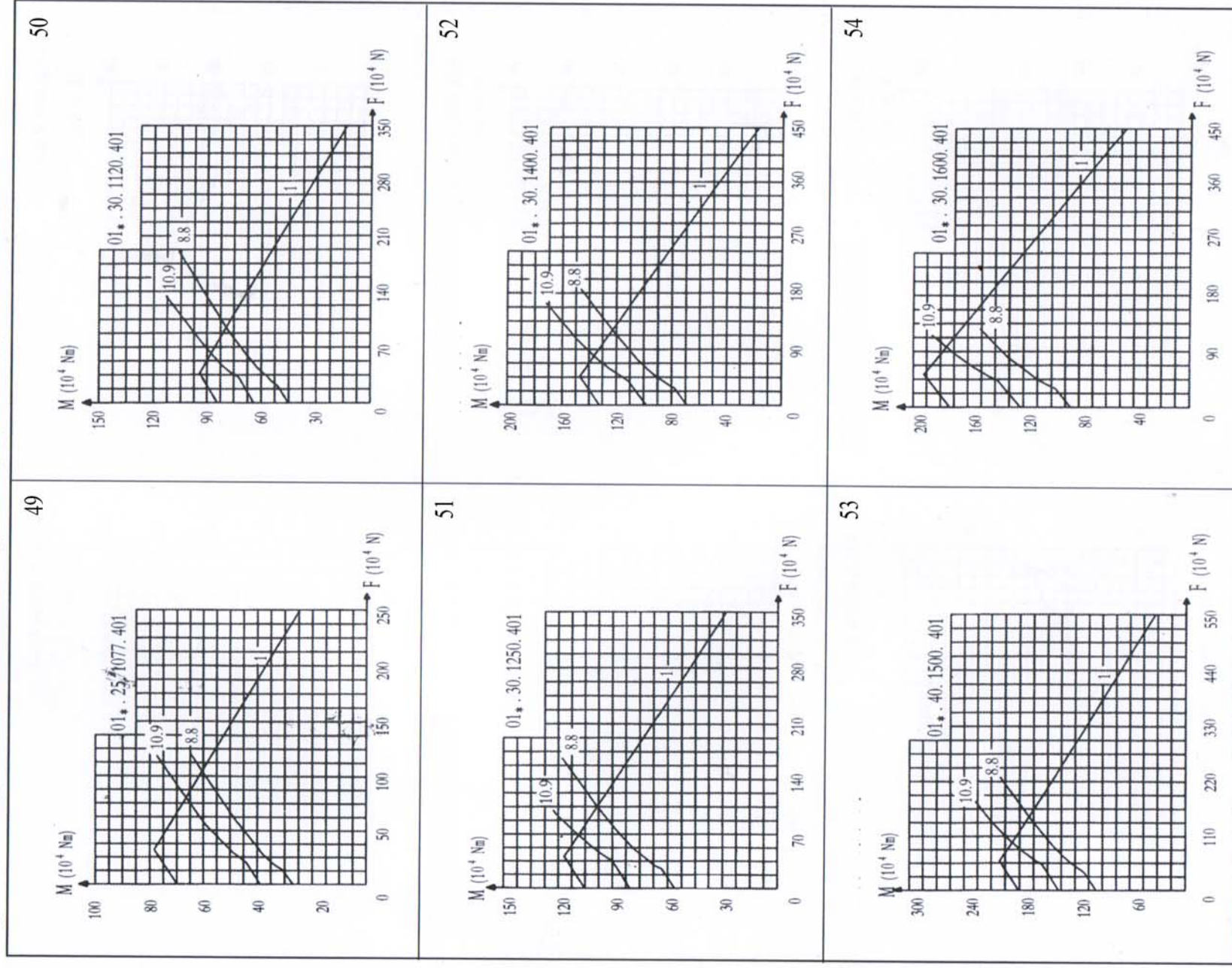
6单排四点接触球式回转支承(O1系列)承载曲线

Single-row four-point contact ball slewing bearings (series O1) static load limit curve



6单排四点接触球式回转支承(O1系列)承载曲线

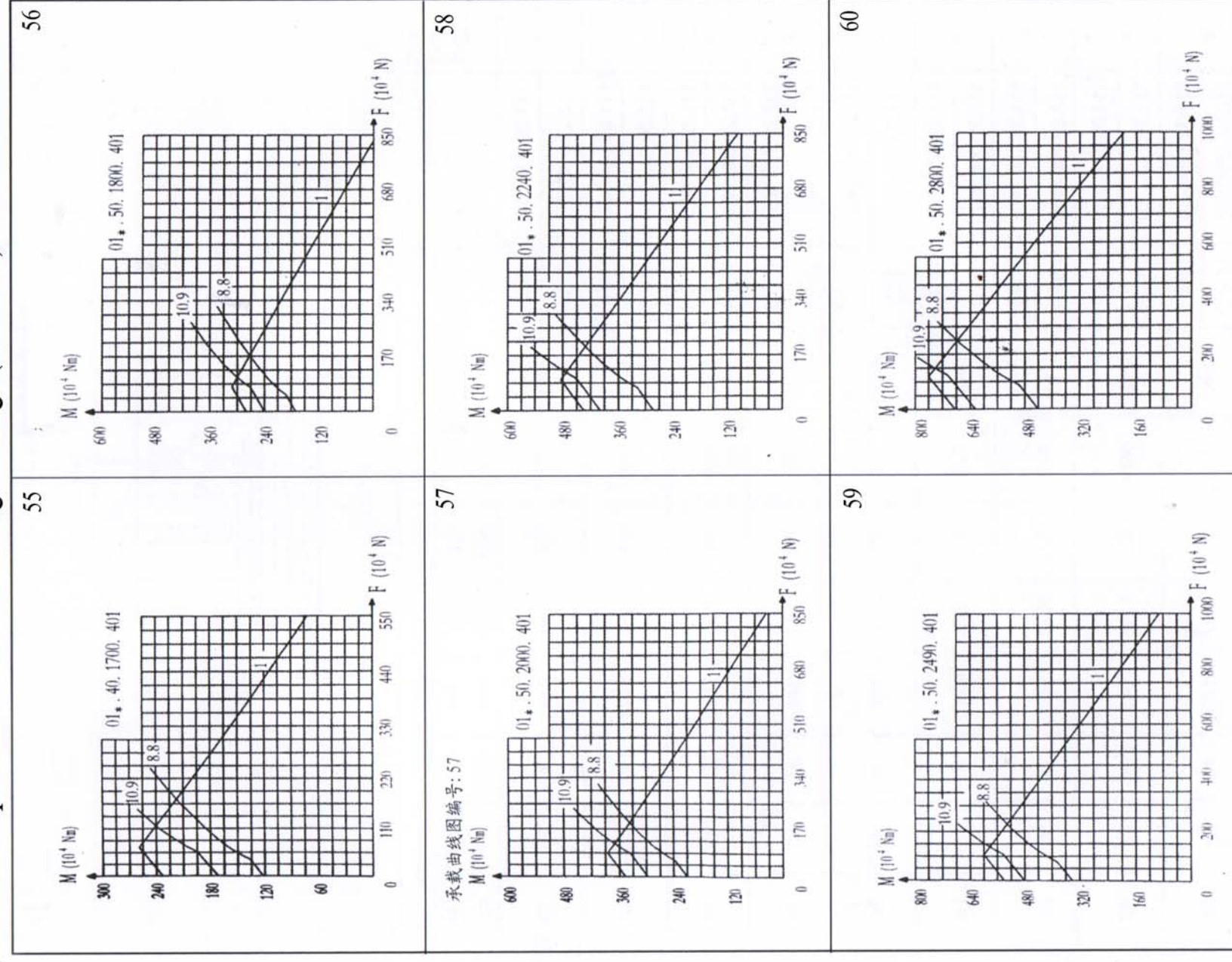
Single-row four-point contact ball slewing bearings (series O1) static load limit curve



37

6单排四点接触球式回转支承(O1系列)承载曲线

Single-row four-point contact ball slewing bearings (series O1) static load limit curve

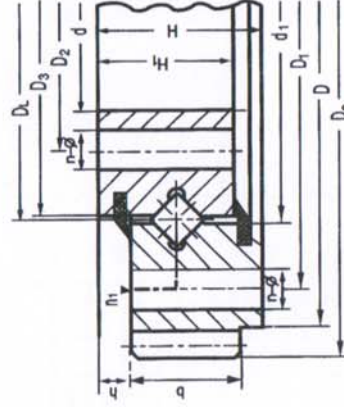


38

7单排交叉滚柱式回转支承(D1系列)结构参数—外齿式

Single-row cross roller slewing bearings (series 11) structural parameters

机械行业标准 Machinery industry standard (JB/T2300-2011)



111,112

承载曲线号 Load diagram No	型号 type DL mm	外型尺寸 Configuration size					安装尺寸 Mounting size				
		De mm	D mm	d mm	H mm	D1 mm	D2 mm	n mm	Φ mm	M mm	
1	111.25.500.001	629	602	398	75	566	434	20	18	16	
	112.25.500.001	628.8									
2	111.25.560.001	689	662	458	75	626	494	20	18	16	
	112.25.560.001	688.8									
3	111.25.630.001	772.8	732	528	75	696	564	24	18	16	
	112.25.630.001	774.4									
4	111.25.710.001	850.8	812	608	75	776	644	24	18	16	
	112.25.710.001	854.4									
5	111.28.800.001	966.4	922	678	82	878	722	30	22	20	
	112.28.800.001	968									
6	111.28.900.001	1062.4	1022	778	82	978	822	30	22	20	
	112.28.900.001	1068									
7	111.28.1000.001	1188	1122	878	82	1078	922	36	22	20	
	112.28.1000.001	1185.6									
8	111.28.1120.001	1298	1242	998	82	1198	1042	36	22	20	
	112.28.1120.001	1305.6									
9	111.32.1250.001	1449.6	1390	1110	91	1337	1163	40	26	24	
	112.32.1250.001	1453.2									

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7单排交叉滚柱式回转支承(1系列)结构参数—外齿式

Single-row cross roller slewing bearings (series 11) structural parameters

注: ●_n为润滑油孔数。油杯M10×1JB/T7940.1-JB/T7940.2。根据应用情况用户可指定油孔位置。

- $n-\phi$ 可改为螺纹孔, 螺纹直径M, 螺纹深度2M。
- 表内齿轮圆周力为最大圆周力, 额定圆周力取其1/2。
- “K” 为消顶系数。
- 样本中的规格为标准产品, 内外径均为自由公差。若主机与回转支承有配合要求, 请在合同或合同附件 (如技术协议) 中注明配合尺寸和精度。
- 表中所列为我公司常规产品, 若有其它特殊要求, 请与我公司联系。

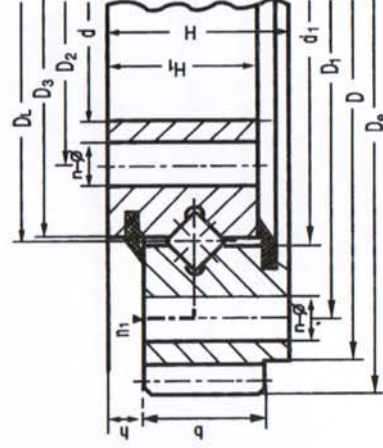
结构尺寸Structural size						齿轮参数 Gear data				齿轮圆周力 Tangential tooth load		重量 Weight kg
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
4	498	502	65	10	60	5	123	+0.5	0.1	37	52	84
						6	102			45	62	84
4	558	562	65	10	60	5	135	+0.5	0.1	37	52	92
						6	112			45	62	92
4	628	632	65	10	60	6	126	+0.5	0.1	45	62	111
						8	94			60	83	111
4	708	712	65	10	60	6	139	+0.5	0.1	45	62	125
						8	104			60	83	125
6	798	802	72	10	65	8	118	+0.5	0.1	65	91	179
						10	94			81	114	179
6	898	902	72	10	65	8	130	+0.5	0.1	65	91	200
						10	104			81	114	200
6	998	1002	72	10	65	10	116	+0.5	0.1	81	114	242
						12	96			97	136	242
6	1118	1122	72	10	65	10	127	+0.5	0.1	81	114	261
						12	106			97	136	261
5	1248	1252	81	10	75	12	118	+0.5	0.1	113	157	362
						14	101			132	182	362

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7单排交叉滚柱式回转支承(D1系列)结构参数—外齿式

Single-row cross roller slewing bearings (series 11) structural parameters

机械行业标准 Machinery industry standard (JB/T2300-2011)



111,112

承载曲线号	Load diagram No	型号 Type	外型尺寸 Configuration size			安装尺寸 Mounting size						
			DL mm	De mm	D mm	d mm	H mm	D1 mm	D2 mm	n mm	Φ mm	M mm
10		111.32.1400.001		1605.6	1540	1260	91	1487	1313	40	26	24
		112.32.1400.001	1607.2									
11		111.32.1600.001		1817.2	1740	1460	91	1687	1513	45	26	24
		112.32.1600.001	1820.8									
12		111.32.1800.001		2013.2	1940	1660	91	1887	1713	45	26	24
		112.32.1800.001	2012.8									
13		111.40.2000.001		2268.8	2178	1825	112	2110	1891	48	33	30
		112.40.2000.001	2264.4									
14		111.40.2240.001		2492.8	2418	2065	112	2350	2131	48	33	30
		112.40.2240.001	2498.4									
15		111.40.2500.001		2768.4	2678	2325	112	2610	2391	56	33	30
		112.40.2500.001	2776									
16		111.40.2800.001		3074.4	2978	2625	112	2910	2691	56	33	30
		112.40.2800.001	3076									
17		111.50.3150.001		3476	3376	2922	134	3286	3014	56	45	42
		112.50.3150.001	3471.6									

7单排交叉滚柱式回转支承(D1系列)结构参数—外齿式

Single-row cross roller slewing bearings (series 11) structural parameter

notes: n is the number of lubrication holes, oil cup M*1JB/T7940.1-JB/T7940.2, users can appoint the oil hole's position according to application circumstances.

n- Φ can be replaced by threaded hole, the diameter is M, the depth is 2M.

the tooth gear's peripheral force in the firm is the maximum peripheral force, the rated peripheral force is half of it.

'k' is indicates cut-top coefficient.

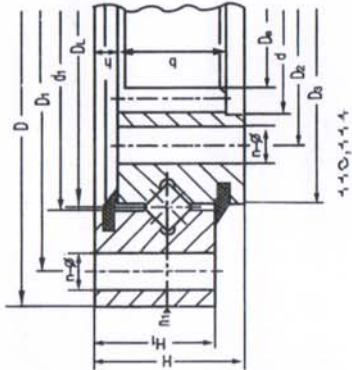
this sample's specification is the standard product, both the inner diameter and outside diameter are all the free to tolerance, if the main engine and the stewing bearings have matching requirement, please note the matching size and accuracy on the contract or the appendix of the contract (like technology agreement).

结构尺寸 Structural size					齿轮参数 Gear data				齿轮周力 Tangential tooth load		重量 Weight kg	
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
5	1398	1402	81	10	75	12	131	+0.5	0.1	113	157	417
						14	112			132	182	411
5	1598	1602	81	10	75	14	127	+0.5	0.1	132	182	488
						16	111			151	224	484
5	1798	1802	81	10	75	14	141	+0.5	0.1	132	182	530
						16	123			151	224	530
8	1997	2003	100	12	90	16	139	+0.5	0.1	181	250	935
						18	123			203	281	935
8	2237	2243	100	12	90	16	153	+0.5	0.1	181	250	1008
						18	136			203	281	1008
8	2497	2503	100	12	90	18	151	+0.5	0.1	203	281	1147
						20	136			226	313	1147
8	2797	2803	100	12	90	18	168	+0.5	0.1	203	281	1320
						20	151			226	313	1320
8	3147	3153	122	12	110	20	171	+0.5	0.1	276	383	2222
						22	155			304	421	2222

7单排交叉滚柱式回转支承(Q1系列)结构参数-内齿式

Single-row cross roller slewing bearings (series 11) structural parameters

机械行业标准 Machinery industry standard (JB/T2300-2011)



承载曲线号 Load diagram No	型号 Type DL mm	外型尺寸 Configuration size				安装尺寸 Mounting size					
		De mm	D mm	d mm	H mm	D1 mm	D2 mm	n mm	Φ mm	M mm	
1	113.25.500.001	367	602	398	75	566	434	20	18	16	
	114.25.500.001	368.4									
2	113.25.560.001	427	662	458	75	626	494	20	18	16	
	114.25.560.001	428.4									
3	113.25.630.001	494.4	732	528	75	696	564	24	18	16	
	114.25.630.001	491.2									
4	113.25.710.001	572.4	812	608	75	776	644	24	18	16	
	114.25.710.001	571.2									
5	113.28.800.001	635.2	922	678	82	878	722	30	22	20	
	114.28.800.001	634									
6	113.28.900.001	739.2	1022	778	82	978	822	30	22	20	
	114.28.900.001	734									
7	113.28.1000.001	824	1122	878	82	1078	922	36	22	20	
	114.28.1000.001	820.8									
8	113.28.1120.001	944	1242	998	82	1198	1042	36	22	20	
	114.28.1120.001	940.8									
9	113.32.1250.001	1048.8	1390	1110	91	1337	1163	40	26	24	
	114.32.1250.001	1041.6									
10	113.32.1400.001	1192.8	1540	1260	91	1487	1313	40	26	24	
	114.32.1400.001	1195.6									
11	113.32.1600.001	1391.6	1740	1460	91	1687	1513	45	26	24	
	114.32.1600.001	1382.4									
12	113.32.1800.001	1573.6	1940	1660	91	1887	1713	45	26	24	
	114.32.1800.001	1574.4									
13	113.40.2000.001	1734.4	2178	1825	112	2110	1891	48	33	30	
	114.40.2000.001	1735.2									
14	113.40.2240.001	1990.4	2418	2065	112	2350	2131	48	33	30	
	114.40.2240.001	1987.2									
15	113.40.2500.001	2239.2	2678	2325	112	2610	2391	56	33	30	
	114.40.2500.001	2228									
16	113.40.2800.001	2527.2	2978	2625	112	2910	2691	56	33	30	
	114.40.2800.001	2528									
17	113.50.3150.001	2828	3376	2922	134	3286	3014	56	45	42	
	114.50.3150.001	2824.8									

7单排交叉滚柱式回转支承(Q1系列)结构参数-内齿式

Single-row cross roller slewing bearings (series 11) structural parameters

注：● n为润滑油孔数。油杯M10×1JB/T7940.1-1JB/T7940.2。根据应用情况用户可指定油孔位置。

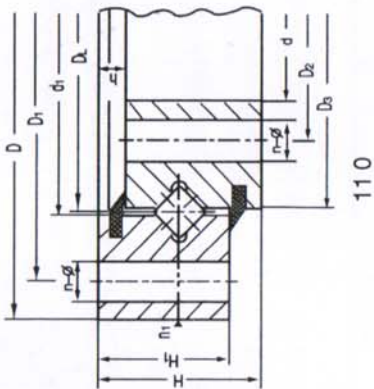
- n-φ 可改为螺纹孔，螺纹直径M，螺纹深度2M。
- 表内齿圆周力为最大圆周力，额定圆周力取其1/2。
- “K” 为消顶系数。
- 本样本中的规格为标准产品，内外径均为自由公差。若主机与回转支承有配合要求，请在合同或合同附件（如技术协议）中注明配合尺寸和精度。
- 表中所列为我公司常规产品，若有其它特殊要求，请与我公司联系。

结构尺寸 Structural size					齿轮参数 Gear data					齿轮圆周力 Tangential tooth load		重量 Weight kg
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
4	498	502	65	10	60	5	74	+0.5	0.2	37	52	85
						6	62					45
4	558	562	65	10	60	5	86	+0.5	0.2	37	52	96
						6	72					45
4	628	632	65	10	60	6	83	+0.5	0.2	45	62	110
						8	62					60
4	708	712	65	10	60	6	96	+0.5	0.2	45	62	126
						8	72					60
6	798	802	72	10	65	8	80	+0.5	0.2	65	91	186
						10	64					81
6	898	902	72	10	65	8	93	+0.5	0.2	65	91	208
						10	74					81
6	998	1002	72	10	65	10	83	+0.5	0.2	81	114	220
						12	69					97
6	1118	1122	72	10	65	10	95	+0.5	0.2	81	114	273
						12	79					97
5	1248	1252	81	10	75	12	88	+0.5	0.2	113	157	386
						14	75					132
5	1398	1402	81	10	75	12	100	+0.5	0.2	113	157	441
						14	86					132
5	1598	1602	81	10	75	14	100	+0.5	0.2	132	182	502
						16	87					151
5	1798	1802	81	10	75	14	113	+0.5	0.2	132	182	605
						16	99					151
8	1997	2003	100	12	90	16	109	+0.5	0.2	181	250	977
						18	97					203
8	2237	2243	100	12	90	16	125	+0.5	0.2	181	250	1072
						18	111					203
8	2497	2503	100	12	90	18	125	+0.5	0.2	203	281	1211
						20	112					226
8	2797	2803	100	12	90	18	141	+0.5	0.2	203	281	1396
						20	127					226
8	3147	3153	122	12	110	20	142	+0.5	0.2	276	383	2344
						22	129					304

7单排交叉滚柱式回转支承(Q1系列)结构参数-无齿式

Single-row cross roller slewing bearings (series 11) structural parameter

机械行业标准 Machinery industry standard (JB/T2300-2011)



7单排交叉滚柱式回转支承(Q1系列)结构参数—无齿式

Single-row cross roller slewing bearings (series 11) structural parameters

notes: n1 is the number of lubrication holes, oil cup M*1JB/T7940.1-JB/T7940.2, users can appoint the oil hole's position according to application circumstances.

n- Φ can be replaced by threaded hole, the diameter is M, the depth is 2M.

k is indicates cut-top coefficient.

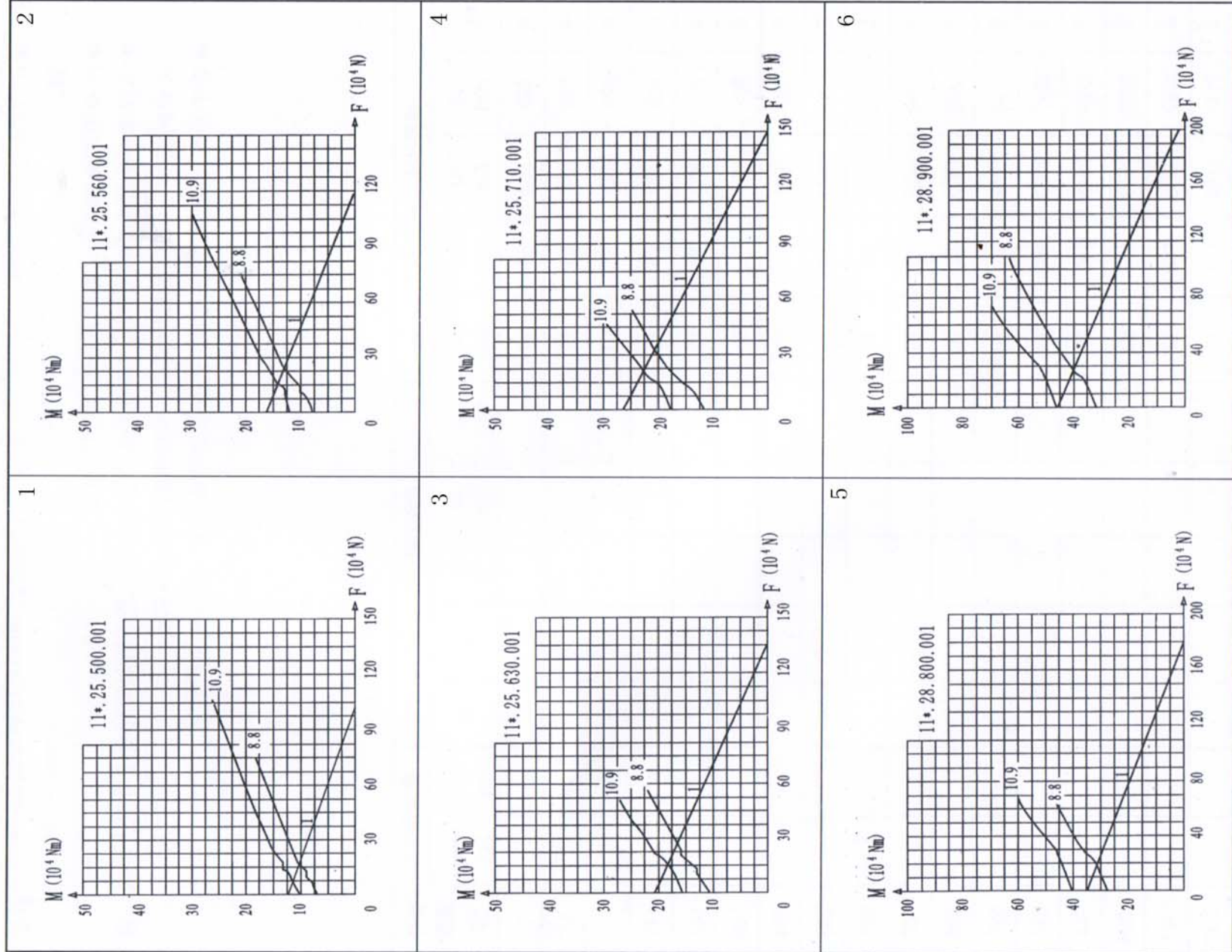
this sample's specification is the standard product,both the inner diameter and outside diameter are all the free to tolerance,if the main engine and the slewing bearings have matching requirement,please note the mismatching size and accuracy on the contract or the appendix of the contract(like technology agreement). these are the standard products of ourpany listed in the form. if you have any other requirements,please contact us.

承载曲线号 Load diagram No	型号 Type DL mm	外型尺寸 Configuration			安装尺寸 Mounting size					
		De mm	D mm	d mm	H mm	D1 mm	D2 mm	n mm	Φ mm	M mm
1	110.25.500.001		602	398	75	566	434	20	18	16
2	110.25.560.001		662	458	75	626	494	20	18	16
3	110.25.630.001		732	528	75	696	564	24	18	16
4	110.25.710.001		812	608	75	776	644	24	18	16
5	110.28.800.001		922	678	82	878	722	30	22	20
6	110.28.900.001		1022	778	82	978	822	30	22	20
7	110.28.1000.001		1122	878	82	1078	922	36	22	20
8	110.28.1120.001		1242	998	82	1198	1042	36	22	20
9	110.32.1250.001		1390	1110	91	1337	1163	40	26	24
10	110.32.1400.001		1540	1260	91	1487	1313	40	26	24
11	110.32.1600.001		1740	1460	91	1687	1513	45	26	24
12	110.32.1800.001		1940	1660	91	1887	1713	45	26	24
13	110.40.2000.001		2178	1825	112	2110	1891	48	33	30
14	110.40.2240.001		2418	2065	112	2350	2131	48	33	30
15	110.40.2500.001		2678	2325	112	2610	2391	56	33	30
16	110.40.2800.001		2978	2625	112	2910	2691	56	33	30
17	110.50.3150.001		3376	2922	134	3286	3014	56	45	42

结构尺寸 Structural size					齿轮参数 Gear data					齿轮圆周力 Tangential tooth load		重量 Weight kg
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
4	498	502	65	10								77
4	558	562	65	10								87
4	628	632	65	10								95
4	708	712	65	10								111
6	798	802	72	10								167
6	898	902	72	10								186
6	998	1002	72	10								204
6	1118	1122	72	10								233
5	1248	1252	81	10								337
5	1398	1402	81	10								369
5	1598	1602	81	10								425
5	1798	1802	81	10								525
8	1997	2003	100	12								815
8	2237	2243	100	12								944
8	2497	2503	100	12								1026
8	2797	2803	100	12								1375
8	3147	3153	122	12								2097

7 单排交叉滚柱式回转支承 (11系列) 承载曲线

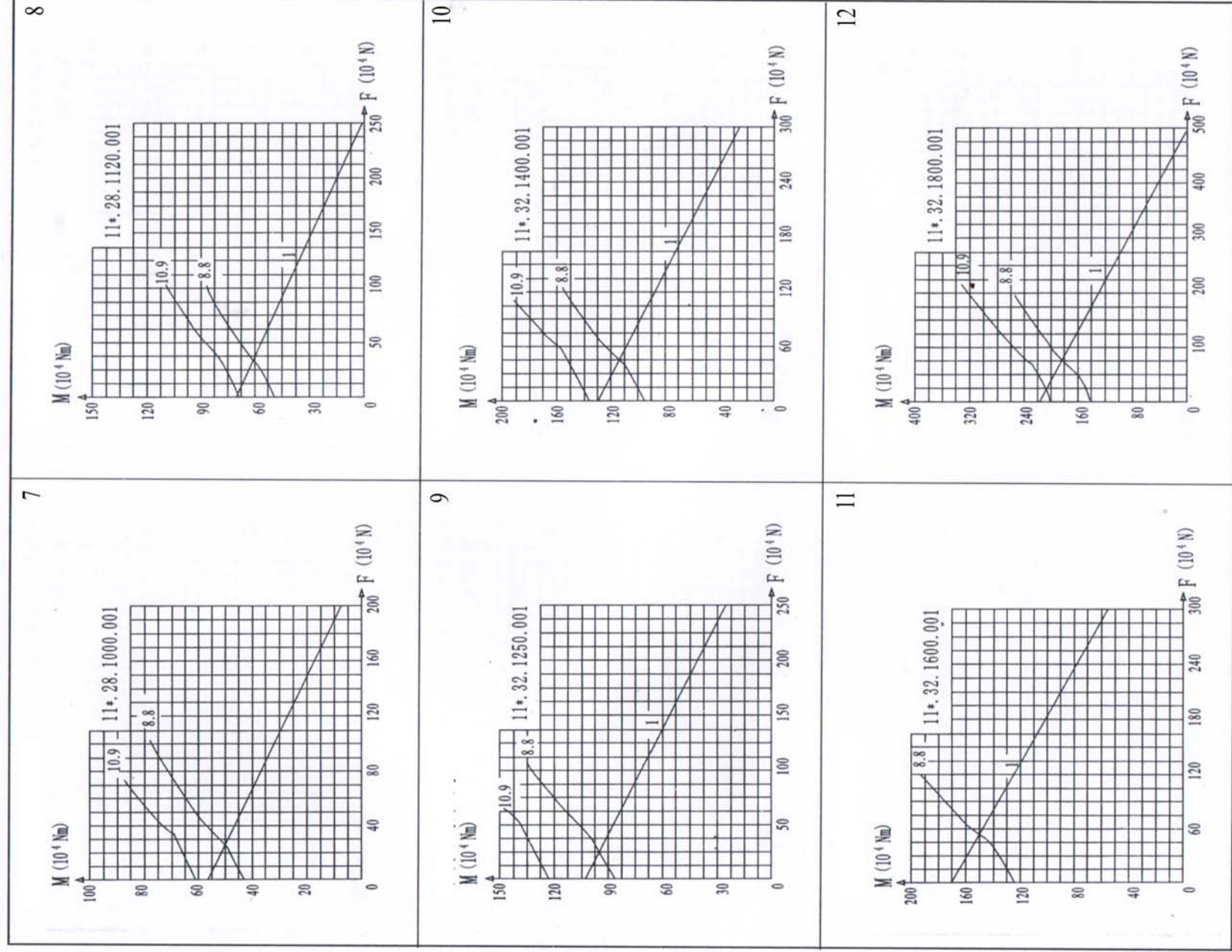
Single-row cross roller slewing bearings (series 11) static load limit curve



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7 单排交叉滚柱式回转支承 (11系列) 承载曲线

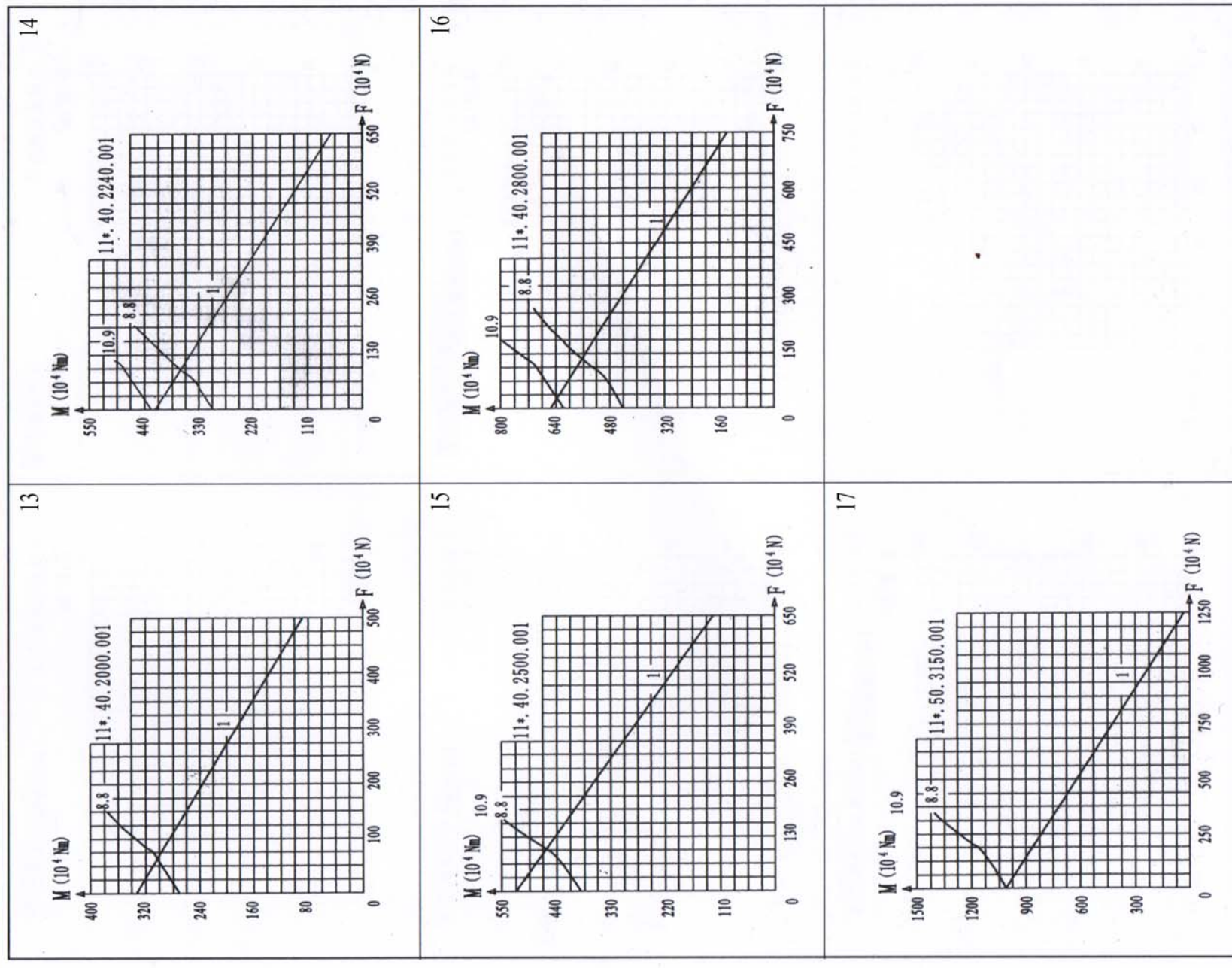
Single-row cross roller slewing bearings (series 11) static load limit curve



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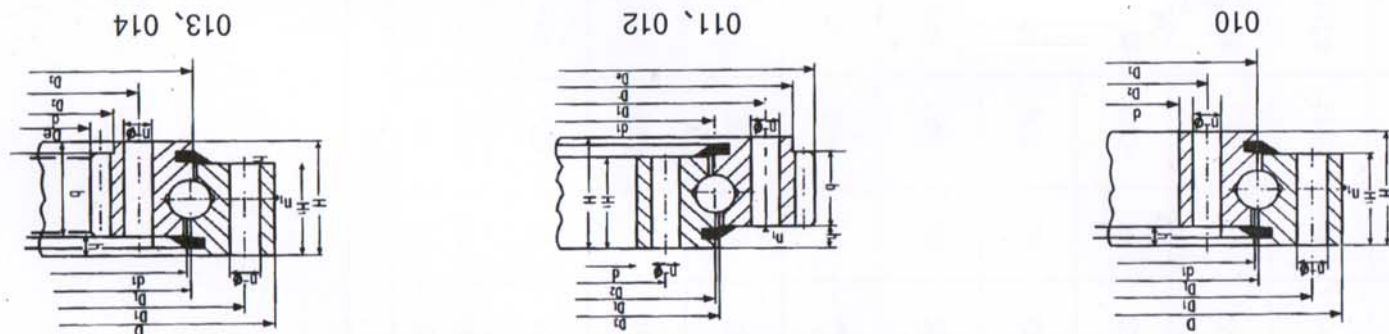
7 单排交叉滚柱式回转支承 (11 系列) 承载曲线

Single-row cross roller slewing bearings (series 11) static load limit curve



8 $\phi 200-\phi 450$ 单排四点接触球式回转支承基本参数表JB2300-2011

$\phi 200-\phi 450$ single-row four-point contact ball slewing bearings basic parameters JB2300-2011

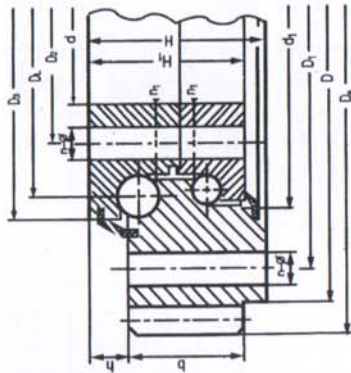


序 号	基本型号		外型尺寸		安装尺寸		结构尺寸		齿轮参数		Ext gear 外齿参数	Int gear 内齿参数									
	Basic type	无齿式	外型尺寸	安装尺寸	结构尺寸	齿轮参数	Ext gear 外齿参数	Int gear 内齿参数													
	DL(mm)	DL(mm)	DL(mm)	DL(mm)	DL(mm)	DL(mm)	DL(mm)	DL(mm)	DL(mm)	DL(mm)	DL(mm)	DL(mm)									
1	010.18.200	011.18.200	280	120	56	248	152	8	16	2	201	199	46	10	40	0	3	300	98	-	-
2	010.18.224	011.18.224	304	144	56	272	176	8	16	2	225	223	46	10	40	0	3	321	105	-	-
3	010.18.250	011.18.250	330	170	56	298	202	12	16	2	251	249	46	10	40	0	4	352	86	-	-
4	010.18.280	011.18.280	360	200	56	328	232	12	16	2	281	279	46	10	40	0	4	384	94	-	-
5	010.20.315	011.20.315	408	222	60	372	258	16	18	2	316	314	50	10	45	0	5	435	85	195	41
6	010.20.355	011.20.355	448	262	60	412	298	16	18	2	356	354	50	10	45	0	5	475	93	235	49
7	010.20.400	011.20.400	493	307	60	457	343	20	18	2	401	399	50	10	45	0	6	528	86	276	48
8	010.20.450	011.20.450	543	357	60	507	393	20	18	2	451	449	50	10	45	0	6	576	94	324	56

9 双排异径球式回转支承（02系列）结构参数—外齿式

Double-row ball slewing bearings (series 02) structural parameters

机械行业标准 Machinery industry standard (JB/T2300 -2011)



021,022

承载曲线号 Load diagram No	型号 type DL mm	外型尺寸 Configuration size			安装尺寸 Mounting size					
		De mm	D mm	d mm	H mm	D1 mm	D2 mm	n mm	Φ mm	M mm
1	021.25.500.002	644	616	384	106	580	420	20	18	16
	022.25.500.002	646.8								
2	021.25.560.002	704	676	444	106	640	480	20	18	16
	022.25.560.002	706.8								
3	021.25.630.002	790.8	746	514	106	710	550	24	18	16
	022.25.630.002	790.4								
4	021.25.710.002	862.8	826	594	106	790	630	24	18	16
	022.25.710.002	862.4								
5	021.30.800.002	982.4	942	658	124	898	702	30	22	20
	022.30.800.002	988								
6	021.30.900.002	1086.4	1042	758	124	998	802	30	22	20
	022.30.900.002	1088								
7	021.30.1000.002	1198	1142	858	124	1098	902	36	22	20
	022.30.1000.002	1197.6								
8	021.30.1120.002	1318	1262	978	124	1218	1022	36	22	20
	022.30.1120.002	1317.6								
9	021.40.1250.002	1497.6	1426	1074	160	1374	1126	40	26	24
	022.40.1250.002	1495.2								
10	021.40.1400.002	1641.6	1576	1224	160	1524	1272	40	26	24
	022.40.1400.002	1649.2								

9 双排异径球式回转支承（02系列）结构参数—外齿式

Double-row ball slewing bearings (series 02) structural parameters

注：● n为润滑油孔数。油杯M10×1JB/T7940.1-JB/T7940.2。根据应用情况用户可指定油孔位置。

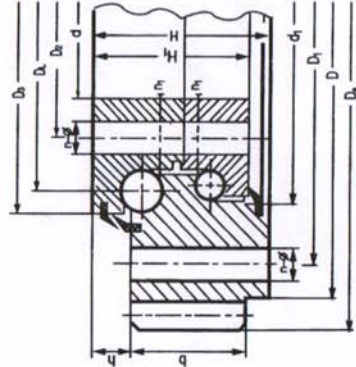
- n-φ 可改为螺纹孔，螺纹直径M，螺纹深度2M。
- 表内齿圆周力为最大圆周力，额定圆周力取其1/2。
- “K” 为消顶系数。
- 本样本中的规格为标准产品，内外径均为自由公差。若主机与回转支承有配合要求，请在合同或合同附件（如技术协议）中注明配合尺寸和精度。
- 表中所列为我公司常规产品，若有其它特殊要求，请与我公司联系。

结构尺寸Structural size						齿轮参数 Gear data				齿轮圆周力 Tangential tooth load		重量 Weight kg
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
4	523	518	96	26	60	5	126	+0.5	0.1	37	52	130
						6	105			45	62	130
4	583	578	96	26	60	5	138	+0.5	0.1	37	52	146
						6	115			45	62	147
4	653	648	96	26	60	6	129	+0.5	0.1	45	62	173
						8	96			60	83	170
4	733	728	96	26	60	6	141	+0.5	0.1	45	62	190
						8	105			60	83	187
6	829	823	114	29	80	8	120	+0.5	0.1	80	111	305
						10	96			100	140	307
6	929	923	114	29	80	8	133	+0.5	0.1	80	111	349
						10	106			100	140	348
6	1029	1023	114	29	80	10	117	+0.5	0.1	100	140	396
						12	97			120	167	391
6	1148	1143	114	29	80	10	129	+0.5	0.1	100	140	445
						12	107			120	167	439
5	1286	1282	150	39	90	12	122	+0.5	0.1	135	188	784
						14	104			158	219	774
5	1436	1432	150	39	90	12	134	+0.5	0.1	135	188	870
						14	115			158	219	878

9 双排异径球式回转支承（02系列）结构参数—外齿式

Double-row ball slewing bearings (series 02) structural parameters

机械行业标准 Machinery industry standard (JB/T2300 -2011)



021,022

承载曲线号 Load diagram No	型号 Type DL mm	外型尺寸 Configuration size			安装尺寸 Mounting size					
		De	D	d	H	D1	D2	n	Φ	M
		mm	mm	mm	mm	mm	mm	mm	mm	mm
11	021.40.1600.002	1845.2	1776	1424	160	1724	1476	45	26	24
	022.40.1600.002	1852.8								
12	021.40.1800.002	2055.2	1976	1624	160	1924	1676	45	26	24
	022.40.1800.002	2060.8								
13	021.50.2000.002	2300.8	2215	1785	190	2149	1851	48	33	30
	022.50.2000.002	2300.4								
14	021.50.2240.002	2540.8	2455	2025	190	2389	2091	48	33	30
	022.50.2240.002	2552.4								
15	021.50.2500.002	2804.4	2715	2285	190	2649	2351	56	33	30
	022.50.2500.002	2816								
16	021.50.2800.002	3110.4	3015	2585	190	2949	2651	56	33	30
	022.50.2800.002	3116								
17	021.60.3150.002	3536	3428	2872	226	3338	2962	56	45	42
	022.60.3150.002	3537.6								
18	021.60.3550.002	3936	3828	3272	226	3738	3362	56	45	42
	022.60.3550.002	3933.6								
19	021.60.4000.002	4395.6	4278	3722	226	4188	3812	60	45	42
	022.60.4000.002	4395								
20	021.60.4500.002	4879.6	4778	4222	226	4688	4312	60	45	42
	022.60.4500.002	4895								

9 双排异径球式回转支承（02系列）结构参数—外齿式

Double-row ball slewing bearings (series 02) structural parameters

notes: n is the number of lubrication holes, oil cup M*1JB/T7940.1-JB/T7940.2, users can appoint the oil hole's position according to application circumstances.

n-Φ can be replaced by threaded hole, the diameter is M, the depth is 2M.

the tooth gear's peripheral force in the firm is the maximum peripheral force, the rated peripheral force is half of it.

'k' indicates cut-top coefficient.

this sample's specification is the standard product, both the inner diameter and outside diameter are all the free to tolerance, if the main engine and the slewing bearings have matching requirement, please note the matching size and accuracy on the contract or the appendix of the contract (like technology agreement).

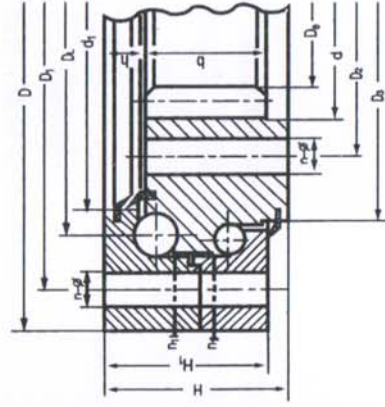
these are the standard products of our company listed in the form. if you have any other requirements, please contact us.

结构尺寸 Structural size						齿轮参数 Gear data				齿轮周力 Tangential tooth load		重量 weight kg
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
5	1636	1635	150	39	90	14	129	+0.5	0.1	158	219	995
						16	113			181	250	1003
5	1836	1835	150	39	90	14	144	+0.5	0.1	158	219	1147
						16	126			181	250	1151
8	2038	2035	178	47	120	16	141	+0.5	0.1	241	333	1794
						18	125			271	375	1780
8	2278	2275	178	47	120	16	156	+0.5	0.1	241	333	2017
						18	139			271	375	2048
8	2538	2532	178	47	120	18	153	+0.5	0.1	271	375	2246
						20	138			301	418	2280
8	2838	2832	178	47	120	18	170	+0.5	0.1	271	375	2553
						20	153			301	418	2563
8	3198	3196	214	56	150	20	174	+0.5	0.1	377	522	4428
						22	158			415	574	4414
8	3598	3596	214	56	150	20	194	+0.5	0.1	377	522	5012
						22	176			415	574	4967
10	4048	4046	214	56	150	22	197	+0.5	0.1	415	574	5706
						25	173			471	652	5656
10	4548	4546	214	56	150	22	219	+0.5	0.1	415	574	6293
						25	193			471	652	6885

9 双排异径球式回转支承(O2系列)结构参数-内齿式

Double-row ball slewing bearings (series 02) structural parameters

机械行业标准 Machinery industry standard (JB/T2300 -2011)



023,024

承载曲线号	Load diagram No	型号 Type DL mm	外型尺寸 Configuration size			安装尺寸 Mounting size					
			De mm	D mm	d mm	H mm	D1 mm	D2 mm	n mm	Φ mm	M mm
1		023.25.500.002	257	616	384	106	580	420	20	18	16
		024.25.500.002	350.4								
2		023.25.560.002	417	676	444	106	640	480	20	18	16
		024.25.560.002	410.4								
3		023.25.630.002	482.4	746	514	106	710	550	24	18	16
		024.25.630.002	475.2								
4		023.25.710.002	560.4	826	594	106	790	630	24	18	16
		024.25.710.002	555.2								
5		023.30.800.002	619.2	942	658	124	898	702	30	22	20
		024.30.800.002	614								
6		023.30.900.002	715.2	1042	758	124	998	802	30	22	20
		024.30.900.002	714								
7		023.30.1000.002	814	1142	858	124	1098	902	36	22	20
		024.30.1000.002	796.8								
8		023.30.1120.002	924	1262	978	124	1218	1022	36	22	20
		024.30.1120.002	916.8								
9		023.40.1250.002	1012.8	1426	1074	160	1374	1126	40	26	24
		024.40.1250.002	1013.6								
10		023.40.1400.002	1156.8	1576	1224	160	1524	1272	40	26	24
		024.40.1400.002	1153.6								

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9 双排异径球式回转支承(O2系列)结构参数—内齿式

Double-row ball slewing bearings (series 02) structural parameters

注: ● n为润滑油孔数。油杯M10×1JB/T7940.1-JB/T7940.2。根据应用情况用户可指定油孔位置。

- $n-\phi$ 可改为螺紋孔, 螺紋直徑 M , 螺紋深度 $2M$ 。
- 表內齒輪圓周力為最大圓周力, 額定圓周力取其 $1/2$ 。
- “ K ”為消頂系數。
- 本樣本中的規格為標準產品, 內外徑均為自由公差。若主機與回轉支承有配合要求, 請在合同或合同附件(如技術協議)中註明配合尺寸和精度。
- 表中所列為我公司常規產品, 若有其它特殊要求, 請與我公司聯繫。

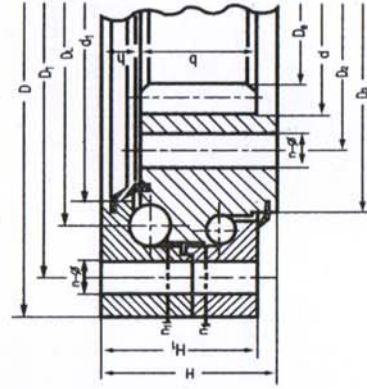
结构尺寸 Structural size						齿轮参数 Gear data				齿轮圆周力 Tangential tooth load		重量 weight kg
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
4	477	482	96	26	60	5	72	+0.5	0.2	37	52	126
						6	59					62
4	537	542	96	26	60	5	84	+0.5	0.2	37	52	143
						6	69					62
4	607	612	96	26	60	6	81	+0.5	0.2	45	62	160
						8	60					83
4	687	692	96	26	60	6	94	+0.5	0.2	45	62	183
						8	70					83
6	771	777	114	29	80	8	78	+0.5	0.2	80	111	300
						10	62					100
6	871	877	114	29	80	8	90	+0.5	0.2	80	111	337
						10	72					100
6	971	977	114	29	80	10	82	+0.5	0.2	100	140	371
						12	67					120
6	1091	1097	114	29	80	10	93	+0.5	0.2	100	140	429
						12	77					120
5	1214	1215	150	39	90	12	85	+0.5	0.2	135	188	746
						14	73					158
5	1364	1365	150	39	90	12	97	+0.5	0.2	135	188	850
						14	83					158

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9 双排异径球式回转支承(O2系列)结构参数-内齿式

Double-row ball slewing bearings (series 02) structural parameters

机械行业标准 Machinery industry standard (JB/T2300 -2011)



023.024

承载 曲线号	Load diagram No	型号 Type DL mm	外型尺寸 Configuration size			安装尺寸 Mounting size					
			De mm	D mm	d mm	H mm	D1 mm	D2 mm	n mm	Φ mm	M mm
11		023.40.1600.002	1349.6	1776	1424	160	1724	1476	45	26	24
		024.40.1600.002	1350.4								
12		023.40.1800.002	1545.6	1976	1624	160	1924	1676	45	26	24
		024.40.1800.002	1542.4								
13		023.50.2000.002	1702.4	2215	1785	190	2149	1851	48	33	30
		024.50.2000.002	1699.2								
14		023.50.2240.002	1942.4	2455	2025	190	2389	2091	48	33	30
		024.50.2240.002	1933.2								
15		023.50.2500.002	2203.2	2715	2285	190	2649	2351	56	33	30
		024.50.2500.002	2188								
16		023.50.2800.002	2491.2	3015	2585	190	2949	2651	56	33	30
		024.50.2800.002	2488								
17		023.60.3150.002	2768	3428	2872	226	3338	2962	56	45	42
		024.60.3150.002	2758.8								
18		023.60.3550.002	3168	3828	3272	226	3738	3362	56	45	42
		024.60.3550.002	3176.8								
19		023.60.4000.002	3616.8	4278	3722	226	4188	3812	60	45	42
		024.60.4000.002	3610								
20		023.60.4500.002	4122.8	4778	4222	226	4688	4312	60	45	42
		024.60.4500.002	4110								

9 双排异径球式回转支承(O2系列)结构参数—内齿式

Double-row ball slewing bearings (series 02) structural parameters

notes: n1 is the number of lubrication holes.oil cup M*JB/T7940.1-JB/7940.2. users can appoint the oil hole's position according to application circumstances.

n- Φ can be replaced by threaded hole, the diameter is M, the depth is 2M.

the tooth gear's peripheral force in the firm is the maximum peripheral force, the rated peripheral force is half of it. 'k' is indicates cut-top coefficient.

this sample's specification is the standard product, both the inner diameter and outside diameter are all the free to tolerance, if the main engine and the slewing bearings have matching requirement, please note the matching size and accuracy on the contract or the appendix of the contract (like technology agreement).

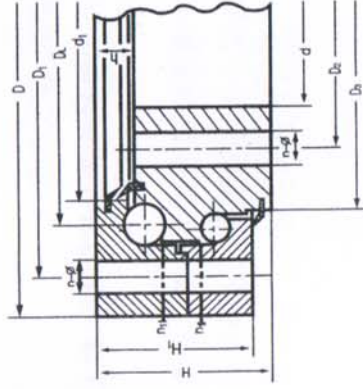
these are the standard products of ourpany listed in the form. if you have any other requirements,pease contact us.

结构尺寸 Structural size						齿轮参数 Gear data				齿轮周力 Tangential tooth load		重量 Weight kg
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
5	1564	1565	150	39	90	14	97	+0.5	0.2	158	219	979
						16	85			181	250	972
5	1764	1765	150	39	90	14	111	+0.5	0.2	158	219	1117
						16	97			181	250	1116
8	1962	1965	178	47	120	16	107	+0.5	0.2	241	333	1733
						18	95			271	375	1732
8	2202	2206	178	47	120	16	122	+0.5	0.2	241	333	1956
						18	108			271	375	1973
8	2462	2465	178	47	120	18	123	+0.5	0.2	271	375	2164
						20	110			301	418	2204
8	2762	2765	178	47	120	18	139	+0.5	0.2	271	375	2486
						20	125			301	418	2485
8	3102	3104	214	56	150	20	139	+0.5	0.2	377	522	4137
						22	126			415	574	4167
8	3502	3504	214	56	150	20	159	+0.5	0.2	377	522	4700
						22	145			415	574	4627
10	3952	3954	214	56	150	22	165	+0.5	0.2	415	574	5298
						25	145			471	652	5309
10	4452	4454	214	56	150	22	188	+0.5	0.2	415	574	5952
						25	165			471	652	6011

9 双排异径球式回转支承(02系列)结构参数—无齿式

Double-row ball slewing bearings (series 02) static load limit curve

机械行业标准 Machinery industry standard (JB/T2300 -2011)



020

承载曲线号	Load diagram No	型号 Type DL mm	外型尺寸 Tonfiguration size			安装尺寸 Mounting size						
			De mm	D mm	d mm	H mm	D1 mm	D2 mm	n mm	Φ mm	M mm	
1		020.25.500.002		616	384	106	580	420	20	18	16	
2		020.25.560.002		676	444	106	640	480	20	18	16	
3		020.25.630.002		746	514	106	710	550	24	18	16	
4		020.25.710.002		826	594	106	790	630	24	18	16	
5		020.30.800.002		942	658	124	898	702	30	22	20	
6		020.30.900.002		1042	758	124	998	802	30	22	20	
7		020.30.1000.002		1142	858	124	1098	902	36	22	20	
8		020.30.1120.002		1262	978	124	1218	1022	36	22	20	
9		020.40.1250.002		1426	1074	160	1374	1126	40	26	24	
10		020.40.1400.002		1576	1224	160	1524	1272	40	26	24	
11		020.40.1600.002		1776	1424	160	1724	1476	45	26	24	
12		020.40.1800.002		1976	1624	160	1924	1676	45	26	24	
13		020.50.2000.002		2215	1785	190	2149	1851	48	33	30	
14		020.50.2240.002		2455	2025	190	2389	2091	48	33	30	
15		020.50.2500.002		2715	2285	190	2649	2351	56	33	30	
16		020.50.2800.002		3015	2585	190	2949	2651	56	33	30	
17		020.60.3150.002		3428	2872	226	3338	2962	56	45	42	
18		020.60.3550.002		3828	3272	226	3738	3362	56	45	42	
19		020.60.4000.002		4278	3722	226	4188	3812	60	45	42	
20		020.60.4500.002		4778	4222	226	4688	4312	60	45	42	

9 双排异径球式回转支承(O2系列) 结构参数—无齿式

Double-row ball slewing bearings (series 02) static load limit curve

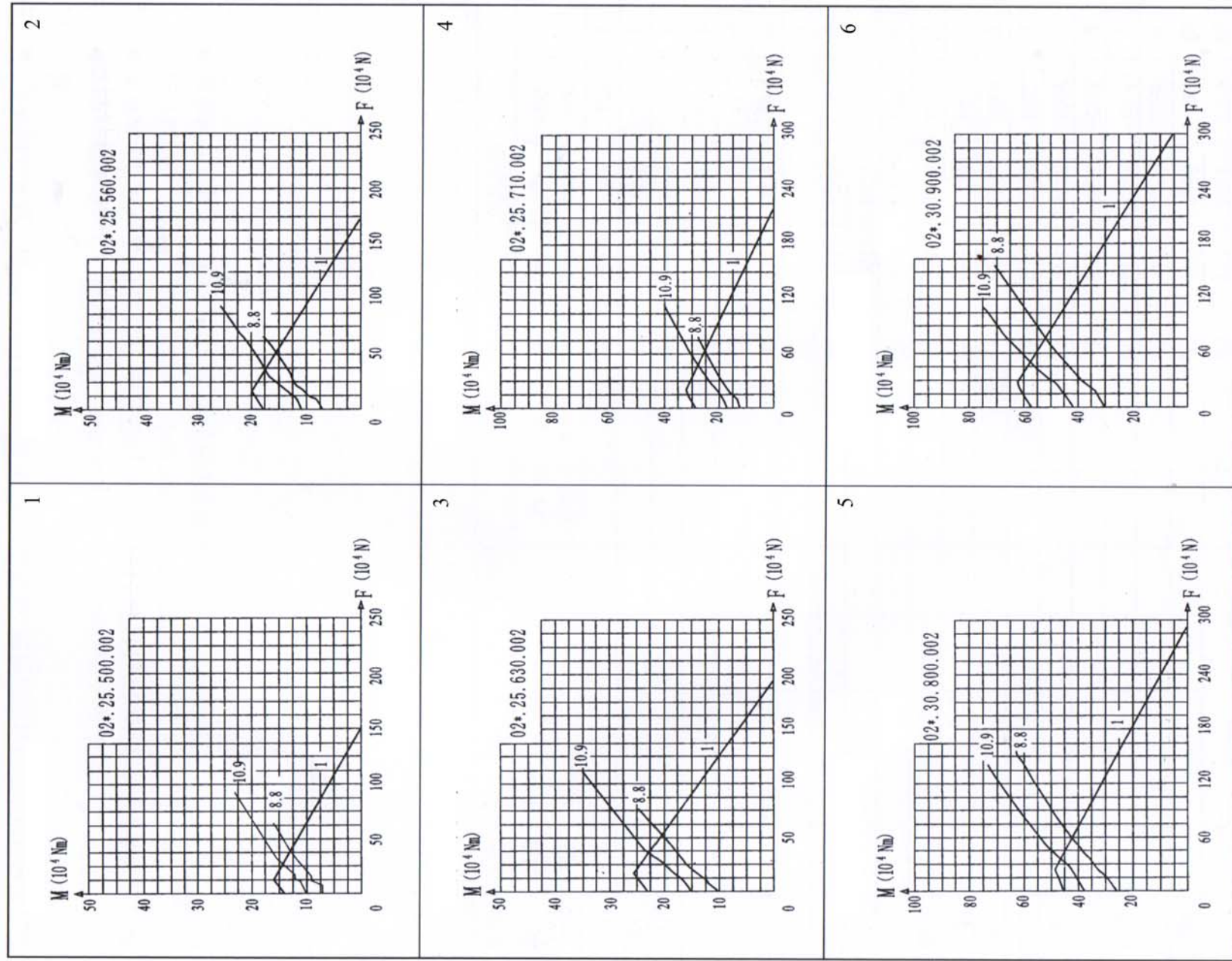
注: ● n 为润滑油孔数。油杯 $M10 \times 1JB/T7940.1-1JB/T7940.2$ 。根据应用情况用户可指定油孔位置。

- $n-\phi$ 可改为螺纹孔, 螺纹直径M, 螺纹深度2M。
- 样本本中的规格为标准产品, 内外径均为自由公差。若主机与回转支承有配合要求, 请在合同或合同附件(如技术协议)中注明配合尺寸和精度。
- 表中所列为我公司常规产品, 若有其它特殊要求, 请与我公司联系。

结构尺寸Structural size					齿轮参数 Gear data				齿轮周力 Tangential tooth load		重量 Weight kg
n1	D3 mm	d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN
4	477	482	96	26							121
4	537	543	96	26							136
4	607	613	96	26							152
4	687	692	96	26							172
6	771	777	114	29							284
6	871	877	114	29							316
6	971	977	114	29							349
6	1091	1097	114	29							394
5	1214	1215	150	39							709
5	1364	1365	150	39							787
5	1564	1565	150	39							899
5	1764	1765	150	39							1018
8	1962	1965	178	47							1586
8	2202	2206	178	47							1789
8	2462	2465	178	47							1990
8	2762	2765	178	47							2243
8	3102	3104	214	56							3762
8	3502	3504	214	56							4272
10	3952	3954	214	56							4828
10	4452	4454	214	56							5465

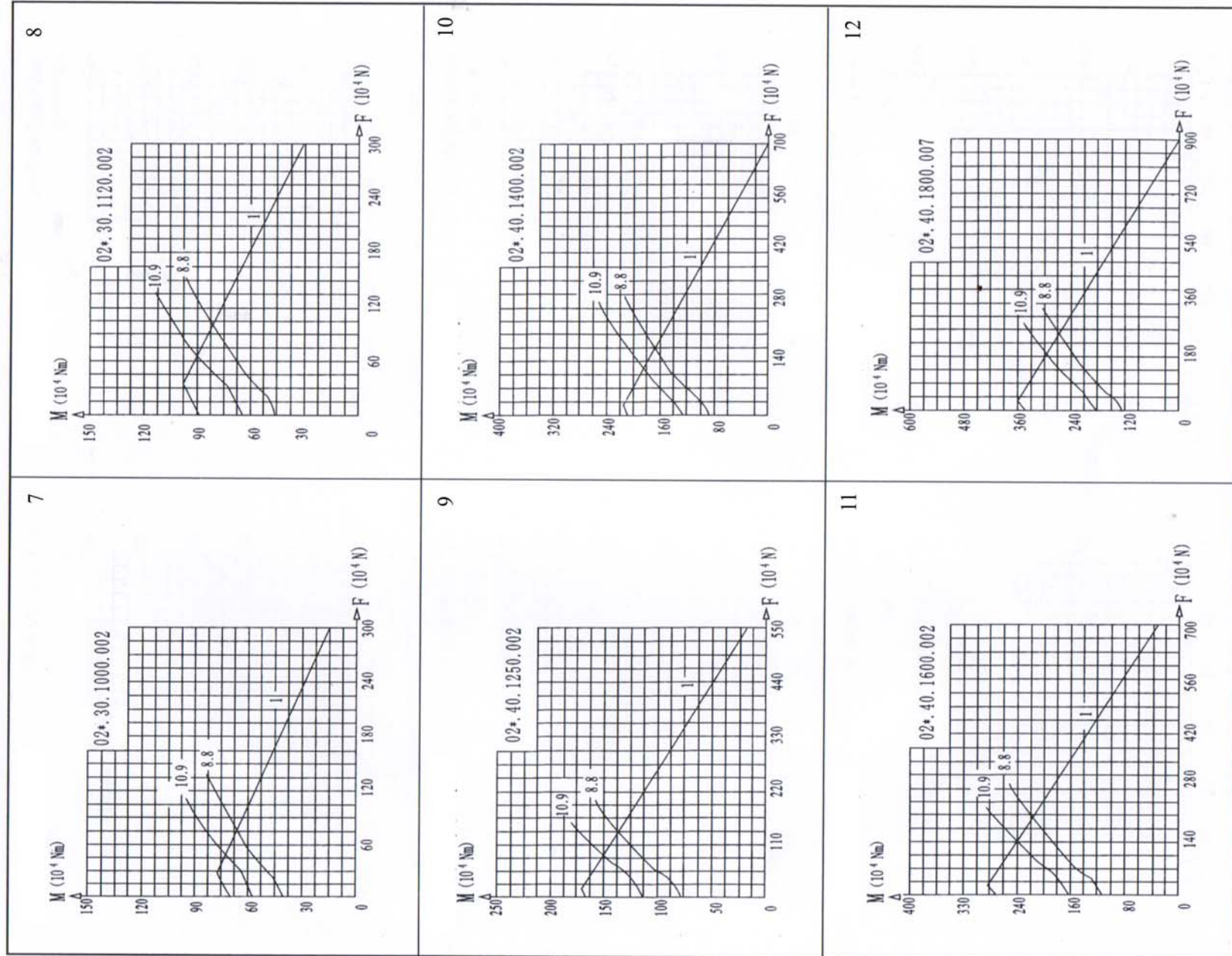
9双排异径球式回转支承 (02系列) 承载曲线

Double-row ball slewing bearings (series 02) static load limit curve



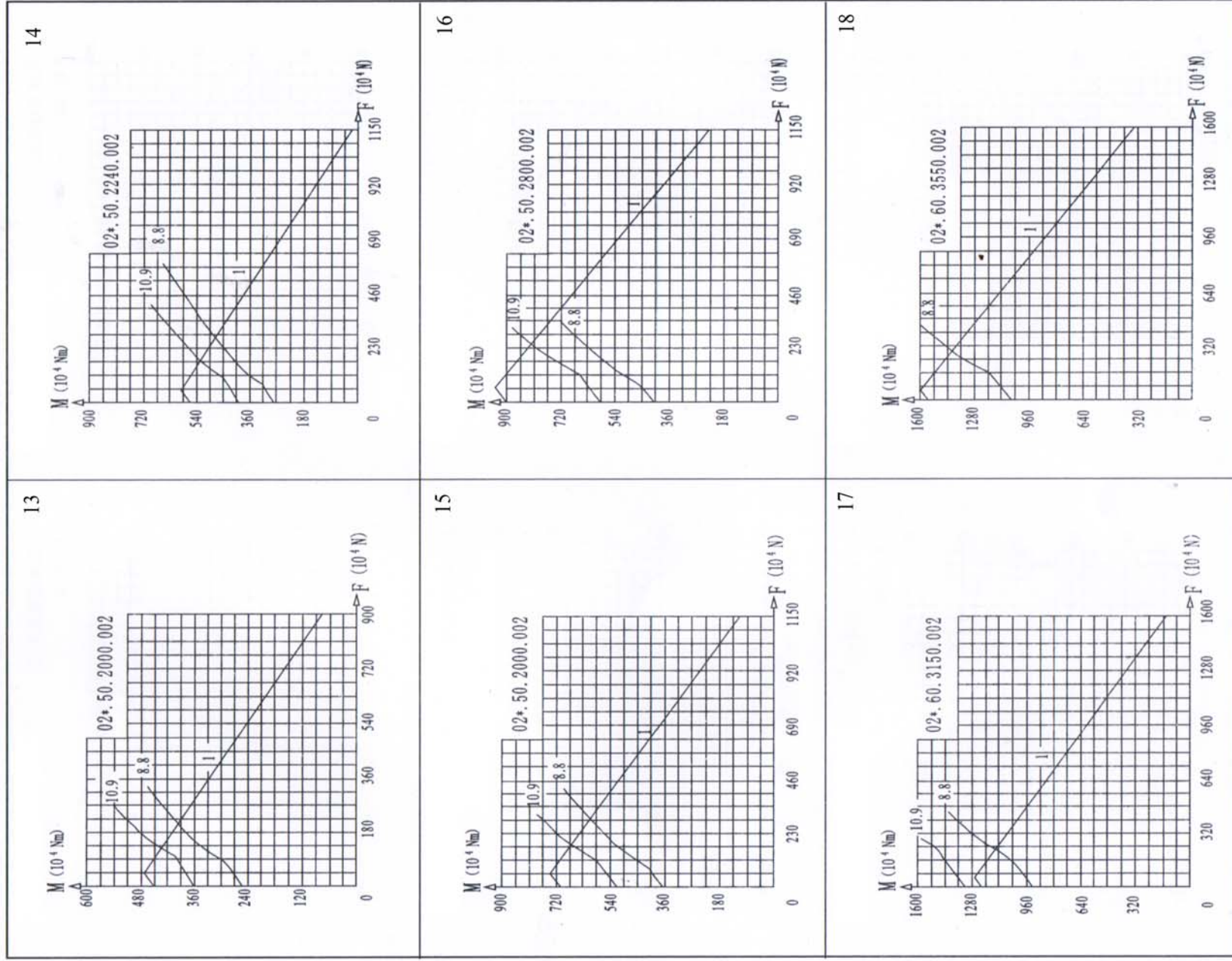
9双排异径球式回转支承 (02系列) 承载曲线

Double-row ball slewing bearings (series 02) static load limit curve



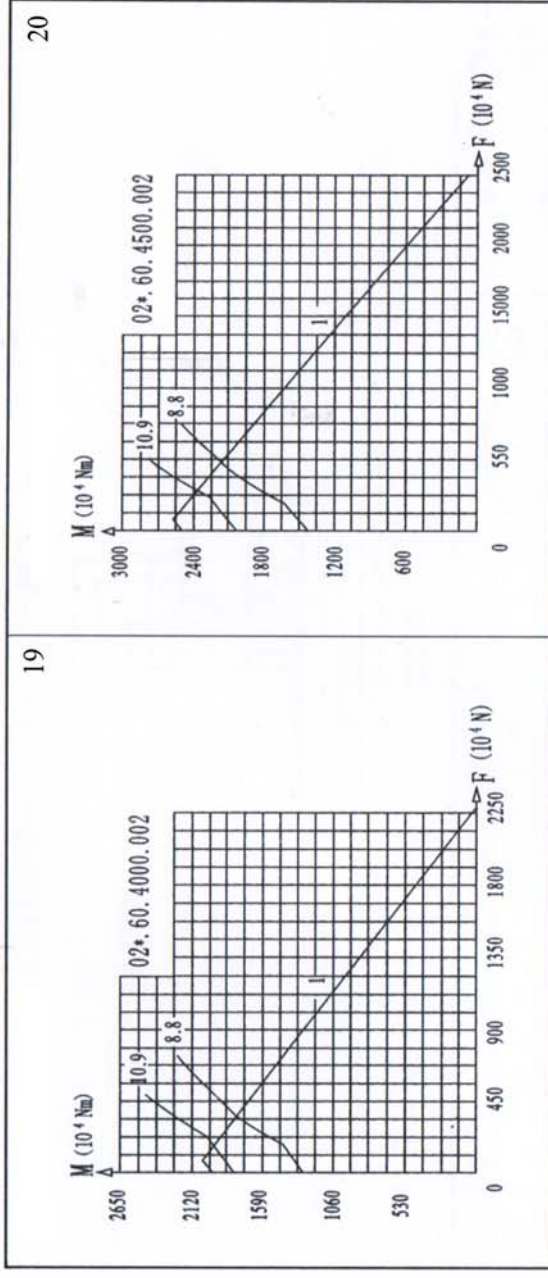
9双排异径球式回转支承 (O2系列) 承载曲线

Double-row ball slewing bearings (series O2) static load limit curve



9双排异径球式回转支承 (O2系列) 承载曲线

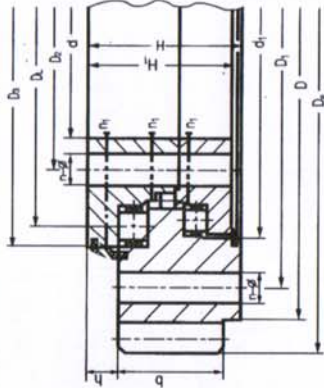
Double-row ball slewing bearings (series O2) static load limit curve



10三排滚柱式回转支承(13系列)结构参数—外齿式

Triple-row roller slewing bearings(series 13) structural parameters

机械行业标准 Machinery industry standard (JB/T2300 -2011)



131,132

承载曲线号 Load diagram No	型号 Type	外型尺寸 Configuration size		安装尺寸Mounting size				结构尺寸	
		De mm	D mm	d mm	H mm	D ₁ mm	D ₂ mm	n mm	Φ mm
1	131.25.500.002	664	634	366	148	598	402	24	18
	132.25.500.002	664.8							
2	131.25.560.002	724	694	426	148	658	462	24	18
	132.25.560.002	724.8							
3	131.25.630.002	808.8	764	496	148	728	532	28	18
	132.25.630.002	806.4							
4	131.25.710.002	886.8	844	567	148	808	612	28	18
	132.25.710.002	886.4							
5	131.32.800.002	1006.4	964	636	182	920	680	36	22
	132.32.800.002	1008							
6	131.32.900.002	1102.4	1064	736	182	1020	780	36	22
	132.32.900.002	1108							
7	131.32.1000.002	1218	1164	836	182	1120	880	40	22
	132.32.1000.002	1221.6							
8	131.32.1120.002	1338	1284	956	182	1240	1000	40	22
	132.32.1120.002	1341.6							
9	131.40.1250.002	1509.6	1445	1055	220	1393	1107	45	26
	132.40.1250.002	1509.2							
10	131.40.1400.002	1665.6	1595	1205	220	1543	1257	45	26
	132.40.1400.002	1663.2							
11	131.40.1600.002	1873.2	1795	1405	220	1743	1457	48	26
	132.40.1600.002	1868.8							
12	131.40.1800.002	2069.2	1995	1605	220	1943	1657	48	26
	132.40.1800.002	2076.8							
13	131.20.2000.402	2236.8		1853	132	2105	1905	54	26
	131.25.2000.402	2268.8		1819	147	2125	1885	44	33
15	131.45.2000.002	2300.8	2221	1779	231	2155	1845	60	33
	132.45.2000.002	2300.4							
16	131.25.2240.402	2516.4		2059	147	2366	2125	48	33
	131.32.2240.402	2552.4		2022	181	2395	2100	40	39
18	131.45.2240.002	2556.8	2461	2019	231	2395	2085	60	33
	132.45.2240.002	2552.4							

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10三排滚柱式回转支承(13系列)结构参数—外齿式

Triple-row roller slewing bearings(13 series) structural parameters

注：● n为润滑油孔数。油杯M10×1JB/T7940.1-1JB/T7940.2。根据应用情况用户可指定油孔位置。

- n-φ可改为螺纹孔，螺纹直径M，螺纹深度2M。
- 表内齿圆周力为最大圆周力，额定圆周力取其1/2。
- “K”为消顶系数。
- 本样本中的规格为标准产品，内外径均为自由公差。若主机与回转支承有配合要求，请在合同或合同附件（如技术协议）中注明配合尺寸和精度。
- 表中所列为我公司常规产品，若有其它特殊要求，请与我公司联系。

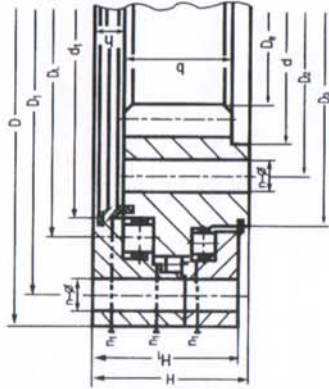
Structural size			齿轮参数 Gear data					齿圆周力 Tangential tooth load		重量 Weight
d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	kg
526	138	32	80	5	130	+0.5	0.1	50	67	200
				6	108			60	80	200
586	138	32	80	5	142	+0.5	0.1	50	67	224
				6	118			60	80	224
656	138	32	80	6	132	+0.5	0.1	60	80	262
				8	98			80	110	257
736	138	32	80	6	145	+0.5	0.1	60	80	310
				8	108			80	110	306
830	172	40	120	8	123	+0.5	0.1	121	167	490
				10	98			151	209	487
930	172	40	120	8	135	+0.5	0.1	121	167	549
				10	108			151	209	562
1030	172	40	120	10	119	+0.5	0.1	151	209	631
				12	99			181	251	631
1150	172	40	120	10	131	+0.5	0.1	151	209	710
				12	109			181	251	710
1290	210	50	150	12	123	+0.5	0.1	229	314	1137
				14	105			263	366	1126
1440	210	50	150	12	136	+0.5	0.1	229	314	1299
				14	116			263	366	1281
1637	210	50	150	14	131	+0.5	0.1	263	366	1501
				16	114			302	417	1471
1837	210	50	150	14	145	+0.5	0.1	263	366	1682
				16	127			302	417	1697
2032	123	26	106	16	137	+0.5	0.1		311	912
2026	138	30	117	16	139	+0.5	0.1		326	1216
2033	219	54	160	16	141	+0.5	0.1	322	445	2147
				18	125			362	501	2129
2266	138	30	117	18	137	+0.5	0.1		366	1378
2270	172	42	139	18	139	+0.5	0.1		435	1975
2273	219	54	160	16	157	+0.5	0.1	322	445	2501
				18	139			362	501	2461

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10三排滚柱式回转支承(13系列)结构参数—内齿式

Triple-row roller slewing bearings (series 13) structural parameters

机械行业标准 Machinery industry standard (JB/72300 -2011)



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承载曲线号 Load diagram No	型号 Type DL mm	外型尺寸 Configuration size			安装尺寸 Mounting size				结构尺寸			
		De mm	D mm	d mm	H mm	D1 mm	D2 mm	n mm	Φ mm	M mm	n1	D3 mm
19	133.25.2500.402	2214	2618		147	2615	2375	54	33	30	6	2474
20	133.32.2500.402	2178	2718		181	2640	2345	44	39	36	7	2470
21	133.45.2500.002	2185.2	2721	2279	231	2655	2345	72	33	30	8	2467
	134.45.2500.002	2188										
22	133.25.2800.402	2500	2981		147	2915	2675	60	33	30	10	2774
23	133.32.2800.402	2460	3018		181	2940	2645	48	39	36	8	2770
24	133.40.2800.402	2460	3038		220	2960	2635	48	39	36	88	2763
25	133.45.2800.002	2491.2	3021	2579	231	2955	2645	72	33	30	8	2767
	134.45.2800.002	2488										
26	133.32.3150.402	2820	3368		181	3290	2995	56	39	36	7	3120
27	134.40.3150.402	2794	3388		220	3310	2985	56	39	36	7	3113
28	133.50.3150.002	2768	3432	2868	270	3342	2958	72	45	42	8	3104
	133.50.3150.002	2758.8										
29	133.32.3550.402	3190	3768		181	3690	3395	66	39	36	8	3520
30	134.40.3550.402	3190	3788		220	3710	3385	66	39	36	8	3513
31	133.50.3550.002	3168	3832	3268	270	3742	3358	72	45	42	8	3504
	134.50.3550.002	3154.8										
32	133.32.4000.402	3652	4218		181	4140	3845	72	39	36	9	3970
33	133.40.4000.402	3624	4238		220	4160	3835	72	39	36	9	3963
34	133.50.4000.002	3616.8	4282	3718	270	4192	3808	80	45	42	8	3954
	134.50.4000.002	3610										
35	133.40.4500.402	4128	4738		220	4660	4335	84	39	36	14	4463
36	133.50.4500.002	4122.8	4782	4218	270	4692	4308	80	45	42	8	4454
	134.50.4500.002	4110										

10三排滚柱式回转支承(13系列)结构参数—外齿式

Triple-row roller slewing bearings (series 13) structural parameters

notes: n1 is the number of lubrication holes,oil cup M*1JB/T7940.1-JB/7940.2,users can appoint the oil hole's position according to application circumstances.

n-Φ can be replaced by threaded hole,the diameter is M,the depth is 2M.

the tooth gear's peripheral force in the frm is the maximum peripheral force,the rated peripheral force is halr of it.

'k' indicates cut-top coefficient.

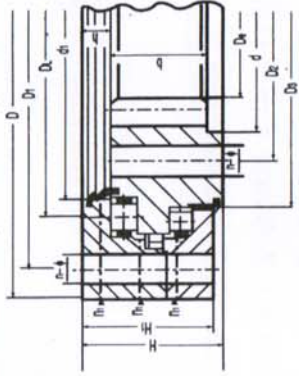
this sample's specification is the standard product,both the inner diameter and outside diameter are all the free to tolerance,if the main engine and the slewing bearings have matching requirement,please note the matching size and accuracy on the contract or the appendix of the contract(like technology agreement).

these are the standard products of ourpany listed in the form. if you have any other requirements,pease contact us.

Structural size			齿轮参数 Gear data					齿轮圆周力 Tangential tooth load		重量 weight kg
d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN	
2526	138	30	117	18	152	+0.5	0.1		366	1567
2530	172	42	139	18	154	+0.5	0.1		435	2260
2533	219	54	160	18	154	+0.5	0.1	362	501	2786
				20	138			402	556	2731
2826	138	30	117	20	152	+0.5	0.1		407	1785
2830	172	42	139	20	154	+0.5	0.1		483	2576
2837	210	50	170	20	154	+0.5	0.1		591	3267
				18	170			362	501	3067
2833	219	54	160	20	153	+0.5	0.1	402	556	3079
3180	172	42	139	20	171	+0.5	0.1		483	2828
3187	210	50	170	22	157	+0.5	0.1		650	3812
3196	258	65	180	20	174	+0.5	0.1	452	626	5025
				22	158			498	689	5009
3580	172	42	139	22	174	+0.5	0.1		532	3249
3587	210	50	170	22	175	+0.5	0.1		650	4255
3596	258	65	180	20	194	+0.5	0.1	452	626	5713
				22	176			498	689	5661
4030	172	42	139	22	195	+0.5	0.1		531	3752
4037	210	50	170	24	179	+0.5	0.1		710	4805
4046	258	65	180	22	197	+0.5	0.1	498	689	6508
				25	173			565	783	6449
4537	210	50	170	24	200	+0.5	0.1		710	5410
4546	258	65	180	22	220	+0.5	0.1	498	689	7438
				25	193			565	783	7308

10三排滚柱式回转支承(I3系列)结构参数-内齿式
Triple-row roller slewing bearings (series 13) structural parameters

机械行业标准 Machinery industry standard (JB/T2300 -2011)



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Table with 10 columns: Load diagram No, Type, D, De, d, H, D1, D2, n, Φ, M, n1, D3. It lists 18 different bearing models and their corresponding dimensions.

10三排滚柱式回转支承(I3系列)结构参数-内齿式
Triple-row roller slewing bearings (series 13) structural parameters

注: ● n1为润滑油孔数。油杯M10×1JB/T7940.1-JB/T7940.2。根据应用情况用户可指定油孔位置。

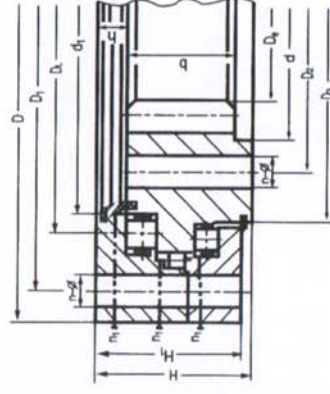
- n-φ 可改为螺纹孔, 螺纹直径M, 螺纹深度2M。
- 表内齿圆周力为最大圆周力, 额定圆周力取其1/2。
- “K” 为消顶系数。
- 本样本中的规格为标准产品, 内外径均为自由公差。若主机与回转支承有配合要求, 请在合同或合同附件(如技术协议)中注明配合尺寸和精度。
- 表中所列为我公司常规产品, 若有其它特殊要求, 请与我公司联系。

Table with 10 columns: Structural size (d1, H1, h, b, m, z, x, k), Gear parameters (m, z, x, k), Tangential tooth load (正火, 调质), and Weight (重量). It lists 18 different bearing models and their corresponding parameters.

10三排滾柱式回轉支承(D3系列)結構參數-內齒式

Triple-row roller slewing bearings (series 13) structural parameters

机械行业标准 Machinery industry standard (JB/T2300 -2011)



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承载曲线号	Load diagram No	型号 Type DL mm	外型尺寸 Configuration size				安装尺寸 Mounting size						结构尺寸	
			De mm	D mm	d mm	H mm	D ₁ mm	D ₂ mm	n mm	Φ mm	M mm	n ₁	D ₃ mm	
19		133.25.2500.402	2214	2618		147	2615	2375	54	33	30	6	2474	
20		133.32.2500.402	2178	2718		181	2640	2345	44	39	36	7	2470	
21		133.45.2500.002	2185.2	2721	2279	231	2655	2345	72	33	30	8	2467	
		134.45.2500.002	2188											
22		133.25.2800.402	2500	2981		147	2915	2675	60	33	30	10	2774	
23		133.32.2800.402	2460	3018		181	2940	2645	48	39	36	8	2770	
24		133.40.2800.402	2460	3038		220	2960	2635	48	39	36	88	2763	
25		133.45.2800.002	2491.2	3021	2579	231	2955	2645	72	33	30	8	2767	
		134.45.2800.002	2488											
26		133.32.3150.402	2820	3368		181	3290	2995	56	39	36	7	3120	
27		134.40.3150.402	2794	3388		220	3310	2985	56	39	36	7	3113	
28		133.50.3150.002	2768	3432	2868	270	3342	2958	72	45	42	8	3104	
		133.50.3150.002	2758.8											
29		133.32.3550.402	3190	3768		181	3690	3395	66	39	36	8	3520	
30		134.40.3550.402	3190	3788		220	3710	3385	66	39	36	8	3513	
31		133.50.3550.002	3168	3832	3268	270	3742	3358	72	45	42	8	3504	
		134.50.3550.002	3154.8											
32		133.32.4000.402	3652	4218		181	4140	3845	72	39	36	9	3970	
33		133.40.4000.402	3624	4238		220	4160	3835	72	39	36	9	3963	
34		133.50.4000.002	3616.8	4282	3718	270	4192	3808	80	45	42	8	3954	
		134.50.4000.002	3610											
35		133.40.4500.402	4128	4738		220	4660	4335	84	39	36	14	4463	
36		133.50.4500.002	4122.8	4782	4218	270	4692	4308	80	45	42	8	4454	
		134.50.4500.002	4110											

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10三排滾柱式回轉支承(D3系列)結構參數-內齒式

Triple-row roller slewing bearings (series 13) structural parameters

notes: n is the number of lubrication holes.oil cup M*1JB/T7940.1-JB/T7940.2. users can appoint the oil hole's position according to application circumstances.

n - Φ can be replaced by threaded hole, the diameter is M , the depth is $2M$.

the tooth gear's peripheral force in the firm is the maximum peripheral force, the rated peripheral force is half of it.

'k' is indicates cut-top coefficient.

this sample's specification is the standard product, both the inner diameter and outside diameter are all the free to tolerance, if the main engine and the slewing bearings have matching requirement, please note the matching size and accuracy on the contract or the appendix of the contract (like technology agreement).

these are the standard products of ourpany listed in the form. if you have any other requirements,please contact us.

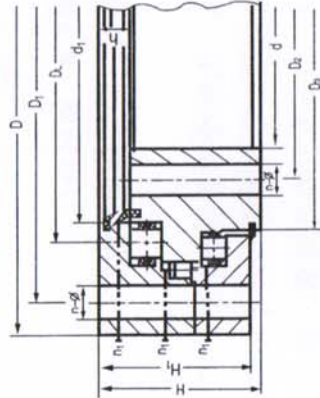
Structural size			齿轮参数 Ggear data						齿轮圆周力 Tangential tooth load		重量 Weight kg
d1 mm	H1 mm	h mm	b mm	m mm	z	x	k	正火 KN	调质 KN		
2463	138	30	117	18	124	+0.5	0		366	1545	
2459	172	42	139	18	122	+0.5	0		435	2210	
2445	219	54	160	18	122	+0.5	0.2	362	501	2862	
				20	110	402		556	2834		
2763	138	30	117	20	126	+0.5	0		407	1767	
2759	172	42	139	20	124	+0.5	0		483	2542	
2750	210	50	170	20	124	+0.5	0		591	3213	
2745	219	54	160	18	139	+0.5	0.2	362	501	3211	
				20	125	402		556	3209		
3109	172	42	139	20	142	+0.5	0		483	2807	
3100	210	50	170	22	128	+0.5	0		650	3683	
3090	258	65	180	20	139	+0.5	0.2	452	626	4954	
				22	126	498		689	4988		
3509	172	42	139	22	146	+0.5	0		532	3302	
3500	210	50	170	22	146	+0.5	0		650	4171	
3940	258	65	180	20	159	+0.5	0.2	452	626	5638	
				22	144	498		689	5706		
3959	172	42	139	22	167	+0.5	0		532	3664	
3950	210	50	170	24	152	+0.5	0		710	4810	
3940	258	65	180	22	165	+0.5	0.2	498	689	6257	
				25	145	565		783	6268		
4450	210	50	170	24	173	+0.5	0		710	5367	
4440	258	65	180	22	188	+0.5	0.2	498	689	7040	
				25	165	565		783	7108		

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10三排滚柱式回转支承(Q3系列)结构参数-无齿式

Triple-row roller slewing bearings (series 13) structural parameters

机械行业标准 Machinery industry standard (JB/T2300 -2011)



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承载曲线号 Load diagram No	型号 Type UL mm	外型尺寸 Configuration size				安装尺寸 Mounting size					
		De mm	D mm	d mm	H mm	D1 mm	D2 mm	n mm	Φ mm	M mm	
1	130.25.500.002		634	366	148	598	402	24	18	16	
2	130.25.560.002		694	426	148	658	462	24	18	16	
3	130.25.630.002		764	496	148	728	532	28	18	16	
4	130.25.710.002		844	576	148	808	612	28	18	16	
5	130.32.800.002		964	636	182	920	680	36	22	20	
6	130.32.900.002		1064	736	182	1020	780	36	22	20	
7	130.32.1000.002		1164	836	182	1120	880	40	22	20	
8	130.32.1120.002		1284	956	182	1240	1000	40	22	20	
9	130.40.1250.002		1445	1055	220	1393	1107	45	26	24	
10	130.40.1400.002		1595	1205	220	1543	1257	45	26	24	
11	130.40.1600.002		1795	1405	220	1743	1457	48	26	24	
12	130.40.1800.002		1995	1605	220	1943	1657	48	26	24	
15	130.45.2000.002		2221	1779	231	2155	1845	60	33	30	
18	130.45.2240.002		2461	2019	231	2395	2085	60	33	30	
21	130.45.2500.002		2721	2279	231	2655	2345	72	33	30	
25	130.45.2800.002		3021	2579	231	2955	2645	72	33	30	
28	130.50.3150.002		3432	2868	270	3342	2958	72	45	42	
31	130.50.3550.002		3832	3268	270	3742	3358	72	45	42	
34	130.50.4000.002		4282	3718	270	4192	3808	80	45	42	
36	130.50.4500.002		4782	4218	270	4692	4308	80	45	42	

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10三排滚柱式回转支承(Q3系列)结构参数-无齿式

Triple-row roller slewing bearings (series 13) structural parameters

注：● n为润滑油孔数。油杯M10×1JB/T7940.1-JB/T7940.2。根据应用情况用户可指定油孔位置。

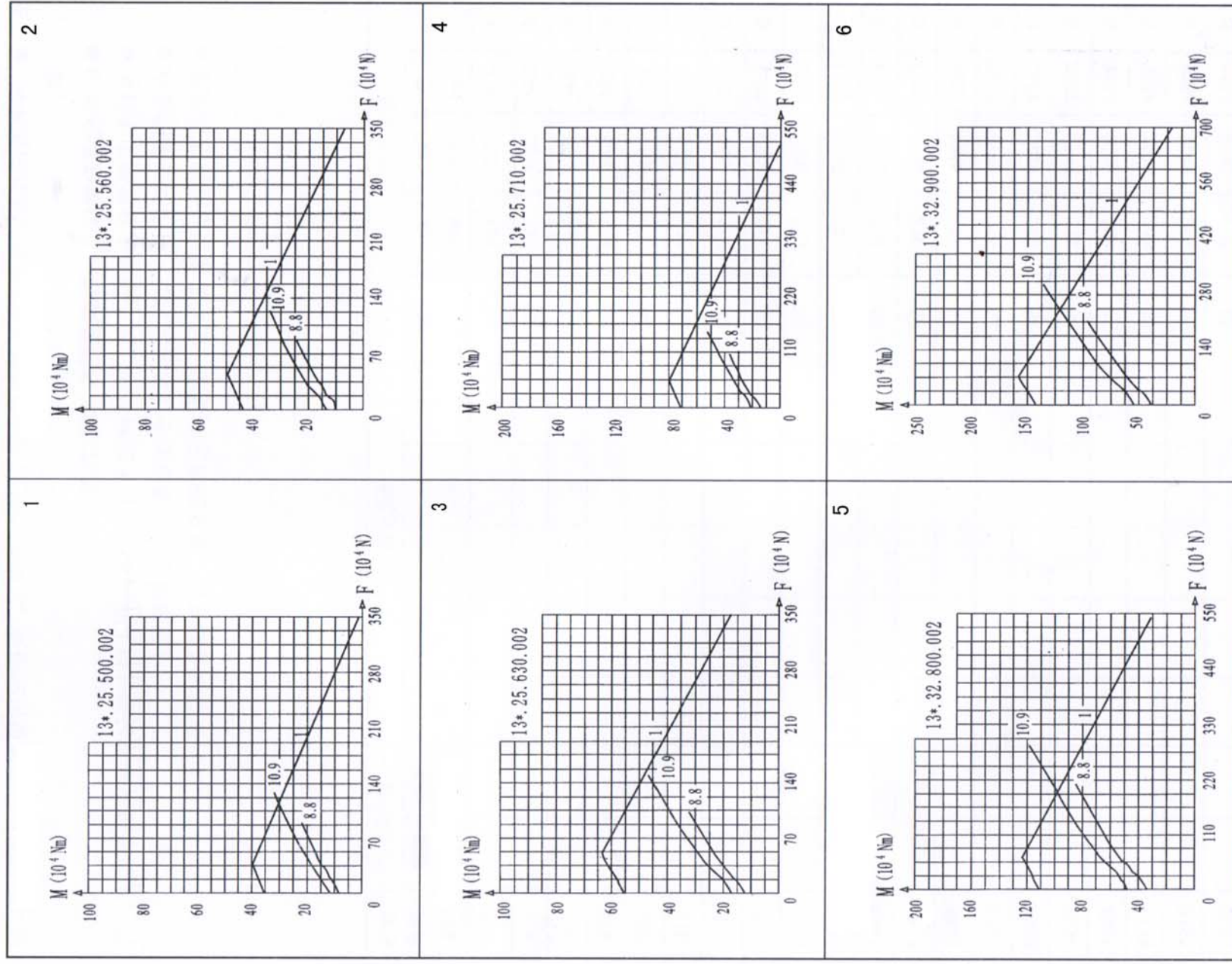
- n-φ 可改为螺纹孔，螺纹直径M，螺纹深度2M。
- 本样本中的规格为标准产品，内外径均为自由公差。若主机与回转支承有配合要求，请在合同或合同附件（如技术协议）中注明配合尺寸和精度。
- 表中所列为我公司常规产品，若有其它特殊要求，请与我公司联系。

Structural												重量 weight kg
n1	D3 mm	d1 mm	H1 mm	h mm								
4	474	463	138	32								191
4	534	523	138	32								214
4	604	593	138	32								240
4	684	673	138	32								272
4	770	759	172	40								459
4	870	859	172	40								519
5	970	959	172	40								577
5	1090	1079	172	40								650
5	1213	1200	210	50								1038
5	1363	1350	210	50								1170
6	1563	1550	210	50								1341
6	1763	1750	210	50								1518
6	1967	1945	219	54								1949
6	2207	2185	219	54								2197
8	2467	2445	219	54								2590
8	2767	2745	219	54								2932
8	3104	3090	258	65								4551
8	3504	3490	258	65								5178
8	3954	3940	258	65								5751
8	4454	4440	258	65								6521

74

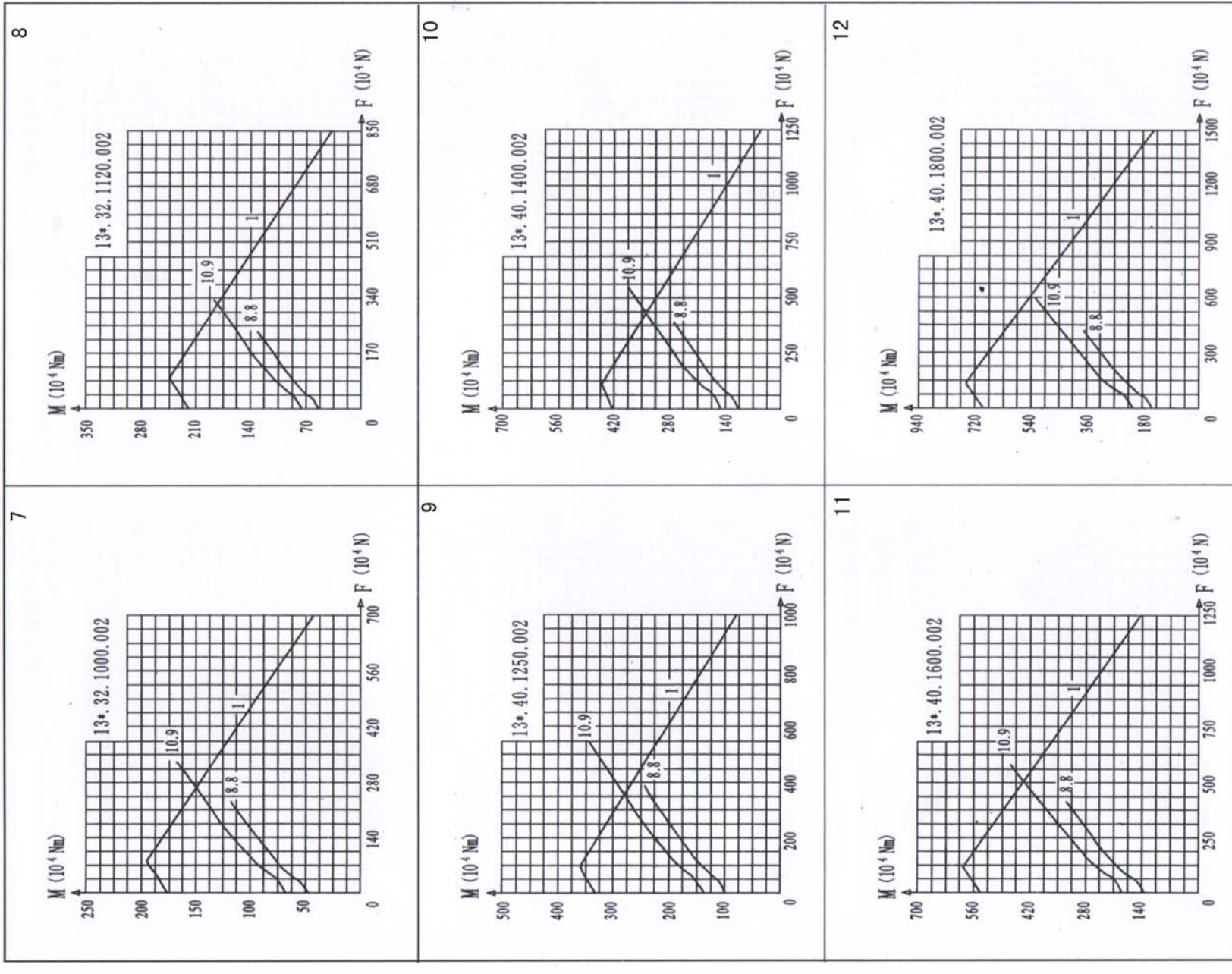
10三排滚柱式回转支承(13系列)承载曲线

Triple-row roller slewing bearings (series 13) static load limit curve



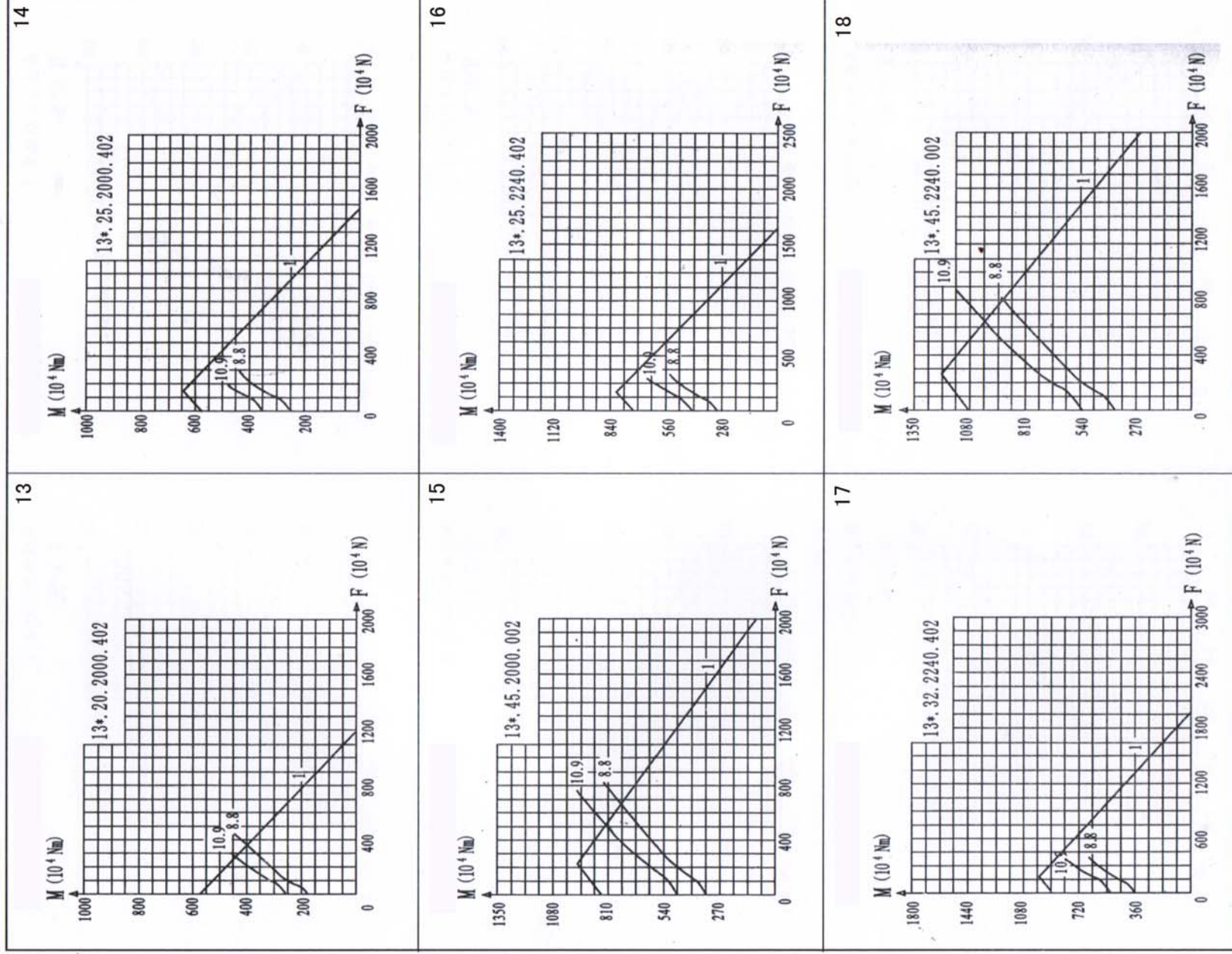
10三排滚柱式回转支承(13系列)承载曲线

Triple-row roller slewing bearings (series 13) static load limit curve



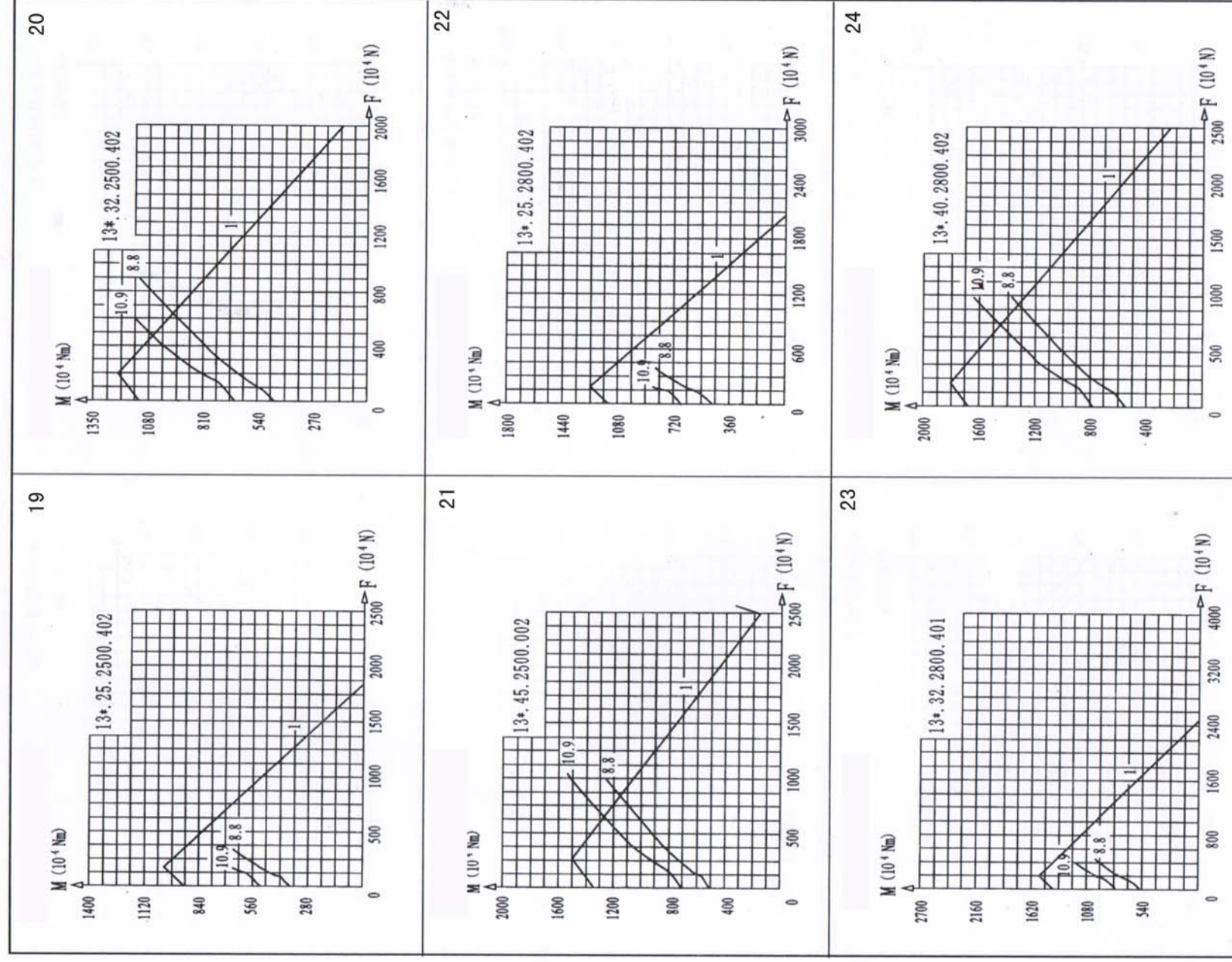
10三排滚柱式回转支承(13系列)承载曲线

Triple-row roller slewing bearings (series 13) static load limit curve



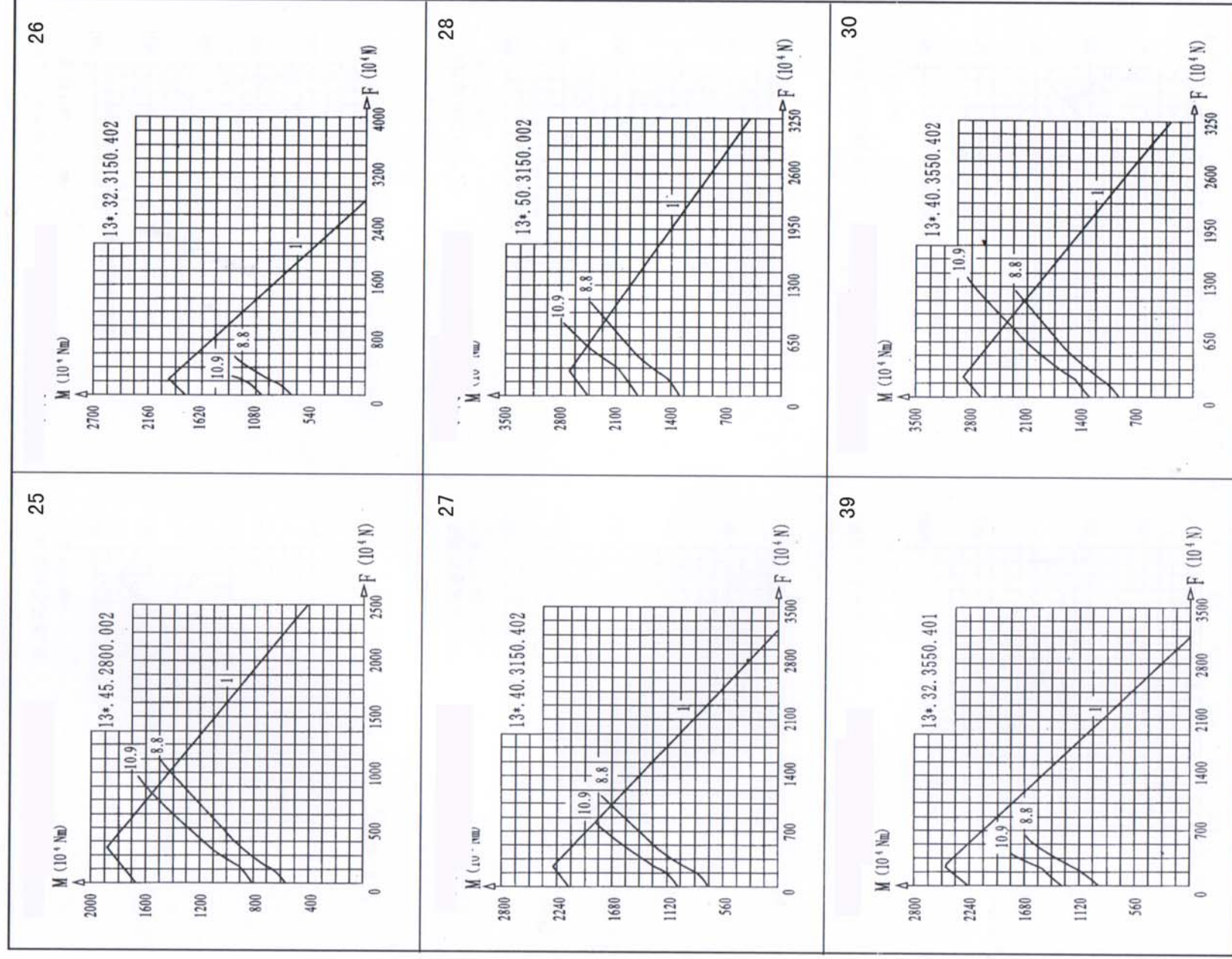
10三排滚柱式回转支承(13系列)承载曲线

Triple-row roller slewing bearings (series 13) static load limit curve



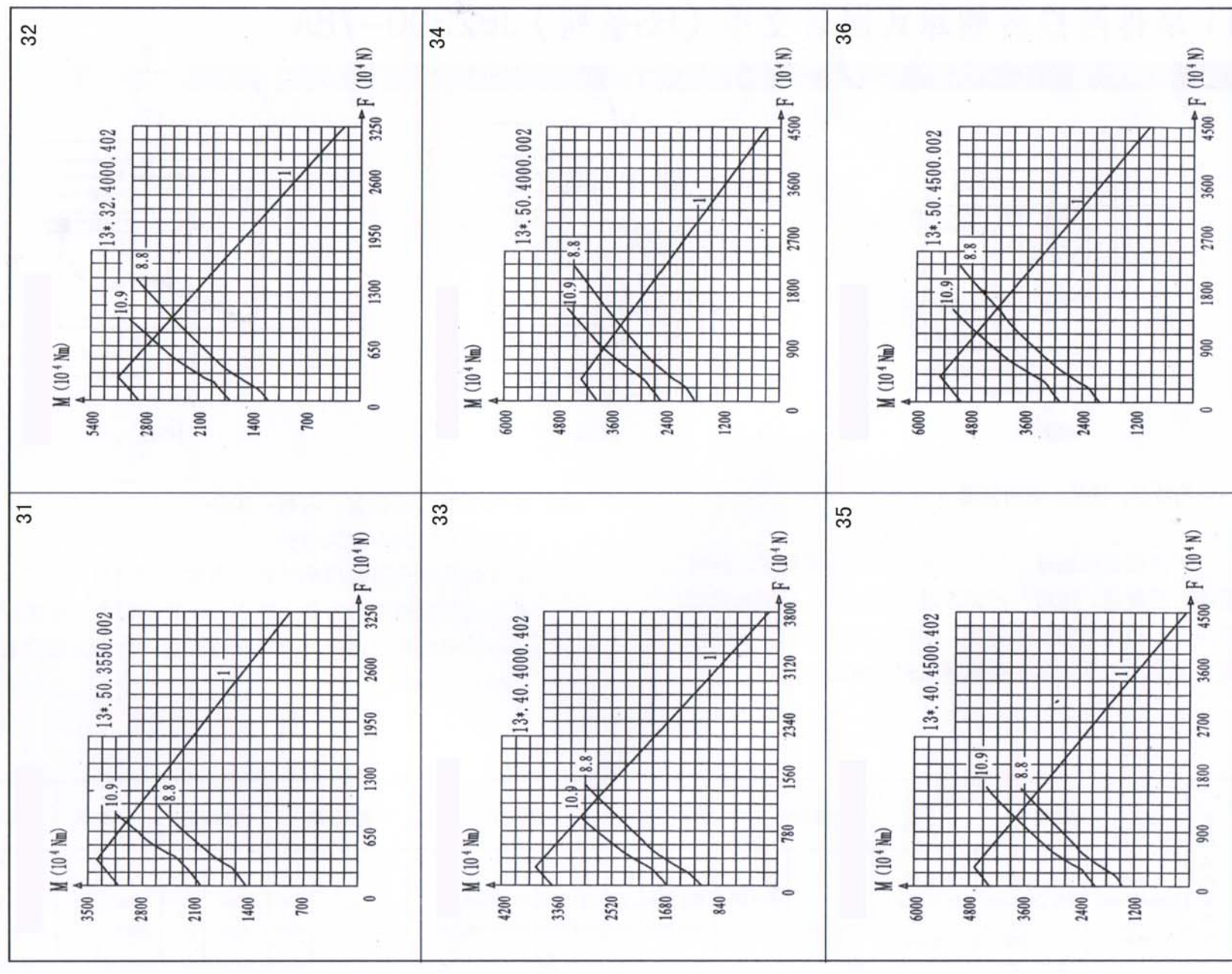
10三排滚柱式回转支承(I3系列)承载曲线

Triple-row roller slewing bearings (series I3) static load limit curve

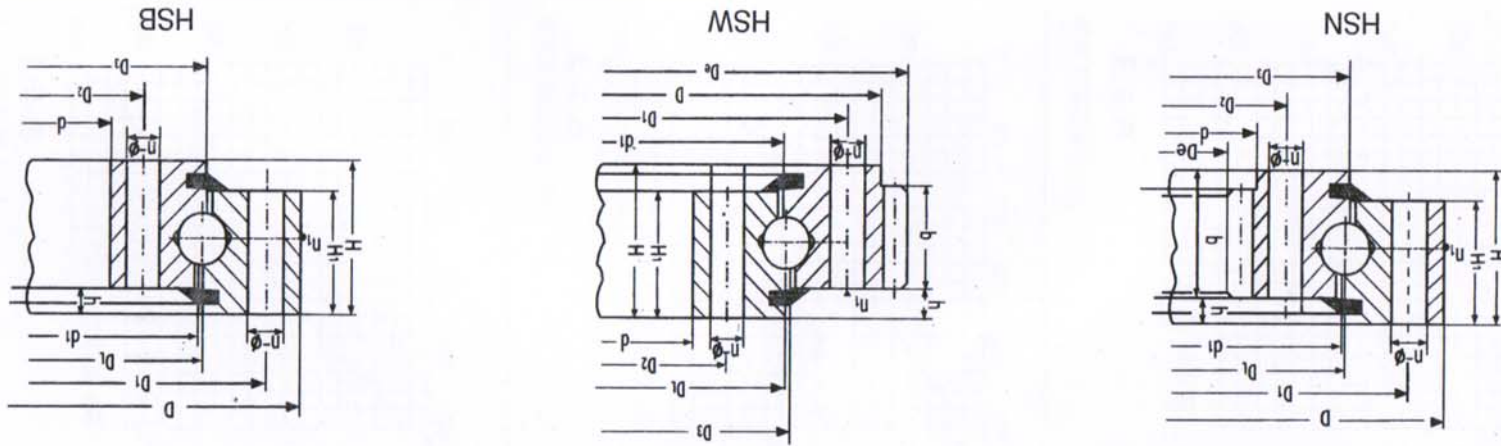


10三排滚柱式回转支承(I3系列)承载曲线

Triple-row roller slewing bearings (series I3) static load limit curve



11 单排四点接触球式回转支承 (HS系列) JB2300-78A
Single-row four-point contact ball slewing bearings (series HS)



注: ● n1为润滑油孔数, 均布;

● M10X1GB1152-1153-79;

● 安装孔n-φ可改用螺纹孔.

● 表内齿轮圆周长为最大圆周长, 额定圆周长取其1/2;

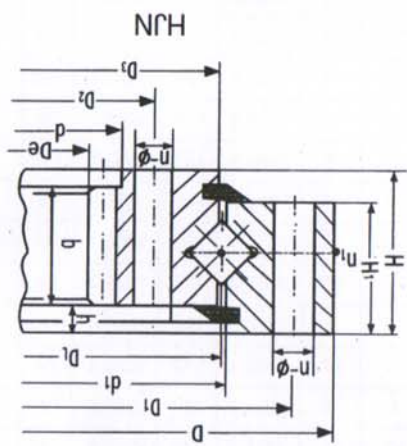
● 表内变位系数均为外齿轮变位系数, 内齿轮变位系数

均为+0.35。

notes: n1-number lubricating holes evenly distributed;
Lubricating nipple M10*1, GB1152~1153-1979;
Mounting hole n-φ can be replaced by threaded hole;
Gear force of periphery given in the table is its maximum value,
nominal force of periphery is taken 1/2 of the given value.
The spaceshift coefficient given in the table is the data of outer
tooth, inner tooth is +0.35.

承载 曲线 图 号 on load diagram	基本型号		Configuration size	安装尺寸		结构尺寸				Gear data		Ext gear		Int gear		tooth load	weight 重量							
	无齿式 DL (Toothless)	外齿式 DL (Ext Toothing)		内齿式 DL (Int Toothing)	D mm	d mm	H mm	D1 mm	D2 mm	n mm	φ mm	n1 mm	D3 mm	d1 mm	H1 mm			h mm	b mm	x	m mm	De mm	z	De mm

Sing-e-row cross roller sewing bearings (series HJ)



notes: n1=number lubricating holes evenly distributed; Lubricating nipple M10*1
GB1152~1153-1979:

● 安装孔 $n-\phi$ 可改为螺纹孔; 齿宽 b 可改为 $H-h$ 。

●表内齿轮圆周力为最大圆周力，额定圆周力取其1/2。

●表内变位系数均为外齿轮变位系数, 内齿轮变位系

数均为+0.35。

说明:

(1)	X
(2)	X
(3)	X
(4)	X X
(5)	X X X X
(6)	X

(1) -回转支承代号
(2) -产品类别
(4) -滚动体:(钢球或滚柱)
直径mm。

(5) -滚动中心圆直径mm
S 单排四点接触球式

(3) -传动方式:
B -无齿式
A -大模数mm。

W—外齿式
不带A: 表示小模数。

N-内齿式

- (1) code of slewing bearings: H
- (2) Type of the products
 - 1) cross roller slewing bearings
 - 2) single-row fourpoint contact ball slewing bearings
- (3) Type of transmission
 - 1) gearless slewing bearings
 - 2) B-external gear slewing bearings
 - 3) W-internal gear slewing bearings
 - 4) rolling element: (steel ball or roller) diameter (mm)
 - 5) raceway centre's diameter (mm)
 - 6) A-large modulus;
without A-minor modulus.