
FRB Bearings



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FRB BEARINGS, YOU BEST CHOICE, YOU BEST SUPPLIER

INSTALLATION

TRANSPORT-HANDLING

FRB Bearings slewing bearings are carefully packed in order to avoid any damage during transport. Transport and storage are to be carried out in horizontal position only; transport in other positions requires special methods. As with any mechanical precision part, the rings of bearings must be handled with care avoiding any shocks, particularly along with radial axis. Handling should be carried out with suitable equipment for the weight of the part, which is indicated on the identification tag.

DELIVERY-STORAGE

The packed rings have an anticorrosive surface protection allowing a 6-month-storage in a covered and temperate room. Asuitable protection must be applied for longer storage.

It is necessary to regrease after each 18-month period.

UNPACKING-PREPARATION

WHEN UNWRAPPING THE BEARING:

- Take care not to cut the protective seals when removing the packing paper.
- Cut this paper, preferalby on the external diameter, and not on the upper or lower faces. When degreasing the bearing;
- Use a standard commercially available solvent. Chlorine containing solvents are prohibited.
- Take care not to introduce any solvent under the seals or in the raceways.
- Before fitting the grease nipples or junction pipes, remove the plastic caps or the Hcscrews from the greasing holes.

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WHEN INSTALLING THE BEARING:

STRUCTURE

1. Make sure that supporting structures comply with specifications. Make sure the supporting structures have enough strength. And the conjunction surfaces must be mechanical process.
2. Check for chips, weld seam particles, corrosion signs, etc.
3. Check for burrs, sundries, etc in the surface. If we couldn't reach to the required flatness by mechanical process, we need inject strongest special plastic into the surfaces as padding in order to reach the precision of mounting surfaces and reduce vibration.

SPIGOTS

When loads along the radial axis are important, especially when the bearing is placed vertically, it is then mandatory to use the centerings provided for that purpose.

Methods: Crossed tighten mounting bolts and check the slewing conditions of slewing bearing. We must put enough pre-stress to tighten bolts. And the pre-stress should be 70% of the bending limiting of bolts material.

POSITIONNING

The hardening junction (soft zone) which is marked by a red line on the geared ring, and located at the filler plug (from where filled with rolling elements) on the other ring, must be placed at 90° to the main load axis line supporting the load.

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FASTENING

1. Check that fasteners are really of the recommended grade. Check the flat washer are really of the confirmed drawings' requirements. Please don't use any elastic washer or other washers.
2. Install all fasteners and tighten lightly.
3. Using a properly calibrated torque wrench, hydraulic deviced are advisable.
4. Use a "star" shape pattern when torquing which ensures a uniform tightening over the whole periphery. The tightening torque to be applied is defined in the following table for bolt grade 10.9.

Bolt dia(mm)	10	12	14	16	18	20	22	24	27	30	33
Torque(Nm)	69	117	185	280	390	560	750	960	1400	1900	2600

INSATALLATION

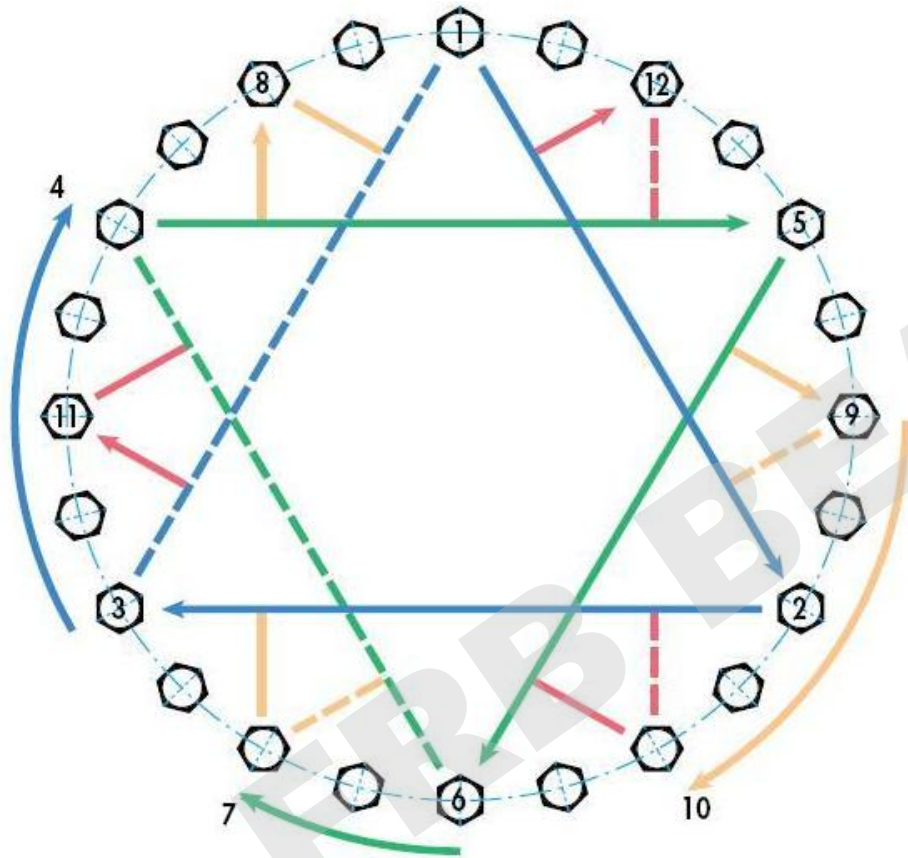
WHEN INSTALLING THE PINION:

GEAR

1. Adjust the driving pinion to the maximum eccentric point of the ring gear which is closed to designed value.
2. When several pinions are used, each one must be adjusted to the same conditions.
3. During tests, make sure that good alignment of the pinion and of the slewing bearing axes permits satisfactory contact across all the gear width.
4. Before running, lubricate the teeth of the slewing ring gear and of the pinion.

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STAR SHAPE



Checking the gear backlash

check backlash

