



中华人民共和国机械行业标准

JB/T2300-2011

Machinery Industry Standard of P.R.C

JB/T 2300-2011

转盘轴承安装维护

Installation, Operation and Maintenance

说明书

Instructions for Slewing Bearing

洛阳东轴轴承有限公司

Luoyang LYDZC Bearing Co., Ltd.



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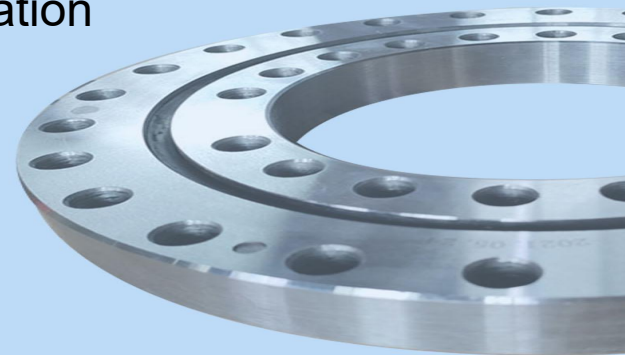
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首先感谢您购买我公司生产的“东轴牌”转盘轴承。

First of all, thank you for buying the "LYDZC" turntable bearing produced by our company.

本公司产品执行中华人民共和国机械行业标准

The company's product execution of the People's Republic of China The Machinery Industry Standard

请您安装使用本产品之前，详细阅读本说明书，

Please read this instructions in detail before installing the product, please,

以避免给您带来不必要的损失。在说明书指导下安装使用本产品，

To avoid unnecessary losses to you. Install this product under the guidance of the instructions,

能使转盘轴承发挥出最佳效能及最长的使用年限。

Can make the rotor bearing to play the best efficiency and the longest period of use.

重要提示：

Important Note:

(1) 本产品在出厂时做了防锈处理，有效期为6个月，如果您储存本产品超过6个月，需打开包装重新做防锈处理。

This product is processed by rust -proof when leaving the factory for 6 months. If you store this product for more than 6 months, you need to open the packaging and re -rust. stored more than 6 months, please antirust processing every 6 month.

(2) 该产品出厂前滚道内涂有少量的润滑脂，您在使用前一定要按要求充满润滑脂

The product is coated with a small amount of grease in the rolling road before the factory.

Before use, you must be filled with lubricating fat as required.



声明:

Statement:

(1)本说明书所含信息如有更改,恕不另行通知。

This note contains information are subject to change without prior notice.

(2)本说明书提供转盘轴承安装、使用、维护的一些相关信息。

This note contains installation, operation and maintenance instructions for slewing bearing.

(3)本说明书未涉及到的事项,请按照JB/T2300-2011标准执行。

The matters not mentioned are according standard JB/T2300-2011.

(4)本说明书解释权归洛阳东轴轴承有限公司所有。

The right to interpretation of this manual belongs to Luoyang East Bearing Co., Ltd.

未经本公司同意,不得影印、复印或以营利为目的传播。

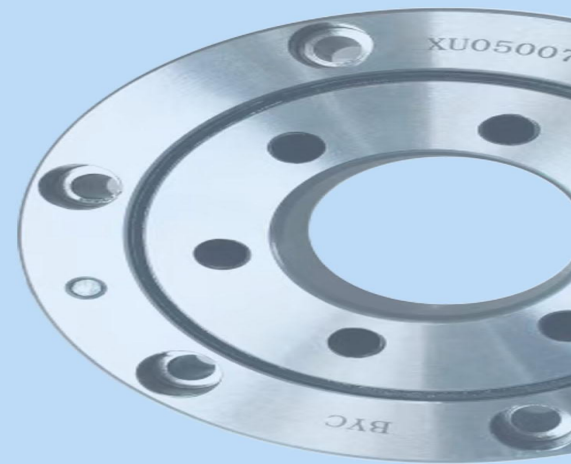
event. Without authorization of our company can not copy or transmission of for-profit.

(5)产品出厂前,已调整好间隙精度,未经过我公司同意不得擅自拆装,以免造成不必要的损失。

The slewing bearing has been adjust clearance precision,so如不经don't disassembly without our allowed. If disassembly not agreed by

我司同意自行拆装,我司不承担任何责任。

us, we do not assume any responsibility.



标牌标记 Scutche note

(1) 标牌 Scutche

标牌位于转盘轴承的滚圈上（可能是外侧或内侧位于堵塞附近），

The scutche on the ring of slewing bearing(maybe on inside or outside of ring which near plug location),

如下图所示。它表明了转盘轴承的简要信息生产厂家、型号、出厂日期、联系方式等。

as shown in below drawing. it shown brief information of slewing bearing like manufacturer, model, date of production and contact information

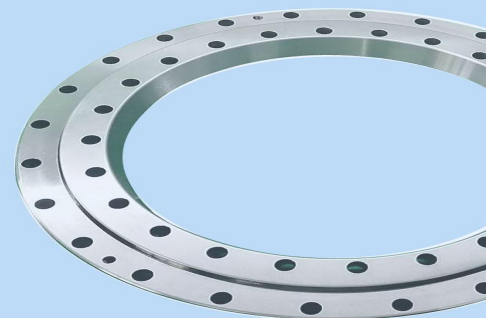
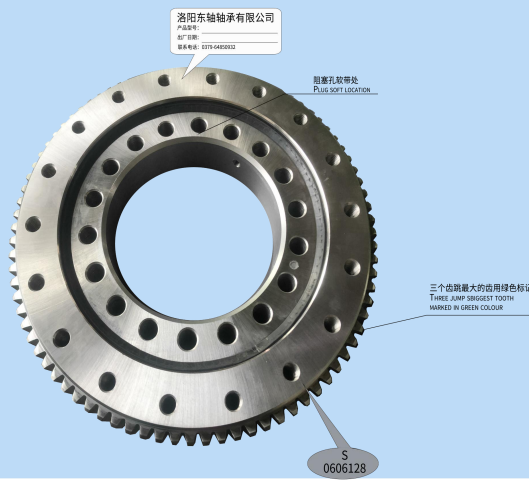
(2) 标记 Marks

转盘轴承滚道淬火软带置于非负荷区或非经常负荷区，标记“S”和堵塞。

The soft which raceway quenching of slewing bearing be located on unloading section or not often loading section, marked in 'S' and plug

齿圈齿轮三个齿跳动最大的齿，用绿色标记，驱动小齿轮的齿侧间隙必须在该处调整。

The point at which the largest deviation of partial arc of the circle on the gear wheel is marked in a green colour. Small pinion backlash in circular tooth must be adjusted here.



转盘轴承安装前准备工作

Preparations for Installation

(1)确认转盘轴承型号与合同订单上的要求一致。

Make sure that the model same with the contract.

(2)检查转盘轴承的包装是否完好，确认转盘轴承在运输过程中没有损坏。Check the package to ensure the integrity during the transportation.

(3)应在清洁而干燥的环境中，打开转盘轴承包装，检查转动是否灵活。

Open the package in clean and dry environment, and check the rotate.

(4)安装支架焊后应进行消除内应力热处理，平面进行机械加工。

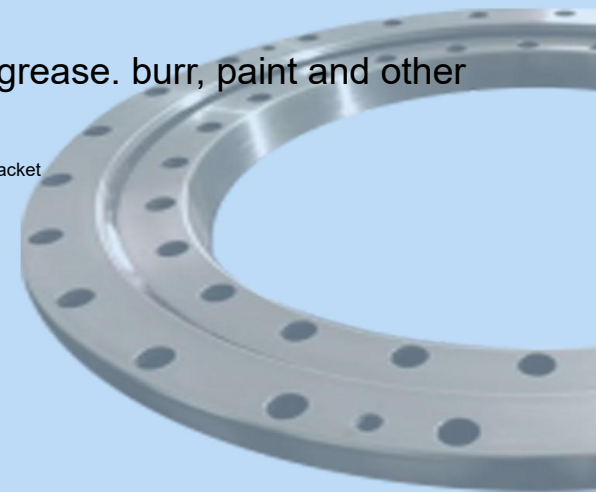
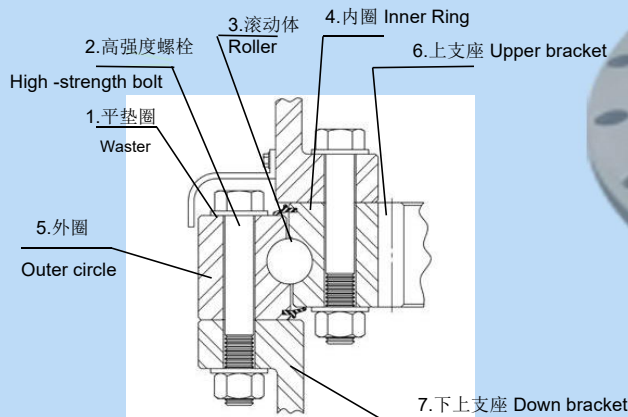
Inner stress and heat treatment should be removed after installing bracket, process machine complanately.

(5)安装支架必须有足够的刚度，防止回转支承变形，影响其使用。

The Bracket should have enough flexility to avoid the distortion of the slewing bearing and influence of its usage.

(6)转盘轴承安装基准面和支架安装平面必须清理干净，去除油污、毛刺、油漆以及其它异物。

The installation datum plane and bracket installing plane should be clean grease, burr, paint and other foreign bodies should be wiped off.



转盘轴承安装说明

Installation

(1)安装平面上的螺孔一定要与支承上的安装孔对准。

The screws in the installing plane should fit with the mounting holes in the slewing bearing.

(2)转盘轴承滚道淬火软带（外部标记“S”或堵塞孔处）应置于非负荷区和非经常负荷区，内外滚圈子的软带应错开180°安装，起重、挖掘机械滚动圈的软带应置于同臂架方向（即最大负荷方向）成90°角的位置。

Slewing Bearing raceway quenching soft zone (lies between the exterior mark 'S' and the jam should in the non-loading zone or non-regularity loading zone, Upper and lower rolling ring's soft zone should stagger for 180 degree. The soft zones of crane and excavator machinery should be in the place which forms a 90 degree angle with the arm support direction (the maximum load direction).

(3)将转盘轴承吊放在支架座上，用塞尺检查回转支承平面与支座的接触情况，如有间隙可以采取垫片垫平，防螺栓拧紧后变形，影响转盘轴承性能。

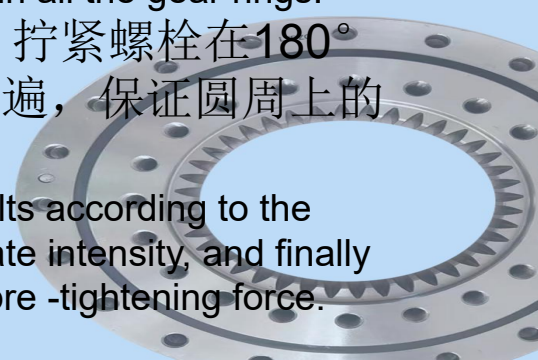
Put the slewing bearing on the bracket and check the contact condition between the supporting plane and bracket with feeler gauge, level up with pad mat if clearance appeared, so as to avoid distortion after screwing down and affect the performance of slewing bearing.

(4)安装螺栓拧紧前，根据齿轮节圆径向跳动最高点(三个涂有绿色漆标记齿)调节齿侧隙，并与螺栓拧紧后，在全部齿圈上进行一次侧间隙检查。

Before screwing down, adjust gear side clearance by gear circle radial runout vertex (3 green gears), after screwing down, check gear side clearance in all the gear rings.

(5)回转支承安装螺栓应采用高强螺栓，并根据受力等级螺栓。拧紧螺栓在180°方向进行对情况选择合适强度称连续进行，最后再顺序拧紧一遍，保证圆周上的螺栓有相同的预紧力。

The installation bolt of the rotary support should be high-strength bolts and bolts according to the stress level. Tighten the bolts in the direction of 180° to choose the appropriate intensity, and finally tighten it in order to ensure that the bolts on the circular week have the same pre-tightening force.



(6)安装工作结束后，应清除回转支承上的脏物及灰尘，并将露出部分涂上防锈漆，滚道和齿轮部分需涂上润滑脂。

After the installation is over, the dirt and dust on the rotating branches should be removed, and the part is exposed to the rust -proof paint.

回转支承使用、维修及润滑

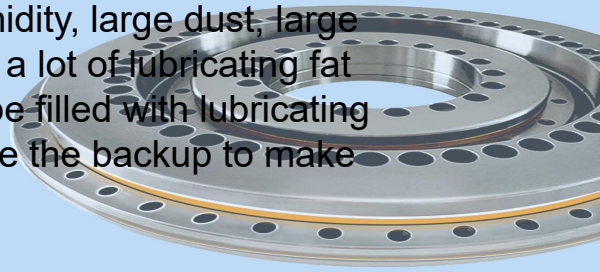
Operation, Maintenance and lubrication

(1)转盘轴承出厂时滚道内加入少量的2号极压锂基脂启用时用户应根据不同的工作条件，重新充满新的润滑脂。

When the turntable shaft is exported to the factory, a small amount of No. 2 polar pressure lithium is added to the rolling track. When the user should be enabled by different working conditions, the user should re -filled the new lubricant.

(2)回转支承滚道应定期加注润滑脂。一般球类回转支承每运转100小时加油一次，滚柱类回转支承每运转50小时加油一次，特殊工作环境，如高温、湿度大、灰尘多、温度变化大以及连续工作时，应缩短润滑周期。机械长期停止运转前后也必须加足新的润滑脂。每次润滑必须将滚道内注满润滑脂，直至从密封处渗出为止。注润滑脂时，慢慢转动回转支承，使润滑填充均匀。

Rotate the rolling road should be injected regularly. The general ball rotation support is refueling every 100 hours, and the roller return branches are refueling once every 50 hours. The special working environment, such as high temperature, high humidity, large dust, large temperature changes, and continuous work. Machinery must also add a lot of lubricating fat before and after the long -term stop operation. Each lubrication must be filled with lubricating grease until the seal from the seal. When you note the fat, slowly rotate the backup to make the lubrication fill evenly.



(3)齿面应经常清除杂物，并及时涂抹相应的润滑脂。

Tooth surface should usually wipe off the foreign bodys and add grease

(4)转盘轴承首次运转100小时后，需检查螺栓预紧力

Check the pretightening force of the bolt after the slewing bearing running

以后每运转500小时，必须保持足够的螺栓预紧力。

first 100 hours, then make sure enough pretightening force every another 500 hours.

(5)使用中注意回转支承的运转情况，如发现噪音，异响、冲击、功率突然增大，应立即停机检查，排除故障，必要时需拆开检查。

Give your attention to the running slewing bearing, you should stop it to check when noises, impulsion, abrupt accretion power appeared, and dismantle it to check when necessary.

(6)使用中最好采取保护措施，避免风尘、雨淋、水浸及高温等造成不良影响，严防较硬的异物接近或进入齿啮合区。

Its better to protect the slewing bearings from dust, rain, water and high temperature in operation, and defend gear engagement zone against hard objects.

(7)经常查看密封完好情况，如果发现密封带破损应及时更换，如发现密封带脱落应及时复位。

Regularly check the intact situation. If the damage of the sealed belt is found, it should be replaced in time.



转盘轴承装卸与贮运

Loading, Unloading, Storage and Transportation

(1)转盘轴承出厂时已进行了油封包装，包装好的回转支承可以在适宜条件下存放6个月，存放的回转支承每6个月更换润滑脂一次，每6个月要重新进行防锈包装。

Slewing bearing has been sealed with grease, it can be stored for 6 months in normal environment, change grease every 6 months and anti-rust package every 6 months.

(2)转盘轴承运输和贮存以水平放置为宜。贮存必须放在干燥的室内环境中。

It's better to place it in level direction, and store it in dry room.

(3)宜用吊环螺钉吊装转盘轴承，以水平方式进行，切勿碰撞，特别是径向方向碰撞。

It's better to load slewing bearing with lifting and move horizontally. Don't hit it especially in radial direction.

(4)叠放时，每个回转支承之间沿圆周方向至少放置三个均布的等高木垫板，且上下层垫块应放置一致。

When stacked, each rotating support is placed at least three equal wood pads in the direction of the circle, and the upper and lower layers should be placed consistently.



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