



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

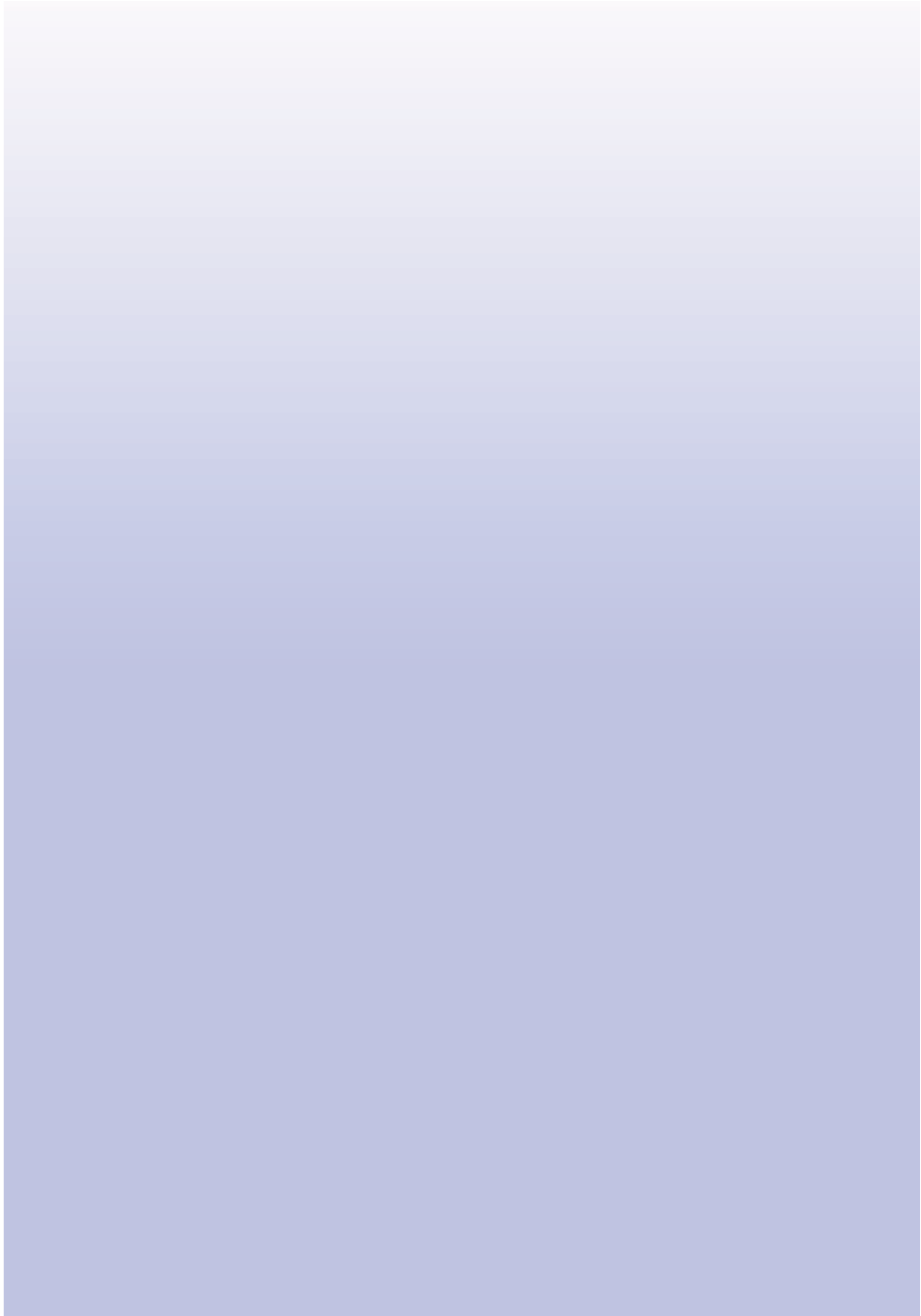
回转支承安装使用

Installation, Operation and Maintenance

说 明 书

Instructions for Slewing Bearing

徐州鑫达回转支承有限公司
Xuzhou Xinda Slewing Bearing Co., Ltd.



目 录

Content

1、回转支承简介

Introduction of slewing bearing

2、回转支承安装前准备工作

Preparations for Installation

3、回转支承安装说明

Installation of slewing bearing

4、回转支承使用、维修及润滑

Operation, Maintenance and Lubrication

5、回转支承装卸与贮运

Loading, Unloading, Storage and Transportation

首先感谢您购买我公司生产的“鑫达牌”回转支承。本公司产品执行中华人民共和国机械行业标准 the Machinery Industry Standard of P.R.C JB/T2300-2011 , Please read JB/T2300-2011, 请您安装使用本产品之前, 仔细阅读 this manual carefully before installing and operating our products so as to 本说明书, 以避免给您带来不必要的损失。在说明书指 avoid some unnecessary loss. If you follow the instructions in this manual, 导下安装使用本产品, 能使回转支承发挥出最佳效能及 you will get a desire result, and the slewing bearings will exert the best 最长的使用年限。

efficiency and have a long working life.

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

The slewing bearing has been antirust processing before dispatch 月, 如果您储存本产品超过6个月, 需打开包装重新做防 out of factory, it can be stored for 6 months in normal environment, if 锈处理。

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

Slewing bearing filling little grease before dispatch, please filling 使用前一定要按要求充满润滑脂。

full grease before use.

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) 本说明书提供回转支承安装、使用、维护的一些

些相关信息。

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。

-2011.

- (4) 本说明书解释权归徐州鑫达回转支承有限公司

所有。未经本公司同意，不得影印、复印或以营利为目的。Without authorization of our company can not copy or transmission of for-profit.

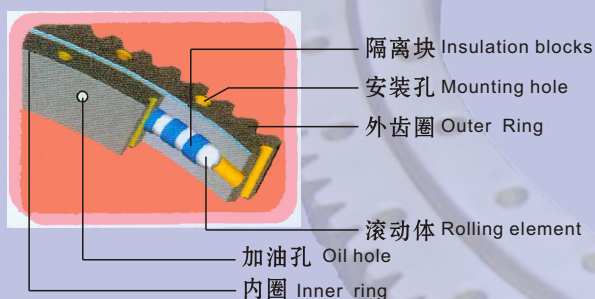
- (5) 产品出厂前，已调整好间隙精度，未经过我公

司同意不得擅自拆装，以免造成不必要的损失。如不经我司同意自行拆装，我司不承担任何责任。

us,we do not assume any responsibility.

回转支承简介

Introduction of slewing bearing



标牌标记 Scutche note

(1) 标牌 Scutche

标牌位于回转支承的滚圈上（可能是外侧或内侧位于堵塞附近），如下图所示。它表明了回转支承的简要信息：生产厂家、型号、出厂日期、联系方式等。

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

回转支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 self 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

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.

特别提示：“S”下方的“数字串”是我公司的产品编号。

Note:the number which below “S” are our serial number.

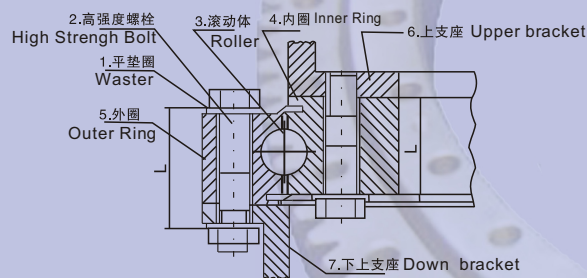
号。



回转支承安装前准备工作

Preparations for Installation

- (1) 确认回转支承型号与合同订单上的要求一致。
Make sure that the model same with the contract.
- (2) 检查回转支承的包装是否完好，确认回转支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，打开回转支承包装，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) 回转支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 bodys should be wiped off.



安装示意图

回转支承安装说明 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) 回转支承滚道淬火软带（外部标记“S”或堵塞

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 arm support direction (即最大负荷方向) 成90°角的位置。

place which forms a 90 degree angle with the arm support direction (the maximum load direction).

(3) 将回转支承吊放在支架座上，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，以防螺栓拧紧后变形，影响回转支承性能。

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

Before screwing down, adjust gear side clearance by gear circle radial

(三个涂有绿色漆标记齿) 调节齿侧隙，并与螺栓拧紧后，runout vertex (3 green gears), after screwing down, check gear side clearance in all the gear rings.

clearance in all the gear rings.

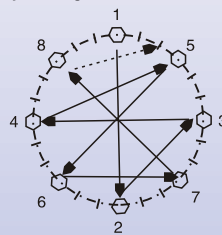
(5) 回转支承安装螺栓应采用高强螺栓，并根据受力

情况选择合适强度等级螺栓。拧紧螺栓在180°方向进行对称连续进行，最后再顺序拧紧一遍，保证圆周上的螺栓有相同的预紧力。安装螺栓垫圈应选用调质平垫圈，禁止使用弹簧垫圈，按图示次序依次拧紧螺栓。

be choosed in installation, screw down bolts in turn by the picture below;

(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。

lubricate grease in raceway and gear.



回转支承使用、维修及润滑

Operation, Maintenance and lubrication

(1) 回转支承出厂时滚道内加入少量的2号极压锂基脂

Before the slewing bearings leave factory, some No.2 EP grease (GB7324-1994), 启用时用户应根据不同的工作条件, (GB7324-1994) should be in slewing bearing raceway, change it into new 重新充满新的润滑脂。

lubricate grease according to your different working conditions.

(2) 回转支承滚道应定期加注润滑脂。一般球类回转支

Add grease regularly in slewing bearing raceway. Ball slewing bearing is lubricated every 100 hours, roller slewing bearing is lubricated every 50 hours, 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 continuously. Add enough grease before and after the Machine's long-time stop. 内注满润滑脂，直至从密封处渗出为止。注润滑脂时，要 Fill the raceway with grease till it is seeping from the seals. Turn slewing bearing 慢慢转动回转支承，使润滑填充均匀。

slowly when you add grease to make the grease equally filling.

(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 bodies and add grease.

(4) 回转支承首次运转100小时后，需检查螺栓预紧力，

以后每运转500小时，必须保持足够的螺栓预紧力。

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

Check the seal usually, change it when it is damaged, reset it when it is breaking off.

回转支承装卸与贮运

Loading, Unloading, Storage and Transportation

(1) 回转支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 antirust package every 6 months.

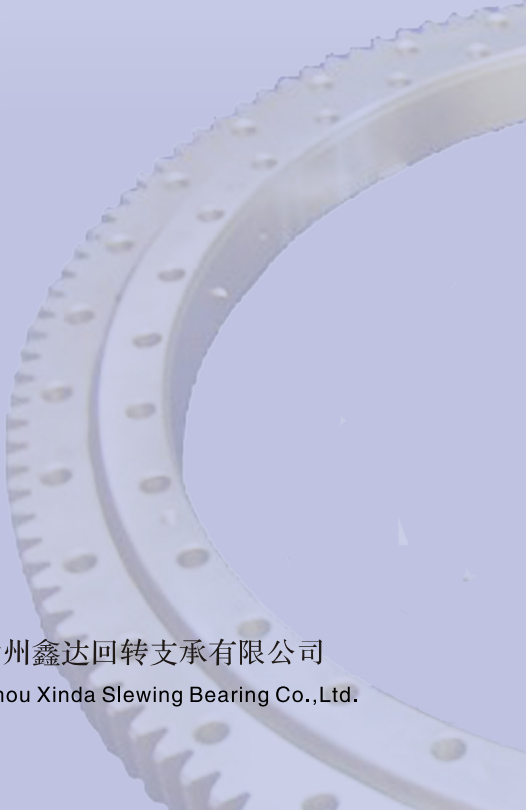
(2) 回转支承运输和贮存以水平放置为宜。贮存必须

放在干燥的室内环境中。

Its better to place it in level direction, and storage it in dry room.

(3) 宜用吊环螺钉吊装回转支承，以水平方式进行，
Its better to load slewing bearing with lifting and move horizontally.
切勿碰撞，特别是径向方向碰撞。
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
If stack up store, put three contour wood blocks evenly in a circular
三个均布的等高木垫板，且上下层垫块应放置一致。
between every bearing, the upper and under filling blocks layers should be in line.



徐州鑫达回转支承有限公司
Xuzhou Xinda Slewing Bearing Co., Ltd.

地址：徐州市北京南路连霍高速出口处南800米
网址：www.xzxinda.com
邮箱：xinda@xzxinda.com
电话：0516-83201088/ 81919135 13815369966
18913480582 13382691699
Q Q: 1508256846
传真：0516-83205618
技术咨询：18912047286
售后服务：13852112000

Xu zhou Xinda Slewing Bearng Co.,Ltd.
Add: 800 meters,high-way export of south
Beijing Road Xuzhou,Jiangsu,China
Website:www.slewing-world.com
E-mail:bearing@slewing-world.com
TEL :+86-516-83206186
FAX:+86-516-83205618
Mobile:86-15152128886 13305203956
Q Q: 1508256846
Zip : 221112