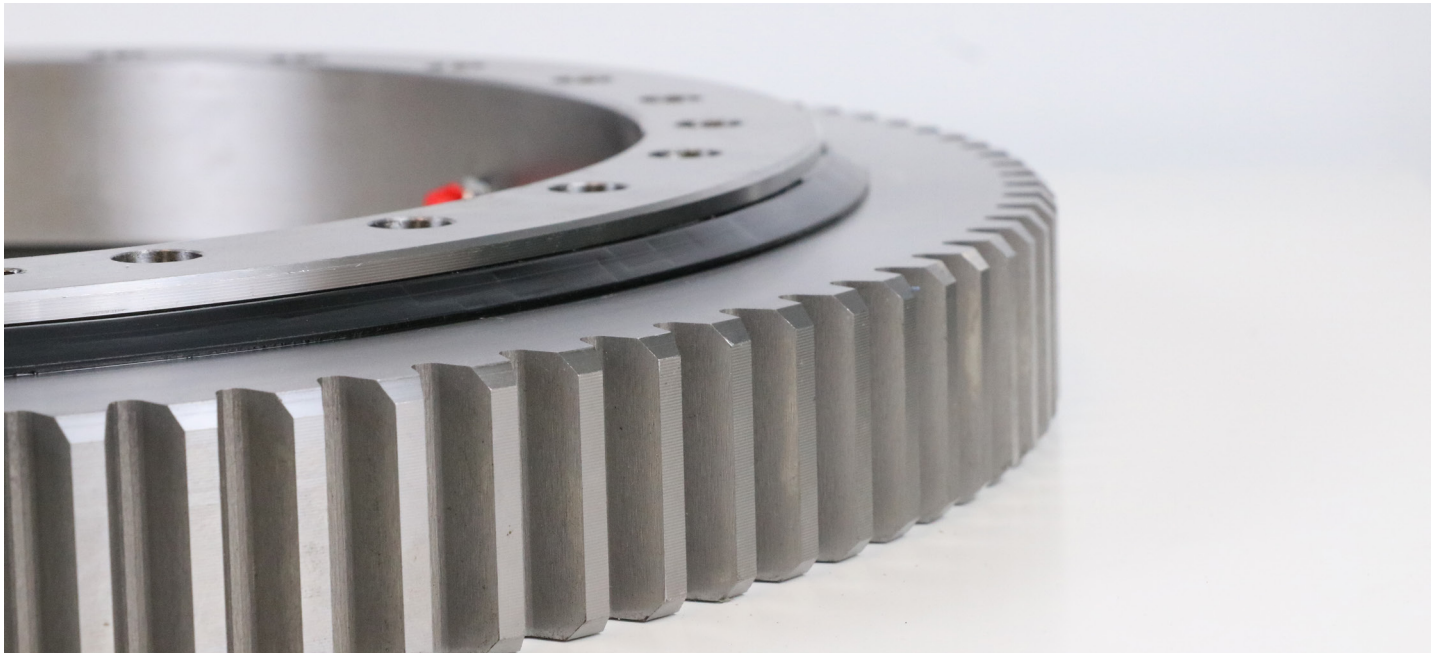
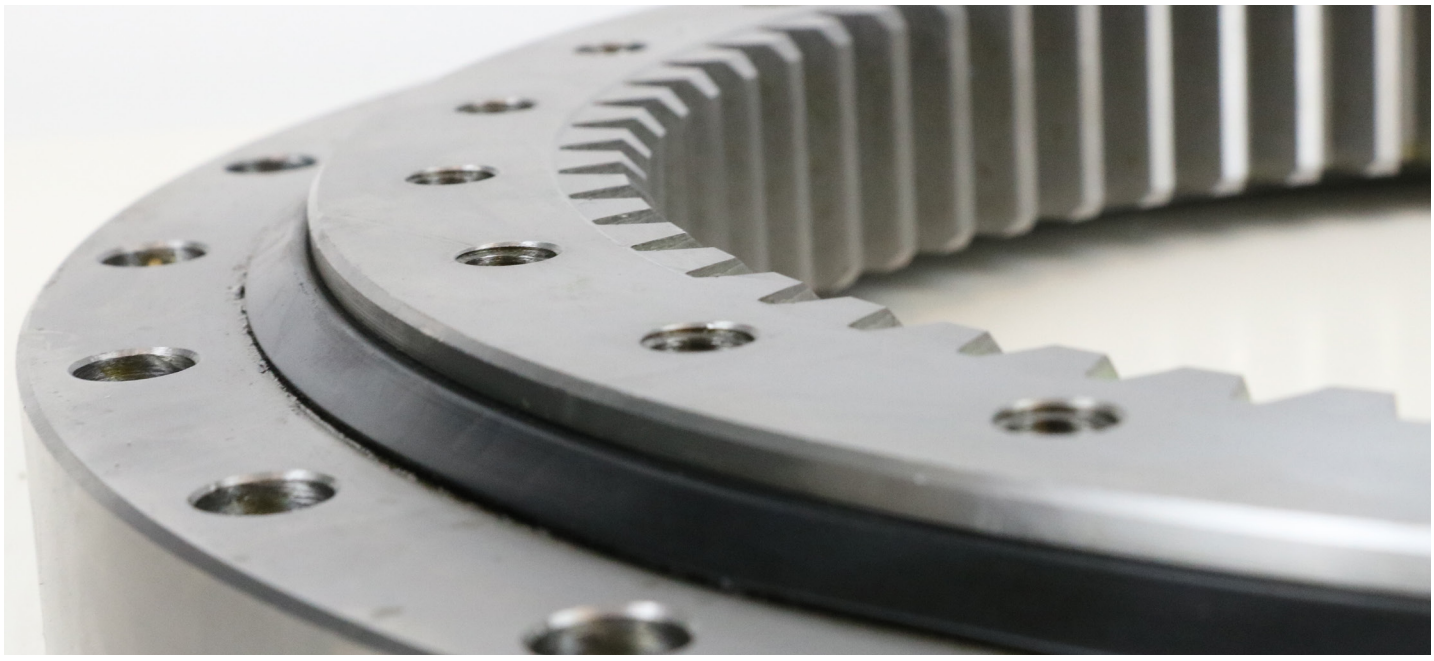
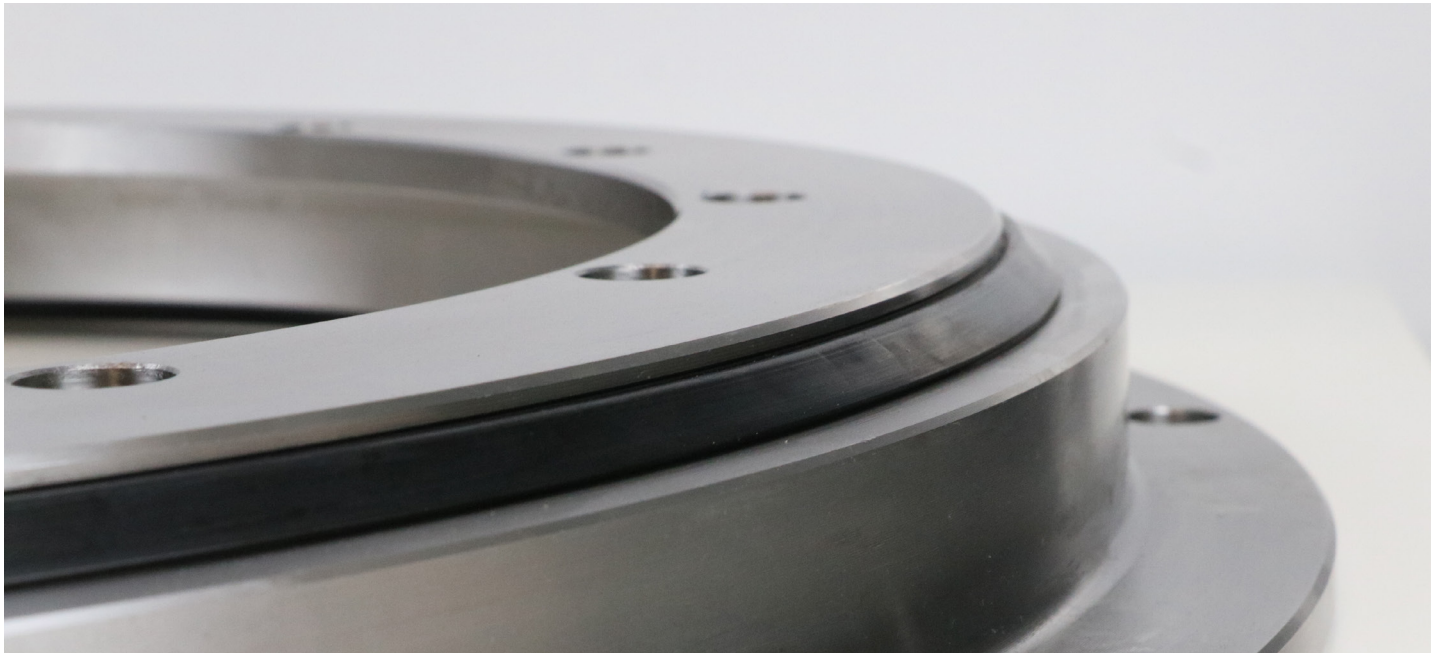


Industrievertretung Miebach GmbH
Tel. 02206 1424 · info@iv-miebach.de · www.iv-miebach.de

BÖNNEKAMP







Slewing Rings

IB-20-F 04
Internal gearing | Ring flange shape | Balls Ø 20 mm

OB-20-F 05
External gearing | Ring flange shape | Balls Ø 20 mm

WB-20-F 06
Without gearing | Ring flange shape | Balls Ø 20 mm

IB-32-F 07
Internal gearing | Ring flange shape | Balls Ø 32 mm

OB-32-F 08
External gearing | Ring flange shape | Balls Ø 32 mm

WB-32-F 09
Without gearing | Ring flange shape | Balls Ø 32 mm

IB-20-M 10
Internal gearing | Ring solid | Balls Ø 20 mm

OB-20-M 11
External gearing | Ring solid | Balls Ø 20 mm

WB-20-M 12
Without gearing | Ring solid | Balls Ø 20 mm

IB-25-M 13
Internal gearing | Ring solid | Balls Ø 25 mm

OB-25-M 14
External gearing | Ring solid | Balls Ø 25 mm

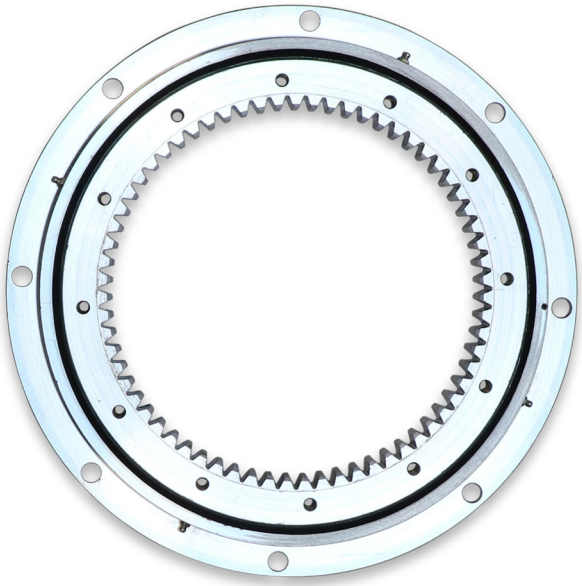
WB-25-M 15
Without gearing | Ring solid | Balls Ø 25 mm

SELECTION OF BÖNNEKAMP SLEWING RINGS 16

INSTALLATION AND MOUNTING 17

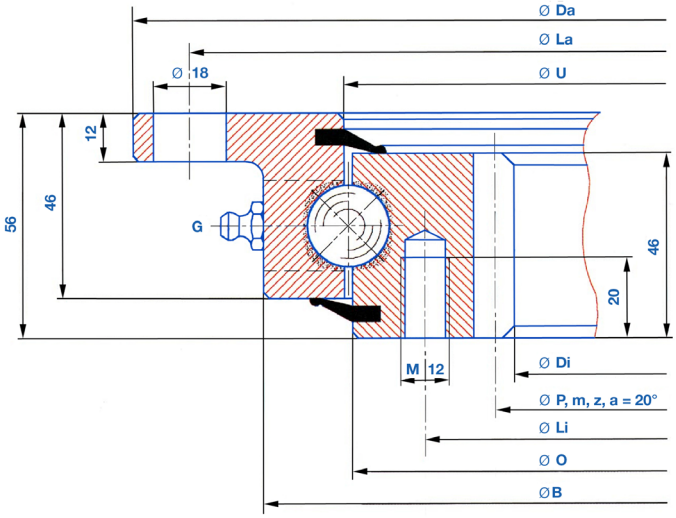
TRANSPORT AND STORAGE INSTRUCTIONS 20

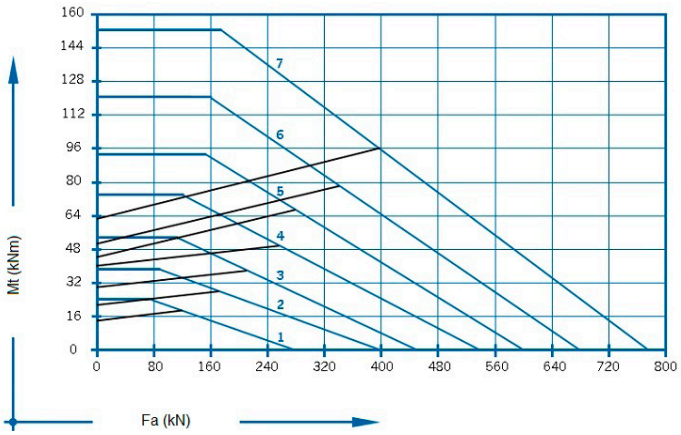




- Internal gearing – Ring flange shape
- Balls Ø 20 mm
- Diameters 518 – 1198 mm

TECHNICAL DATA

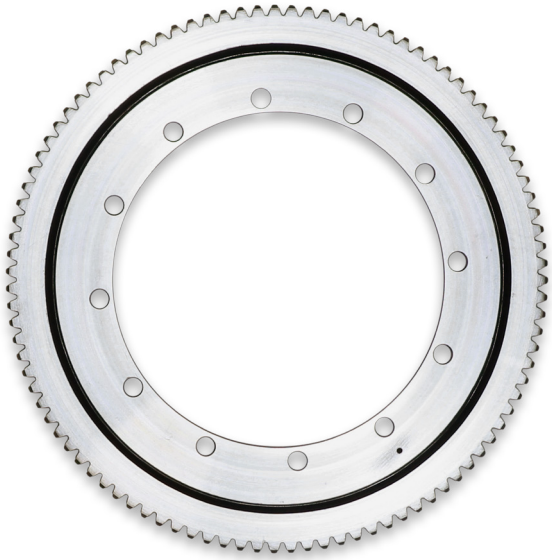




No.	Type	Dimensions					Mounting holes				Gearing			Tooth force		Mass
		Da (mm)	B (mm)	U (mm)	O (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	P (mm)	m	z	Fz nom (kN)	Fz max (kN)	(kg)
1	IB-1-20-505-1-F	518	453	415,5	412,5	326,5	490	8	375	12	335	5	67	11,40	22,80	27
2	IB-1-20-650-1-F	648	583	545,5	542,5	445,2	620	10	505	16	456	6	76	13,70	27,40	37,5
3	IB-1-20-750-1-F	748	683	645,5	642,5	547,2	720	12	605	18	558	8	93	13,70	27,40	44,5
4	IB-1-20-850-1-F	848	783	745,5	742,5	649,2	820	12	705	20	660	6	110	13,70	27,40	51
5	IB-1-20-950-1-F	948	883	845,5	842,5	737,6	920	14	805	20	752	8	94	18,30	36,60	61
6	IB-1-20-1050-1-F	1048	983	945,5	942,5	841,6	1020	16	905	22	856	8	107	18,30	36,60	65
7	IB-1-20-1200-1-F	1198	1133	1095,5	1092,5	985,6	1170	16	1055	24	1000	8	125	18,30	36,60	80

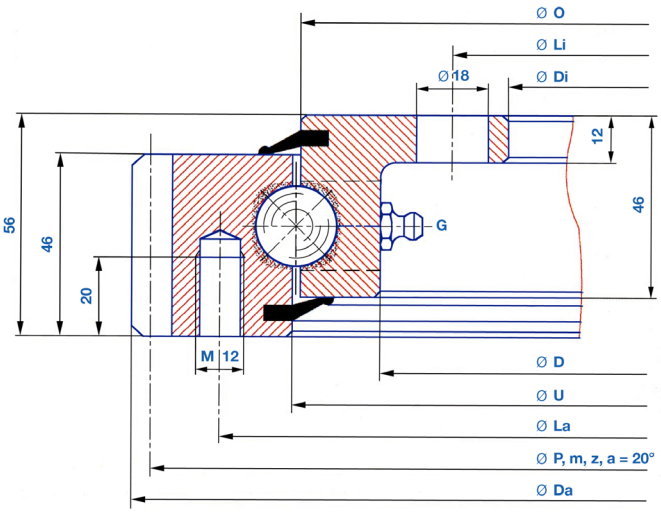
G = 4 Grease nipples DIN 71412 AM 8x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

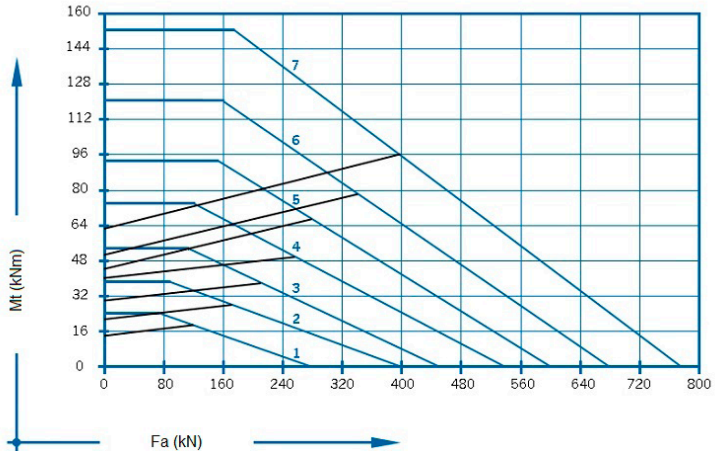




- External gearing – Ring flange shape
- Balls Ø 20 mm
- Diameters 504 – 1198 mm

TECHNICAL DATA





No.	Type	Dimensions					Mounting holes				Gearing			Tooth force		Mass
		Da (mm)	U (mm)	O (mm)	D (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	P (mm)	m	z	Fz nom (kN)	Fz max (kN)	(kg)
1	OB-1-20-505-1-F	504	415,5	412,5	375	304	455	10	332	12	495	5	99	10,80	21,60	29
2	OB-1-20-650-1-F	640,8	545,5	542,5	505	434	585	14	462	14	630	6	105	13,10	26,20	40
3	OB-1-20-750-1-F	742,8	645,5	642,5	605	534	685	16	562	16	732	6	122	13,10	26,20	47
4	OB-1-20-850-1-F	838,8	745,5	742,5	705	634	785	18	662	16	828	6	138	13,10	26,20	53
5	OB-1-20-950-1-F	950,4	845,5	842,5	805	734	885	20	762	18	936	8	117	17,60	35,20	64
6	OB-1-20-1050-1-F	1046,4	945,5	942,5	905	834	985	20	862	20	1032	8	129	17,60	35,20	69
7	OB-1-20-1200-1-F	1198,4	1095,5	1092,5	1055	984	1135	22	1012	20	1184	8	148	17,60	35,20	82

G = 4 Grease nipples DIN 71412 AM 8x1 equally spaced
Line No. = maximum static load raceway, Black line = maximum bolt (8.8)

Slewing Ring

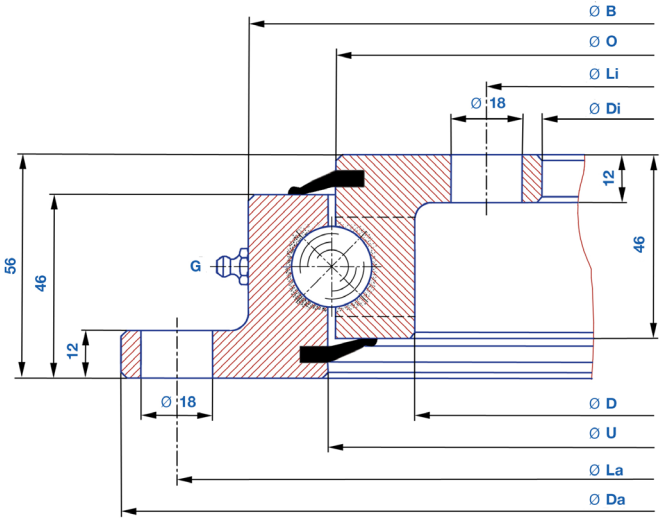
WB-20-F | RING FLANGE SHAPE | WHITOUT GEARING

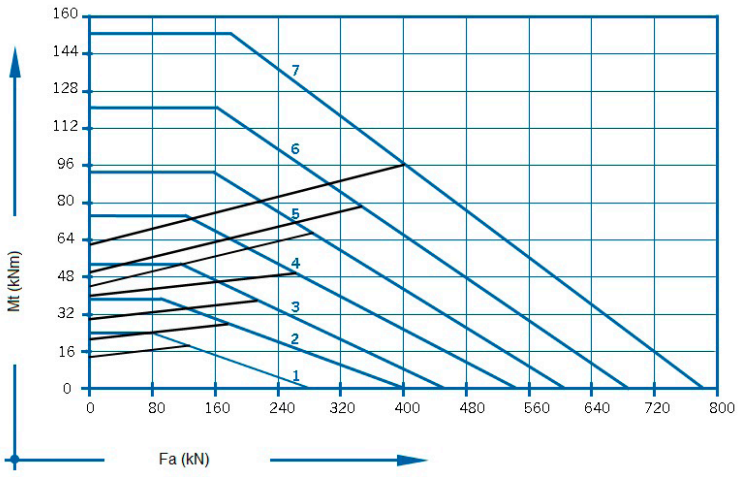




- Without gearing – Ring flange shape
- Balls Ø 20 mm
- Diameters 518 – 1198 mm

TECHNICAL DATA

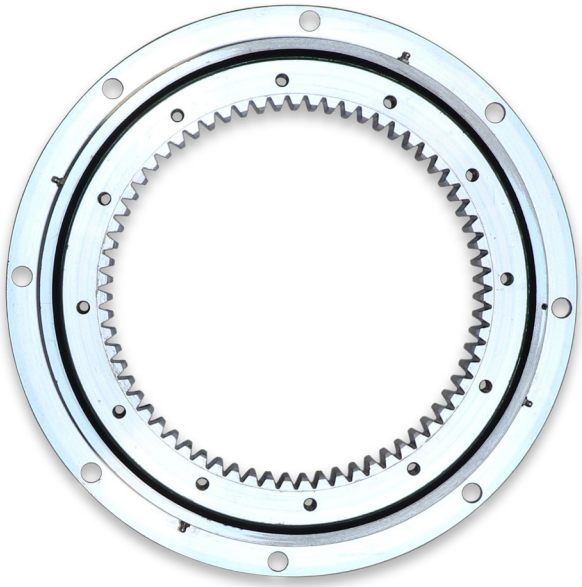




No.	Type	Dimensions						Mounting holes				Mass
		Da (mm)	B (mm)	U (mm)	O (mm)	D (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	(kg)
1	WB-1-20-505-1-F	518	453	415,5	412,5	375	304	490	8	332	12	23,5
2	WB-1-20-650-1-F	648	583	545,5	542,5	505	434	620	10	462	14	31
3	WB-1-20-750-1-F	748	683	645,5	642,5	605	534	720	12	562	16	36,5
4	WB-1-20-850-1-F	848	783	745,5	742,5	705	634	820	12	662	16	43
5	WB-1-20-950-1-F	948	883	845,5	842,5	805	734	920	14	762	18	48
6	WB-1-20-1050-1-F	1048	983	945,5	942,5	905	834	1020	16	862	20	53
7	WB-1-20-1200-1-F	1198	1133	1095,5	1092,5	1055	984	1170	16	1012	20	62

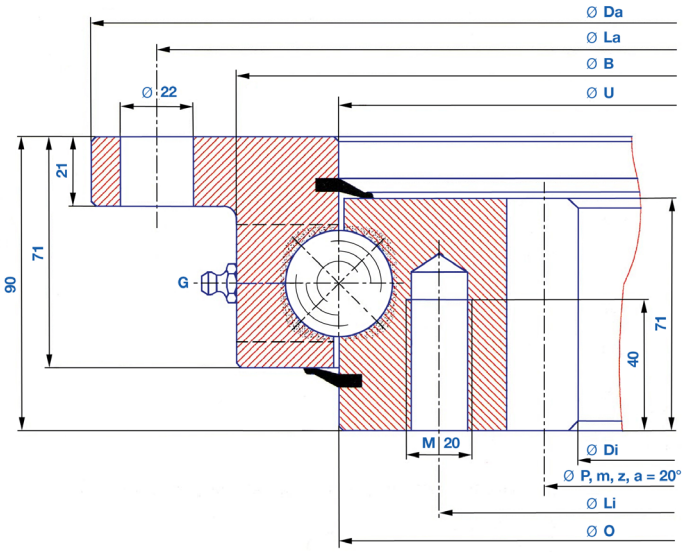
G = 4 Grease nipples DIN 71412 AM 8x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

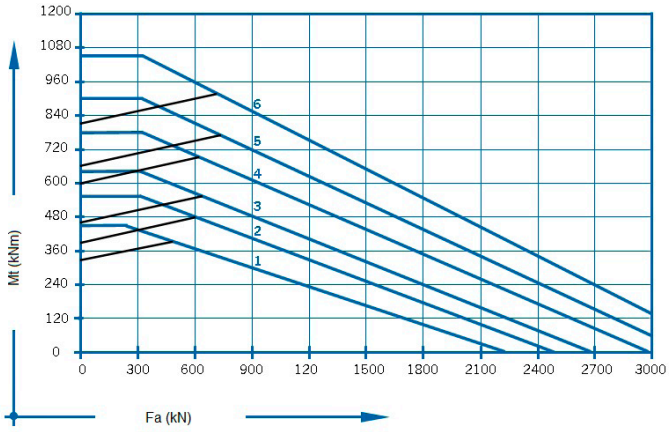




- Internal gearing – Ring flange shape
- Balls Ø 32 mm
- Diameters 1100 – 1600 mm

TECHNICAL DATA

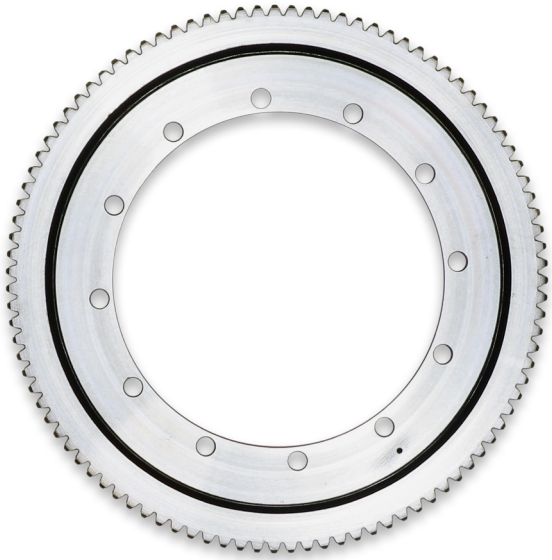




No.	Type	Dimensions					Mounting holes				Gearing			Tooth force		Massa
		Da (mm)	U (mm)	O (mm)	D (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	P (mm)	m	z	Fz nom (kN)	Fz max (kN)	(kg)
1	IB-1-32-1100-1-F	1100	1017	955	955	812	1060	30	894	30	830	10	83	42,10	84,20	159
2	IB-1-32-1200-1-F	1200	1117	1055	1055	912	1160	30	994	30	930	10	93	42,10	84,20	176
3	IB-1-32-1300-1-F	1300	1217	1155	1155	1012	1260	36	1094	36	1030	10	103	42,10	84,20	192
4	IB-1-32-1400-1-F	1400	1317	1255	1255	1112	1360	42	1194	42	1130	10	113	42,10	84,20	208
5	IB-1-32-1500-1-F	1500	1417	1355	1355	1212	1460	42	1294	42	1230	10	123	42,10	84,20	226
6	IB-1-32-1600-1-F	1600	1517	1455	1455	1310	1560	48	1394	48	1330	10	133	42,10	84,20	243

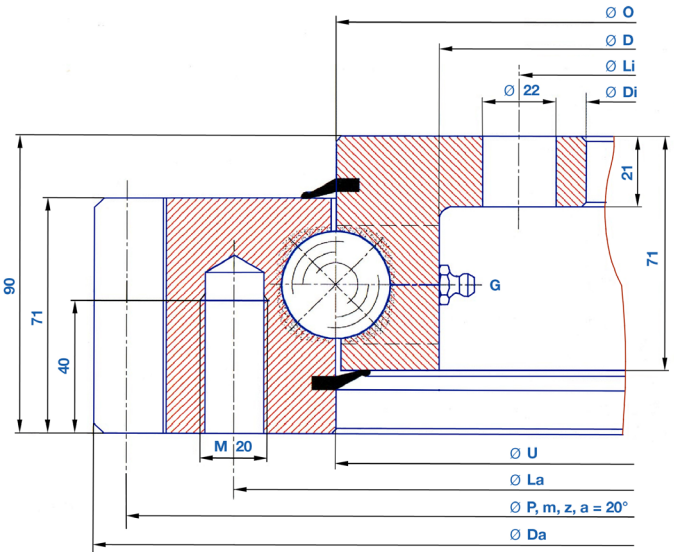
G = 6 Grease nipples DIN 71412 AM 10x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

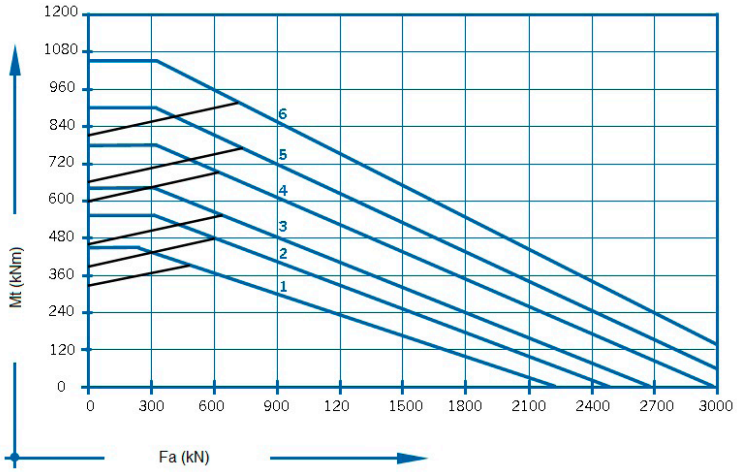




- External gearing – Ring flange shape
- Balls Ø 32 mm
- Diameters 1100 – 1600 mm

TECHNICAL DATA





No.	Type	Dimensions					Mounting holes				Gearing			Tooth force		Mass
		Da (mm)	U (mm)	O (mm)	D (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	P (mm)	m	z	Fz nom (kN)	Fz max (kN)	(kg)
1	OB-1-32-1100-1-F	1098	955	955	893	805	1016	30	845	30	1080	9	120	34,10	68,20	165
2	OB-1-32-1200-1-F	1200	1055	1055	993	905	1116	30	945	30	1180	10	118	37,85	75,70	183
3	OB-1-32-1300-1-F	1300	1155	1155	1093	1005	1216	36	1045	36	1280	10	128	37,85	75,70	200
4	OB-1-32-1400-1-F	1400	1255	1255	1193	1105	1316	42	1145	42	1380	10	138	37,85	75,70	216
5	OB-1-32-1500-1-F	1500	1355	1355	1293	1205	1416	42	1245	42	1480	10	148	37,85	75,70	234
6	OB-1-32-1600-1-F	1600	1455	1455	1393	1305	1516	48	1345	48	1580	10	158	37,85	75,70	250

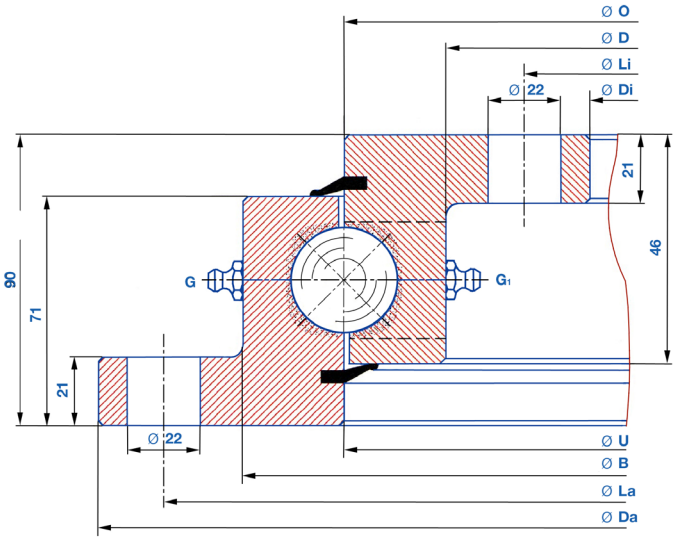
G = 6 Grease nipples DIN 71412 AM 10x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

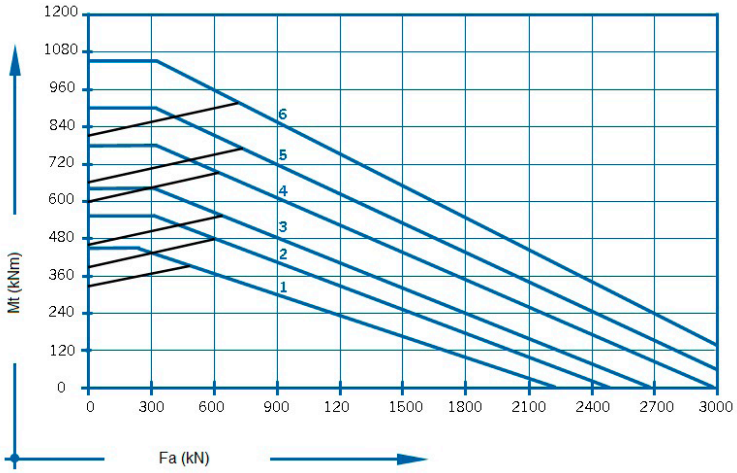




- Without gearing – Ring flange shape
- Balls Ø 32 mm
- Diameters 1100 – 1600 mm

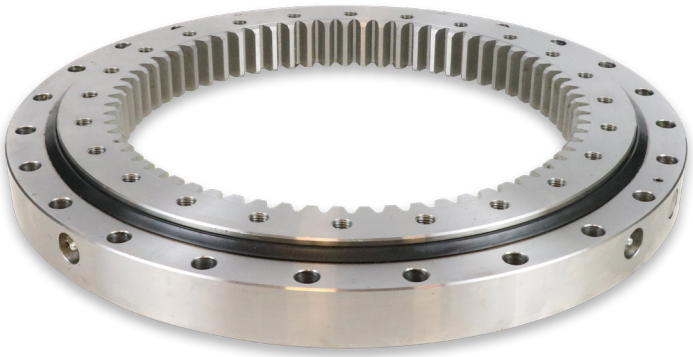
TECHNICAL DATA

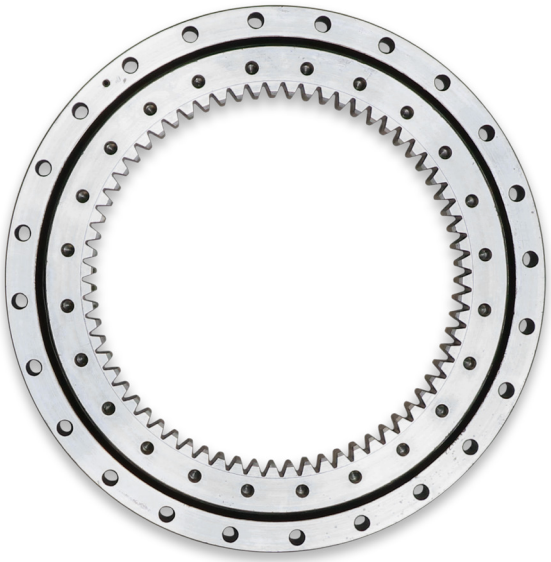




No.	Type	Dimensions						Mounting holes				Mass
		Da (mm)	B (mm)	U (mm)	O (mm)	D (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	(kg)
1	WB-1-32-1100-1-F	1100	1017	955	955	893	805	1060	30	845	30	131
2	WB-1-32-1200-1-F	1200	1117	1055	1055	993	905	1160	30	945	30	145
3	WB-1-32-1300-1-F	1300	1217	1155	1155	1093	1005	1260	36	1045	36	159
4	WB-1-32-1400-1-F	1400	1317	1255	1255	1193	1105	1360	42	1145	42	172
5	WB-1-32-1500-1-F	1500	1417	1355	1355	1293	1205	1460	42	1245	42	186
6	WB-1-32-1600-1-F	1600	1517	1455	1455	1393	1305	1560	48	1345	48	200

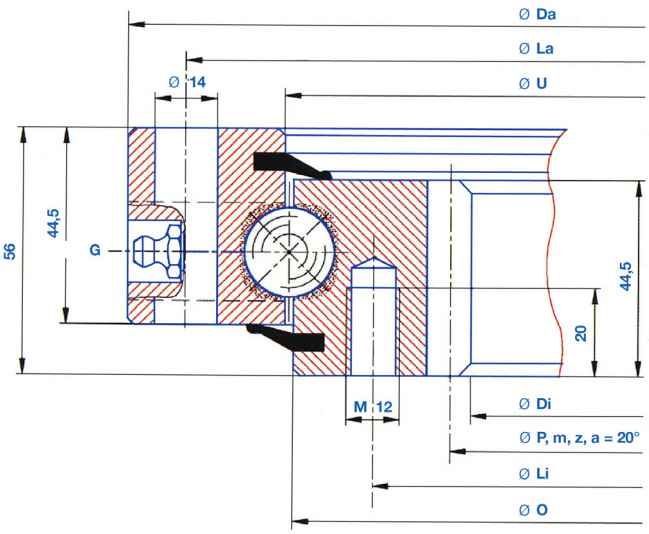
G = 6 Grease nipples DIN 71412 AM 10x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

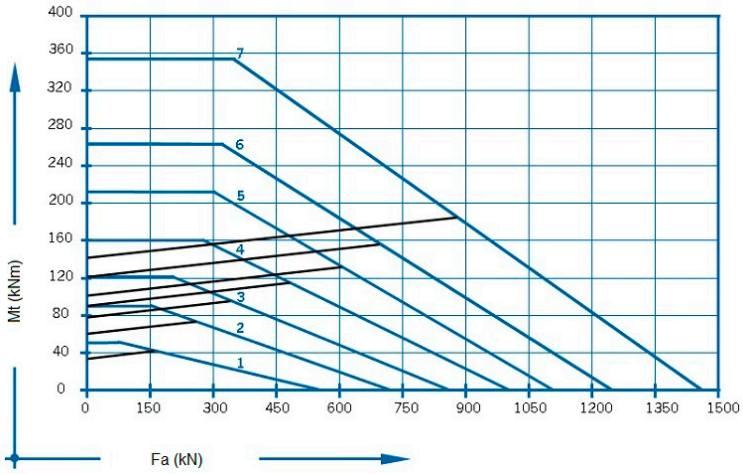




- Internal gearing – Ring solid
- Balls Ø 20 mm
- Diameters 486 – 1166 mm

TECHNICAL DATA





No.	Type	Dimensions				Mounting holes				Gearing			Tooth force		Mass
		Da (mm)	U (mm)	O (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	P (mm)	m	z	Fz nom (kN)	Fz max (kN)	(kg)
1	IB-1-20-486-1-M	486	415,5	412,5	325	460	24	375	24	335	5	67	11,40	22,80	31
2	IB-1-20-616-1-M	616	545,5	542,5	444	590	32	505	32	456	6	76	13,70	27,40	42
3	IB-1-20-716-1-M	716	645,5	642,5	546	690	36	605	36	558	6	93	13,70	27,40	50
4	IB-1-20-816-1-M	816	745,5	742,5	648	790	40	705	40	660	6	110	13,70	27,40	58
5	IB-1-20-916-1-M	916	845,5	842,5	736	890	40	805	40	752	8	94	18,30	36,60	69
6	IB-1-20-1016-1-M	1016	945,5	942,5	840	990	44	905	44	856	8	107	18,30	36,60	76
7	IB-1-20-1166-1-M	1166	1095,5	1092,5	984	1140	48	1055	48	1000	8	125	18,30	36,60	91

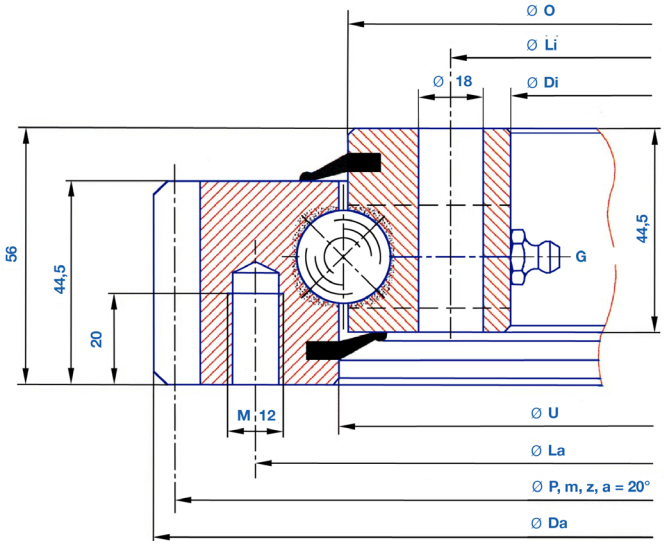
G = 4 Grease nipples DIN 71412 AM 8x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

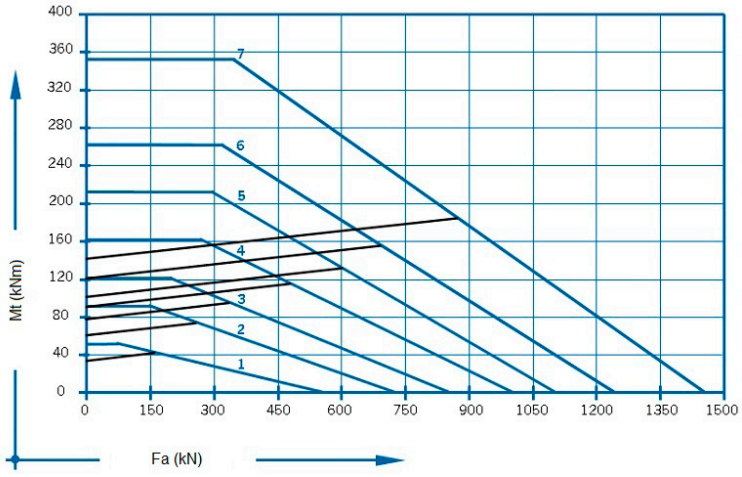




- External gearing – Ring solid
- Balls Ø 20 mm
- Diameters 503 – 1198 mm

TECHNICAL DATA

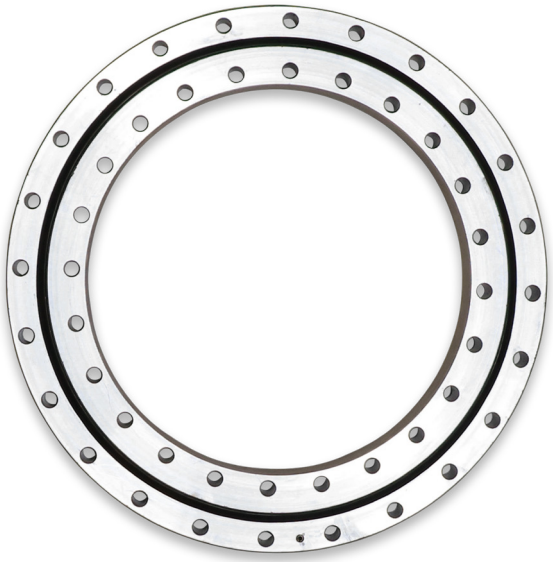




No.	Type	Dimensions				Mounting holes				Gearing			Tooth force		Mass
		Da (mm)	U (mm)	O (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	P (mm)	m	z	Fz nom (kN)	Fz max (kN)	(kg)
1	OB-1-20-505-1-M	503,3	415,5	412,5	342	455	20	368	24	495	5	99	10,80	21,60	31
2	OB-1-20-650-1-M	640,3	545,5	542,5	472	585	28	498	32	630	6	105	13,10	26,20	43
3	OB-1-20-750-1-M	742,3	645,5	642,5	572	685	32	598	36	732	6	122	13,10	26,20	52
4	OB-1-20-850-1-M	838,1	745,5	742,5	672	785	36	698	40	828	6	138	13,10	26,20	59
5	OB-1-20-950-1-M	950,1	845,5	842,5	772	885	36	798	40	936	8	117	17,60	35,20	71
6	OB-1-20-1050-1-M	1046,1	945,5	942,5	872	985	40	898	44	1032	8	129	17,60	35,20	77
7	OB-1-20-1200-1-M	1198,1	1095,5	1092,5	1022	1135	44	1048	48	1184	8	148	17,60	35,20	91

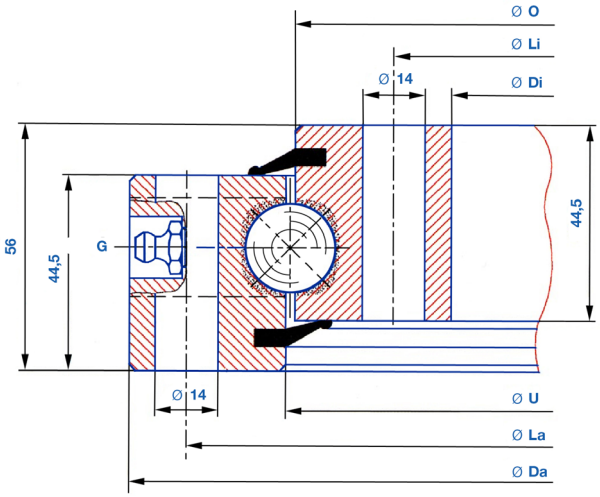
G = 4 Grease nipples DIN 71412 AM 8x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

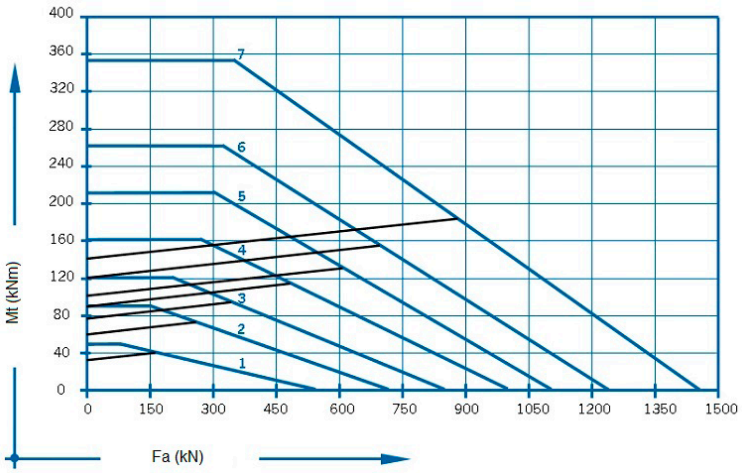




- Without gearing – Ring solid
- Balls Ø 20 mm
- Diameters 486 – 1166 mm

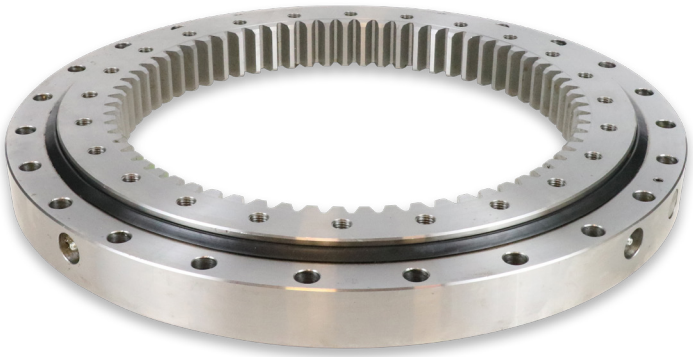
TECHNICAL DATA

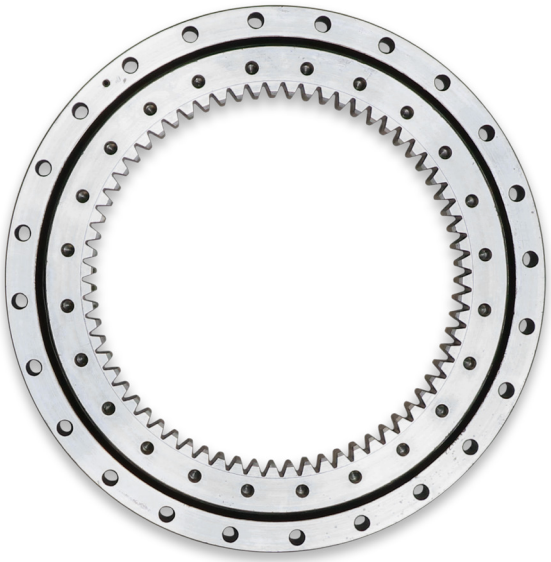




No.	Type	Dimensions				Mounting holes				Mass
		Da (mm)	U (mm)	O (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	(kg)
1	WB-1-20-486-1-M	486	415,5	412,5	342	460	24	375	24	29
2	WB-1-20-616-1-M	616	545,5	542,5	472	590	32	505	32	37
3	WB-1-20-716-1-M	716	645,5	642,5	572	690	36	605	36	44
4	WB-1-20-816-1-M	816	745,5	742,5	672	790	40	705	40	52
5	WB-1-20-916-1-M	916	845,5	842,5	772	890	40	805	40	60
6	WB-1-20-1016-1-M	1016	945,5	942,5	872	990	44	905	44	67
7	WB-1-20-1166-1-M	1166	1095,5	1092,5	1022	1140	48	1055	48	77

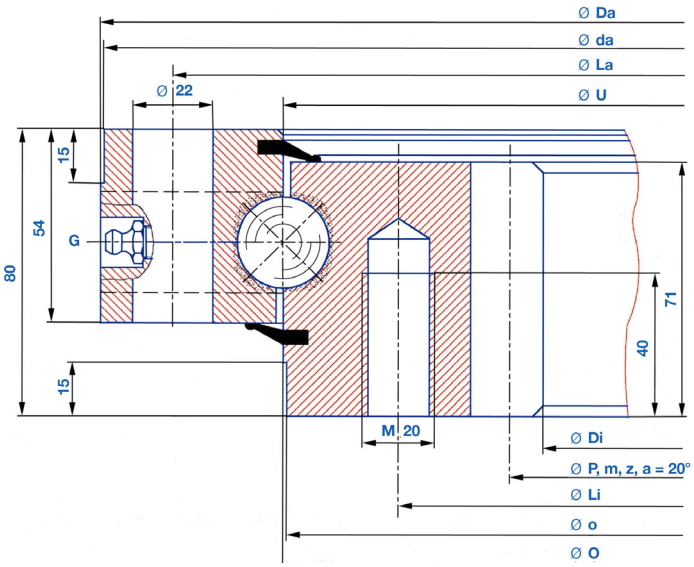
G = 4 Grease nipples DIN 71412 AM 8x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

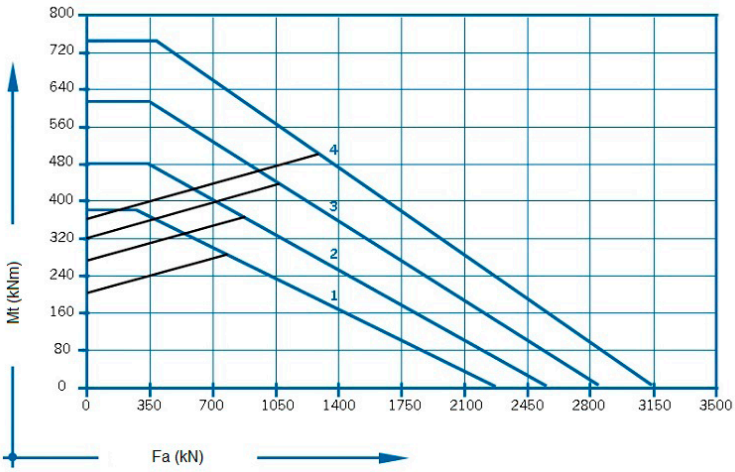




- Internal gearing – Ring solid
- Balls Ø 25 mm
- Diameters 855 – 1155 mm

TECHNICAL DATA





No.	Type	Dimensions						Mounting holes				Gearing			Tooth force		Mass
		Da (mm)	da +IT8 (mm)	U (mm)	O (mm)	c +IT8 (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	P (mm)	m	z	Fz nom (kN)	Fz max (kN)	(kg)
1	IB-1-25-855-1-M	855	853	756	756	755	610	815	24	694	24	630	10	63	42,10	84,20	119
2	IB-1-25-955-1-M	955	953	856	856	855	710	915	28	794	28	730	10	73	42,10	84,20	137
3	IB-1-25-1055-1-M	1055	1053	956	956	955	810	1015	30	894	30	830	10	83	42,10	84,20	149
4	IB-1-25-1155-1-M	1155	1153	1056	1056	1055	910	1115	30	994	30	930	10	93	42,10	84,20	165

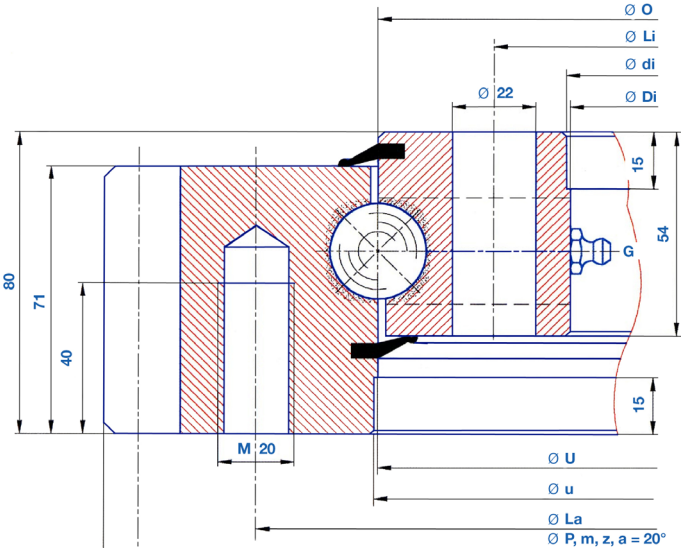
G = 4 Grease nipples DIN 71412 AM 10x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

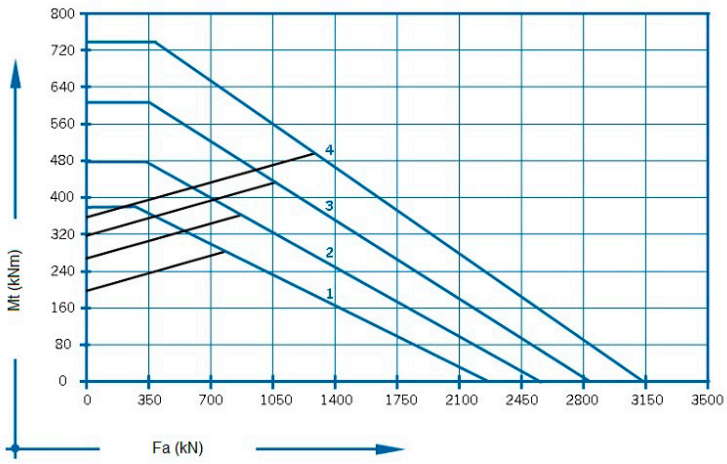




- External gearing – Ring solid
- Balls Ø 25 mm
- Diameters 898 – 1198 mm

TECHNICAL DATA

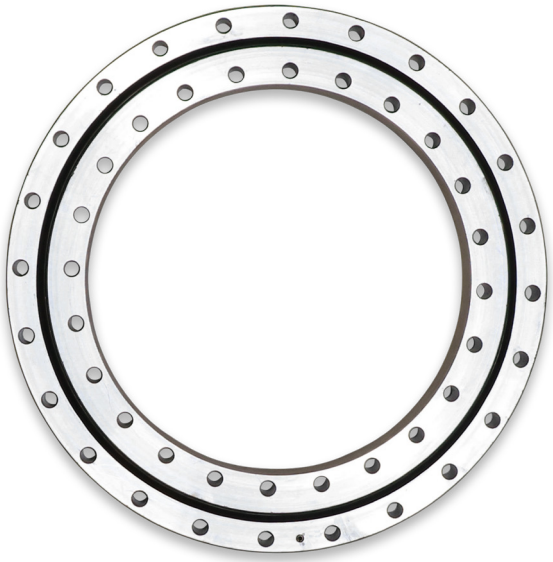




No.	Type	Dimensions						Mounting holes				Gearing			Tooth force		Mass
		Da (mm)	U (mm)	u +IT8 (mm)	O (mm)	di +IT8 (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	P (mm)	m	z	Fz nom (kN)	Fz max (kN)	(kg)
1	OB-1-25-900-1-M	898	754	755	754	657	655	816	24	695	24	882	9	98	34,10	68,20	128
2	OB-1-25-1000-1-M	997	854	855	854	757	755	916	28	795	28	981	9	109	34,10	68,20	145
3	OB-1-25-1100-1-M	1096	954	955	954	857	855	1016	30	895	30	1080	9	120	34,10	68,20	155
4	OB-1-25-1200-1-M	1198	1054	1055	1054	957	955	1116	30	995	30	1180	10	118	37,85	75,70	171

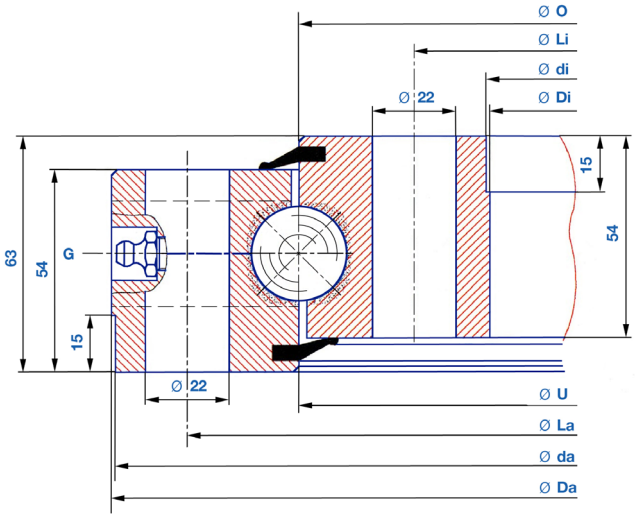
G = 4 Grease nipples DIN 71412 AM 10x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

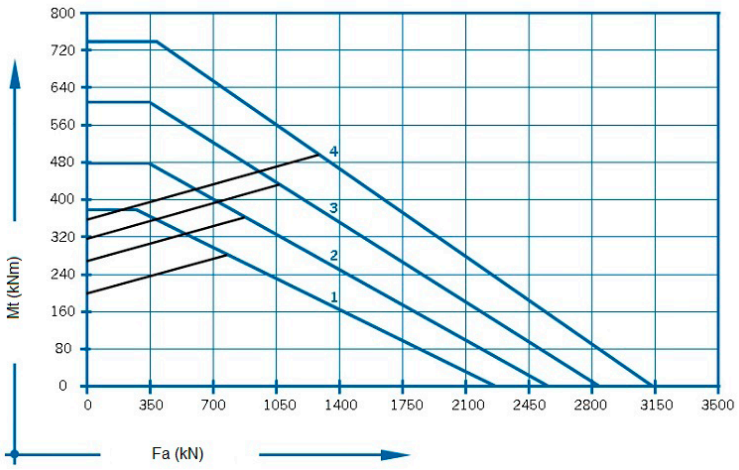




- Without gearing – Ring solid
- Balls Ø 25 mm
- Diameters 855 – 1155 mm

TECHNICAL DATA





No.	Type	Dimensions						Mounting holes				Mass
		Da (mm)	da +IT8 (mm)	U (mm)	O (mm)	di +IT8 (mm)	Di (mm)	La (mm)	na	Li (mm)	ni	(kg)
1	WB-1-25-855-1-M	855	853	756	756	657	655	815	24	695	24	90
2	WB-1-25-955-1-M	955	953	856	856	757	755	915	28	795	28	101
3	WB-1-25-1055-1-M	1055	1053	956	956	857	855	1015	30	895	30	115
4	WB-1-25-1155-1-M	1155	1153	1056	1056	957	955	1115	30	995	30	128

G = 4 Grease nipples DIN 71412 AM 10x1 equally spaced
Line No. = maximum static load raceway. Black line = maximum bolt (8.8)

Selection of Bönnekamp slewing rings must be carried out by comparing the occurring loads: tilting moment (M_t), axial force (F_a), and radial force (F_r) with the load diagram for the raceway and the bolted connection. Unless otherwise stated, the diagrams apply to grade 8.8 bolts.

Radial forces should, if exceeding $0,2 * \frac{Mt}{D_L} + 0,046 * F_a$, be multiplied by a factor of 3 and added to the axial force, where M_t is the tilting moment, D_L is the raceway diameter, and F_a is the axial force (please consult us if you have a different value).
These values must be multiplied by the corresponding application factor before comparing.

Application factors:

Excavator	1.70	Aerial platform	1.25
Pillar slewing crane	1.30	Ship crane	1.40
Grab crane	1.70	Mobile crane	1.35
Tower crane	1.25	Agricultural crane	1.10
Dragline	1.50	Concrete pump	1.30

All values in the diagrams refer to an upright load and ambient temperature from -25°C to +60°C.
For suspended loads or different temperatures, please consult us.

Drive torque
The nominal torque required to drive a slewing ring is:

$M_{nom} = M_w + M_r$ where M_w is the frictional resistance from the seals and M_r is the moment from the rolling resistance.

$M_w = D_L * 200Nm$ and $M_r = \left(\frac{4,37*Mt}{D_L} + F_a\right) * 0,01 * \frac{D_L}{2} Nm$

The drive torque required during start-up is: $M_{max} = M_{nom} + M_a$

$M_a = \frac{J*\pi*n}{30*t_a} Nm$ where J and n are the mass inertia and rotational speed of the rotating part, and t_a is the start-up time.

The resulting nominal and maximum tooth forces must be checked against Fz_{nom} and Fz_{max}.
These values are listed in the table for the relevant slewing ring.

Explanation of type code: E.g. OB-1-20-505-1-F

O	Outer gear	505	Outer diameter
I	Inner gear		
W	Without gear	1	50Mn Q+T
		2	42CrMo Q+T
B	Ball		
C	Cross roller	F	Series
20	Size ball/roller		

Installation must be carried out with great care and by a professionally trained person. Improper installation negatively affects performance and safety.

Cleaning

Remove external corrosion protection with standard cold solvents (e.g. naphtha etc.). Avoid contact with seals and raceway.

Mounting

The mounting surface must be flat and free of contaminants (e.g. paint, weld spatter etc.).
The inner and outer rings of the slewing ring must lie flat and across the entire width of the connecting structure.

Table 1 – Permissible flatness and angular deviation of surfaces

Diameter Raceway (mm)		250	500	750	1000	1250	1500	2000
Flatness deviation including angular deviation of each mounting surface (mm)	Ball (4-points contact)	0,08	0,10	0,13	0,15	0,18	0,19	0,22
	Cross roller	0,06	0,08	0,09	0,10	0,11	0,13	0,15

The deviations may only be reached once per sector of 180°. The angle deviation relates to a flange width of 100 mm and may only amount to half of the table value.
In case of deviation from the flange width of 100 mm, the value can be calculated proportionally.

Setup for assembly

Verify that the slewing ring is completely supported by the structure. Position the slewing ring on the mounting surface. For optimum functioning, both rings of the slewing ring are marked with different markings. The hardening gap marked with an “S” (always fill plug position) must be outside the load zone on the slewing ring with point load, i.e. the marking must be positioned at 90° perpendicular to the load direction of the engaging load.

On geared slewing rings, the point with the highest eccentricity of the gearing is marked with green paint. The tooth clearance is adjusted at this point using a feeler gauge or plumb line. To avoid unacceptable pressure on the tooth flanks, the minimum value of the flank clearance between the pinion and the gear ring should be approx. 0.03 - 0.04 x module.

After tightening the bolts, the tooth clearance must be checked again around the entire circumference.

Fastening bolts

The safe functioning and service life of the slewing ring are influenced by the bolt connection. It is therefore necessary to adhere to the specified number, quality, and size of the bolts.

The support surface of the threaded part of the bolt and of the nut must not have any chamfered corners. A chamfered corner causes an additional alternating bending load, which has a negative effect on the service life of the bolt
In addition, the mounting holes of the bearing rings and the connecting structure must match, otherwise this will cause stress in the bearing.

When using bolts with a higher quality class than 8.8, hardened washers in accordance with DIN 6916 are required under the bolt head and nut. Due to the high clamping force of the bolts, this otherwise leads to material yielding and thus to a reduction in bolt tension and the resulting loosening of the bolts. Only with hardened slewing rings the hardened washers can be omitted.

Assembly and fastening

The thread of the bolts must be greased. For geared slewing rings, the non-geared ring must generally be fastened first.
Lightly tighten the bolts and then turn the ring that is not yet fastened several times without jerking. After this, the bolts must be tightened crosswise according to the table value. The loose ring must be rotated approx. 15° during tightening, which ensures correct running of the slewing ring during operation. Bolts > M30 must always be tightened using a hydraulic tensioning device. The ring that is not yet attached must be bolted to the connecting structure as described above.
The actual tightening torques for the bolts may differ from the table values due to factors that cannot be influenced, such as more or less heavily greased threads.

Locking and spring washers must not be used under any circumstances! The bolts are secured by the preload of the bolts. Due to material stresses, welding work on the slewing ring is not permitted.

Clearance

In order to determine the rejection value, the initial play must be measured immediately after assembly and recorded.

Wear limits for increased axial (tilt) play:

Ball diameter	Increased clearance
14 mm	initial + 1.1 mm
16 mm	initial +1.2 mm
20 mm	initial +1.3 mm
22 mm	initial +1.4 mm
25 mm	initial +1.5 mm
32 mm	initial +1.7 mm
40 mm	initial +2.0 mm

Table 2
A tightening torque table for bolts up to M30 based on VDI 2230 μK = 0,14 ; μG = 0,125

Bolt Size	Tightening torque (Nm) for bolt grade	
	8.8	10.9
M10	45	63
M12	78	117
M14	126	184
M16	193	279
M20	387	558
M24	666	954
M27	990	1395
M30	1260	1800

Inspection bolts

Approximately 100 operating hours after initial installation, the bolts must be checked for the required tightening torque due to settling. Thereafter, every 700 operating hours, but at least twice a year. The bolts must be tightened when the slewing ring is completely unloaded, i.e., free of radial force and without overhanging torque.
The inspection interval may be changed due to special use and specifications from purchasing organizations.

Permissible circumferential speed

For four-point contact slewing rings, the permissible circumferential speed is 1 m/s. If the slewingring need to be used at a higher speed, please consult us. Special measures are required for this.

Lubrication

Water-repellent lithium soap grease in accordance with DIN 51825 TI of NLGI class 2 DIN 51818 should be used for the raceway.

Lubricating oils Typ B in accordance with DIN 51513 should be used for the gearing.

The lubrication intervals depend largely on environmental influences and operating conditions (bearing load, speed) of the slewing ring.

Under normal use, the lubrication interval should not be less than 100 hours. However, if the number of operating hours per week exceeds 70 hours, the lubrication interval must be limited to 50 hours.

In aggressive and highly contaminated environments, lubrication should also be carried out every 50 hours. Enough grease should be pressed into the lubrication points one after the other to squeeze out the old grease. A new circle with fresh lubricating grease should then form around the entire seal. Lubrication should be carried out while slowly rotating the slewing ring.

The slewing rings must not be exposed to “the elements” and must be installed as soon as possible.

If the expected storage time exceeds twelve months, it is recommended that surfaces that are not normally treated should also be treated. On request, it is possible to treat the surfaces with a protective oil that can be washed off with naphtha or degreaser.

The running surfaces are generally supplied with a type of lubricant specified in the lubrication instructions. The gearing, on the other hand, are not lubricated.

The slewing rings are generally packaged on pallets or in boxes and wrapped in foil.

Disclaimer
All data has been thoroughly checked for accuracy. However, we cannot accept responsibility for any incorrect or incomplete data. Dimensions and construction are subject to change. Please consult Bönnekamp for feedback, advice, selections, and stock items. Many more models (also from stock) are available outside of this catalogue.

BONNEKAMP-EU.COM

Authorized distributor

Industrievertretung Miebach GmbH

Landsberger Str. 10 · 51491 Overath
Tel. 02206 1424 · info@iv-miebach.de
www.iv-miebach.de

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