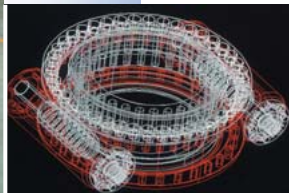


**ST 105 E**

**Sleew Drive**  
Product Catalog

# Strong Partnership

Strong Partnership



The strong partnership IMO has with Brück GmbH in Saarbrücken for seamless rolled rings and Brück AM in Zamsrk, Czech Rep., for CNC pre-machining, enables IMO to present a line of high performance, high quality Slewing Rings and Slew Drives.

Brück is running five rolling mills with a monthly capacity up to 3,500 tons (7,700,000 lbs)!

A strong partnership is created by Brück owners holding a 50 percent stake in IMO's equity. For you as our customer, this enables IMO to be a fast, flexible and reliable Slewing Ring and Slew Drive manufacturer.





## Preface & Imprint

IMO has developed, manufactured and sold innovative Slew Drives to global customers for many years.

Our range of products is presented in this catalog.

Our wide range of standard size Slew Drives is unique on the market.

Special designs are also available, please contact our Engineering Department for assistance (the contact details are on the back of the catalog).

This catalog has a reference number on the front cover. Please always check this is the latest edition before using the information contained within it.

You will find the "Application Data Sheet" on page 108/109 in this catalog. If you require assistance with any Slew Drive application, please fill in this form. This gives us an overview of the application and represents a record of your requirements.

Slew Drives are high-tech products. They have to meet your requirements exactly and perform in the environmental conditions of your application. Therefore, it is important to fill in the form completely, with as much detail as possible and send it to us. You will then receive our recommendation for the right IMO product for your application and gain the benefit of years of experience meeting challenging customer requirements and operating conditions!

The application data sheet can also be downloaded from our homepage [www.goimo.com](http://www.goimo.com).

You can find information on our Slewing Ring product line in the Slewing Ring catalog DV 105 E, which we will send you on request. Further details of our company, products, and their application and utilization can be found in our detailed brochure IM 104 E.

IMO terms and conditions shall apply to all quotations and purchase orders.

Further we would like to ask you to follow closely our Installation and Maintenance Instructions which contain important data. You can find these on pages 46 to 51 of this catalog, or on our homepage which has the latest revision.

The observance of our Installation and Maintenance Instructions is important for the reliability and safety of our product and has a great influence on the service-life.

The Installation and Maintenance Instructions are also available in other languages. Please contact us or visit our homepage if you need the instructions in a different language.

Our product range and designs are being continually updated and revised. Please always check with us for the latest information.


All the information in this catalog has been carefully evaluated and checked. We cannot accept responsibility for omissions and errors in this publication.

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Ensheim/Saarbrücken

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The innovative business group IMO, with headquarters in Gremsdorf, Germany, has been designing, manufacturing and supplying Slewing Rings and self-contained Slew Drives for more than 16 years. IMO currently holds EN ISO 9001:2000 approval and has been certified since 1995.

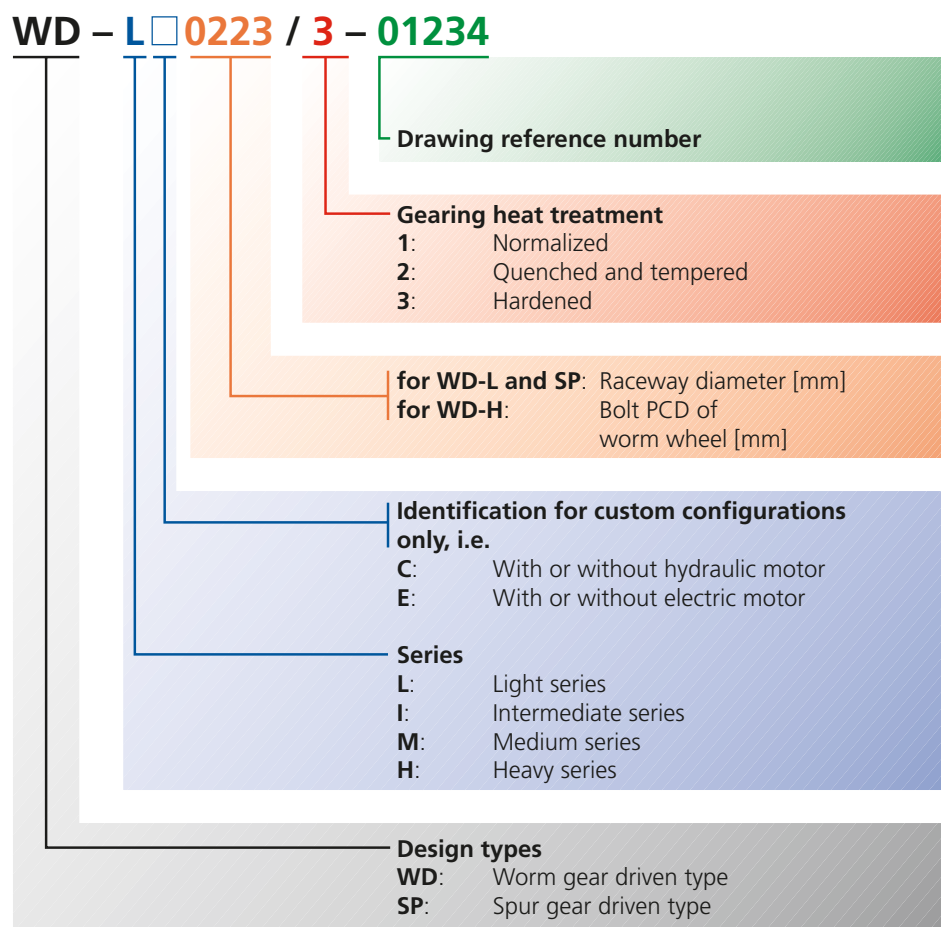
IMO, with its modern manufacturing facilities, manufactures and delivers over 10,000 Ball and Roller Slewing Rings and Slew Drives each year, in diameters up to 5,200 mm (204 in). IMO is a globally recognized supplier of Slewing Rings and patented Slew Drives.

IMO is proud to have been recently named one of Bavaria's Top 50 companies by the State Minister of Economy. IMO has also earned several technical awards at international exhibitions for new and innovative product introductions.



 Rolling mill  
Ensheim/Saarbrücken









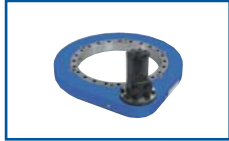





**Nomenclature** **Table of Contents**



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## Product Line Overview/Comparison

Design types	Series	Sizes	Raceway diameters  DL [mm]	Maximum torque <sup>1)</sup>	Maximum tilting moment <sup>1) 2)</sup>	Load carrying capacity <sup>1)</sup>		Weight <sup>1)</sup>	Clearance
				$M_{d \max}$ [Nm]	$M_{k \max}$ [kNm]	Static axial load rating $C_{0 \text{ ax}}$ [kN]	Static radial load rating $C_{0 \text{ rad}}$ [kN]	G [kg]	
		0223	223	from 9303 to 42824	from 28 to 318	from 547 to 2364	from 204 to 883	from 48 to 250	Preloaded raceway system
		0343	343						
		0419	419	from 4010 to 152610	from 51 to 1052	from 1208 to 7199	from 451 to 3528	from 63 to 480	Preloaded raceway system
		0478	478						
		0625	625	from 4010 to 152610	from 51 to 1052	from 1208 to 7199	from 451 to 3528	from 63 to 480	Preloaded raceway system
		0146	205						
		0220	280	from 4010 to 152610	from 51 to 1052	from 1208 to 7199	from 451 to 3528	from 63 to 480	Preloaded raceway system
		0300	370						
		0373	452	from 4010 to 152610	from 51 to 1052	from 1208 to 7199	from 451 to 3528	from 63 to 480	Preloaded raceway system
		0490	569						
		0645	725	from 4010 to 152610	from 51 to 1052	from 1208 to 7199	from 451 to 3528	from 63 to 480	Preloaded raceway system
		0311	311						
		0411	411	from 3118 to 9702	from 14 to 146	from 208 to 733	from 89 to 313	from 45 to 120	Radial clearance 0 - 0,2 mm Axial tilting clearance 0 - 0,4 mm
		0541	541						
		0641	641	from 3462 to 5900	from 22 to 118	from 426 to 922	from 156 to 394	from 42 to 85	Radial clearance 0 - 0,2 mm Axial tilting clearance 0 - 0,4 mm
		0741	741						
		0841	841	from 8622 to 25482	from 31 to 299	from 447 to 1570	from 191 to 672	from 80 to 200	Radial clearance 0 - 0,2 mm Axial tilting clearance 0 - 0,4 mm
		0941	941						
		1091	1091	from 8622 to 25482	from 31 to 299	from 447 to 1570	from 191 to 672	from 80 to 200	Radial clearance 0 - 0,2 mm Axial tilting clearance 0 - 0,4 mm
		0455	455						
		0555	555	from 27673 to 51888	from 144 to 548	from 1432 to 3006	from 535 to 1123	from 190 to 320	Radial clearance 0 - 0,25 mm Axial tilting clearance 0 - 0,4 mm
		0655	655						
		0755	755	from 27673 to 51888	from 144 to 548	from 1432 to 3006	from 535 to 1123	from 190 to 320	Radial clearance 0 - 0,25 mm Axial tilting clearance 0 - 0,4 mm
		0855	855						
		0955	955	from 27673 to 51888	from 144 to 548	from 1432 to 3006	from 535 to 1123	from 190 to 320	Radial clearance 0 - 0,25 mm Axial tilting clearance 0 - 0,4 mm
		0955	955						

1) The data refers to the minimum and maximum diameter per series

2) The tilting moment capacity for each unit should be confirmed by referring to the limiting load diagram for each individual model.

## Slew Drive – what is it? What does it do? Where is it used?

A complete system, ready to install, consists of

- A Ball or Roller Slewing Ring to handle simultaneously occurring radial, axial and moment loads
- Hydraulic or electric motor to pitch or rotate the Slewing Ring
- A totally enclosed housing

**Bolt, connect, run... done!**



### Advantages of IMO Slew Drives

- Compact packages for space saving installations
- Maximum load capacity in compact design
- Extended life
- Reduced maintenance costs
- Easy to integrate into existing applications
- Modular construction allows very quick modifications
- Special designs available

### Used by customers around the globe in:

- Vehicle and crane steering systems
- Manlift systems for boom and basket rotation
- Light crane systems
- Rotation of attachments such as excavators, grabs and fork lifts
- Handling equipment (automation systems)
- Loading and unloading devices
- Positioning systems / turntables

**IMO -  
the driving force for  
innovative technology**



**Slew Drives**  
Introduction

#### A complete unit

- All components guaranteed to work together
- Easy to order - simple to install
- Eliminates component assembly
- One source - total system responsibility

#### Easy selection

- Complete line of various standard sizes
- Immediate, off-the-shelf availability
- Online sizing and selection programs available at [www.goimo.com](http://www.goimo.com)
- Extensive technical support

#### IMO Slew Drive in a totally enclosed housing

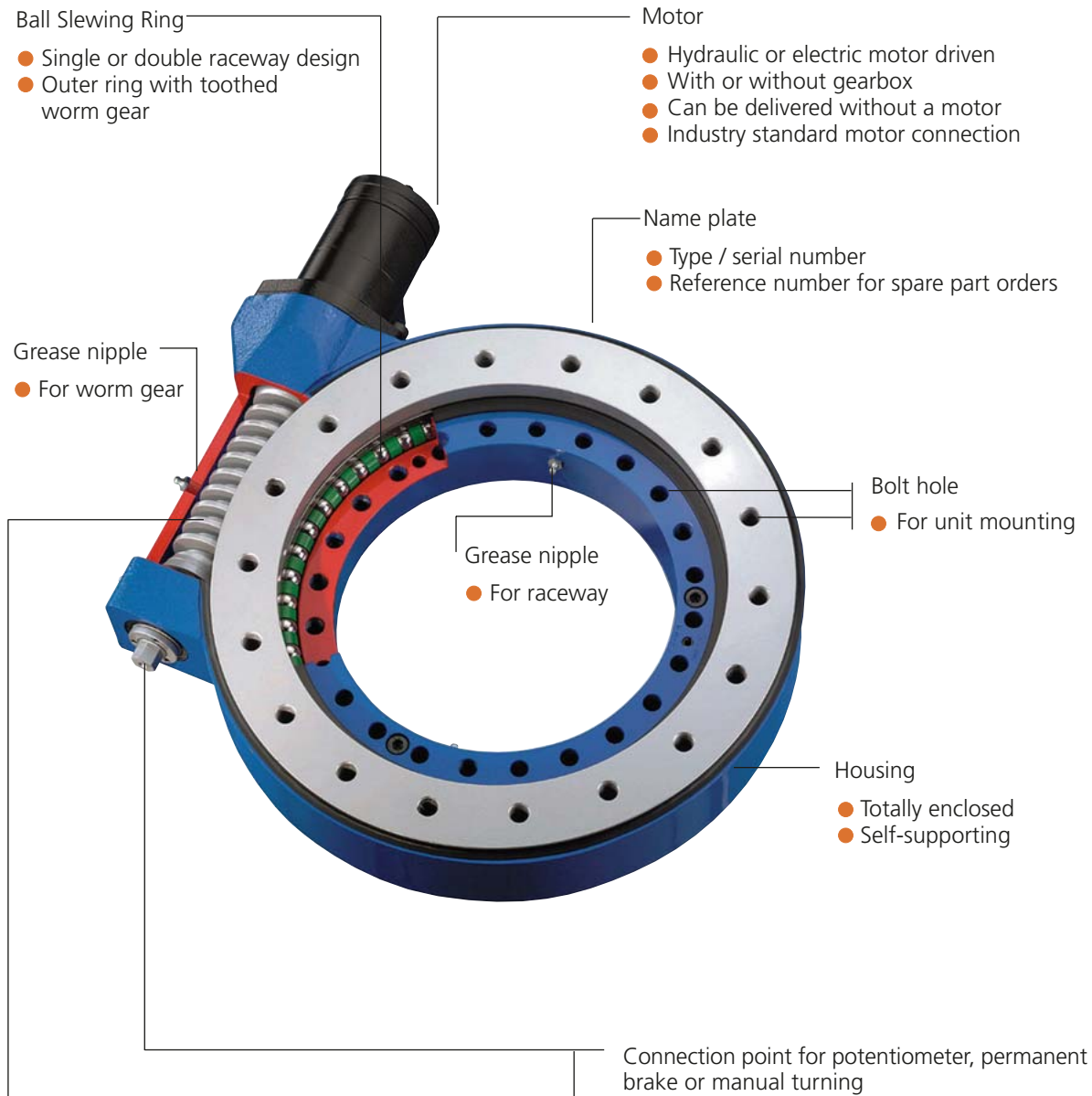
- Slew Drive protected from:
  - Contamination
  - Damage
  - Loss of lubrication
- Provides:
  - Extended life
  - Reduced maintenance costs
  - Enhanced operator safety
  - Sleek, clean appearance

#### Wide range of load capacities

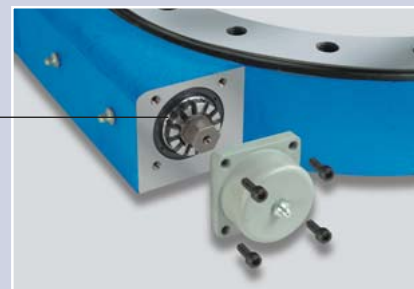
- Peak torque up to 152610 Nm
- Tilting moment load up to 1052 kNm
- Raceway diameters: 205 up to 1091 mm
- Special designs are also available in larger diameters



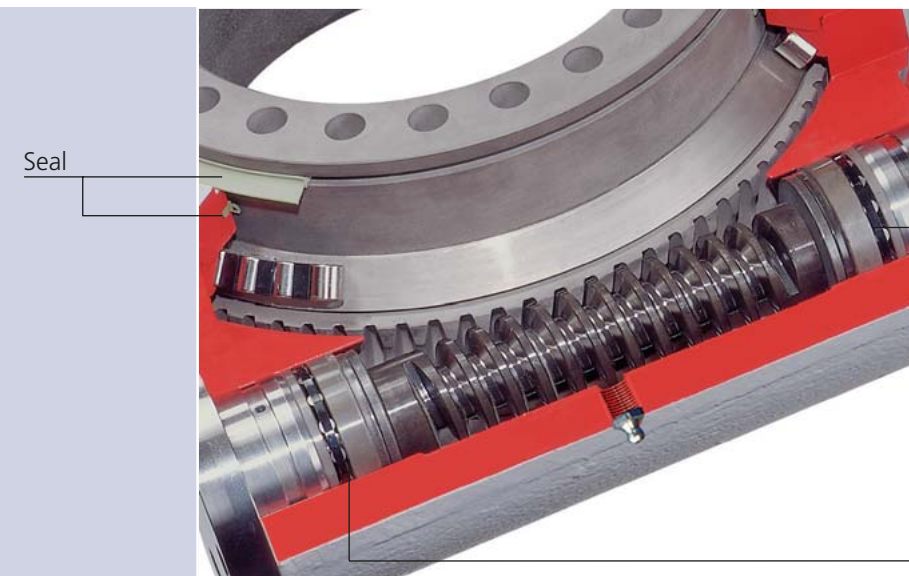
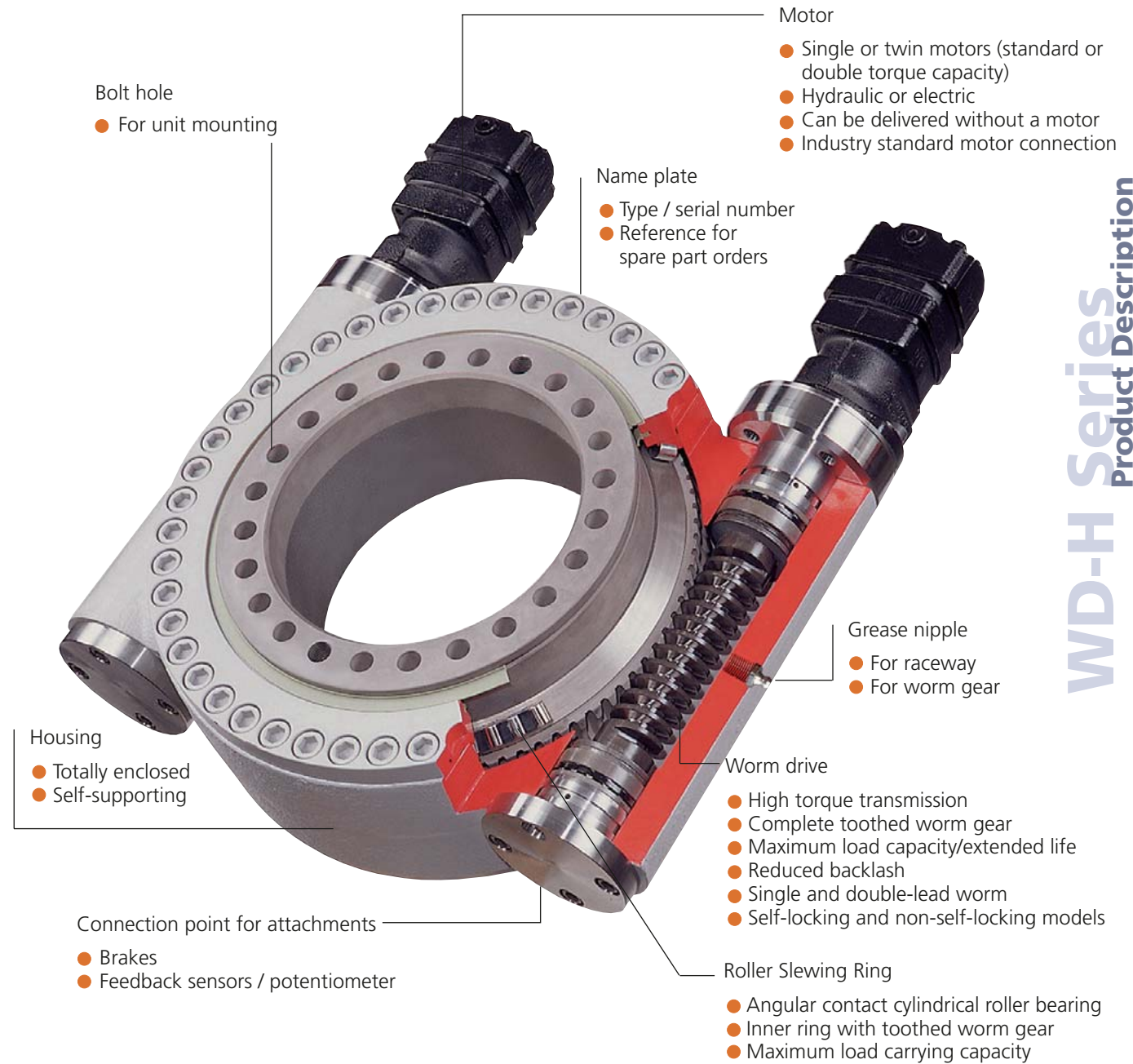
**WD-L Series**  
Product Description



- Worm drive**
- High torque transmission
  - Complete toothed worm gear
  - Maximum load capacity and extended life
  - Reduced backlash
  - Self-locking and non-self-locking models



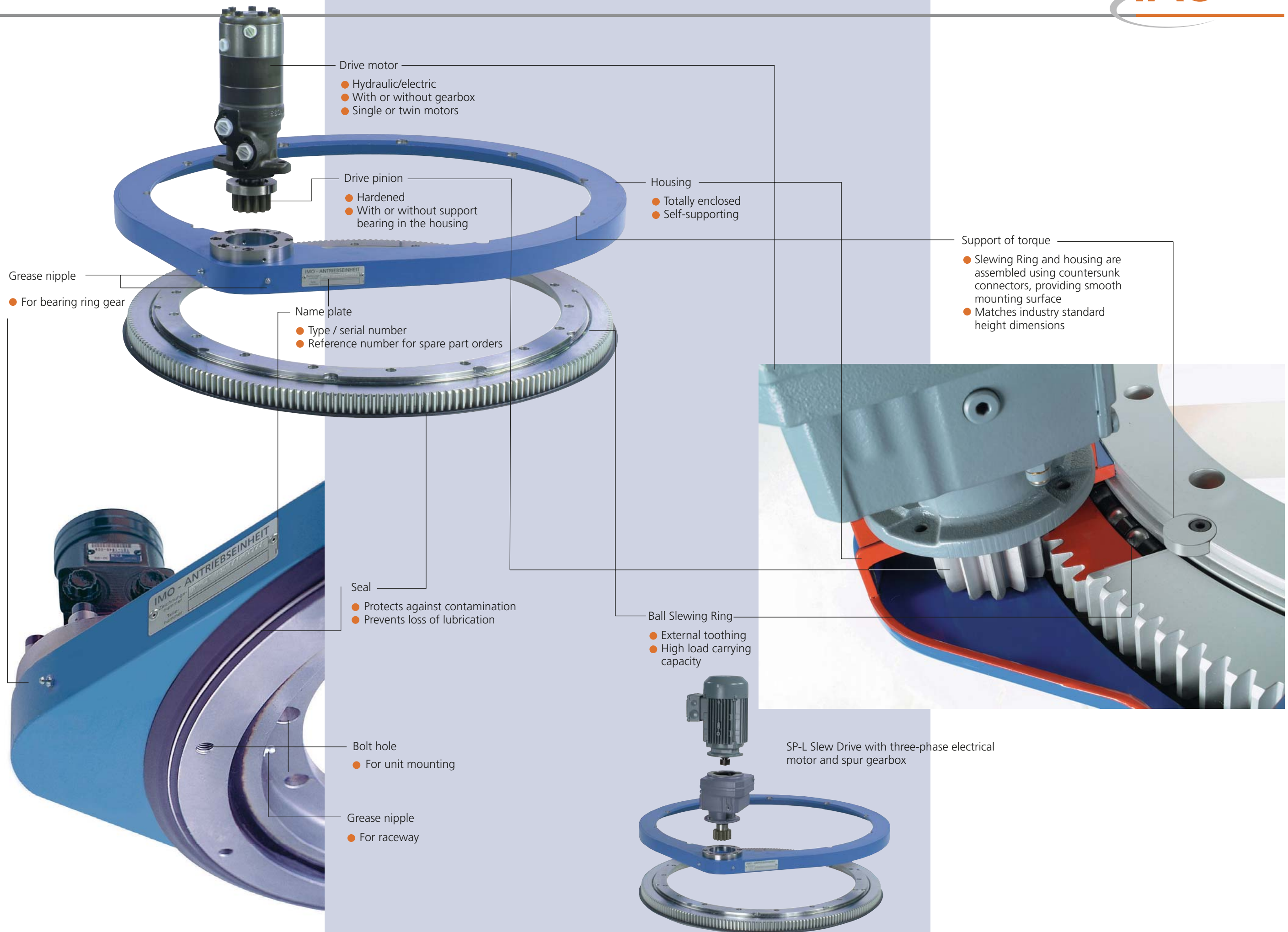
**WD-H Series**  
Product Description



Axial bearing for the worm shaft



SP Series  
Product Description



- Drive motor
- Hydraulic/electric
  - With or without gearbox
  - Single or twin motors

- Drive pinion
- Hardened
  - With or without support bearing in the housing

- Housing
- Totally enclosed
  - Self-supporting

- Support of torque
- Slewing Ring and housing are assembled using countersunk connectors, providing smooth mounting surface
  - Matches industry standard height dimensions

- Grease nipple
- For bearing ring gear

- Name plate
- Type / serial number
  - Reference number for spare part orders

- Seal
- Protects against contamination
  - Prevents loss of lubrication

- Ball Slewing Ring
- External tothing
  - High load carrying capacity

- Bolt hole
- For unit mounting

- Grease nipple
- For raceway

SP-L Slew Drive with three-phase electrical motor and spur gearbox



WD-L Slew Drives from IMO have an impressive combination of unique features.

WD-L series comprises 7 standard models

WD-L Slew Drives  
Overview



WD-L 0223 Single Row Slewing Ring

WD-L 0223 Double Row Slewing Ring

WD-L 0343 Single Row Slewing Ring

WD-L 0419 Single Row Slewing Ring

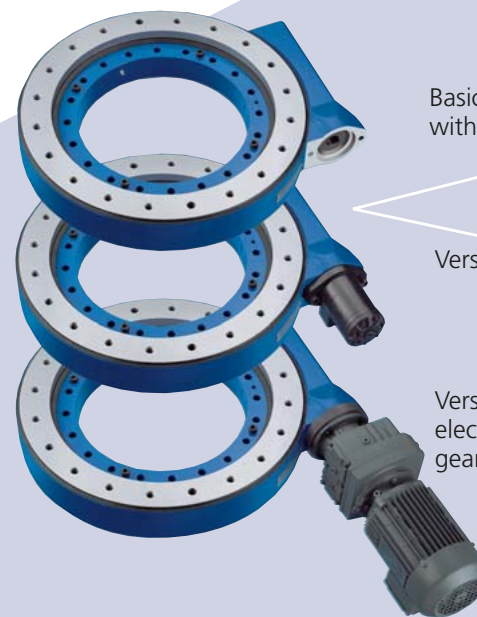
WD-L 0419 Double Row Slewing Ring

WD-L 0478 Single Row Slewing Ring

WD-L 0625 Single Row Slewing Ring

IMO Slew Drives, with a wide range of **industry standard sizes** and torque capacities offer fast, cost effective slewing solutions.

Modular system enables the utilization of various motors (e.g. WD-L 0419)



Basic version WD-L 0419 without motor

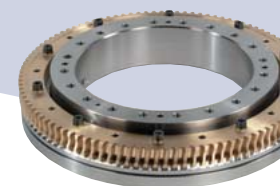
Version with hydraulic motor

Version with a three-phase electrical motor and spur gearbox

Drives are easily modified to meet special operating conditions.



Standard steel ring of a Double Row Slew Drive WD-L 0419, optimized for a high capacity, short cycle application



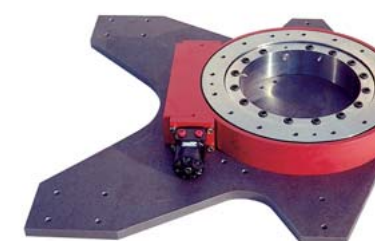
Modified worm gear of the WD-L 0419 made of bronze for applications with extended duty cycle



Worm shaft with appropriate worm gear (WD-L 0419)



WD-L 0419 with flanged spring energised multi-plate disk brake and motor, in a manlift system



The subsystem consists of a WD-L special design which is bolted to a base plate for a paver stone laying machine turning device



WD-L 0343 with the attached potentiometer, used in manlift systems



Frameless worm gear with integrated Slewing Ring suitable for extreme high temperatures for a forklift rotator (IMO is providing the worm gear and the customer is assembling them in its own housing)

## Our WD-H family - which model do you need?

WD-H series comprises **6 standard sizes**

**Standard units** easily adaptable to meet specific applications (i.e: WD-H 0300)

WD-H Slew Drives  
Overview



WD-H 0146

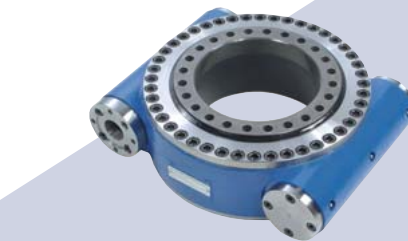
WD-H 0220

WD-H 0300

WD-H 0373

WD-H 0490

WD-H 0645



Basic version WD-H 0300 without motor



Version with single motor



Version with twin motors (double torque capacity) available from size WD-H 0300 and above

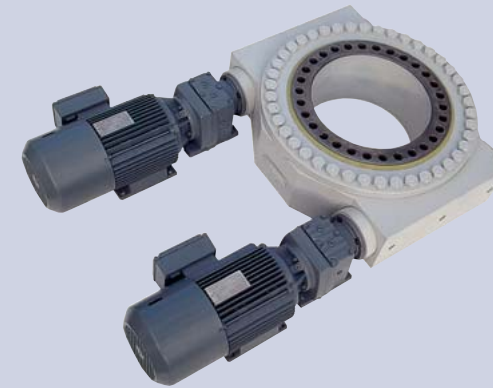


Version with twin motors and additional brakes (mounted between motors and housing)



Version with twin motors and flanged feedback sensors (gearing potentiometer)

Best possible application solution to meet our customers **design requirements**



WD-HE 0373 with twin three phase electrical motors and spur gearboxes



WD-HC 0373 bronze worm gear for increased operating life expectancy (amusement park ride)



WD-HC 0220 with integral clutch to protect unit from overloading (for a rock drill rig)



WD-HC 0300 with special housing (seamless rolled, quenched and tempered steel) and a special designed worm gear pair for a higher capacity load

### The WD-H series is unique on the market!

Our design solution is protected by international patents, allowing IMO to offer the unique combination of high torque and tilting moment capacities in the industries smallest footprints.



## SP-Slew Drives with totally enclosed housing.

Standard Slewing Ring mounting hole patterns provide full product interchangeability.

### Overview

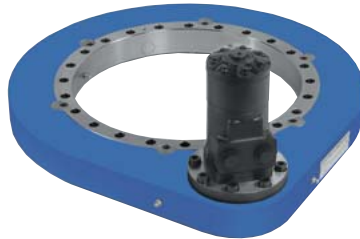
SP-L



SP-L, light series

- mounting hole patterns and height identical to IMO Ball Slewing Ring series 920
- ball diameter 20 mm
- module 4 mm
- direct drive

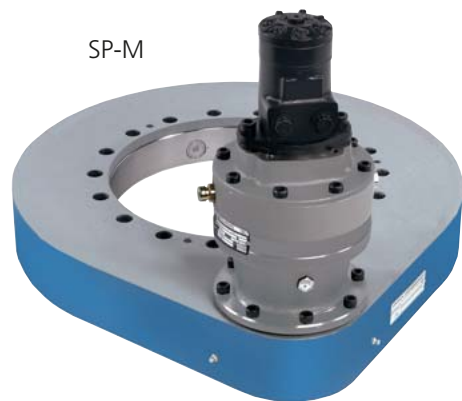
SP-I



SP-I, intermediate series

- mounting hole patterns and height identical to IMO Ball Slewing Ring series 120
- ball diameter 20 mm
- module 4 mm
- direct drive

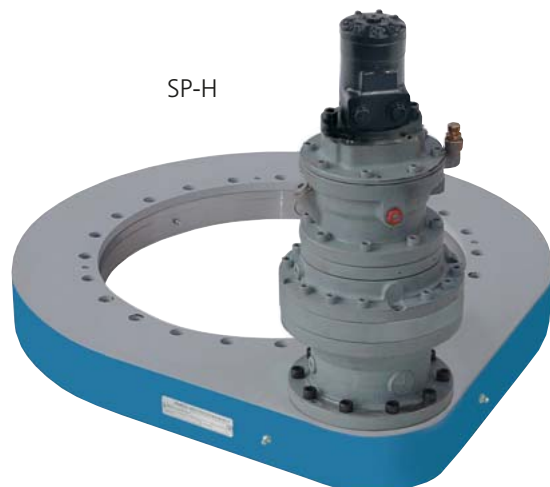
SP-M



SP-M, medium series

- mounting hole patterns identical to IMO Ball Slewing Ring series 120
- height increased by base plate thickness of 15 mm
- ball diameter 20 mm
- module 6 mm
- one or multistage planetary gearbox

SP-H



SP-H, heavy series

- mounting hole patterns identical to IMO Ball Slewing Ring series 125
- height increased by base plate thickness of 15 mm
- ball diameter 25 mm
- module 8 mm
- one or multistage planetary gearbox

### Examples of customer initiated special designs

SP-LE 0841



SP-L series Slew Drive with electrical motor and spur gearbox for handling equipment.

SP-HC 0755



SP-H series Slew Drive with two motor modules (hydraulic motor/planetary gearbox) for a ship rescue crane.

SP-HC 0655



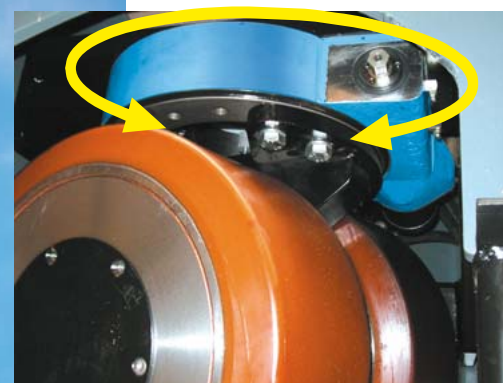
Custom design with a feedback potentiometer as well as a planetary gearbox. Application is a rotation device for a special excavator attachment.



Applications  
Steering Gears For Special Vehicles



◁ **Heavy load transporters** present big technical challenges. Each single axle is steered by an IMO Slew Drive requiring the maximum axial, radial and tilting moment capacity. The **WD-H 0300** with steering torques of 27000 Nm is an excellent solution.



△ **Side loader** with the steering gears of the **WD-L 0223** and **WD-L 0419** series; the high operating time requires the use of bronze worm gears.

Straddle carrier with eight independently steered axles.



Applications  
Smart Steering Solutions



The combination of IMO steering gears with additional hydraulic, electrical and electromechanical components and the system integration into the vehicle enables an effective solution, including **“steering by wire”**.



We stand ready to work closely with an experienced design team to provide the optimum **Slew Drive solution**.

Unlike typical hydraulic push rod actuated steering solutions IMO Slew Drives offer 360 degree steering capability.



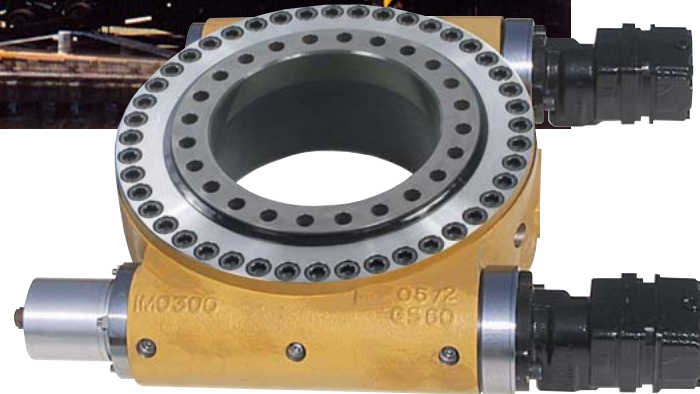


With the capacity to handle extreme tilting moments, high output torques, all in a compact design, the IMO **WD-H Slew Drives** are especially suited as **steering devices**.

In addition, integrated position feedback sensors support computer controlled steering systems.

Using IMO Slew Drives, cranes and special vehicles achieve **unique maneuvering capabilities** including turning on the spot.

## Applications Steering Gears For Undercarriages



Undercarriage of a **harbor mobile crane** with **WD-HC 0300** steering gears; In combination with the hydraulic motor, the gear potentiometer indicates the position of the wheel.



In concrete factories, large **movable gantry cranes** displace heavy and bulky prefabricated concrete. With the Slew Drive **WD-HC 0645**, each axle can be turned individually. The steering torque required at the maximum load while turning on the spot is about 150000 Nm.



**Ship lifting** device to lift and place ships up to a weight of 650 tons. Eight Slew Drives of the **WD-HC** series carry this load capacity.





Small manlift on a crawler chassis with a **WD-L 0223** Slew Drive.

This bridge inspection equipment uses Slew Drive **WD-HC 0300** in the boom joint. The unit is able to accommodate the suspended loads and is fitted with a worm drive and multi-plate disk brake.

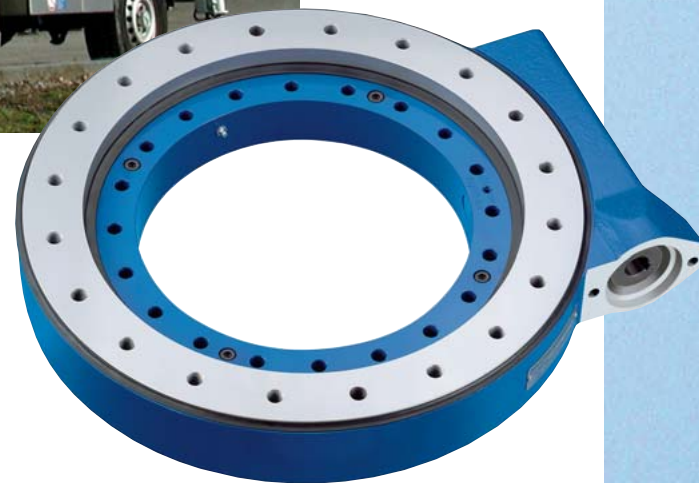


This working platform with a height of 35 m uses two IMO Slew Rings on a synchronous rotating **turntable** which are driven by an IMO **WD-HC 0146** Slew Drive.

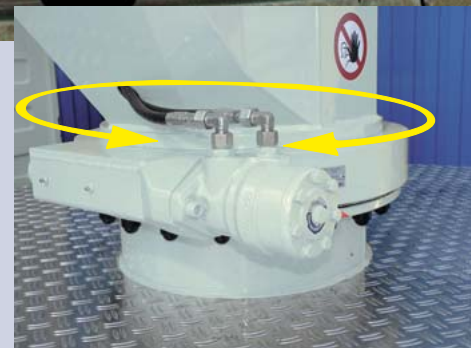


The high capacity and low profile of the **WD-L** series are perfectly suited for **manlift platforms**.

The wide variety of sizes in this series enables their use in many different kinds of platforms (heights ranging between 7 and 27 meters). Design standardisation "at its best"!



Combining low unit weight and high capacity, the Single and Double Row Slew Drives of the series **WD-L 0223** perfectly match **basket rotator requirements** of large manlift systems.



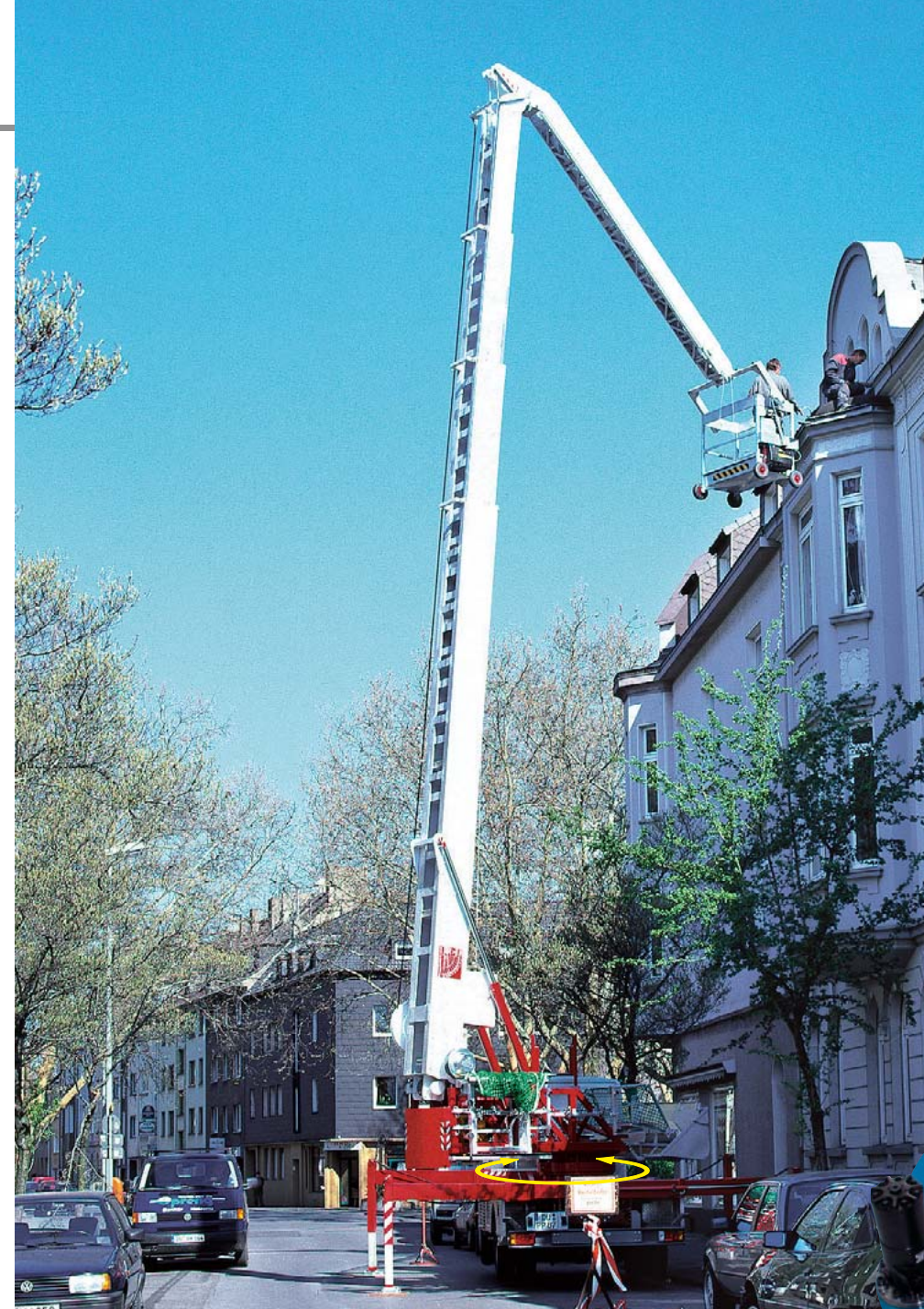
Telescopic working platform with a **WD-L 0419** Slew Drive.



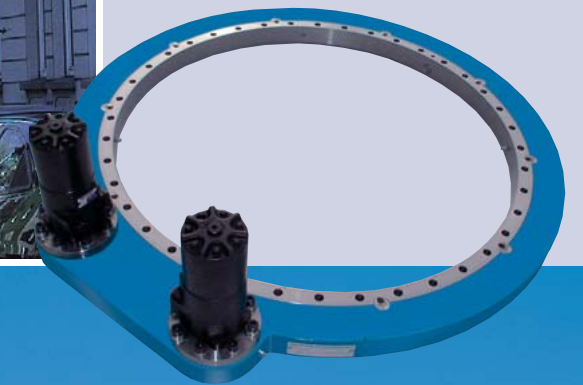
Applications  
Manlift Platforms



The IMO Slew Drive, model **WD-L 0478** is used for **railway slewing cranes** used to position track sections.



Applications  
Cranes



This functional but elegant twin worm Slew Drive **WD-H 0645**, is ideally suited for the slewing gear of a **yacht crane**.



Light cranes - the standard equipment of **service trucks**, using the IMO **WD-L 0343** Slew Drive (also available with special flanges).



The special series **SP-IC 0841** with two direct hydraulic motors was developed for this **special crane**, used for roof top operations.





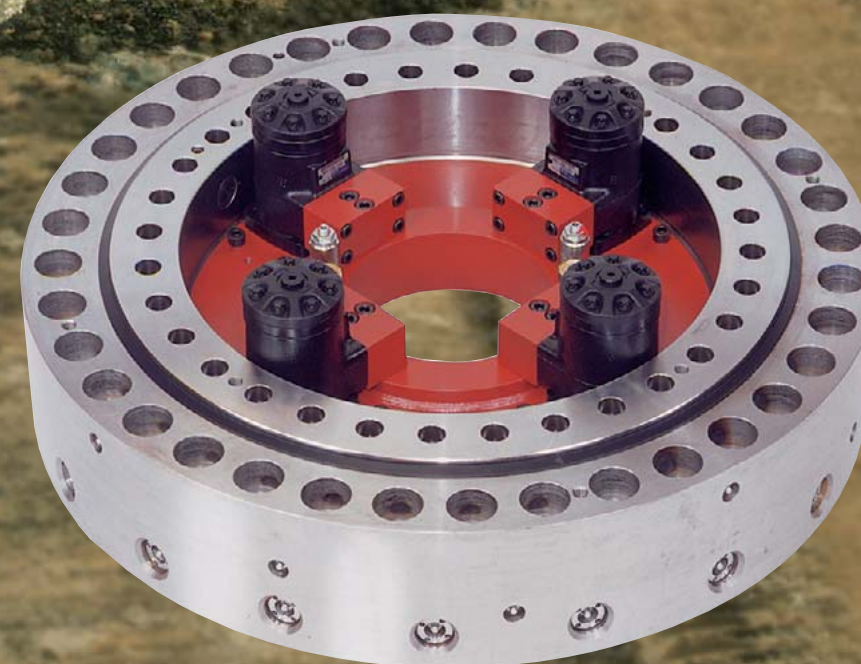
Cement mixer equipped with a conveyor belt with a length of 16.5 m, which is rotated with two **WD-LC 0419**; the considerable length of the belt leads to high tilting moments. Therefore a double row design with a reinforced housing is used.



This rotation and tilting device of a **front loader** uses an IMO Slew Drive, model **WD-LC 0419** with twin motors (double the torque).



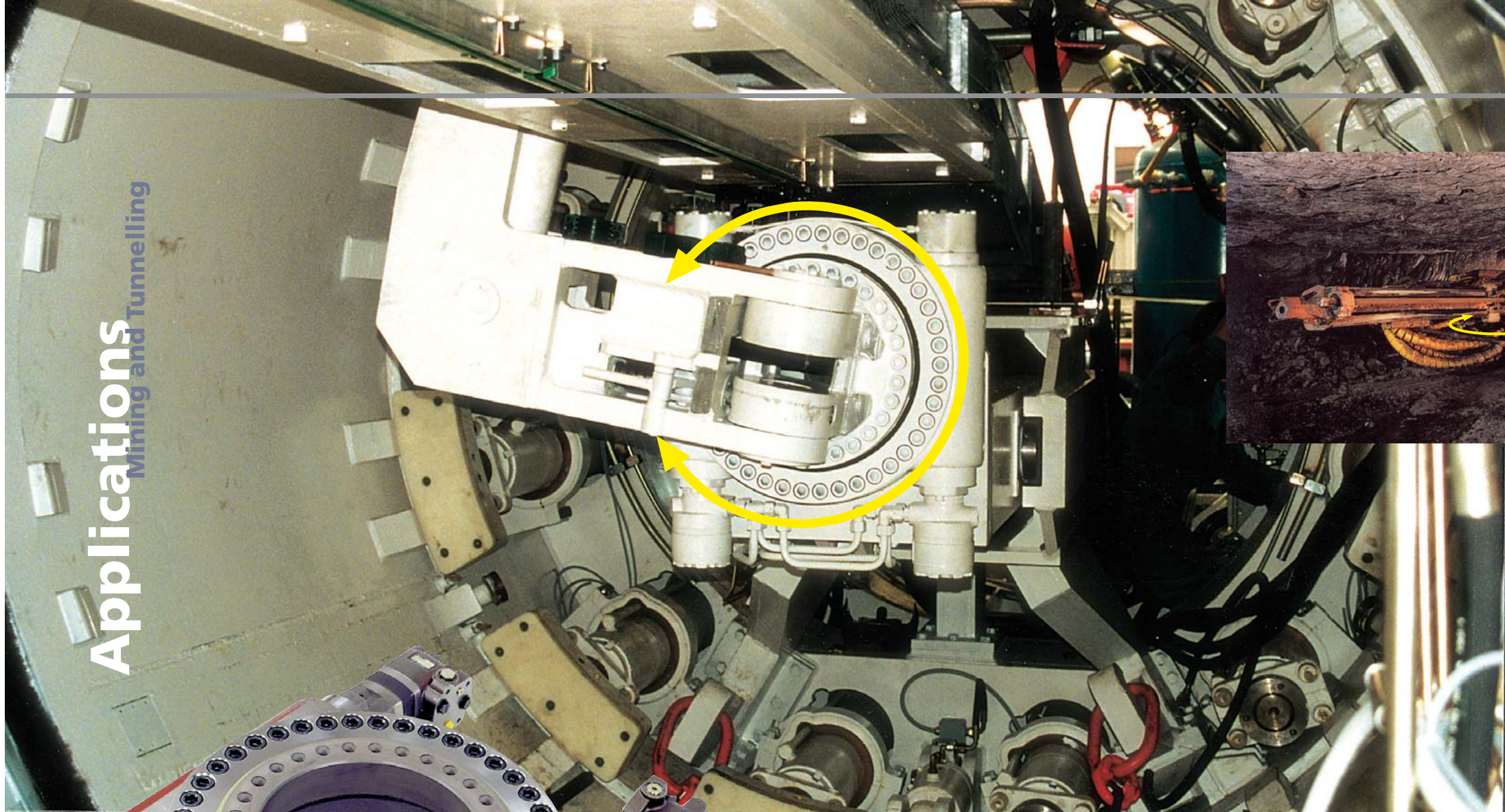
Cemetery excavator with the IMO Slew Drive **WD-L 0343**.



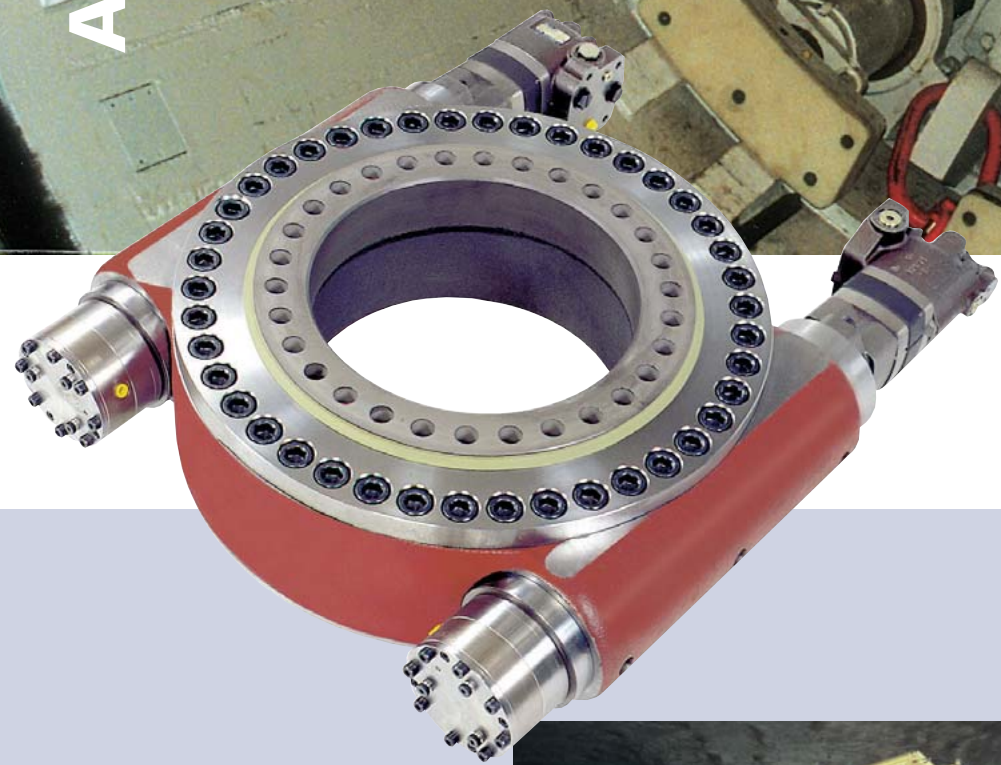
To protect the teeth of this **demolition equipment** from overload damages, a friction coupling is integrated in the spur gear driven Slew Drive **SP-OP 0580** (OP= "overload protected").



Applications  
Mining and Tunnelling



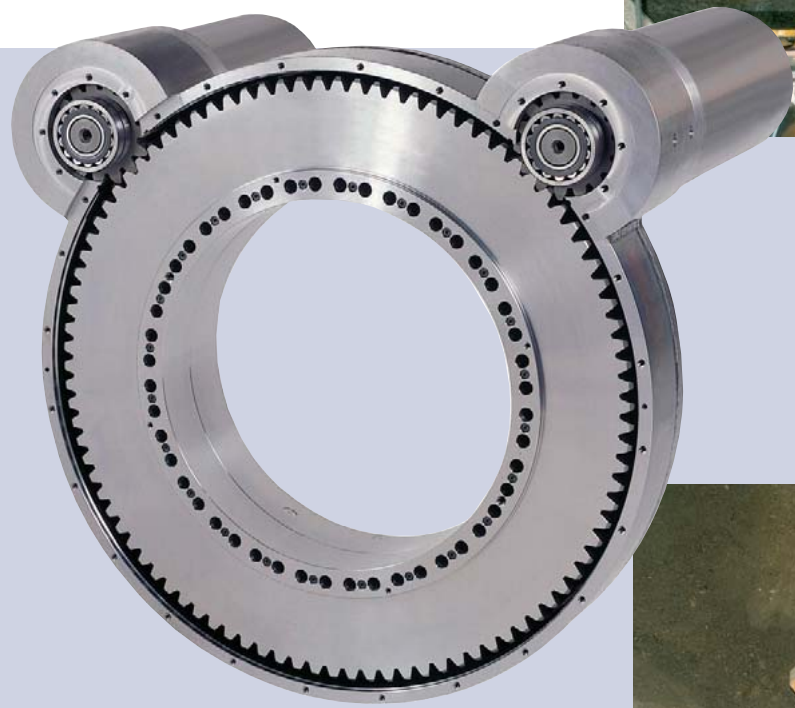
To ensure that the **blasthole boring tool** remains locked in place during the boring process, the **WD-HC 0220** shown has an integrated locking system with a position holding device.



Instead of a traditional large diameter toothed Slew Ring, this **manipulator** uses a compact Slew Drive **WD-HC 0373** with twin worm and locking brakes.



Working in aggressive environmental conditions, the Slew Drive **WD-HC 0373** is adapted for the use by a **crane in a salt mine**. Brakes ensure position holding at extreme crane decline.



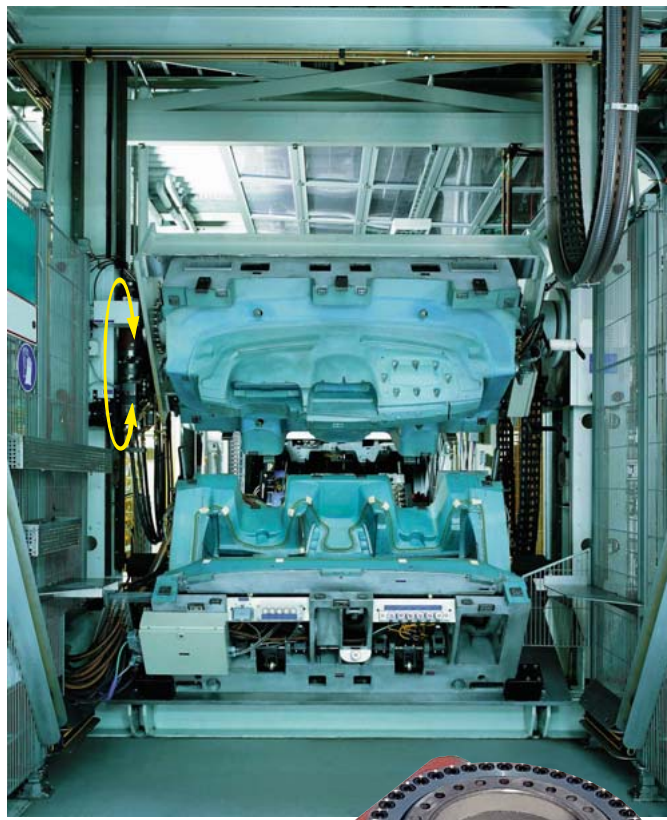
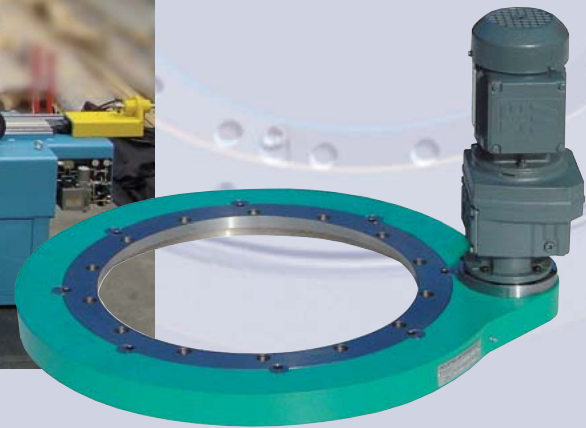
Slew Drive **SP-HC 0698** with hydraulic motors and gear boxes for turning an **excavator boom**, part of a cutter bar of a tunnel boring machine.







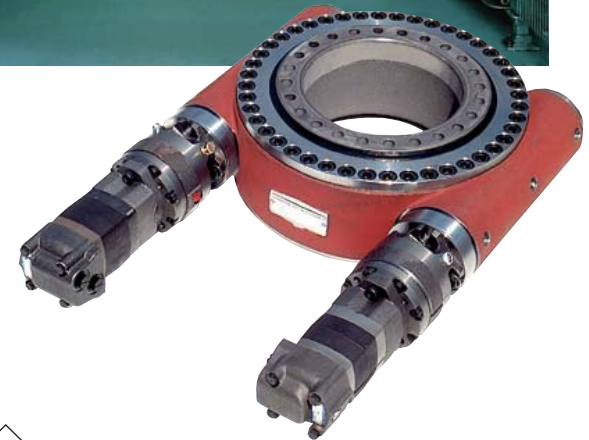
SP-Slew Drives are used in automation systems. Picture: Slew Drive **SP-LE 0641** with three-phase electrical motor and spur gearbox.



▽ **Manipulator** for turning concrete parts with Slew Drive **WD-HE 0373**.



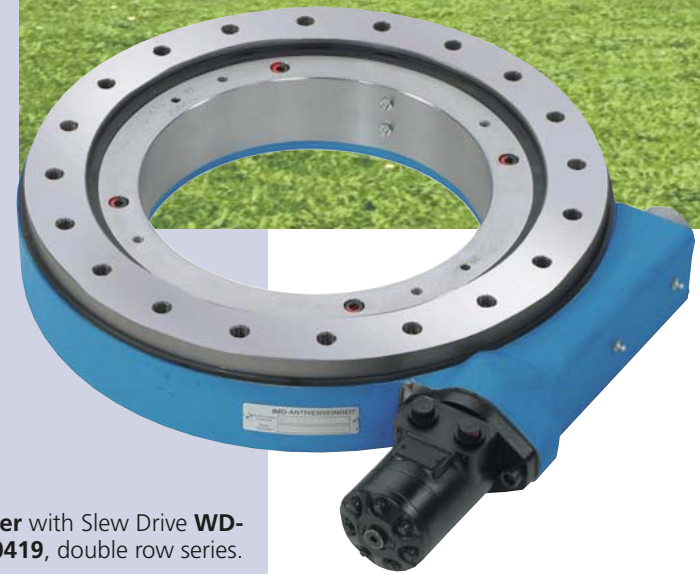
△ This is a **facility** to cover car fascia panels with leather. It contains Slew Drive **WD-HC 0300**. Because of its operating condition, it is fitted with a spring energised multi-plate disk brake.



**Applications**  
Positioning / Automation



**Bank mower** with Slew Drive **WD-L 0419**, double row series.



Slew Drives of **WD-series** fitted with electric motors used for the yaw and pitch controls of this **solar table**.



## Technical Information

### Symbols and units

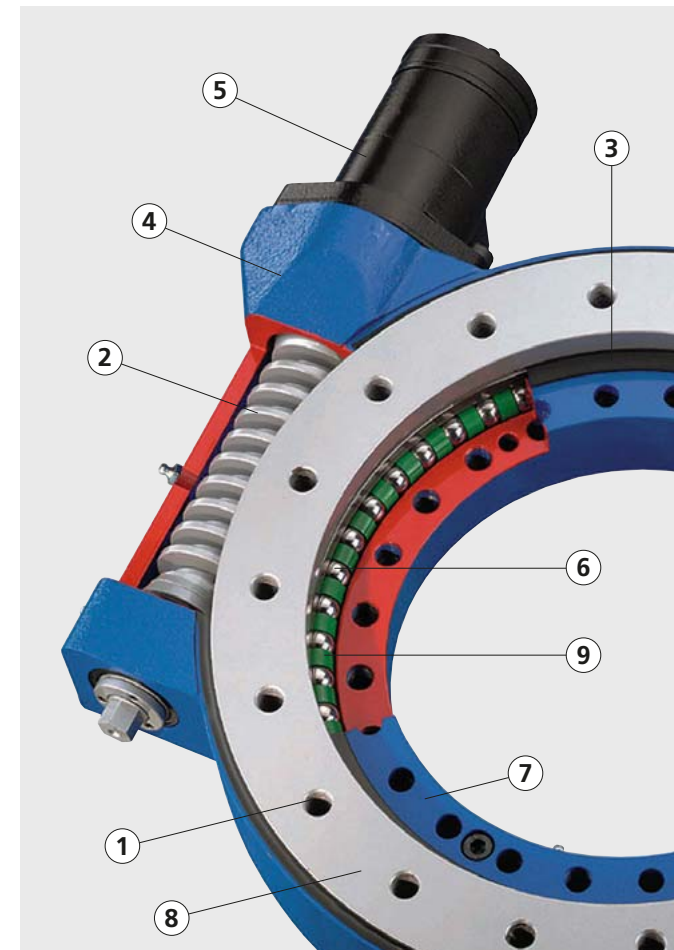
$B_h$	h	Basic rating life in operating hours	$M_k$	kNm	Equivalent tilting moment including all occurring impact loads and required safety factors, calculated from all axial and radial forces that cause the tilting effect
$C_{ax}$	kN	Basic axial dynamic load rating	$M_{kD}$	kNm	Equivalent tilting moment including radial load and application service factor for determining the load point in the limiting load diagram
$C_{rad}$	kN	Basic radial dynamic load rating	$M_W$	Nm	Friction torque of the Slew Drive under operating load in the installed state
$C_{0 ax}$	kN	Basic axial static load rating	$M_{WA}$	Nm	Friction torque of the Slew Drive, unloaded
$C_{0 rad}$	kN	Basic radial static load rating	$n$	rpm	Operating speed of Slew Ring
$D_L$	mm	Raceway diameter (see Product Overview P. 4/5)	$n_{perm}$	rpm	Permissible operating speed of Slew Ring
$ED_B$	%	Duty	$n_b$	—	Number of fastening holes per bearing ring
$ED_B \cdot$	%/min	Duty per minute	SF1	—	Series SP: Safety factor against tooth base fatigue Series WD: Safety factor against tooth wear
$ED_{max} \cdot$	%/min	Maximum permissible duty of rotation per minute (see diagram series description)	SFS 1	—	Series WD: Safety factor against tooth fracture
$f_a$	—	Application service factor	SFS 1.75	—	Series SP: Safety factor against static tooth base fracture
$f_{Md}$	—	Ratio of operating torque to maximum torque	$S_w$	—	Calculation safety factor 1.3 for wear diagram
$F_{ax}$	kN	Equivalent axial load including all occurring shock loads and required safety factors, calculated from all axial forces	Q	l/min	Oil flow
$F_{axD}$	kN	Equivalent axial load including application service factor for determining the load point in the limiting load diagram	$z_1$	—	Number of teeth, pinion
$F_{rad}$	kN	Equivalent radial load including all occurring shock loads and required safety factors, calculated from all radial forces; the effective gearing circumferential force has to be considered	$z_2$	—	Number of teeth, Slew Ring
$F_{rad max}$	kN	Limit value for checking frictional contact	$\alpha_A$	—	Bolt tightening factor
$F_{sp}$	kN	Initial preload on bolt	$\Delta p$	bar	Pressure differential
$G_w$	h	Limit value	$\delta_k$	mm	Tilting clearance increase
$i$	—	Gear ratio	$\delta_{k perm}$	mm	Maximum permissible tilting clearance increase
$m$	mm	Module	$\delta_p$	mm	Maximum permissible flatness deviation
$M_A$	Nm	Tightening torque for mounting bolts	$\delta_v$	mm	Maximum permissible deformation of mounting structure
$M_{dB}$	Nm	Operating torque	$\delta_w$	mm	Maximum permissible perpendicularity deviation
$M_{d nom}$	Nm	Nominal torque			
$M_{d max}$	Nm	Maximum torque			
$M_h$	Nm	Maximum holding torque			

### General

#### Function of Slew Drive

Slew drives comprise a highly robust Slew Ring provided with gear teeth (1), one or several toothed drive elements (2), a worm gear in this case, seal (3), housing (4) and a hydraulic or an electric drive (5). Slew Drives are designed for grease lubrication.

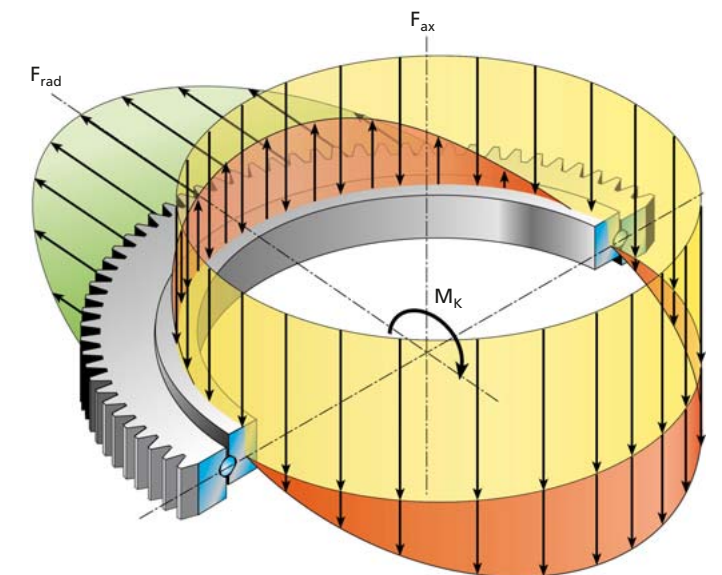
In a Slew Drive the rolling elements (6) carry the load between the inner ring (7) and outer ring (8). The raceway system's capacity is determined predominantly by Slew Ring design, the depth of hardening and the number and size of the rolling elements. Spacers (9) separate the rolling elements and minimise friction and wear.



#### Load distribution

Depending on external load, the load distribution contact and the angle around the rolling elements will vary.

- In the case of axial load, all rolling elements are loaded in the same direction.
- In the case of radial load, a segment of the rolling elements carries the load.
- In the case of tilting moment load, a segment on one side and a segment on the opposite side carry the load.
- Mostly, a combination of axial, radial and tilting moment loads occur.

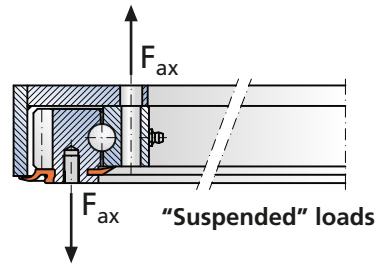




## Technical Information

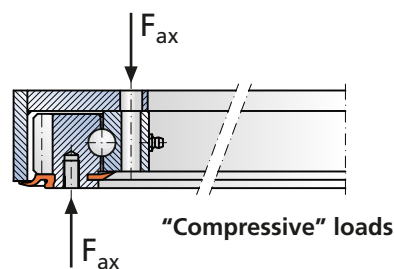
- Axial loads can be “compressive” or “suspended”.
- A “suspended” axial load and the load on a rising segment in tilting moments must be adequately resisted by mounting bolts.

**Caution: Catalog bolt data is not valid in this case!**



- Radial loads must be transmitted by means of frictional contact between Slew Drive and the attached structure.
- A good bolt connection is vital for satisfactory function of the Slew Drive. Bolt connection and tilting clearance of a Slew Drive must be checked regularly.

**All catalog bolt data is valid only for “compressive” loads!**



### Gear

Slew Drives of series WD are designed with worm gear. Slew Drives of series SP are designed with spur gear. Permissible torque is specified in the Technical Information section.

### Drive

Drive is provided by either an attached hydraulic or electric motor. Both motor mountings as well as the shaft/hub connection conform to industrial standards, hence hydraulic motors available on the market can be mounted without difficulty. For electric motors, corresponding adapter pieces are necessary. The design specification for drive motors is undertaken by IMO, based upon rotational speed and torque information provided by the customer.

### Housing

Housing is designed as a welded or cast component and adapted to the size of the Slew Drive. As a standard feature, housings are supplied with a priming paint.

### Sealing

Polymer seals protect the Slew Drive from normal dirt penetration, dust and light sprayed water. For very dirty and wet environments, the seals shall be protected with pre-mounted labyrinth seals on the mounting structure. Performance and reliability of a Slew Drive depend strongly on avoiding ingress of contaminants to the interior of the unit.

**Pressure washing must not be used to clean Slew Drives.**

### Operating temperature

Standard version IMO Slew Drives can be used in ambient temperatures from  $-20^{\circ}\text{C}$  up to  $+70^{\circ}\text{C}$ .

### Selection criteria

The following criteria must be considered for the correct selection of a Slew Drive.

### Position of the output shaft

Vertical: Slew Drives of all series can be used (even with a self-locking gear).

Horizontal: Slew Drives of all series can be used with exception of series WD-H. Here, it is necessary to use a Slew Drive with a 2-start gear, since using gear with self-locking and external driving force does not ensure smooth (jerk free) operation.

Alternating: Slew Drives provided with self-locking gear cannot be used. Using a Slew Drive of series WD-H with 1-start gear without self-locking is possible only up to  $10^{\circ}$  inclination angle to the vertical, otherwise smooth operation cannot be guaranteed.

Slew Drives that are not self-locking can, as an option, be equipped with a locking brake, if required.

### Loads

External forces such as axial load, radial load and tilting moment must lie below the static limiting load curve, as regards their operating load point. For this, please refer to the chapters “Static capacity of raceway” and “Mounting bolts”.

### Shocks, vibrations

To account for the peculiarities of different applications, the shock factors for gears should be considered. Slew Drives of the series WD are not suitable for applications under permanent vibration.

### Back load

Keep in mind that in the case of series WD Slew Drives, due to the high gear ratio, that in the case of back load (e.g. caused by boom impacting on obstacle), there is danger of irreparable damage to the worm gearbox, so long as the driving torque exceeds the maximum permissible table values  $M_{d\text{ max}}$ .

### Torque

The operating torque may not exceed the maximum torque specified in the Technical Data section, calculated with application service factor 1. Explanations of different torque specifications are as follows:

### Series SP:

#### Maximum torque $M_{d\text{ max}}$ :

Slew Drive series SP-H, SP-M: Maximum torque is limited by maximum radial load of the planetary gear-set used.

Slew Drive series SP-L, SP-I:

The maximum torque is calculated with a safety factor against static tooth base fracture SFS 1.75.

#### Nominal torque $M_{d\text{ nom}}$ :

The nominal torque is calculated with a safety factor against tooth base fatigue SF1, at the rotational output speed specified in the Technical Data section, under one-way varying load.

### Series WD:

#### Maximum torque $M_{d\text{ max}}$ :

The calculation of the maximum torque with a safety factor against tooth fracture SFS 1 is done according to G. Niemann / H. Winter, Machine Elements, Band III, 1986, for worm gears and is influenced by:

- Limiting value of tooth base stress
- Module
- Gearing width

#### Nominal torque $M_{d\text{ nom}}$ :

The nominal torque is calculated with a safety factor against tooth wear of SF1,

- at the output speed specified in the table
- for a calculated service life of 10000 h
- at a duty of 5%

For Slew Drives with two motors, the specified values are valid for a slewing angle of  $\leq 170^{\circ}$ .

### Series SP and WD:

#### Maximum holding torque $M_h$ :

The maximum holding torque determines which retroactive torque can be transmitted or held without damage being caused to the gearing. In general, the value of the maximum torque is assumed.

### Rotational speed

Slew Drive series SP:

The maximum permissible speed is  $n_{\text{perm}} = \frac{40000}{D_L}$

Slew Drive series WD:

The maximum permissible speed is specified in the Technical Data section. For higher speeds, our Engineering Department should be consulted.

### Duty

Slew Drive series WDs are designed for intermittent duty. Application with continuous running or with higher rate of duty and simultaneously high output torque are not permissible. This would lead to unacceptable temperature increase in the gearing and thus to premature failure of the Slew Drive. Transmission of the maximum torque is to be limited to 10% of each minute. Please check the diagram for the maximum permissible duty per minute of the respective series on P. 53 and P. 63.

### Static capacity of raceway

**Static capacity of the Slew Drive is determined by:**

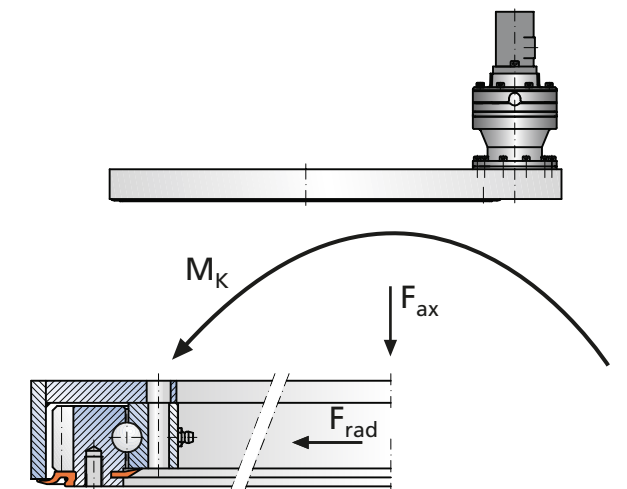
- Hardening depth of the raceway
- Number and size of the rolling elements
- Slewing Ring design
- Raceway geometry

The limiting load diagram shows permissible axial and tilting moment loads for a respective size unit.

Every loading case including the required or recommended safety must lie below the limiting load line.

**Limiting load diagrams are valid under the following condition:**

- Static loading
- Limiting load line with safety 1
- Clamping length of bolts, minimum 5-times, maximum 10-times the bolt diameter
- Continuous threads up to the bolt head is not permissible
- Bolts of quality class 10.9
- All mounting holes used
- “Compressive” load
- Adequately stiff and level mounting structure (see chapter “Installation and Maintenance Instructions” on P. 46 - 51)
- Minimum strength of the mounting structure  $500\text{ N/mm}^2$
- Radial loading considered as specified
- Compliance with “Installation and Maintenance Instructions”



## Technical Information

To address the peculiarities of different applications, the following application service factors are to be considered in the prevailing loads:

Application	Application service factor $f_a$	Remark
Construction machinery	1.25	Normal operation
Forestry machinery	1.50	Rough operation
Foundries	1.75	Rough operation
Manlift platforms	1.30	Normal operation
Mech. engineering, general	1.25	Normal operation
Mech. engineering, general	1.50	Heavy operation
Measuring technique	2.00	Accuracy
Robot / mech. handling sys.	1.50	Accuracy
Rail vehicles	1.50	Rough operation
Special vehicles	1.50	Rough operation
Deep mining	1.75	Rough operation
Machine tools	1.50	Accuracy

Application service factors are to be considered in the following equations for the prevailing loads:

$$F_{axD} = F_{ax} \cdot f_a$$

$$M_{kD} = (M_k + 1.73 \cdot F_{rad} \cdot \frac{D_L}{1000}) \cdot f_a$$

To account for the prevailing radial load, the tilting moment is increased accordingly.

This equation applies only if:

$$F_{rad} \leq 220 \cdot \frac{M_k}{1000} + 0.5 \cdot F_{ax}$$

Should the value be exceeded, the limiting load diagram no longer applies.

Please contact our Engineering Department.

### Calculation example:

Application: Slewing equipment for a construction machine under normal operation

Load:	Axial load	55 kN
	Radial load	6 kN
	Tilting moment load	86 kNm

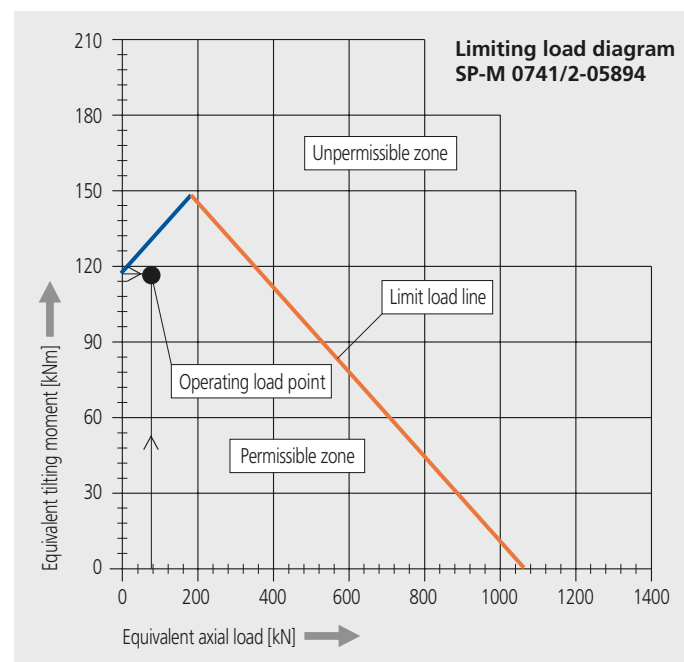
Slew Drive: pre-selected SP-M 0741/2-05894

The following values are achieved with an application service factor of 1.25:

$$F_{axD} = 55 \cdot 1.25 = 68.75 \text{ kN}$$

$$M_{kD} = (86 + 1.73 \cdot 6 \cdot \frac{741}{1000}) \cdot 1.25 = 117.11 \text{ kNm}$$

At this point it can be verified in the limiting load diagram, whether or not the pre-selected Slew Drive is statically adequate.



If the operating load point lies below the limiting load line then the Slew Drive is statically adequately dimensioned. If loads frequently occur during the slewing process, the selected type should be reevaluated dynamically for lifespan. For this, please contact our Engineering Department.

### Mounting bolts

Prevailing loads must be safely transmitted. To ensure this, mounting bolts should be sized to handle the raceway loading. The bolt curve is depicted in the static limiting load diagram, subject to the following conditions:

- Quote the fulfillment of the conditions in the case of considering the static load Slew Drive capacity of the raceway.
- Bolts are appropriately tightened with a torque wrench (bolt tightening factor  $\alpha_A = 1.6$ ). For tightening torques, see table P. 48
- For Slew Drives with through holes, use the largest possible metric bolts with regular threads.

Caution: In the case of "suspended" loads, the bolts are subject to additional tensional forces.

Please contact our Engineering Department.

### Static load carrying capacity of mounting bolts

Determining the operation load level, both with and without radial load, occurs along with the verification of the static load carrying capacity of the raceway.

If the prevailing load case lies below the limiting load line in the static limiting load diagram then the bolt connection is statically adequately dimensioned.

### Dynamic load Slew Drive capacity of mounting bolts

Mostly, static dimensioning of a mounting bolt is sufficient. In cases where very high numbers of stress reversals act on the Slew Drive, dynamic verification is necessary. For this, please contact our Engineering Department.

### Pressure lock of mounting bolts

When radial loads act on the Slew Drive, it must be ensured that these loads can be transmitted without shearing forces occurring inside the bolts. Therefore, it must be determined whether the radial load can be transmitted via frictional contact between the mounting structure and the Slew Drive.

$$F_{rad \max} = \frac{n_b \cdot F_{sp}}{18.8}$$

$n_b$  = number of fixing holes per ring

$F_{sp}$  = pre-stressing force on a mounting bolt

If the prevailing radial load exceeds the limit value, we request that you contact our Engineering Department.

For Slew Drives with a different number or size of bolts in the inner and outer ring, the permissible radial load is to be determined for both rings. The smaller value is the limiting value. Frictional contact prevails if  $F_{rad \max}$  is greater than the prevailing radial load.

Slew Drives, series WD-H, are basically to be centralized.

### Securing the mounting bolts

When a customer desires that the mounting bolts be secured, we recommend the following products (manufacturer specification is valid):

#### Loctite®

Application of Loctite 270 is suitable for the highest level of connections. This prevents loosening and the threads are also sealed.

#### Nord lock®

Nord lock, self-locking washers, are recommended for cases of vibration or dynamic loading cycles. Due to a pair of square tapered washers with tapered surface gradients between both Nord-lock securing washers greater than the gradient of the bolt threads, any loosening tendency of the bolt is immediately prevented.

Other bolt securing systems are not recommended.

### Friction torque

The friction torque in Slew Drives depends upon many influence factors, e.g.:

- Rigidity and flatness of the mounting structure
- Load and loading combination
- Rotational speed and operating temperature
- Design of Slew Drive
- Number and frictional torque of seals
- Lubrication grease and level of filling
- Manufacturing tolerances
- Other factors

The friction torque of an unloaded Slew Drive can be determined approximately with the following equations:

Slew Drive series SP, with minimum Slew Drive clearance greater than zero

$$M_{wA} = 0.2 \cdot \frac{D_L^2}{2000}$$

Slew Drive series WD-L, with preloaded Slew Drive

$$M_{wA} = 2.0 \cdot \frac{D_L^2}{2000}$$

Slew Drive series WD-H, with preloaded Slew Drive

$$M_{wA} = 4.0 \cdot \frac{D_L^2}{2000}$$

The friction torque for a Slew Drive under load can be determined with the following equation, approximately:

$$M_w = 0.005 \cdot (4400 \cdot M_k + 4 \cdot D_L \cdot F_{rad} + D_L \cdot F_{ax}) + M_{wA}$$

### Gear

#### Slew Drive series SP

#### Type of gear

Slew Drives series SP are provided with spur gear according to DIN 3960, DIN 3962 and DIN 3967.

If higher torque is necessary or longer operating lifespan is required, it is possible to manufacture the gear in tempered or hardened form.

#### Permissible torque

Corresponding data is available in the Technical Information section.

#### Drive pinion

The pinions used in different sizes are provided with hardened gear. In the Technical Data section you will find data about transmission ratios and numbers of teeth.

For the direct drive (SP-L, SP-I), the drive pinion is equipped with a radial bearing that is integrated in the motor flange.

In the case of Slew Drives equipped with planetary transmission, the drive pinion is mounted via the planetary transmission.



## Technical Information

### Tooth backlash

Tooth backlash is factory-set at the highest point of the gear. It depends on the module of the gear and is calculated according to the following formula:

**Tooth backlash to be set = 0.03 to 0.04 • module**

### Slew Drive series WD

#### Design of the gear

Slew Drive series WD is designed with a hardened worm gear according to DIN 3960, DIN 3962 and DIN 3967,

#### Permissible torque

Corresponding data is provided in the published Technical Information section.

#### Worm shaft

Worm shafts are made of hardened steel, with ground tooth flanks.

### Tooth backlash

The tooth backlash is set at approx. 0.3 mm for Slew Drive series WD.

## Self-locking

### Series SP Slew Drives

Series SP Slew Drives are not self-locking.

### Series WD Slew Drives

Self-locking only exists in the case of series WD Slew Drives if it cannot be driven from the output side. Self-locking is directly related to the efficiency of the Slew Drive, which depends on very many factors, e.g.

- Lead angle
- Angle of friction
- Rotation speed
- Lubrication
- Material matching
- Surface finish, etc.

Theory indicates self-locking occurs if the gear efficiency is < 50%. Data in the Technical Data section conforms to this statement. However, it is vital to determine the actual existence of the self-locking characteristics in the supplied Slew Drive individually during actual usage.

We take no responsibility for conformity of the theoretical data in the Technical Data section with the practically prevailing self-locking or non-self-locking characteristics.

### Shock coefficient

As for the applications in which impact is expected, the appropriate impact coefficients must be considered when determining the Slew Drives' maximum torque rating.

### Lifespan

The expected lifespan of the gear depends on the operating conditions. The following factors are key:

- Torque
- Output speed
- Duty factor
- Ambient temperature, etc.

### Lubrication

To ensure flawless operation and long usable life, adequate and regular lubrication is necessary. The grease fulfills the following functions:

#### For the raceway:

- Reduction of friction and wear in the rolling contacts
- Corrosion protection
- Lubrication of seals
- Additional sealing effect of the grease "collar"

#### For the gears:

- Smooth running
- Less wear
- Reduced operation noise
- Longer operating life
- Less heat development

### Initial greasing

IMO Slew Drives are supplied pre-lubricated. High-quality lithium-complex grease, based on mineral oil, with EP-additives according to DIN 51825, KP2P-20 is the standard lubrication.

### Regreasing intervals

Regreasing must be done at regular intervals, depending on frequency of use and ambient operating conditions. General attention must be paid to ensure that the grease used during the greasing is compatible with the sealing material. Special attention should be paid to ensure that lubricating grease types originally specified are used throughout the life of the unit.

Should you wish to use other types of grease, it must be verified whether the grease is compatible with that used for initial greasing. Please contact your grease manufacturer.

Please observe also the data in the "Installation and Maintenance Instructions" chapter.

Beside regular regreasing during operation, it is also necessary to grease the Slew Drive after long standstill periods. Equally important is to grease the equipment in which the Slew Drive is integrated after cleaning.

### ATTENTION:

**Slew Drives must not be cleaned with pressure washing equipment. During pressure washing, large amounts of pressurized water can penetrate into the Slew Drive through the sealing gap and cannot be removed, even by massive re-greasing. This will strongly reduce the usable lifespan of a Slew Drive.**

### Mixing greases

Grease with different thickener and base oil should generally not be mixed. The manufacturer should always confirm if different grease types can be mixed.

### Shelf life of lubricants

Lubricants are subject to ageing even if unused. If after 3 years grease is not yet used, it should be replaced.

## Design of mounting structure

Safe transmission of application loads and reliable operation of Slew Drives is achieved, along with other factors, through using adequately designed mounting structures.

To ensure safe operation of Slew Drives, there are certain minimum requirements to the mounting structure.

- Sufficient rigidity (see "Installation and Maintenance Instructions")
- Maintain flatness according to "Installation and Maintenance Instructions"
- No hard points (e.g. through cross beams)
- Surfaces for bolts must be machined plane
- Hollow mounting structure is preferred
- Use all mounting bolts
- Bolts of recommended strength should be used
- Minimum strength of attached structure 500 N/mm<sup>2</sup>

Very different mounting structure solutions can be used, depending upon maximum load and application.

If hollow mounting structure is designated for attached structure, flange thickness should be at least 50 % of Slew Drive's overall height. The thickness of the hollow mounting structure should be about 30% of flange thickness. For weight-critical applications, flange thickness can only be reduced if appropriate stiffening ribs are provided and the specifications on permissible flatness and perpendicularity deviations and deformation under load are upheld. Values on this are specified in the "Installation and Maintenance Instructions" P. 46 - 51.

## A few simple steps for selecting a Slew Drive

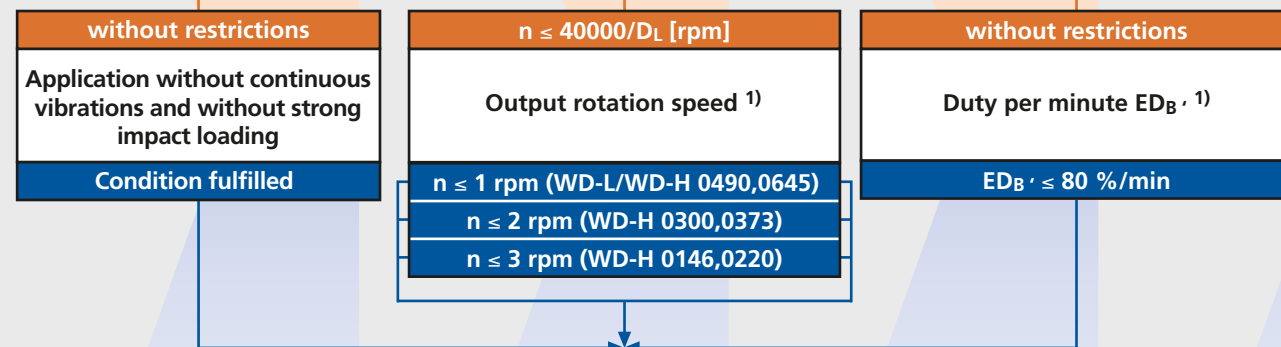
You will find a detailed procedure on the following pages!



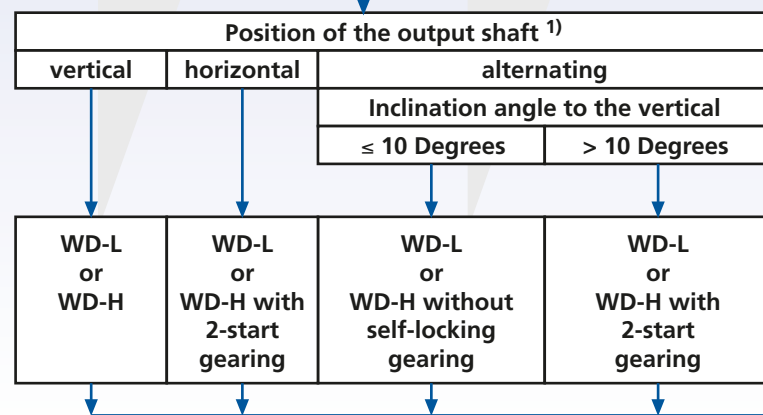
### Spur gear driven type SP Series



START

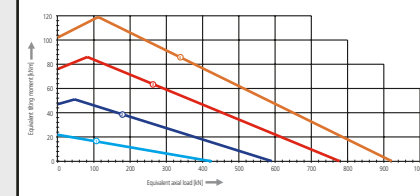


### Worm gear driven type WD Series

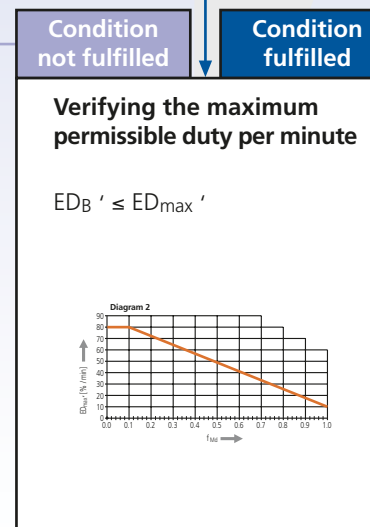
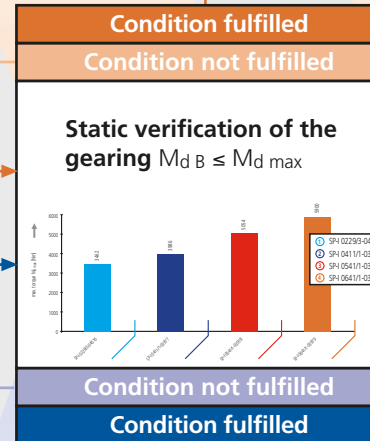
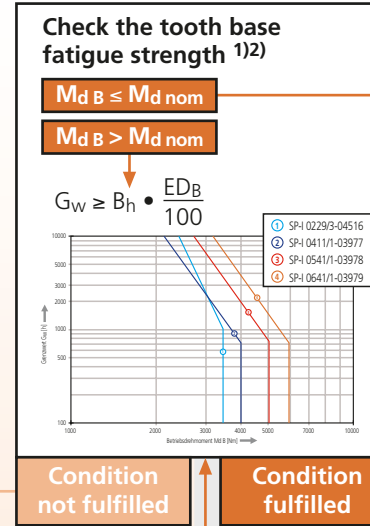


Selecting Slew Drive with larger maximum torque  $M_d$  max

Selecting a Slew Drive using the limiting load diagram <sup>1)2)</sup>  
Operating point must lie below the selected curve.



Selecting Slew Drive with a larger maximum torque  $M_d$  max



Verifying the selected Slew Drive by IMO Engineering Department

Please fill out an Application Data Sheet and supply a sketch of the application.

SOLUTION

1) Selection criteria can be used only as rough typical values; if limit value is exceeded, please contact IMO.  
 2) Please accurately consider operating conditions.



## Technical Information

### Procedure for selecting a Slew Drive in only 5 steps:

Pre-selecting a suitable Slew Drive is described using the following example:

#### Example:

Application: Steering gears for an in-house transport vehicle; rough operation; limited assembly space; "compressive" load.

#### Load data:

Axial load:	$F_{ax} = 100 \text{ kN}$
Radial load:	$F_{rad} = 35 \text{ kN}$
Tilting moment:	$M_k = 75 \text{ kNm}$
Operating torque:	$M_{dB} = 13200 \text{ Nm}$
Output speed:	$n = 1.0 \text{ rpm}$
Operating time:	$B_h = 14000 \text{ h}$
Duty:	$ED_B = 5 \%$

Rotation cycle description under operating torque:  
 60° rotation in 10 seconds in clockwise direction  
 60° rotation in 10 seconds in counter-clockwise direction  
 Pause for 40 seconds  
 Operation of Slew Drive per minute:  
 20 seconds rotating – 40 seconds standing still  
 → 0,333 minute, rotating per minute  
 → Duty per minute:

$$ED_B = \frac{0,333}{\text{min.}} \cdot 100\% = \frac{33,3\%}{\text{min.}}$$

### 1. Step: Selecting a suitable design (WD or SP)

#### Comparing product characteristics

#### WD design:

- Exhibits high torque at low output speeds and transmits high tilting moments, axial and radial loads
- Attains highest capacity with smallest diameter configuration
- Flat design, due to tangentially located drives
- Provides high torque transmission (however, the duty must be taken into consideration)
- Self-locking and non-self-locking Slew Drives are available
- Non-self-locking Slew Drives can be equipped with locking brakes
- Consider the position of the output shaft when selecting the Slew Drive
- Not recommended in case of continuous vibrations and heavy impact loading

Typical application:  
 Manlift platforms, steering gears for undercarriages of cranes and heavy-duty vehicles, loading cranes, turntables, forklift rotators, mining equipment, etc.

#### SP design:

- Enables higher output rotary speeds
- Very narrow in size around the Slewing Ring, but the drive is broad in axial direction
- Offers a large, open internal diameter
- Very suitable for upper structures with larger radial diameters
- Basically not self-locking in design
- Can be equipped with locking brakes
- The position of output shaft is insignificant
- Preferred design for vibration and impact loading applications

#### Typical applications:

Handling and automation equipment, packaging machines, tool changers, grippers, construction machines, land and forestry machines, etc.

#### Typical selection:

Worm gear driven types have proven themselves as steering gears. Features such as high torque, low output rotary speed with smaller assembly height and diameter clearly speak for the application of WD design. The smallest assembly height of a worm gear driven Slew Drive is provided by the WD-L series.

### 2. Step: Selecting a suitable design size in the limiting load diagram for "compressive" load:

A suitable Slew Drive is selected iteratively. For a pre-selected Slew Drive, (e.g. WD-L 0478/3-04995), an operation load point is calculated depending on external loading, the application service factor and the raceway diameter  $D_L$ .

Loading is permissible for raceway and bolt connection, provided that the operating point lies below the limiting load line of a pre-selected Slew Drive.

If the operation load point lies above the corresponding limiting load line, a Slew Drive with higher power rating must be selected, for which the limiting load line lies above the current operation load point. For the newly selected size, the operation load point must be calculated again and the permissibility of the new operation load point must be verified against the limiting load line.

On the contrary, if the operating load point also lies below the limiting load line of a smaller size, then, for this size, permissibility of the newly calculated operating point can be verified within the limiting load diagram.

This iterative approach is repeated until an optimally suitable size is determined, by which the operation load point lies below the corresponding limiting load line.

The following conditions must be fulfilled:

- Preconditions for limiting load diagram apply.
- Equation  $F_{rad} \leq 220 \cdot \frac{M_k}{1000} + 0.5 \cdot F_{ax}$  fulfilled

#### Example:

- Preconditions for the limiting load diagram apply
- Verifying the operating parameters:

$$F_{rad} \leq 220 \cdot \frac{M_k}{1000} + 0.5 \cdot F_{ax}$$

$$35 \leq 220 \cdot \frac{75}{1000} + 0.5 \cdot 100 = 66.5 \text{ (condition fulfilled)}$$

Calculation of the operation load point:

Application service factor  $f_a = 1.5$  (special vehicles)

Raceway diameter for WD-L 0478/3-04995:  $D_L = 478 \text{ mm}$  (see product program overview / compare P. 4 and P. 5)

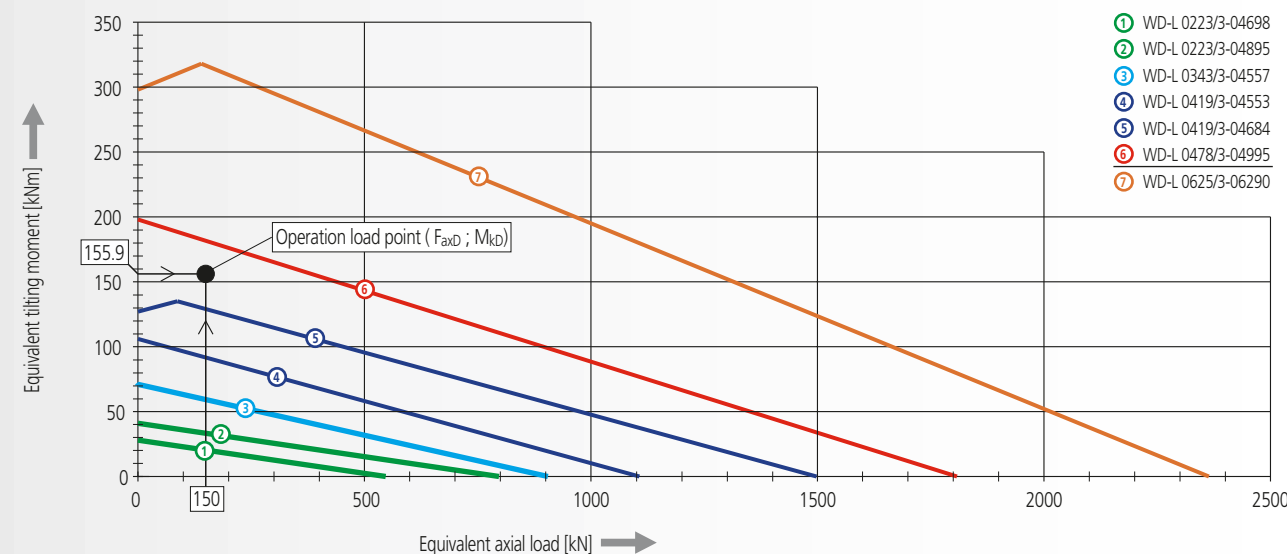
$$F_{axD} = F_{ax} \cdot f_a$$

$$F_{axD} = 100 \text{ kN} \cdot 1.5 = 150 \text{ kN}$$

$$M_{kD} = (M_k + 1.73 \cdot F_{rad} \cdot \frac{D_L}{1000}) \cdot f_a$$

$$M_{kD} = (75 + 1.73 \cdot 35 \cdot \frac{478}{1000}) \cdot 1.5 = 155.9 \text{ kNm}$$

The operation load point lies below the limiting load line of the selected Slew Drive WD-L 0478/3-04995 and is permissible. The operation load point of the selected Slew Drive lies above the limiting load line of the smaller size, which would not be permissible. A Slew Drive that is larger than the selected Slew Drive WD-L 0478/3-04995 would not be the best solution from the economic point of view.



## Technical Information

### Step 3: Static reliability verification of operation torque $M_{dB}$ :

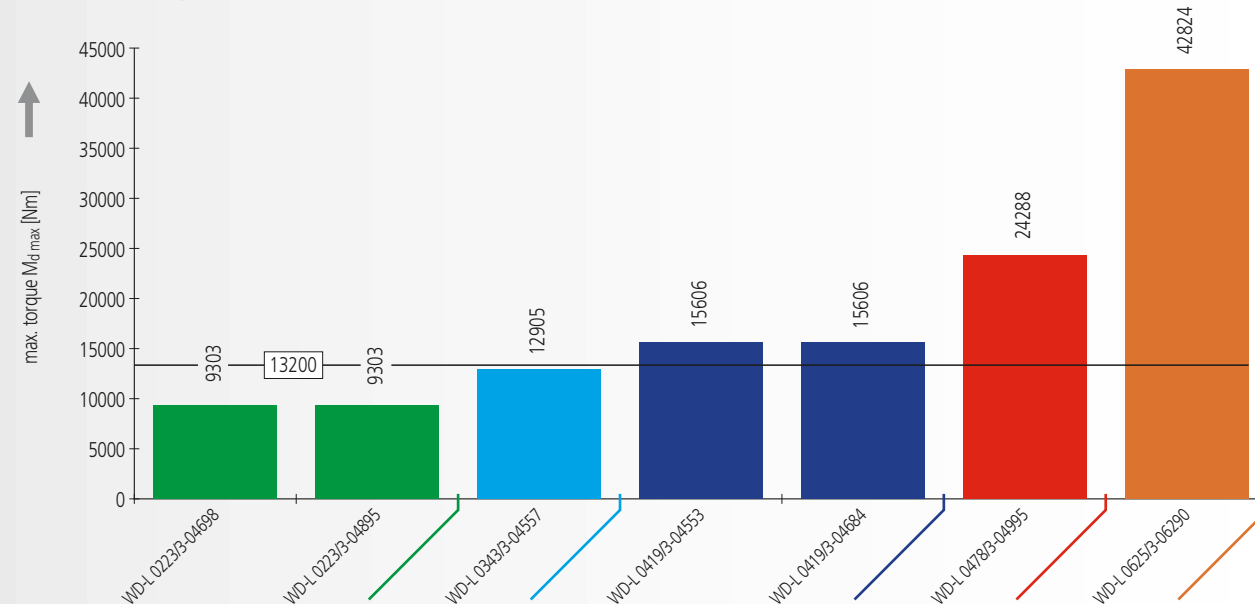
The following condition must be fulfilled:  
Operating torque  $M_{dB} \leq$  maximum torque  $M_{d \max}$   
(see series overview WD-L P. 52)

**Example:  $13200 \text{ Nm} \leq 24288 \text{ Nm}$  (condition fulfilled)**

Slew Drives WD-L 0419/3-04553, WD-L 0419/3-04684, WD-L 0478/3-04995 and WD-L 0625/3-06290 can statically transmit the operating torque  $M_{dB}$ .

Since the operation load points of series WD-L 0419/3-04553 and WD-L 0419/3-04684 lie above their limiting load lines (cf. Step 2), the size WD-L 0478/3-04995 selected in Step 2 has to be selected. If the operating torque  $M_{dB}$  is greater than 24288 Nm, then WD-L 0625/3-06290 must be selected; in this example, however, WD-L 0625/3-06290 is not an economical solution.

Maximum torque  $M_{d \max}$  of individual sizes



### Step 4: Verifying the maximum permissible duty per minute $ED_{\max}$ :

The following condition must be fulfilled:

- Preconditions for the diagram of maximum permissible duty per minute  $ED_{\max}$  apply (see series overview WD-L P. 53)

Duty per minute  $ED_B \leq$  maximal permissible duty per minute  $ED_{\max}$   
(see series overview WD-L P. 53)

### Example:

- Pre-conditions for the diagram of maximum permissible duty per minute  $ED_{\max}$  apply.

Verifying the condition:  $ED_B \leq ED_{\max}$

Duty per minute  $ED_B = 33.3 \text{ \% / min}$

Determining the maximum permissible duty per minute (see series overview WD-L P. 53)

$$\text{Factor } f_{Md} = \frac{M_{dB}}{M_{d \max}} = \frac{13200 \text{ Nm}}{24288 \text{ Nm}} = 0.543$$

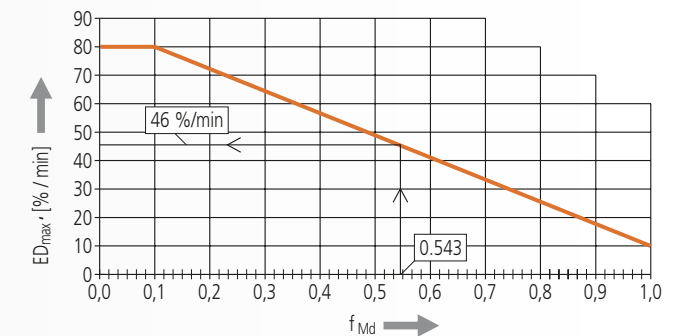
Maximum permissible duty per minute

$ED_{\max} = 46 \text{ \% / min}$

Verifying the condition:  $ED_B \leq ED_{\max}$

$33.3 \text{ \% / min} \leq 46 \text{ \% / min} \rightarrow$  condition fulfilled

Duty per minute is permissible.



### Step 5: Verifying wear characteristics of worm gear

The following condition must be fulfilled:

- Preconditions for wear diagram apply (see series overview WD-L P. 53)

$$\text{Limit value } G_W \geq \text{operation time } B_h \cdot \frac{\text{duty } ED_B}{100}$$

### Example:

- Preconditions for wear diagram apply

$$\text{Verifying the condition: } G_W \geq B_h \cdot \frac{ED_B}{100}$$

Determining the limit value  $G_W$  at the operating torque  $M_{dB}$  from the diagram for the selected Slew Drive WD-L 0478/3-04995 (see series overview WD-L S. 53)

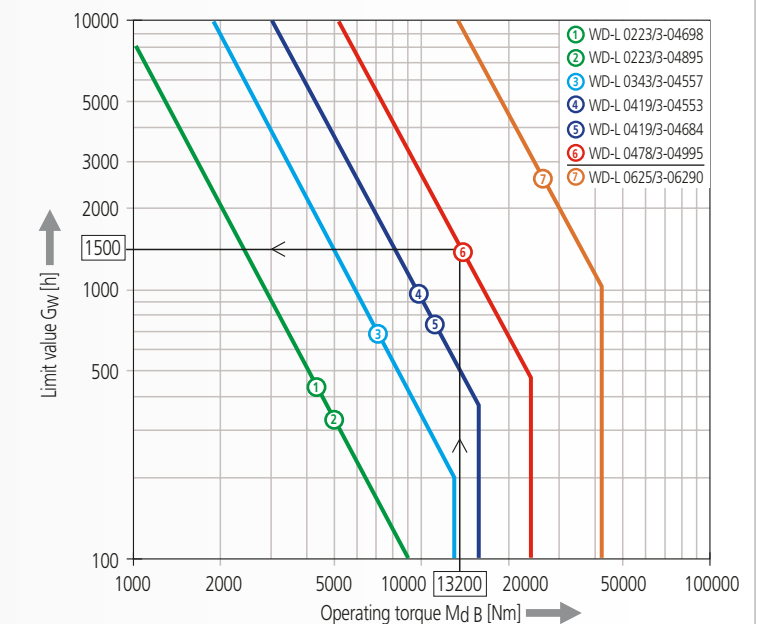
$$\text{Verifying the condition: } G_W \geq B_h \cdot \frac{ED_B}{100}$$

Limit value  $G_W = 1500$  hours (from diagram)

$$B_h \cdot \frac{ED_B}{100} = 14000 \text{ hours} \cdot \frac{5 \text{ \%}}{100} = 700 \text{ hours}$$

$1500 \text{ hours} \geq 700 \text{ hours} \rightarrow$  condition fulfilled

Operation is permissible as regards wear characteristics.



### Result:

- Verification as regards:
- Suitability of design
  - Load carrying capacity of raceway and bolt connection in the limiting load diagram
  - Permissibility of the operating torque
  - Maximum permissible duty per minute
  - Wear characteristic of worm gearing was considered and the Slew Drive WD-L 0478/3-04995 evaluated as applicable in all aspects.

Verification of the selected Slew Drive by IMO is recommended.

Please enclose Application Data Sheet and a sketch of the application (see P. 108 and P. 109).



## Installation and Maintenance Instructions for Slew Drives (EW ST Rev. 5.02)

### Preface

The following instructions give you the information you need to be able to correctly install and maintain an IMO Slew Drive.

These instructions replace earlier versions for series SP and WD. All instructions are provided with a revision number. Installation and maintenance instructions with previous revision numbers are invalid. The latest version is published on our homepage and can be downloaded from there ([www.goimo.com](http://www.goimo.com)). Please always check that you are working with the latest revision!

These instructions shall be attached to your product or to the final product or to the Installation and Maintenance Instructions. All work steps listed here are to be executed by suitably qualified personnel.

Please do not hesitate to contact our Engineering Department for any further assistance.

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#### 0. Transport, handling and storage provisions

0.1 Transport, handling and storage

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1.1.2 Determining permissible deviations and/or deformation of mounting structure

1.1.3 Lubricating or checking oil level

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1.1.5 Choice of tightening torques

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#### 2. Maintenance / safety checks and lubrication

2.1 Checking the mounting bolts

2.2 Checking the tilting clearance

2.3 Checking the rotational clearance of series WD

2.4 Relubrication or checking oil level

2.5 Relubrication intervals

2.6 Lubricants

IMO accepts no liability for:



1. Non-compliance with Installation and Maintenance Instructions.
2. Failure to pass on content to third party.

### Notice

The following text includes special notices and procedures that shall be observed.

Technical properties of Slew Drives are found in our product catalog or in the technical offer.

### 0. Transport, handling and storage provisions

#### 0.1 Transport, handling and storage

Transport only in horizontal position. Impacts shall be avoided.

Wear work gloves when handling the Slew Drives.

Slew Drives are generally provided with threaded holes in which eye bolts can be fixed. This enables safe handling on a hoisting device. Please observe relevant legal regulations when doing this.

Store only in a horizontal position and in closed rooms. The surface corrosion protection holds for approx. 3 months in closed packaging. Longer storage periods require special protective measures.

### 1. Installation

#### 1.1 Preparation for installation

##### 1.1.1 Cleaning the Slew Drive and the mounting structure

1. Remove extraneous material from supporting surfaces (including paint residue, welding beads, burr formation)
2. Clean corrosion protection coating from supporting surfaces of the Slew Drive.

In doing this, ensure that:



- Cleaning material does not penetrate into the Slew Drive.
- Applicable provisions for cleaning media are observed (e.g. manufacturer provisions, protection of workers, environment protection).
- Cleaning material that attacks the sealing material is not used.

Applicable cleaning materials:

Cold solvents (e.g. white spirit, diesel oil, Kaltryl KEV etc.)

##### 1.1.2 Determining permissible flatness deviation $\delta_p$ , perpendicularity deviation $\delta_w$ and the permissible deformation $\delta_v$ of the mounting surface of the supporting structure

Table 1: Permissible flatness including perpendicularity deviations for Slew Drives series WD-H

Size of Slew Drive	146	220	300	373	490	645
Flatness including perpendicularity deviation per supporting surface [mm]	0.06	0.06	0.07	0.07	0.08	0.09

Table 2: Permissible flatness including perpendicularity deviations for Slew Drives series WD-L and all SP

Raceway diameter [mm]	100	250	500	750	1000	1250
Flatness including perpendicularity deviation per supporting surface [mm]	0.04	0.06	0.08	0.09	0.10	0.11

Table 3: Permissible deformation of mounting structure under maximum load for Slew Drive series WD-H

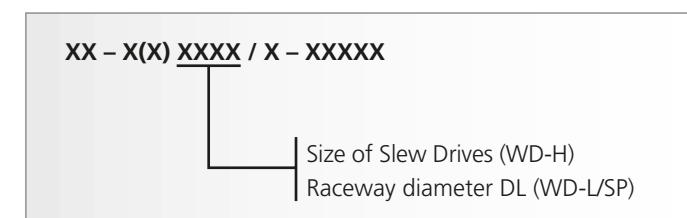
Size of Slew Drive	146	220	300	373	490	645
Deformation of mounting structure per support surface [mm]	0.10	0.11	0.12	0.13	0.15	0.16

Table 4: Permissible deformation of mounting structure under maximum load for Slew Drive series WD-L and all SP

Raceway diameter [mm]	100	250	500	750	1000	1250
Deformation of mounting structure per supporting surface [mm]	0.13	0.16	0.21	0.24	0.27	0.29

For Slew Drives between specified sizes, the closest smaller value shall be taken. For Slew Drives larger than type 645, the value for size 645 shall be used. For Slew Drives with a raceway diameter above 1250 mm, the value for 1250 mm shall be used.

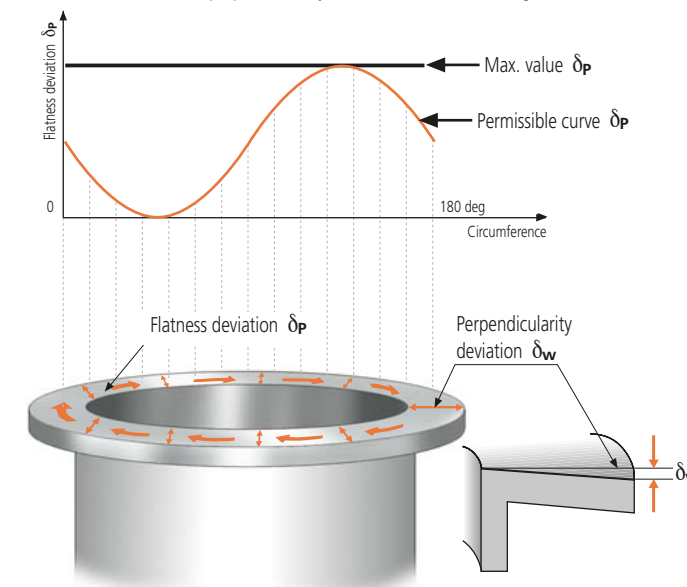
The size of Slew Drives (WD-H) or raceway diameter  $D_L$  (WD-L, SP) can be found on our Drawings.



Permissible perpendicularity deviation  $\delta_w$  (tilting) is based on the actual flange width and may only amount to one half of the values in Table 1 and 2.

The maximum residual value for flatness deviation  $\delta_p$  (waviness) along the circumference may total to only once per 180 deg. The form must resemble a sine curve that gradually rises and falls.

Sketch: Permissible curve of flatness deviation of the mounting structure and flatness and perpendicularity deviations on the mounting structure






## Installation and Maintenance Instructions for Slew Drives (EW ST Rev. 5.02)

### 1.1.3 Lubricating the Slew Drive or checking oil level

Slew Drives are supplied fully lubricated. They shall be greased again prior to initial operation. It is essential to use the grease specified on the delivery drawing. Suitable grease types for normal cases are listed on Table 9.

-  1. Inject grease into the grease nipples one after the other while rotating the drive until a bead of fresh grease forms at least on one sealing lip.
- 2. For Slew Drives equipped with an intermediate device using gears (For example: Planetary gear), the oil level should be checked and refilled if necessary. For this see Installation and Maintenance Instructions of the intermediate transmission manufacturer.

### 1.1.4 Choice of mounting bolts

Prescribed sizes, number and quality grades shall be used.

- Grip ratio (grip length to diameter of bolt) shall be observed, from minimum  $\geq 5$  to maximum  $\leq 10$ .
- Bolts with a fully threaded shaft are not permissible.
- Slew Drive function, lifespan, and durability can be affected in case of non-compliance.
- When the permissible interfacial pressure is exceeded, use suitable washers of appropriate size and strength.
- Do not reuse bolts, nuts and washers.

Table 5: Permissible interfacial pressure for different materials

Materials	Max. surface pressure in N/mm <sup>2</sup>
St52 / C45N / 46Cr2N	420
42CrMo4V	700

### 1.1.5 Choice of tightening torques

Mounting bolts are in normal cases adequately secured by correct preloading.

- Mounting bolts can be secured by Loctite. Nord-Lock bolt lock washers may be necessary in case of shock loading or vibration.
- Use of split rings, split washers, etc. is not permissible.

Table 6: Tightening torques for mounting bolts according to DIN13

Mounting bolt Dimension	Tightening torque $M_A^{1)}$ in Nm bolt strength class			Mounting bolt Dimension	Tightening torque $M_A^{1)}$ in Nm bolt strength class		
	8.8	10.9	12.9		8.8	10.9	12.9
M4	2.25	3.31	3.87	M16	168	246	288
M5	4.61	6.77	7.92	M18	229	336	394
M6	7.80	11.5	13.4	M20	327	481	562
M8	19.1	28.0	32.8	M22	450	661	773
M10	38.0	55.8	65.3	M24	565	830	972
M12	66.5	97.7	114	M27	837	1230	1439
M14	107	156	183	M30	1131	1661	1944

<sup>1)</sup>  $M_A$  according to VDI-guideline 2230 (February 2003) for  $\mu_k=0.08$  and  $\mu_v=0.12$


### 1.2 Installing the Slew Drive

#### 1.2.1 Positioning the Slew Drive

1. Determine the main load-carrying zone.
2. For all Slew Drives except series WD-H, the soft spot of the bearing raceway shall be placed at a 90° point to the maximum load zone. The soft spot is designated with a filling plug or a punched "S" mark.
3. With a gauge, check whether the supporting surface of the Slew Drive is fully supported by the mounting structure.

#### 1.2.2 Securing the Slew Drive with bolts


The Slew Drive shall be mounted in the unloaded condition. First the housing or toothless bearing ring is attached and then the worm wheel or the gear bearing ring.

-  The following procedure shall be followed in order to avoid deviations between bolt tightening forces.

1. Lightly lubricate bolt threads and head in order to ensure uniform frictional resistance (does not apply to bolts with adhesive).
2. Preload the bolts, including washers, if required, crosswise in 3 steps - 30%, 80%, 100% of the tightening torque.
3. Repeat the procedure for the worm wheel / bearing ring.

When applying a hydraulic fastening device, the tightening forces for preloading shall not exceed 90% of yield stress.

#### 1.2.3 Determining the existing tilting clearance

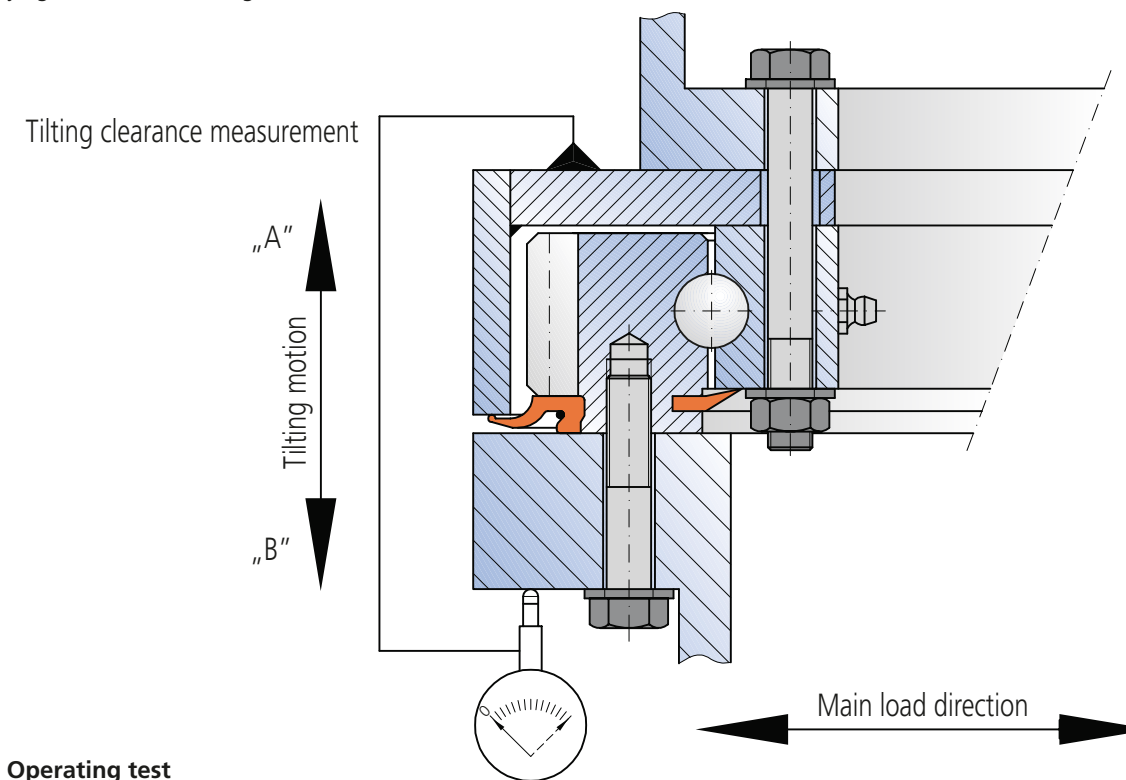
-  The tilting clearance increases with additional raceway wear. To determine the increase in tilting clearance, it is necessary to take basic measurements after installation prior to putting the drive into operation for the first time.

- Permanently designate the measuring point in the mainload direction.
- Record all measured values.

#### Procedure

1. Determine and mark the measuring point at the point of load, both on the housing as well as on the worm wheel or on the gear ring.
2. Fix the dial gauge – see sketch.
3. Apply the defined tilting torque, minimum of 50% of the maximum operational load in "A" direction.
4. Set the dial gauge on zero.
5. Apply the defined tilting torque, minimum of 50% of the maximum operational load in "B" direction.
6. The measured difference between "A" and "B" corresponds to the tilting clearance and serves as the basis for comparison for later inspections.

- All subsequent measurements are performed at the same measuring point, with the same loads, at the same position of the housing relative to the worm wheel or gear ring and in the same sequence.
- All the measured values are to be recorded.
- For purely axial or radial loads, tilting clearance is inspected by applying an additional tilting load.



#### 1.2.4 Operating test


If the mounting bolts are properly tightened and the drive motor is correctly connected, then the Slew Drive shall rotate uniformly. Deviations of the mounting structure and the effect of extraneous loads can strongly impact the friction torque.

1. Rotate mounted Slew Drive several times.
2. Check whether Slew Drive runs smoothly without jumping.
3. Perform further test runs under full load.

After operating test, recheck the tightening torques of mounting bolts.

## 2. Maintenance / safety checks and lubrication

### 2.1 Checking mounting bolts

-  To compensate for possible settling, it is necessary to retighten the bolts to the prescribed torque. This shall be done without externally loading the bolts after the first 100 hours in operating. This inspection shall be repeated after every 700 hours in operation. The inspection period may be reduced under special operating conditions. In case of loose bolts, replace all bolts, nuts and washers with new ones.



## Installation and Maintenance Instructions for Slew Drives (EW ST Rev. 5.02)

### 2.2 Checking the tilting clearance



Wear in the raceway system leads to increased tilting clearance. It is therefore necessary to check the clearance after 700 operating hours, or at the latest after 6 months.

#### Checking the increase in tilting clearance $\delta_k$ directly on a Slew Drive

For the procedure to check the increase in the tilting clearance, see P. 48 and P. 49.  
The value (m1) determined after installation of the Slew Drive is considered as the basic value and is deducted from the latest inspection value (mx). The difference between mx and m1 may not exceed 0.45 mm

$$\delta_k = mx - m1 \leq \delta_k \text{ perm}$$

$$\delta_k \text{ perm} = 0.45 \text{ mm}$$

#### Checking the increase in tilting clearance $\delta_k$ not directly on Slew Drive

Increase in tilting clearance is to be converted proportionally for each measurement (after the installation measurement) and compared with  $\delta_k$  permissible.

#### For both checks:

- Reduce the inspection interval to 200 operating hours if the measured increase in tilting clearance amounts to approx. 75% of the maximum permissible increase in tilting clearance.
- Reduce the inspection interval once again after further increase in tilting clearance (to 50 – 100 operating hours).
- Replace the Slew Drive if the maximum permissible increase in tilting clearance is reached.

### 2.3 Checking the rotational clearance of series WD



Gear wear leads to increased rotational backlash. Therefore it is necessary to check the rotational backlash after 700 operating hours, at the latest after 6 months. The values specified in Table 7 for rotational backlash shall not be exceeded.

#### Procedure

1. Determine and permanently mark the measuring point in the main loading zone, both on the housing as well as on the worm wheel or on the gear ring.
2. Secure the Slew Drive against rotation.
3. Remove the drive to enable the worm wheel to be easily rotated by hand.

- For front-end-brake application (brake flanged between motor and Slew Drive), the brake shall be removed with the motor.
- For an application with a brake mounted to the Slew Drive, the brake shall be disengaged.
- For a Slew Drive with an attached permanent brake (series WD-L), the brake shall be removed.

4. Determine the rotational play of the worm shaft.
5. The established rotational play serves as the basis for comparison after later checks.

- All subsequent checks are performed at the same measuring point, at the same position on the housing and worm wheel or gear ring relative to another and in the same sequence.
- All measured values are to be recorded.

Table 7: Rotational play – limit values

Module of Slew Drive gearing	Rotational play – limit value	Module of Slew Drive gearing	Rotational play – limit value
3	34°	6	28°
4	32°	6 / 2 start	14°
4 / 2 start	16°	7	28°
4.5	31°	7 / 2 start	14°
5	30°	8	27°
5 / 2 start	15°	8 / 2 start	13.5°

The size of the module is listed on the unit name plate.

- Reduce the inspection intervals to 200 operating hours if the measured rotational play amounts to approx. 75% of the maximum permissible limit value.
- Reduce the inspection interval once again after further increase (to 50 – 100 operating hours).
- Replace the Slew Drive if the maximum permissible rotational play is reached.

### 2.4 Relubrication of Slew Drive or checking oil level / oil change



Grease types specified in the delivery drawing shall be used. Suitable substitute lubricants can be found in Table 9.

Legal and manufacturer provisions about handling the respective lubricants must be observed.

1. While rotating the Slew Drive, inject grease into all the cleaned grease nipples consecutively until a bead of fresh grease forms at least on one seal or at the bearing gap.
2. Ensure that old grease can flow out of the drive freely.
3. For Slew Drives equipped with an intermediate transmission device (ie - planetary gear), oil shall be changed according to manufacturer instructions.

### 2.5 Relubrication intervals



Relubrication intervals depend mainly on the prevailing work and environmental conditions as well as on the version of the Slew Drive.  
Exact relubrication intervals can only be determined by tests under actual operating conditions.  
Intermediate transmissions are filled with oil; prescribed maintenance intervals are found in the maintenance instruction of the respective manufacturer.  
In case no comparative results are available, the following table can be used for a reference value.

Table 8:

Work conditions	Grease-filled Slew Drive Lubrication intervals
Dry and clean workshop (rotary tables / robots, etc.)	every 300 hours of operation or once every 6 months
Difficult conditions in open grounds (crane / bulldozer, etc.)	every 200 hours of operation or once every 6 months
Aggressive climatic conditions sea/deserts/ Arctic climate/very dirty surrounding/more than 70 operating hours per week	every 150 hours of operation or once every 4 months
Extreme conditions (tunnelling machines/steel mills)	every 50 operating hours, at least, however, every 2 months

The specified values are valid for the following conditions:

- Operating temperature on Slew Drive < 70° C
- Circumferential velocity < 0,5 m/s for SP Slew Drives
- Driver rotational speed < 5 rpm for WD Slew Drives
- Low to medium loads

The table can never replace values established through experience; the most frequent cause of failure of Slew Drives is insufficient lubrication.

Slew Drives shall generally be relubricated:

- After every cleaning.
- Before and after long inactive periods, e.g. for cranes and construction machines during winter months.
- Cleaning a Slew Drive with steam jet or high-pressure cleaner is not permissible!



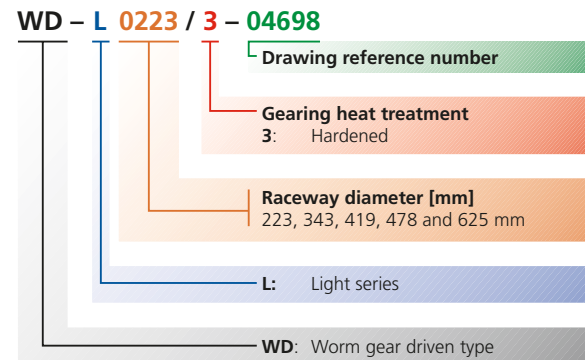
### 2.6 Lubricants

Table 9:

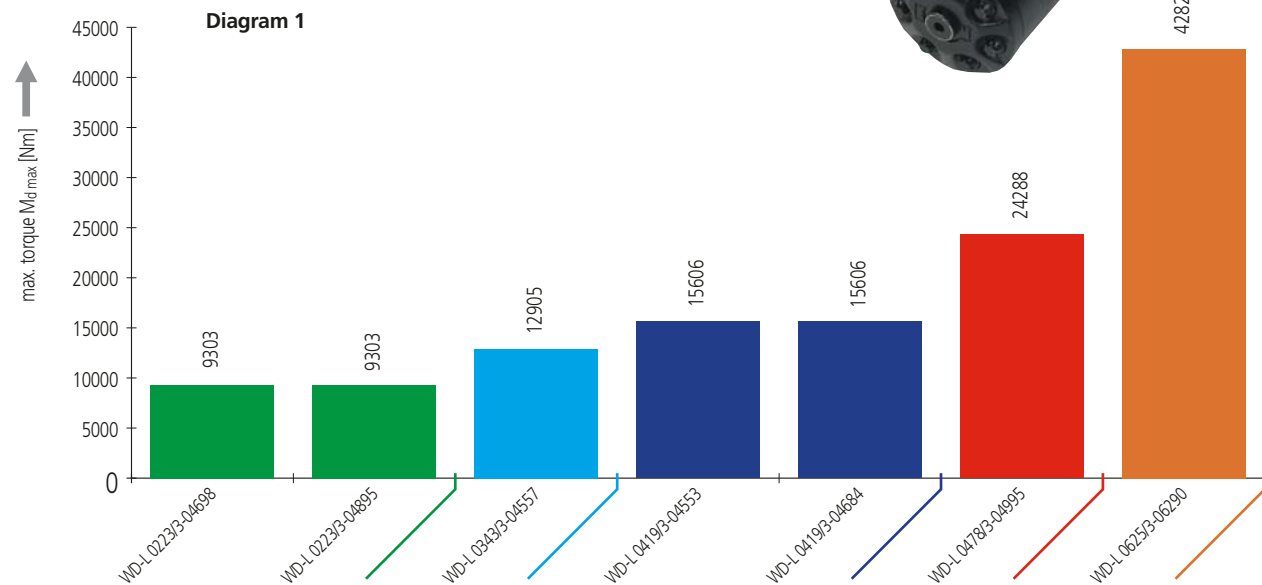
Supplier	Product name	Applicable temperature range in °C	
Avia	Avialith 2 EP	-30	+130
Bechem	High-Lub L 474-2	-20	+120
Bechem	Beruplex EP-O	-35	+150
Bechem	RHUS LT 2 EP	-25	+120
Castrol	Longtime PDO	-40	+140
Fuchs	Renolit Duraplex EP2	-30	+160
Rhenus	Norplex LKP2	-20	+150



## Series Overview

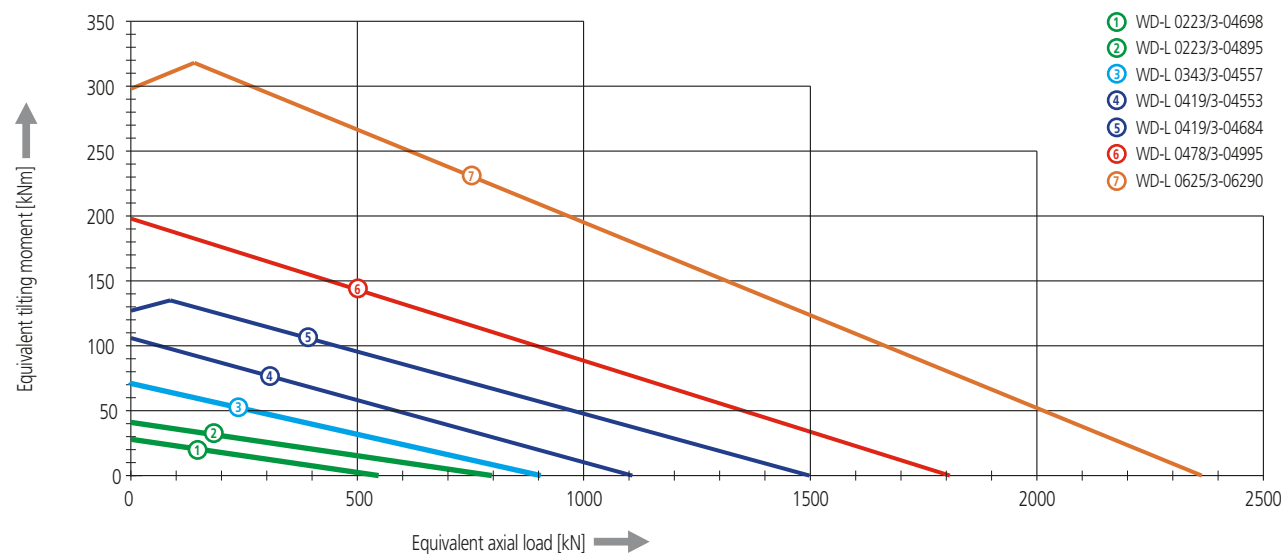


### Maximum torque $M_{d\max}$ of individual sizes



### Limiting load diagrams of individual sizes for "compressive" load

Please refer to the explanations in the Technical Information section of the catalog



Due to the high gear ratio and the large surface contact between worm and worm gear, very high torque values can be transmitted using very small sized Slew Drives (highest power density). Worm gear driven Slew Drives of the light series WD-L are short-cycle drives for rotation and swiveling applications. Use in continuous rotation applications is not permissible due to higher duty. The duty should be selected so that over-heating around the gearing contact cannot occur. Diagram 2 exhibits the maximum permissible duty per minute, depending upon operation torque. When this maximum permissible duty per minute  $ED_{\max}$  is exceeded, the permissibility must be checked by the IMO Engineering Department.

The following conditions apply when determining the maximum permissible duty per minute and when verifying the wear characteristic of worm gearing:

- Output speed:  $n = 1.0$  rpm
- Wear safety factor of worm gearing:  $S_W = 1.3$
- Observance of the maximum permissible duty  $ED_{\max}$  (see diagram 2)
- Ambient temperature  $20^\circ\text{C}$

### Determining the maximum permissible duty per minute $ED_{\max}$ :

The maximum permissible duty per minute should never be exceeded

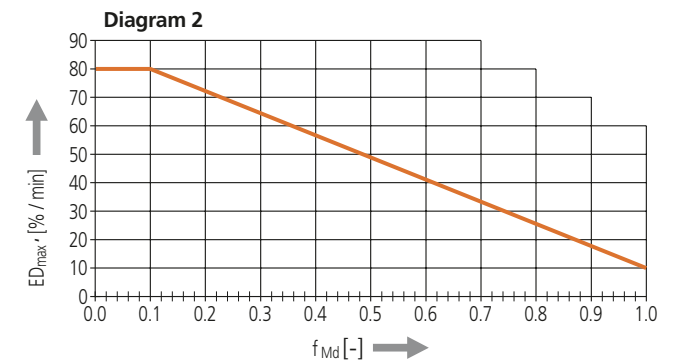
$ED_{\max}$ : Maximum permissible duty per minute in percent per minute [% / min] (see diagram 2)

$$f_{Md} = M_{dB} / M_{d\max}$$

$f_{Md}$ : Ratio of operating torque to maximum torque [-]

$M_{dB}$ : Operating torque [Nm]

$M_{d\max}$ : Maximum torque [Nm] (see diagram 1)



### Wear characteristics of the worm gearing:

$G_w$ : Limit value [h] (see diagram 3)

$B_h$ : Operation time [h]

The operation is permissible as regards wear characteristics, if the following relationship prevails:

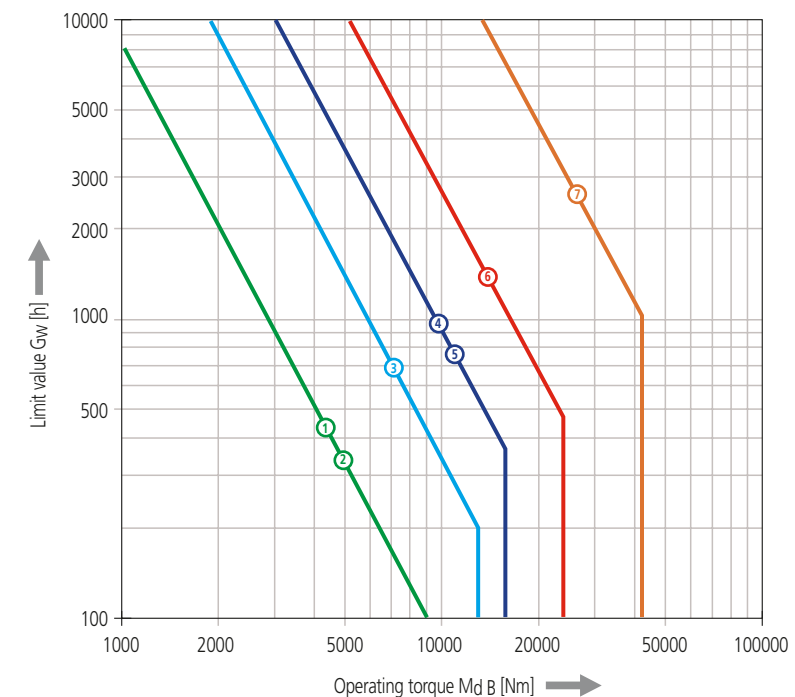
$ED_B$ : Duty in operation [%]

$M_{dB}$ : Operating torque [Nm]

$$G_w \geq B_h \cdot \frac{ED_B}{100}$$

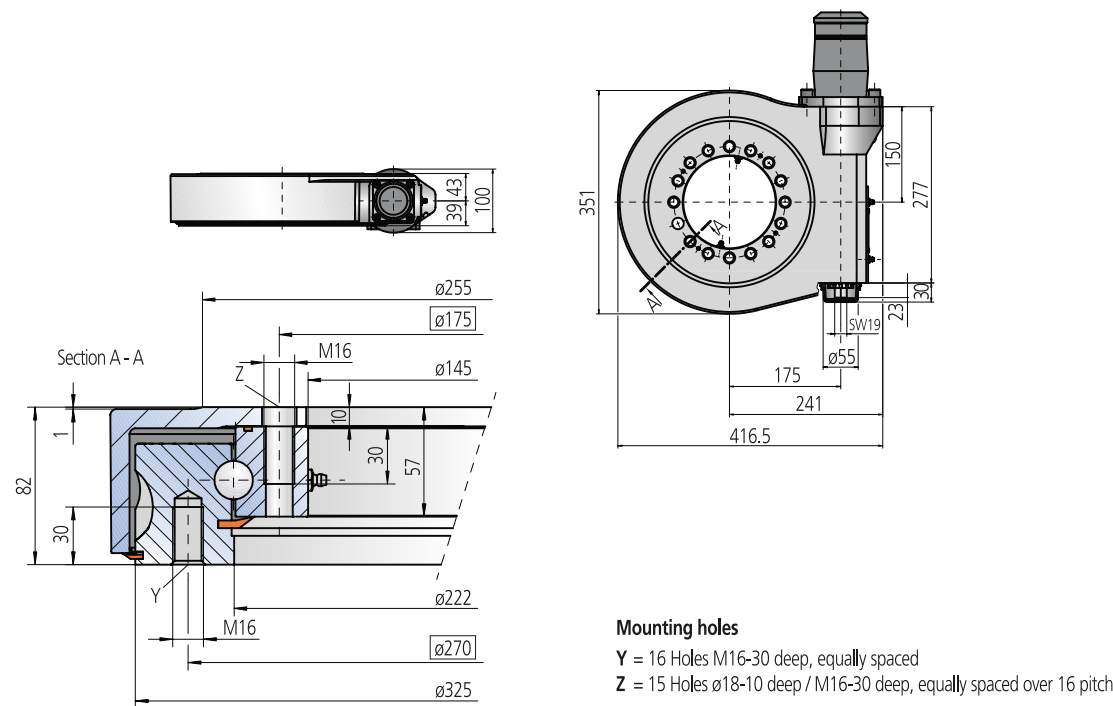
If this relationship is not fulfilled, a high rate of wear must be expected.

### Diagram 3





## Size 0223 / single row



Note, mounting face against upper surface shall be within the limits of  $\varnothing 223$  and  $\varnothing 329$

**Mounting holes**  
**Y** = 16 Holes M16-30 deep, equally spaced  
**Z** = 15 Holes  $\varnothing 18$ -10 deep / M16-30 deep, equally spaced over 16 pitch

**Lubrication ports**  
 2 Taper type grease nipples on the internal diameter  
 2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

**Drawing reference number WD-L 0223/3-04698**

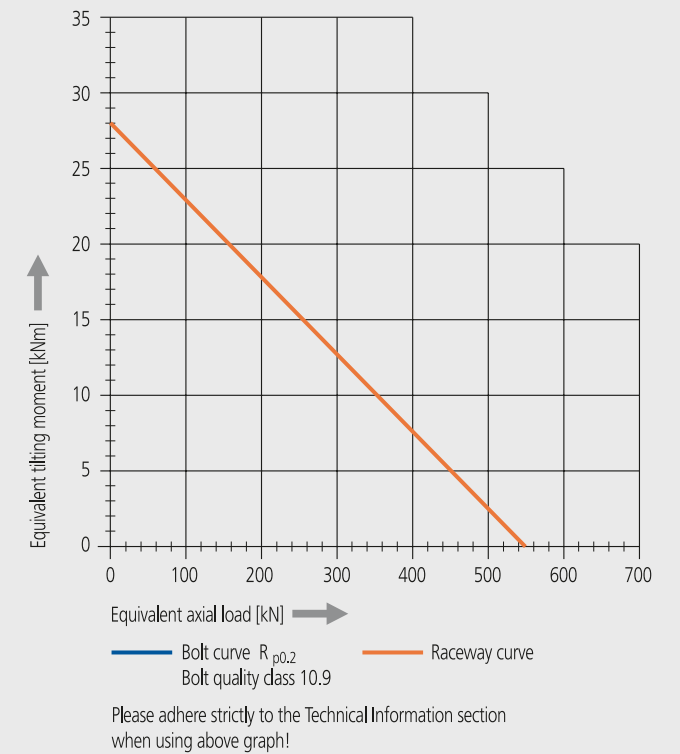
Module	<b>m</b> [mm]	5
Number of starts of the worm	[-]	1
Gear ratio	<b>i</b> [-]	62
Self-locking gears		no**
Maximum torque $s_{FS} = 1$	<b>M<sub>d max</sub></b> [Nm]	9303
Nom. torque $s_{FS} = 1$ at $n = 1$ rpm	<b>M<sub>d nom</sub></b> [Nm]	4795
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	9303
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	204
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	547
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	132
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	154
Weight	[kg]	48

\*Optional with brake  
 \*\*Self-locking with mounted permanent brake or with mounted hydraulic motor and oil return stop

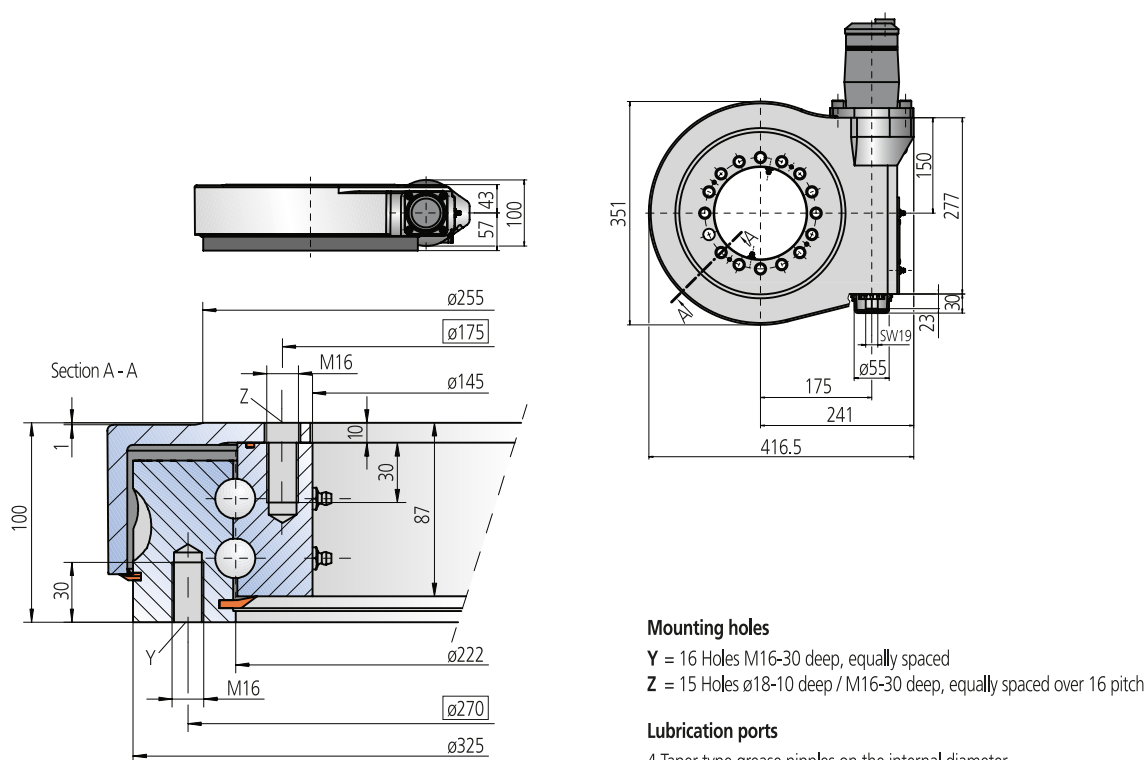
The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
 Selection example: performance data with hydraulic motor H-160

Pressure differential	$\Delta p$ [bar]	145
Oil flow	<b>Q</b> [l/min]	14
Output speed	<b>n</b> [rpm]	1
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	9303

Limiting load diagram for 'compressive' load



## Size 0223 / double row



Note, mounting face against upper surface shall be within the limits of  $\varnothing 223$  and  $\varnothing 329$

**Mounting holes**  
**Y** = 16 Holes M16-30 deep, equally spaced  
**Z** = 15 Holes  $\varnothing 18$ -10 deep / M16-30 deep, equally spaced over 16 pitch

**Lubrication ports**  
 4 Taper type grease nipples on the internal diameter  
 2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

**Drawing reference number WD-L 0223/3-04895**

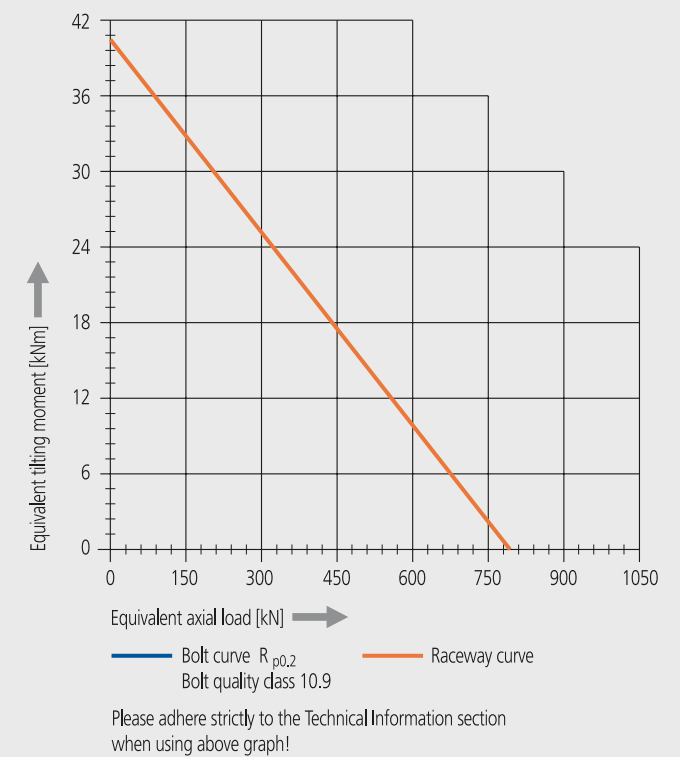
Module	<b>m</b> [mm]	5
Number of starts of the worm	[-]	1
Gear ratio	<b>i</b> [-]	62
Self-locking gears		no**
Maximum torque $s_{FS} = 1$	<b>M<sub>d max</sub></b> [Nm]	9303
Nom. torque $s_{FS} = 1$ at $n = 1$ rpm	<b>M<sub>d nom</sub></b> [Nm]	4795
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	9303
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	297
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	797
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	215
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	250
Weight	[kg]	64

\*Optional with brake  
 \*\*Self-locking with mounted permanent brake or with mounted hydraulic motor and oil return stop

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
 Selection example: performance data with hydraulic motor H-160

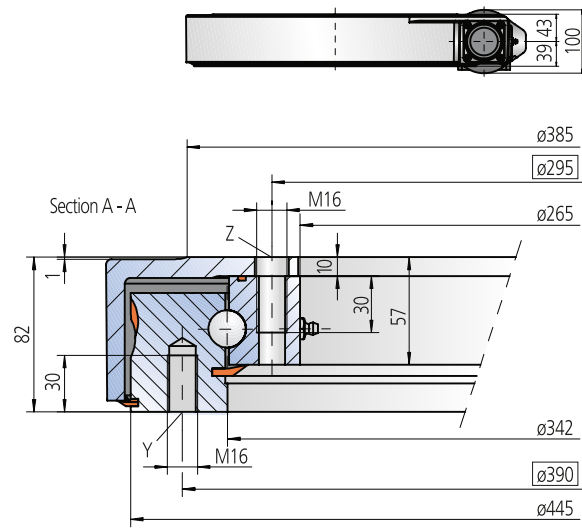
Pressure differential	$\Delta p$ [bar]	145
Oil flow	<b>Q</b> [l/min]	14
Output speed	<b>n</b> [rpm]	1
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	9303

Limiting load diagram for 'compressive' load

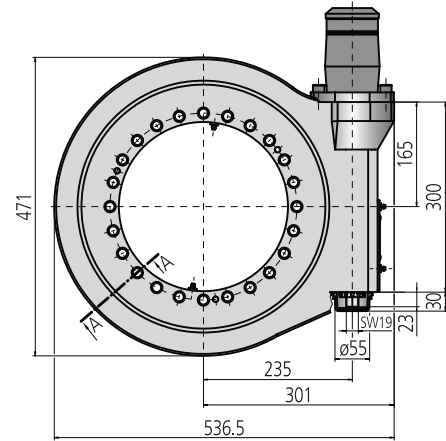




## Size 0343 / single row



Note, mounting face against upper surface shall be within the limits of  $\varnothing 343$  and  $\varnothing 449$



### Mounting holes

Y = 18 Holes M16-30 deep, equally spaced  
Z = 24 Holes  $\varnothing 18-10$  deep / M16-30 deep, equally spaced

### Lubrication ports

2 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

**Drawing reference number WD-L 0343/3-04557**

Module	<b>m</b> [mm]	5
Number of starts of the worm	[-]	1
Gear ratio	<b>i</b> [-]	86
Self-locking gears		no**
Maximum torque $s_{FS} = 1$	<b>M<sub>d max</sub></b> [Nm]	12905
Nom. torque $s_{FS} = 1$ at $n = 1$ rpm	<b>M<sub>d nom</sub></b> [Nm]	10150
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	12905
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	338
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	905
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	157
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	183
Weight	[kg]	72

\*Optional with brake

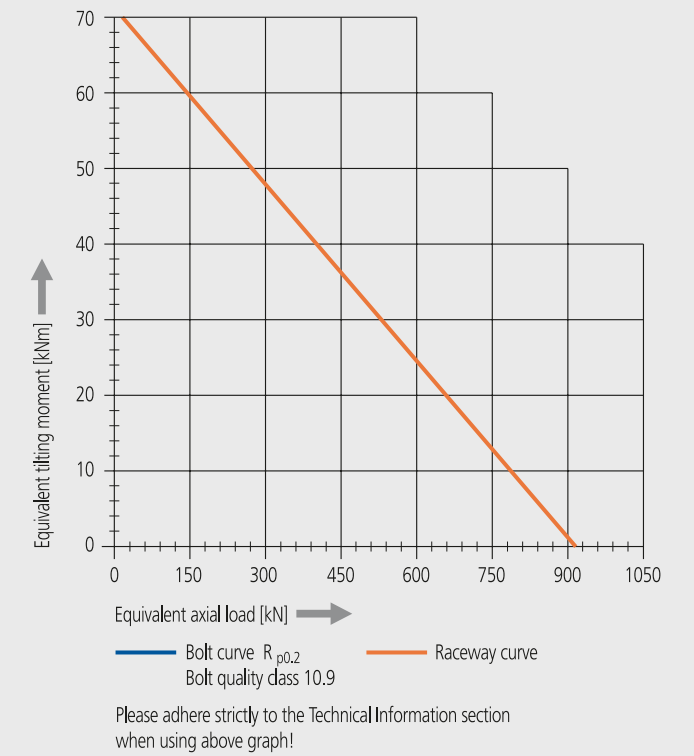
\*\*Self-locking with mounted permanent brake or with mounted hydraulic motor and oil return stop

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.

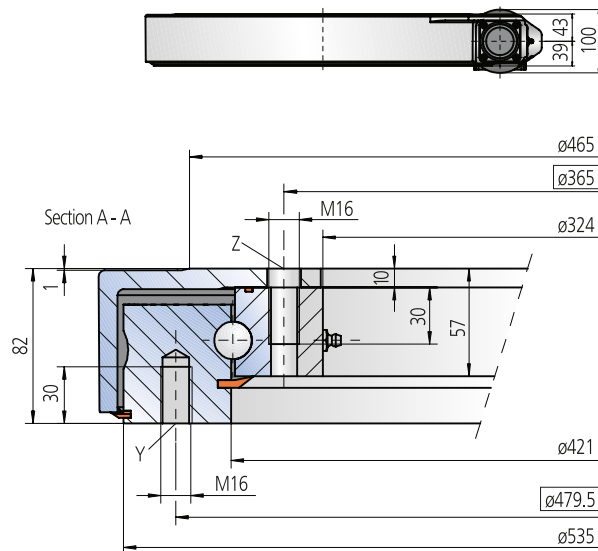
Selection example: performance data with hydraulic motor H-160

Pressure differential	<b><math>\Delta p</math></b> [bar]	145
Oil flow	<b>Q</b> [l/min]	18
Output speed	<b>n</b> [rpm]	1
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	12905

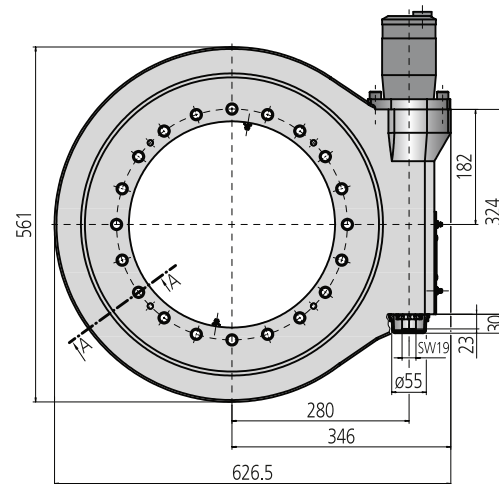
### Limiting load diagram for 'compressive' load



## Size 0419 / single row



Note, mounting face against upper surface shall be within the limits of  $\varnothing 419$  and  $\varnothing 539$



### Mounting holes

Y = 20 Holes M16-30 deep, equally spaced  
Z = 20 Holes  $\varnothing 18-10$  deep / M16-30 deep, equally spaced

### Lubrication ports

2 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

**Drawing reference number WD-L 0419/3-04553**

Module	<b>m</b> [mm]	5
Number of starts of the worm	[-]	1
Gear ratio	<b>i</b> [-]	104
Self-locking gears		no**
Maximum torque $s_{FS} = 1$	<b>M<sub>d max</sub></b> [Nm]	15606
Nom. torque $s_{FS} = 1$ at $n = 1$ rpm	<b>M<sub>d nom</sub></b> [Nm]	15606
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	15606
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	413
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	1107
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	170
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	198
Weight	[kg]	89

\*Optional with brake

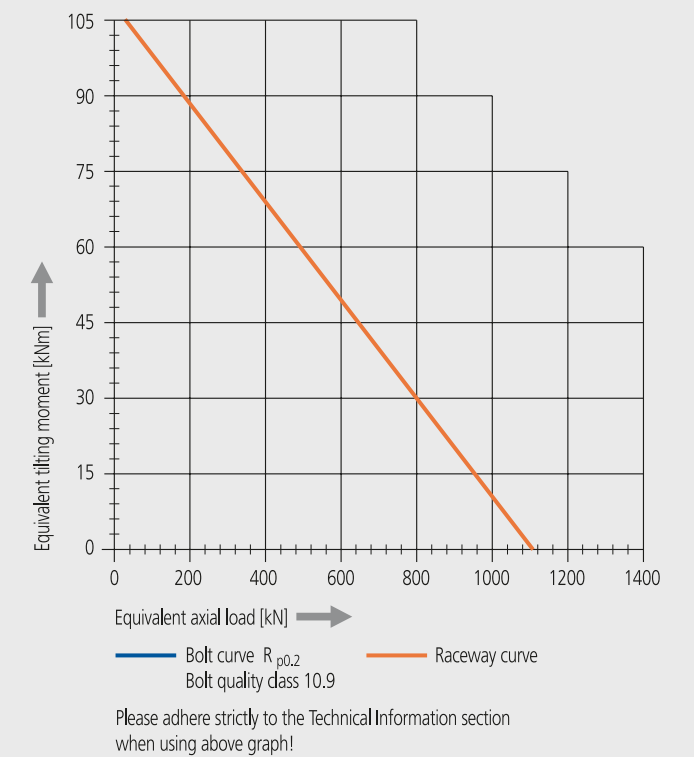
\*\*Self-locking with mounted permanent brake or with mounted hydraulic motor and oil return stop

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.

Selection example: performance data with hydraulic motor H-160

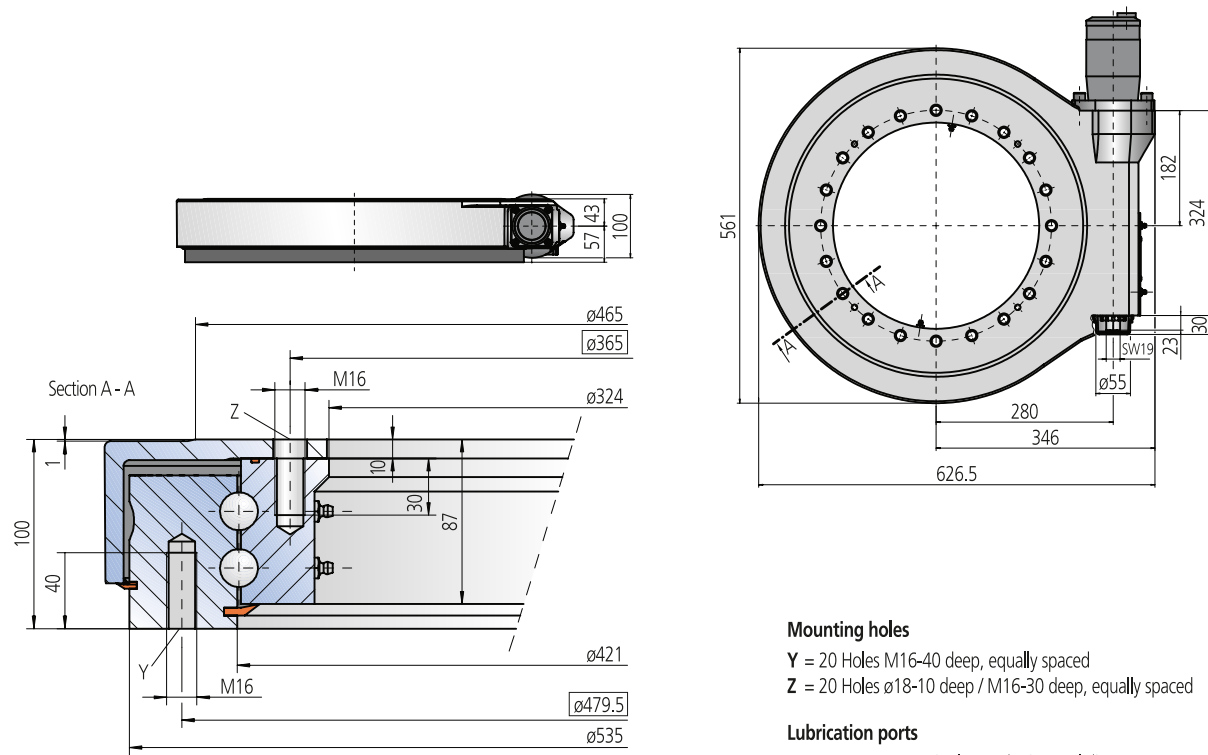
Pressure differential	<b><math>\Delta p</math></b> [bar]	145
Oil flow	<b>Q</b> [l/min]	20
Output speed	<b>n</b> [rpm]	1
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	15606

### Limiting load diagram for 'compressive' load





Size 0419 / double row



Note, mounting face against upper surface shall be within the limits of ø419 and ø539

- Mounting holes**  
 Y = 20 Holes M16-40 deep, equally spaced  
 Z = 20 Holes ø18-10 deep / M16-30 deep, equally spaced
- Lubrication ports**  
 4 Taper type grease nipples on the internal diameter  
 2 Taper type grease nipples on the outside of the housing  
 Slew Drive supplied pre-lubricated

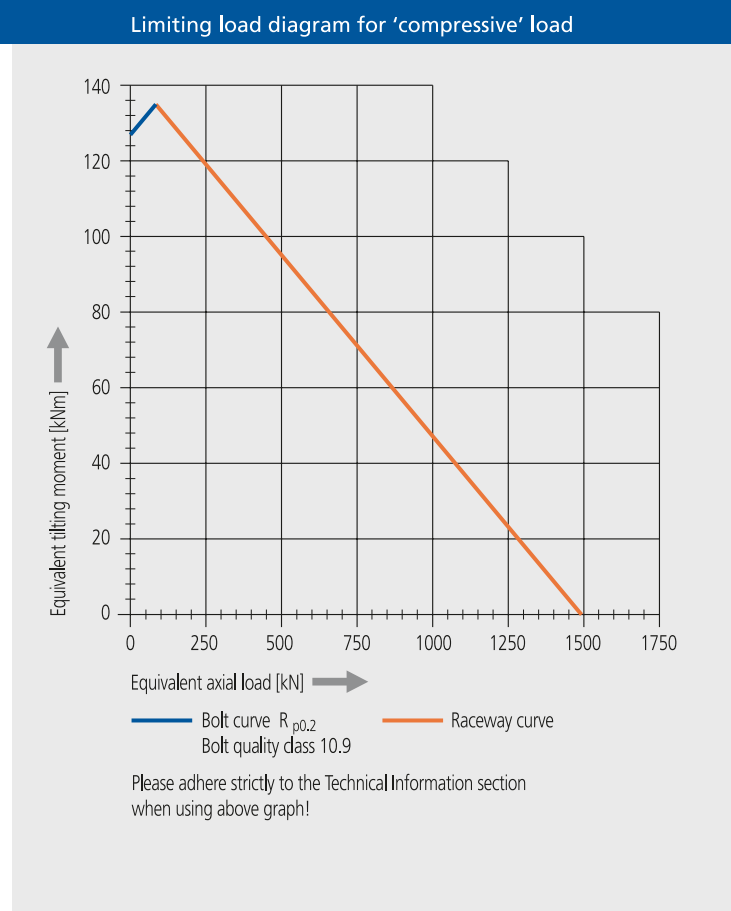
**Drawing reference number WD-L 0419/3-04684**

Module	m	[mm]	5
Number of starts of the worm		[-]	1
Gear ratio	i	[-]	104
Self-locking gears			no**
Maximum torque sfs = 1	<b>M<sub>d max</sub></b>	[Nm]	15606
Nom. torque sfs = 1 at n = 1 rpm	<b>M<sub>d nom</sub></b>	[Nm]	15606
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	15606
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	559
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	1498
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	277
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	323
Weight		[kg]	117

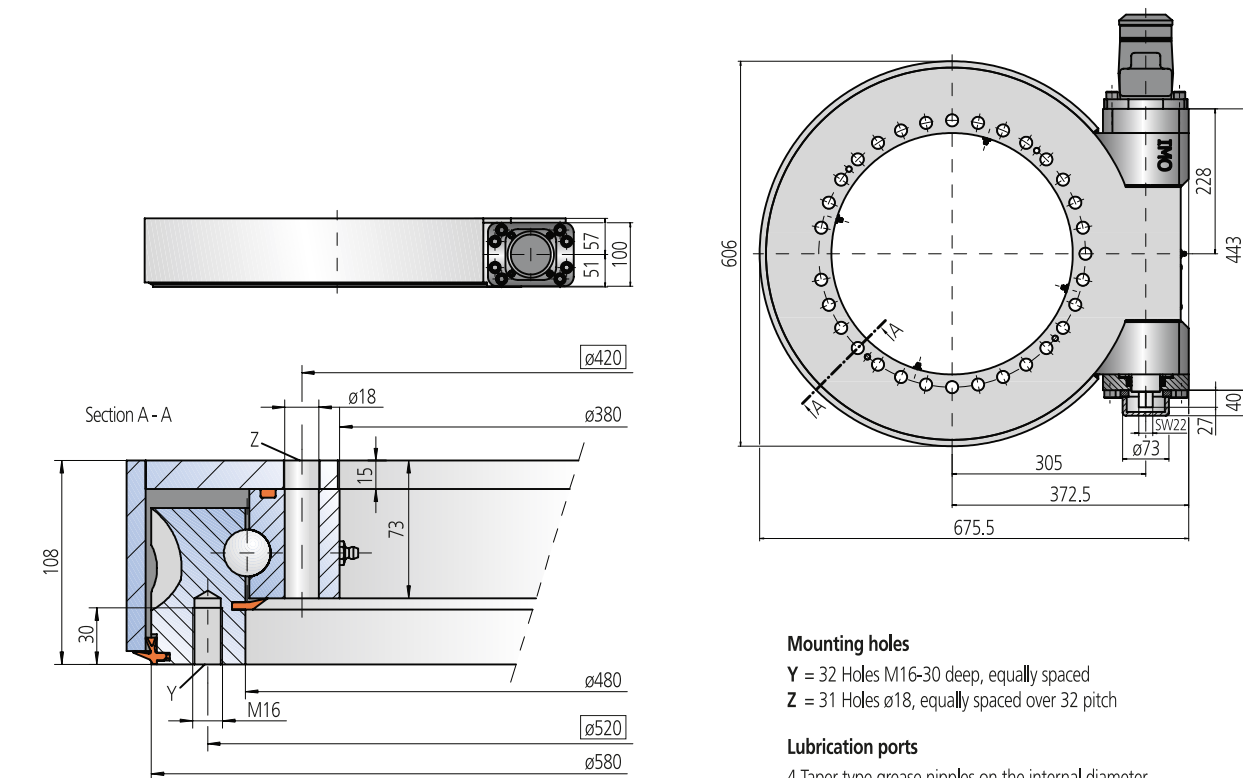
\*Optional with brake  
 \*\*Self-locking with mounted permanent brake or with mounted hydraulic motor and oil return stop

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
 Selection example: performance data with hydraulic motor H-160

Pressure differential	<b>Δp</b>	[bar]	145
Oil flow	<b>Q</b>	[l/min]	20
Output speed	<b>n</b>	[rpm]	1
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	15606



Size 0478 / single row



Note, mounting face against upper surface shall be within the limits of ø478 and ø584

- Mounting holes**  
 Y = 32 Holes M16-30 deep, equally spaced  
 Z = 31 Holes ø18, equally spaced over 32 pitch
- Lubrication ports**  
 4 Taper type grease nipples on the internal diameter  
 1 Taper type grease nipples on the outside of the housing  
 Slew Drive supplied pre-lubricated

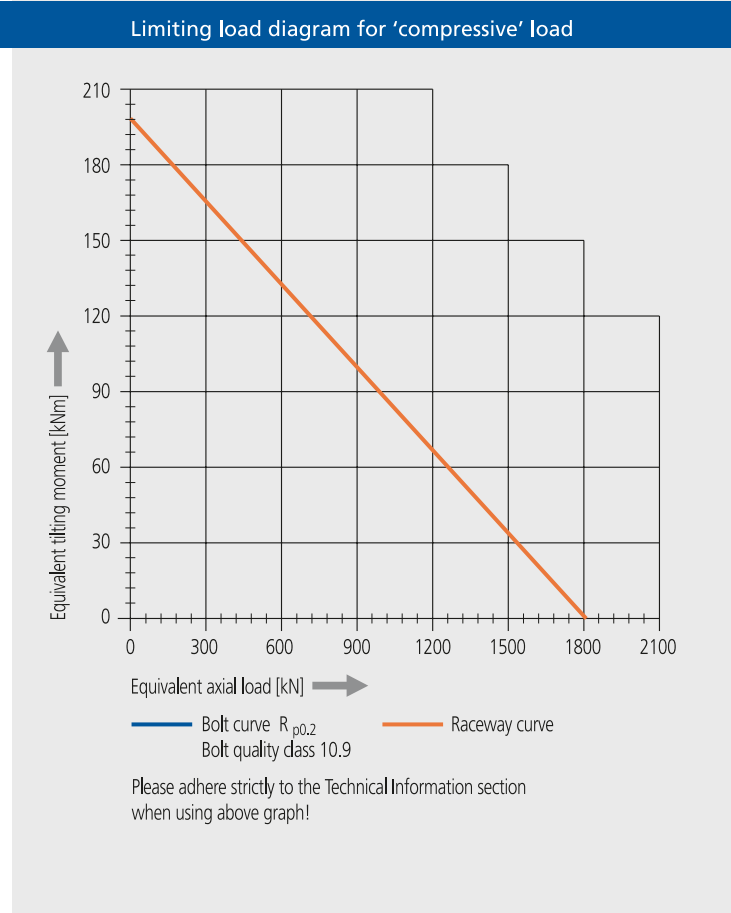
**Drawing reference number WD-L 0478/3-04995**

Module	m	[mm]	6
Number of starts of the worm		[-]	1
Gear ratio	i	[-]	93
Self-locking gears			no**
Maximum torque sfs = 1	<b>M<sub>d max</sub></b>	[Nm]	24288
Nom. torque sfs = 1 at n = 1 rpm	<b>M<sub>d nom</sub></b>	[Nm]	24288
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	24288
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	675
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	1808
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	251
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	293
Weight		[kg]	130

\*Optional with brake  
 \*\*Self-locking with mounted permanent brake or with mounted hydraulic motor and oil return stop

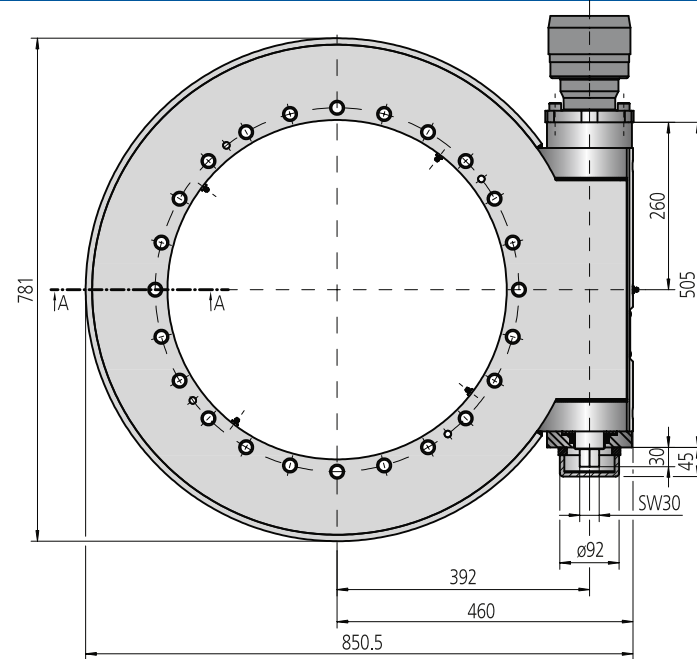
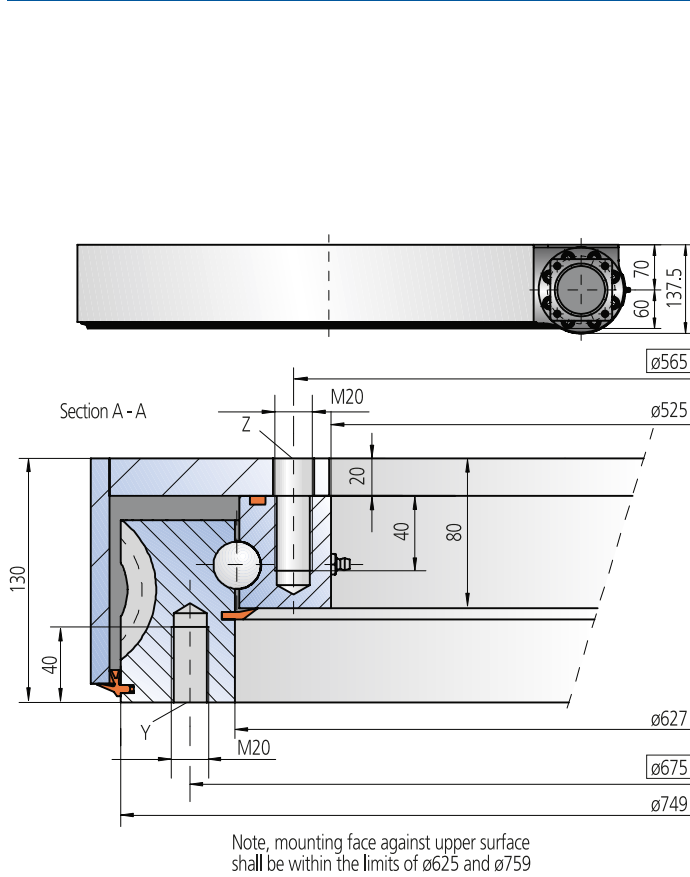
The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
 Selection example: performance data with hydraulic motor 2-200

Pressure differential	<b>Δp</b>	[bar]	200
Oil flow	<b>Q</b>	[l/min]	24
Output speed	<b>n</b>	[rpm]	1
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	24288





## Size 0625 / single row



**Mounting holes**  
**Y** = 24 Holes M20-40 deep, equally spaced  
**Z** = 24 Holes  $\varnothing 20$ -22 deep / M20-40 deep, equally spaced

**Lubrication ports**  
 4 Taper type grease nipples on the internal diameter  
 1 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

**Drawing reference number WD-L 0625/3-06290**

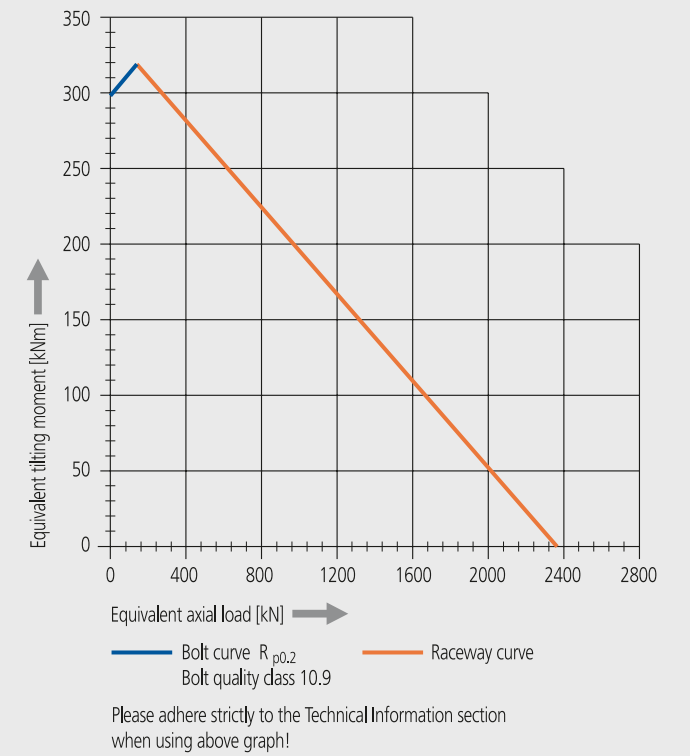
Module	<b>m</b> [mm]	7
Number of starts of the worm	[-]	1
Gear ratio	<b>i</b> [-]	104
Self-locking gears		no**
Maximum torque $sfs = 1$	<b>M<sub>d max</sub></b> [Nm]	42824
Nom. torque $sfs = 1$ at $n = 1$ rpm	<b>M<sub>d nom</sub></b> [Nm]	42824
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	42824
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	883
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	2364
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	280
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	327
Weight	[kg]	250

\*Optional with brake  
 \*\*Self-locking with mounted permanent brake or with mounted hydraulic motor and oil return stop

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
 Selection example: performance data with hydraulic motor RE-18

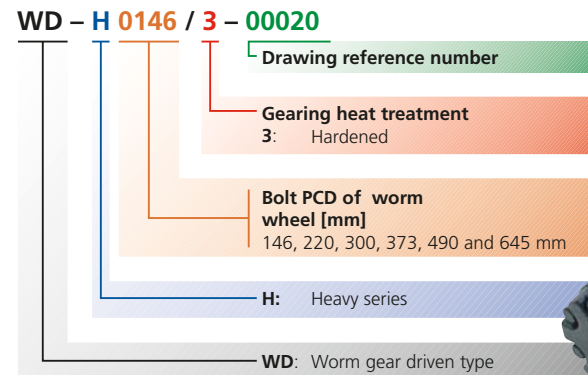
Pressure differential	$\Delta p$ [bar]	210
Oil flow	<b>Q</b> [l/min]	40
Output speed	<b>n</b> [rpm]	1
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	42824

Limiting load diagram for 'compressive' load





## Series Overview



Due to the high gear ratio and the large surface contact between worm and worm gear, very high torque values can be transmitted using very small sized Slew Drives (highest power density). Worm gear driven Slew Drives of the heavy series, WD-H, are short-cycle units for rotation and swiveling applications. Use in applications with continuous rotation is not permissible, due to the higher duty. The duty is to be selected so that over-heating around the gearing contact cannot occur. Diagram 2 exhibits maximum permissible duty per minute, depending upon operation torque. When this maximum permissible duty per minute  $ED_{max}$  is exceeded, the permissibility must be checked by the IMO Engineering Department.

The following conditions apply when determining the maximum permissible duty per minute and when verifying the wear characteristic of worm gearing:

- Output speed:  $n = 1.0$  rpm
- Wear safety factor of worm gearing:  $S_w = 1.3$
- Observance of the maximum permissible duty per minute  $ED_{max}$  (see diagram 2)
- Ambient temperature  $20^\circ\text{C}$

### Determining the maximum permissible duty per minute $ED_{max}$ :

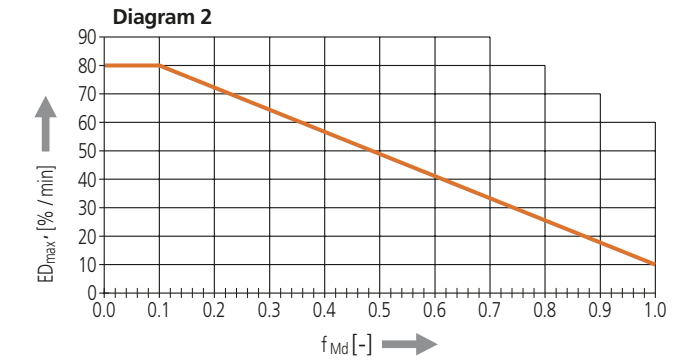
The maximum permissible duty per minute may never be exceeded

$ED_{max}$ : Maximum permissible duty per minute in percent per minute [% / min] (see diagram 2)

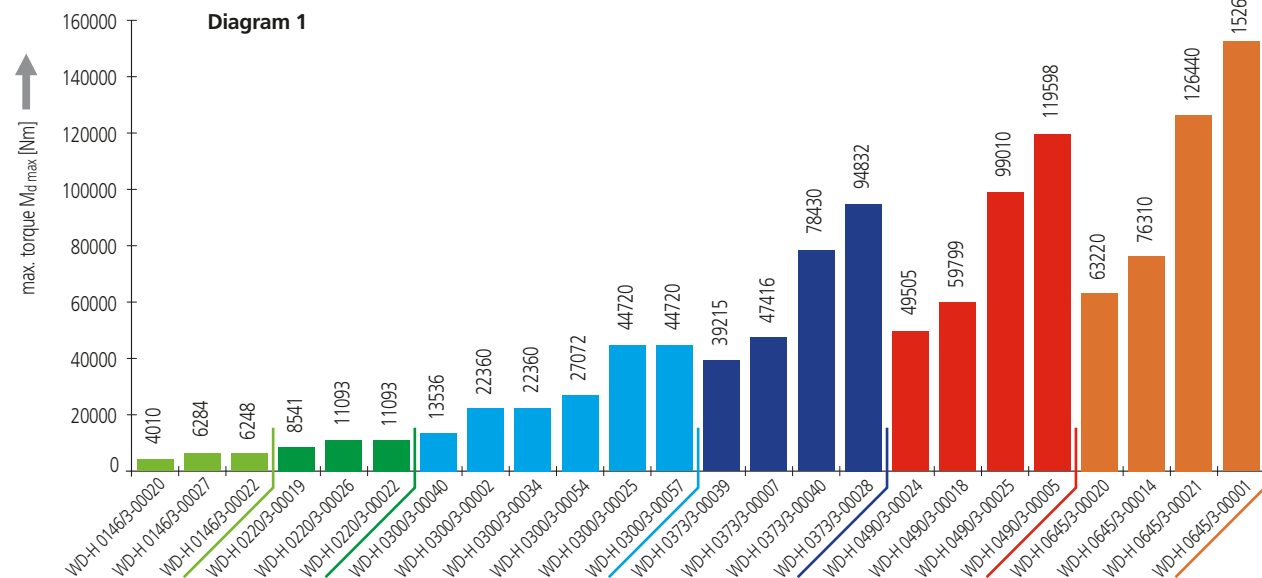
$$f_{Md} = M_{dB} / M_{dmax}$$

$f_{Md}$ : Ratio of operating torque to maximum torque [-]

$M_{dB}$ : Operating torque [Nm]  
 $M_{dmax}$ : Maximum torque [Nm] (see diagram 1)

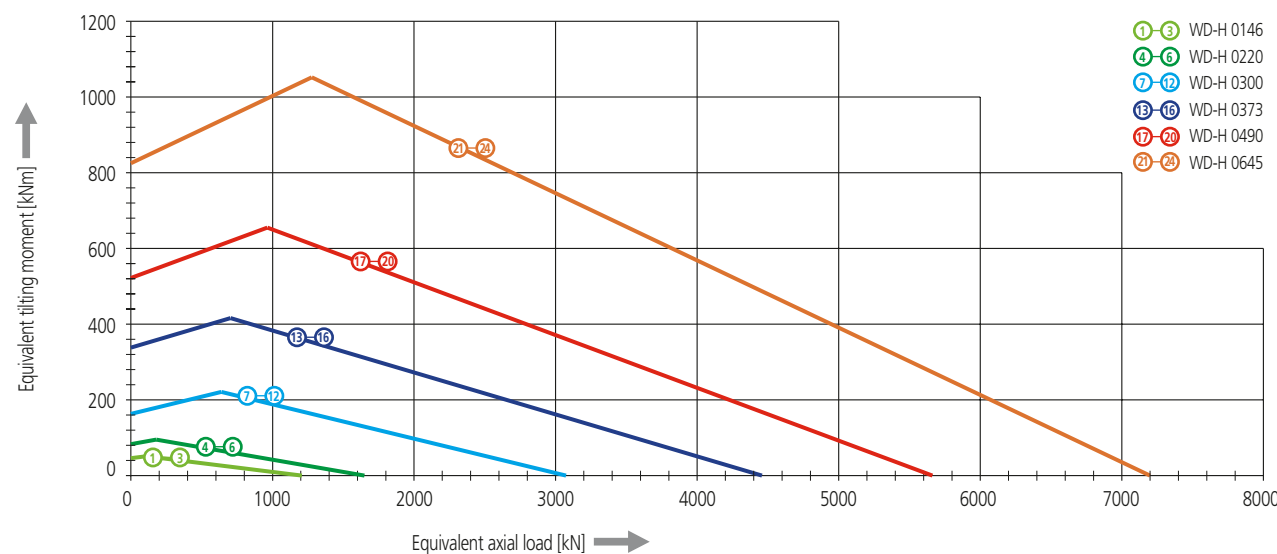


### Maximum torque $M_{dmax}$ of individual sizes



### Limiting load diagrams of individual sizes for "compressive" load

Please refer to the explanations in the Technical Information section of the catalog



### Wear characteristics of the worm gear:

$G_w$ : Limit value [h] (see diagram 3)  
 $B_h$ : Operation time [h]

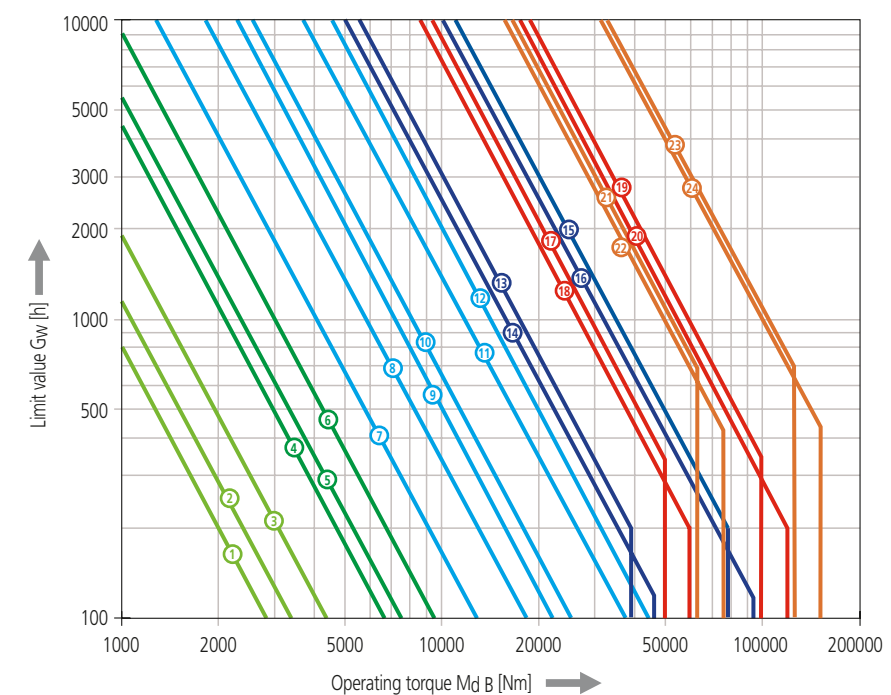
The application is permissible as regards wear characteristics, if the following relationship prevails:

$ED_B$ : Duty [%]  
 $M_{dB}$ : Operating torque [Nm]

$$G_w \geq B_h \cdot \frac{ED_B}{100}$$

If this relationship is not fulfilled, a high rate of wear must be expected.

### Diagram 3

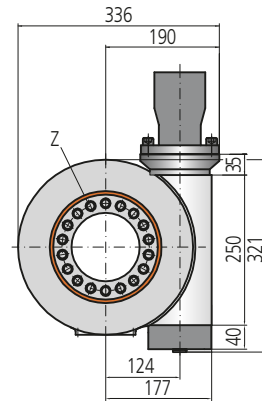
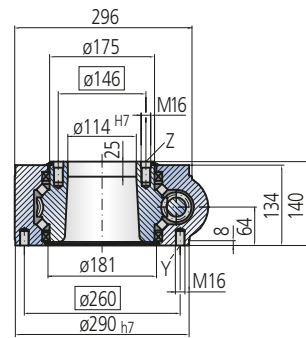


- 1 WD-H 0146/3-00020
- 2 WD-H 0146/3-00027
- 3 WD-H 0146/3-00022
- 4 WD-H 0220/3-00019
- 5 WD-H 0220/3-00026
- 6 WD-H 0220/3-00022
- 7 WD-H 0300/3-00040
- 8 WD-H 0300/3-00002
- 9 WD-H 0300/3-00034
- 10 WD-H 0300/3-00054
- 11 WD-H 0300/3-00025
- 12 WD-H 0300/3-00057
- 13 WD-H 0373/3-00039
- 14 WD-H 0373/3-00007
- 15 WD-H 0373/3-00040
- 16 WD-H 0373/3-00028
- 17 WD-H 0490/3-00024
- 18 WD-H 0490/3-00018
- 19 WD-H 0490/3-00025
- 20 WD-H 0490/3-00005
- 21 WD-H 0645/3-00020
- 22 WD-H 0645/3-00014
- 23 WD-H 0645/3-00021
- 24 WD-H 0645/3-00001

For slew drives with 2 drives, the limit lines for swivel angle  $\leq 170^\circ$  applies



## Size 0146



### Mounting holes

Y = 20 Holes M16-24 deep, equally spaced  
Z = 18 Holes  $\phi$ 17-10 deep / M16-25 deep, equally spaced

### Lubrication ports

1 Taper type grease nipple on the outside of the housing  
Slew Drive supplied pre-lubricated

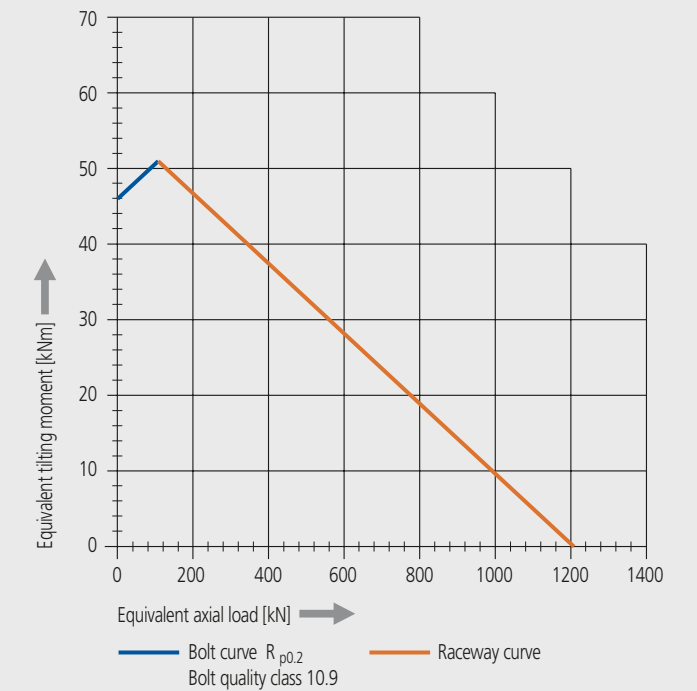
Drawing reference number WD-H 0146/3-00022				
Drawing reference number WD-H 0146/3-00027				
Drawing reference number WD-H 0146/3-00020				
Module	m [mm]	3	4	4
Number of starts of the worm	[-]	1	1	2
Gear ratio	i [-]	68	51	25.5
Self-locking gears**		yes	yes	no
Maximum torque $s_{FS} = 1$	$M_{d max}$ [Nm]	4010	6284	6284
Nom. torque $s_{FS} = 1$ at $n = 3$ rpm	$M_{d nom}$ [Nm]	1950	2100	2300
Maximum holding torque*	$M_h$ [Nm]	4010	6284	6284
Static load rating, radial	$C_{o rad}$ [kN]	451	451	451
Static load rating, axial	$C_{o ax}$ [kN]	1208	1208	1208
Dynamic load rating, radial	$C_{rad}$ [kN]	172	172	172
Dynamic load rating, axial	$C_{ax}$ [kN]	199	199	199
Weight	[kg]	63	63	63

\*Optional with brake  
\*\*See technical data

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

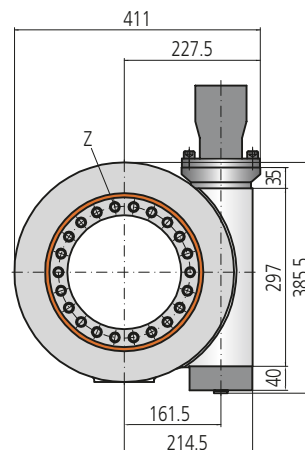
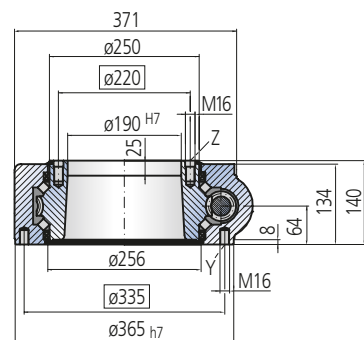
Pressure differential	$\Delta p$ [bar]	50	80	110
Oil flow	Q [l/min]	60	46	28
Output speed	n [rpm]	3	3	3
Maximum achievable torque	$M_d$ [Nm]	4010	6284	6284

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0220



### Mounting holes

Y = 24 Holes M16-24 deep, equally spaced  
Z = 22 Holes  $\phi$ 17-10 deep / M16-25 deep, equally spaced

### Lubrication ports

1 Taper type grease nipple on the outside of the housing  
Slew Drive supplied pre-lubricated

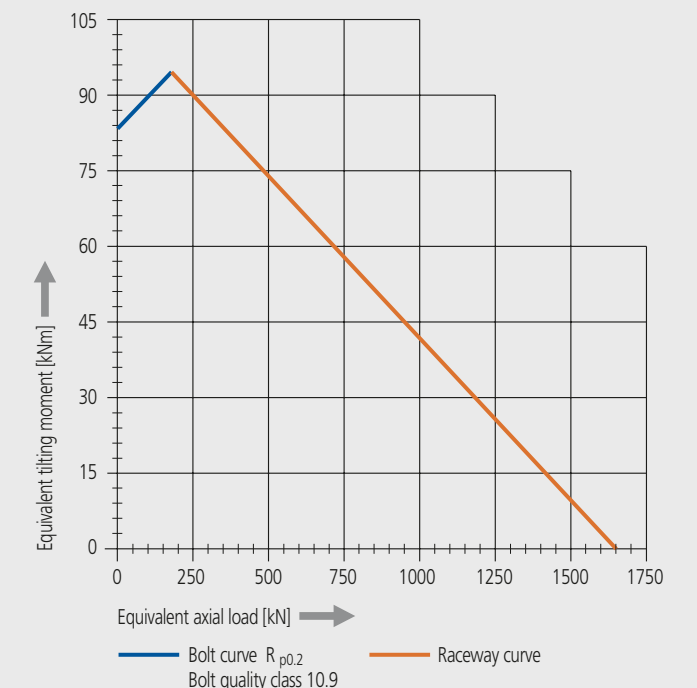
Drawing reference number WD-H 0220/3-00022				
Drawing reference number WD-H 0220/3-00026				
Drawing reference number WD-H 0220/3-00019				
Module	m [mm]	4	5	5
Number of starts of the worm	[-]	1	1	2
Gear ratio	i [-]	70	56	28
Self-locking gears**		yes	no	no
Maximum torque $s_{FS} = 1$	$M_{d max}$ [Nm]	8541	11093	11093
Nom. torque $s_{FS} = 1$ at $n = 3$ rpm	$M_{d nom}$ [Nm]	4550	4800	5150
Maximum holding torque*	$M_h$ [Nm]	8541	11093	11093
Static load rating, radial	$C_{o rad}$ [kN]	616	616	616
Static load rating, axial	$C_{o ax}$ [kN]	1650	1650	1650
Dynamic load rating, radial	$C_{rad}$ [kN]	193	193	193
Dynamic load rating, axial	$C_{ax}$ [kN]	224	224	224
Weight	[kg]	80	80	80

\*Optional with brake  
\*\*See technical data

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor HB-12

Pressure differential	$\Delta p$ [bar]	110	150	220
Oil flow	Q [l/min]	44	37	25
Output speed	n [rpm]	3	3	3
Maximum achievable torque	$M_d$ [Nm]	8541	11093	11093

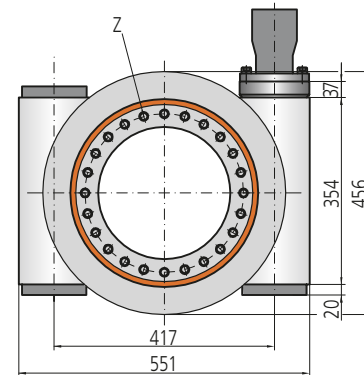
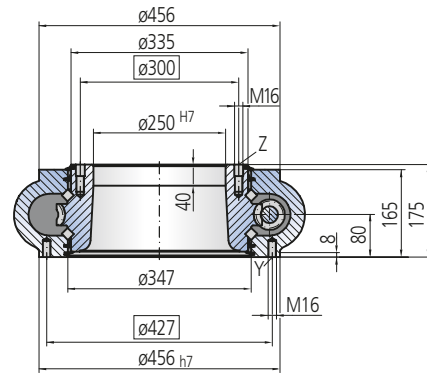
### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!



## Size 0300 / single drive



### Mounting holes

Y = 24 Holes M16-30 deep, equally spaced  
Z = 24 Holes ø17-22 deep / M16-30 deep, equally spaced

### Lubrication ports

1 Taper type grease nipple on the outside of the housing on the right side  
3 Taper type grease nipples on the outside of the housing on the left side

Slew Drive supplied pre-lubricated

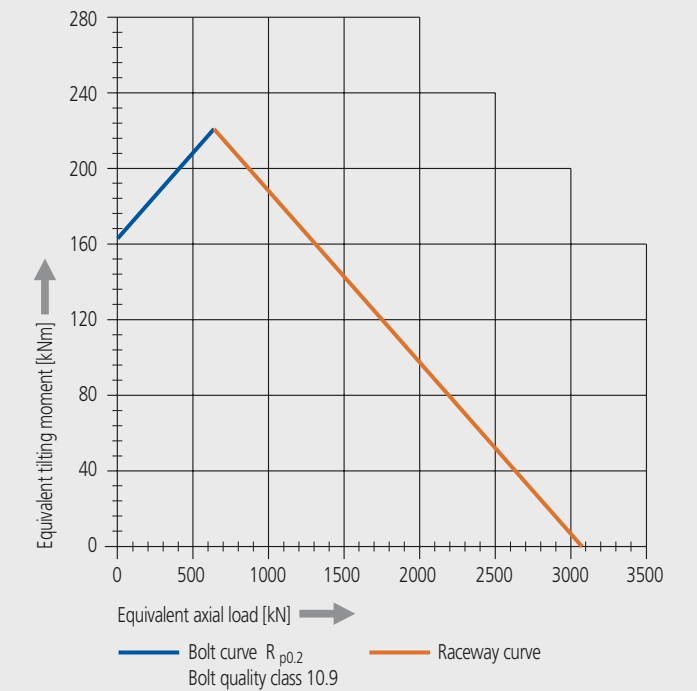
Drawing reference number WD-H 0300/3-00034				
Drawing reference number WD-H 0300/3-00002				
Drawing reference number WD-H 0300/3-00040				
Module	m [mm]	4.5	6	6
Number of starts of the worm	[-]	1	1	2
Gear ratio	i [-]	84	61	30.5
Self-locking gears**		yes	no	no
Maximum torque $s_{FS} = 1$	$M_{d max}$ [Nm]	13536	22360	22360
Nom. torque $s_{FS} = 1$ at $n = 2$ rpm	$M_{d nom}$ [Nm]	9000	12600	14000
Maximum holding torque*	$M_h$ [Nm]	13536	22360	22360
Static load rating, radial	$C_{o rad}$ [kN]	1506	1506	1506
Static load rating, axial	$C_{o ax}$ [kN]	3074	3074	3074
Dynamic load rating, radial	$C_{rad}$ [kN]	316	316	316
Dynamic load rating, axial	$C_{ax}$ [kN]	445	445	445
Weight	[kg]	160	160	160

\*Optional with brake  
\*\*See technical data

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor RE-26

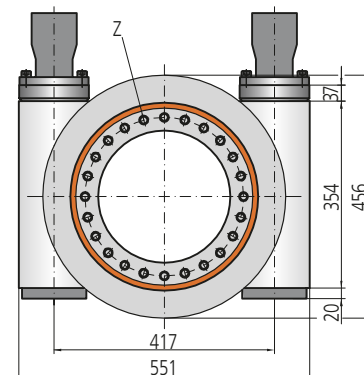
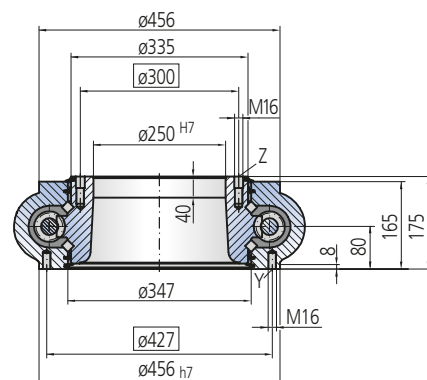
Pressure differential	$\Delta p$ [bar]	85	125	180
Oil flow	Q [l/min]	80	61	35
Output speed	n [rpm]	2	2	2
Maximum achievable torque	$M_d$ [Nm]	13565	22360	22360

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0300 / twin drive



### Mounting holes

Y = 24 Holes M16-30 deep, equally spaced  
Z = 24 Holes ø17-22 deep / M16-30 deep, equally spaced

### Lubrication ports

1 Taper type grease nipple on the outside of the housing on the right side and on the left side

Slew Drive supplied pre-lubricated

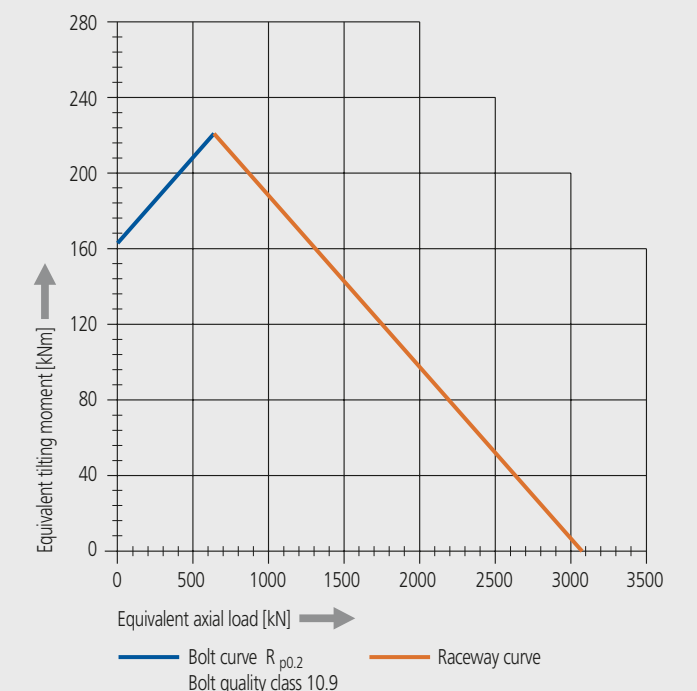
Drawing reference number WD-H 0300/3-00057				
Drawing reference number WD-H 0300/3-00025				
Drawing reference number WD-H 0300/3-00054				
Module	m [mm]	4.5	6	6
Number of starts of the worm	[-]	1	1	2
Gear ratio	i [-]	84	61	30.5
Self-locking gears**		yes	no	no
Maximum torque $s_{FS} = 1$	$M_{d max}$ [Nm]	27072	44720	44720
Nom. torque $s_{FS} = 1$ at $n = 2$ rpm	$M_{d nom}$ [Nm]	18000	25200	28000
Maximum holding torque*	$M_h$ [Nm]	27072	44720	44720
Static load rating, radial	$C_{o rad}$ [kN]	1506	1506	1506
Static load rating, axial	$C_{o ax}$ [kN]	3074	3074	3074
Dynamic load rating, radial	$C_{rad}$ [kN]	316	316	316
Dynamic load rating, axial	$C_{ax}$ [kN]	445	445	445
Weight	[kg]	191	188	180

\*Optional with brake  
\*\*See technical data

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor RE-26

Pressure differential	$\Delta p$ [bar]	85	125	180
Oil flow	Q [l/min]	160	122	70
Output speed	n [rpm]	2	2	2
Maximum achievable torque	$M_d$ [Nm]	27072	44720	44720

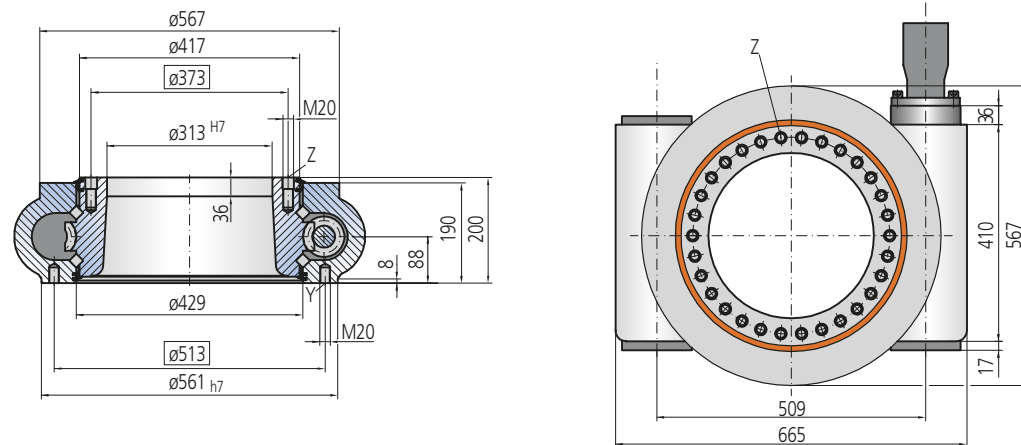
### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!



## Size 0373 / single drive



### Mounting holes

Y = 32 Holes M20-30 deep, equally spaced  
Z = 30 Holes ø22-22 deep / M20-36 deep, equally spaced

### Lubrication ports

1 Taper type grease nipple on the outside of the housing on the right side  
3 Taper type grease nipples on the outside of the housing on the left side

Slew Drive supplied pre-lubricated

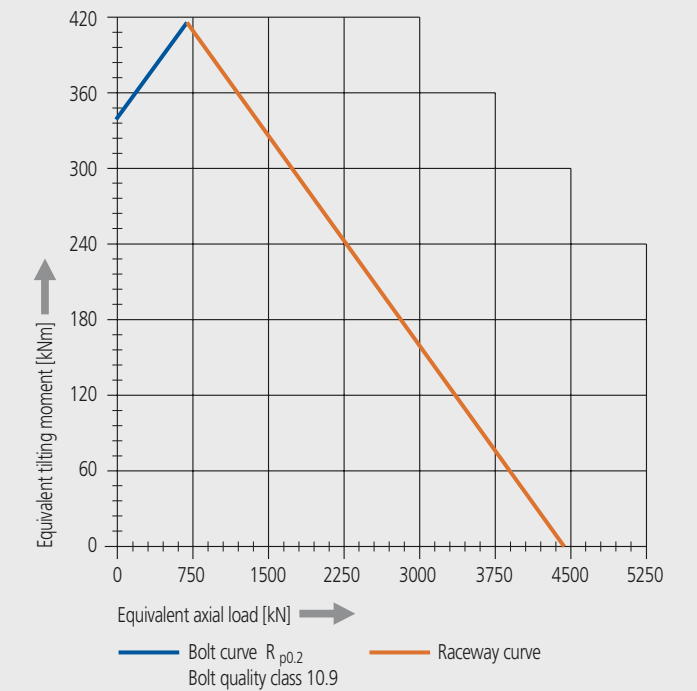
Drawing reference number WD-H 0373/3-00007			
Drawing reference number WD-H 0373/3-00039			
Module	m [mm]	7	8
Number of starts of the worm	[-]	2	1
Gear ratio	i [-]	31.5	56
Self-locking gears**		no	no
Maximum torque $s_{FS} = 1$	$M_{d\ max}$ [Nm]	39215	47416
Nom. torque $s_{FS} = 1$ at $n = 2$ rpm	$M_{d\ nom}$ [Nm]	36000	35500
Maximum holding torque*	$M_h$ [Nm]	39215	47416
Static load rating, radial	$C_{o\ rad}$ [kN]	2185	2185
Static load rating, axial	$C_{o\ ax}$ [kN]	4458	4458
Dynamic load rating, radial	$C_{rad}$ [kN]	442	442
Dynamic load rating, axial	$C_{ax}$ [kN]	622	622
Weight	[kg]	285	285

\*Optional with brake  
\*\*See technical data

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor DT-56

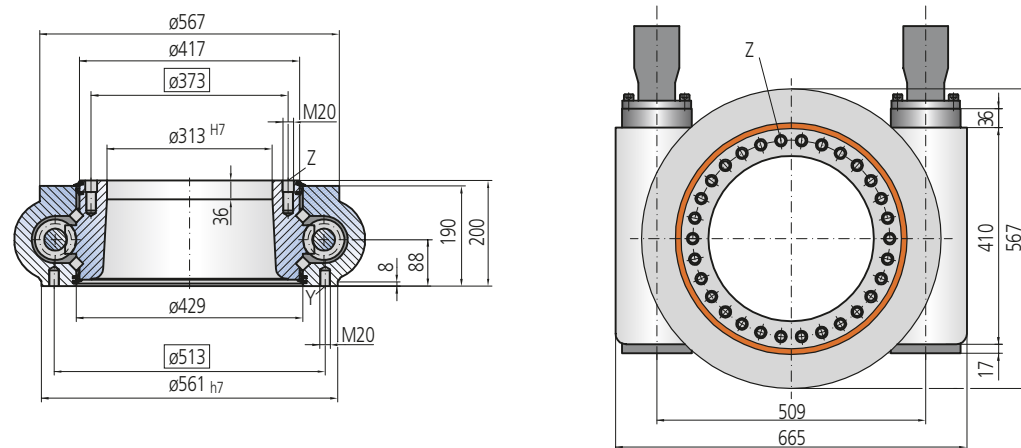
Pressure differential	$\Delta p$ [bar]	165	160
Oil flow	Q [l/min]	75	114
Output speed	n [rpm]	2	2
Maximum achievable torque	$M_d$ [Nm]	39215	47416

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0373 / twin drive



### Mounting holes

Y = 32 Holes M20-30 deep, equally spaced  
Z = 30 Holes ø22-22 deep / M20-36 deep, equally spaced

### Lubrication ports

1 Taper type grease nipple on the outside of the housing on the right side and on the left side

Slew Drive supplied pre-lubricated

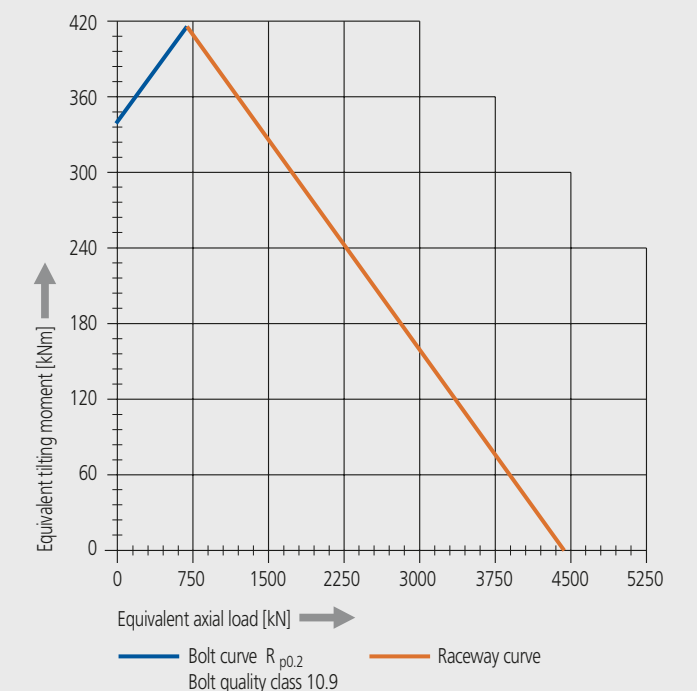
Drawing reference number WD-H 0373/3-00028			
Drawing reference number WD-H 0373/3-00040			
Module	m [mm]	7	8
Number of starts of the worm	[-]	2	1
Gear ratio	i [-]	31.5	56
Self-locking gears**		no	no
Maximum torque $s_{FS} = 1$	$M_{d\ max}$ [Nm]	78430	94832
Nom. torque $s_{FS} = 1$ at $n = 2$ rpm	$M_{d\ nom}$ [Nm]	72000	71000
Maximum holding torque*	$M_h$ [Nm]	78430	94832
Static load rating, radial	$C_{o\ rad}$ [kN]	2185	2185
Static load rating, axial	$C_{o\ ax}$ [kN]	4458	4458
Dynamic load rating, radial	$C_{rad}$ [kN]	442	442
Dynamic load rating, axial	$C_{ax}$ [kN]	622	622
Weight	[kg]	335	335

\*Optional with brake  
\*\*See technical data

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor DT-56

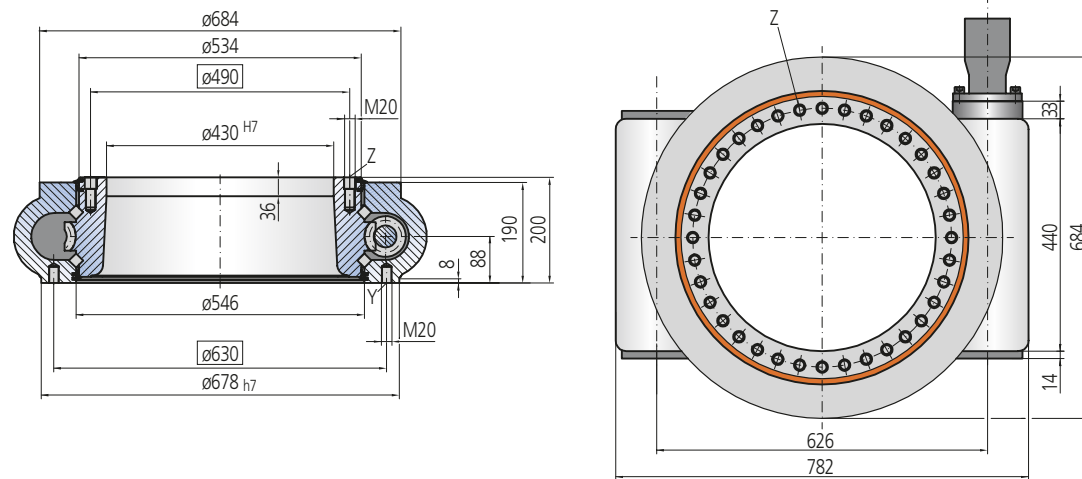
Pressure differential	$\Delta p$ [bar]	165	150
Oil flow	Q [l/min]	150	228
Output speed	n [rpm]	2	2
Maximum achievable torque	$M_d$ [Nm]	78430	94832

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0490 / single drive



### Mounting holes

Y = 36 Holes M20-30 deep, equally spaced  
Z = 36 Holes ø22-22 deep / M20-36 deep, equally spaced

### Lubrication ports

1 Taper type grease nipple on the outside of the housing on the right side  
3 Taper type grease nipples on the outside of the housing on the left side

Slew Drive supplied pre-lubricated

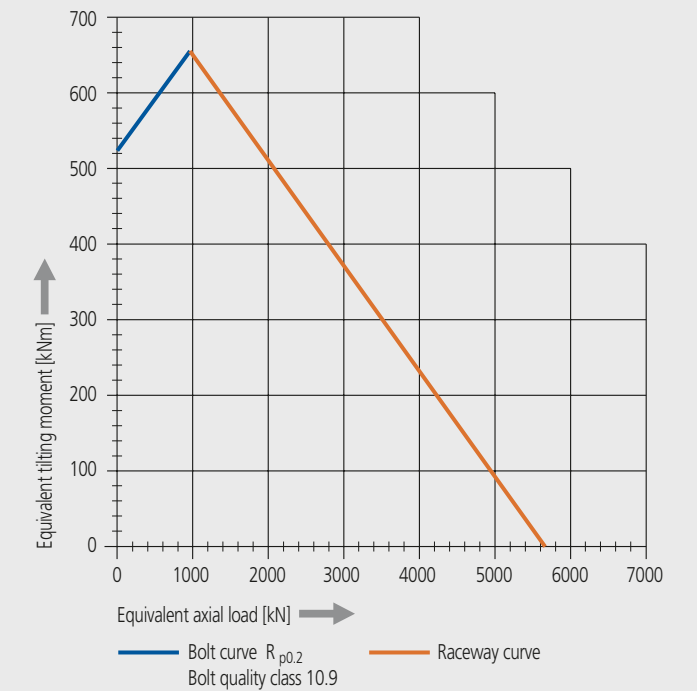
Drawing reference number WD-H 0490/3-00018			
Drawing reference number WD-H 0490/3-00024			
Module	m [mm]	7	8
Number of starts of the worm	[-]	2	1
Gear ratio	i [-]	40	70
Self-locking gears**		no	no
Maximum torque $s_{FS} = 1$	$M_{d max}$ [Nm]	49505	59799
Nom. torque $s_F = 1$ at $n = 1$ rpm	$M_{d nom}$ [Nm]	49505	59799
Maximum holding torque*	$M_h$ [Nm]	49505	59799
Static load rating, radial	$C_{o rad}$ [kN]	2775	2775
Static load rating, axial	$C_{o ax}$ [kN]	5662	5662
Dynamic load rating, radial	$C_{rad}$ [kN]	502	502
Dynamic load rating, axial	$C_{ax}$ [kN]	707	707
Weight	[kg]	360	360

\*Optional with brake  
\*\*See technical data

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor DT-46

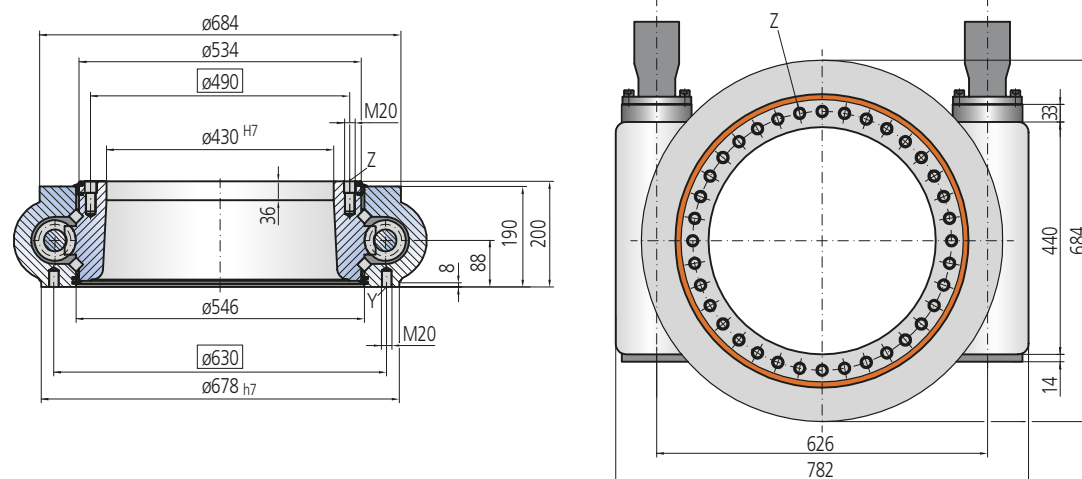
Pressure differential	$\Delta p$ [bar]	190	170
Oil flow	Q [l/min]	53	68
Output speed	n [rpm]	1	1
Maximum achievable torque	$M_d$ [Nm]	49505	59799

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0490 / twin drive



### Mounting holes

Y = 36 Holes M20-30 deep, equally spaced  
Z = 36 Holes ø22-22 deep / M20-36 deep, equally spaced

### Lubrication ports

1 Taper type grease nipple on the outside of the housing on the right side and on the left side

Slew Drive supplied pre-lubricated

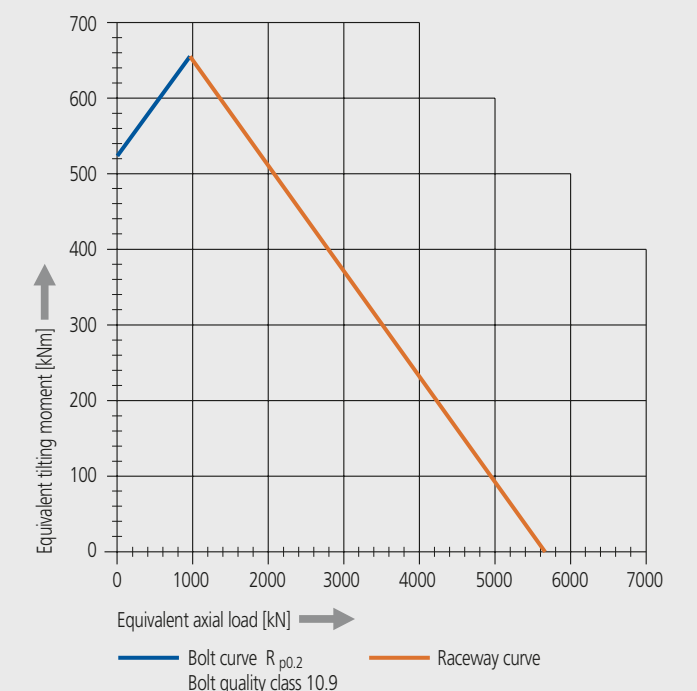
Drawing reference number WD-H 0490/3-00005			
Drawing reference number WD-H 0490/3-00025			
Module	m [mm]	7	8
Number of starts of the worm	[-]	2	1
Gear ratio	i [-]	40	70
Self-locking gears**		no	no
Maximum torque $s_{FS} = 1$	$M_{d max}$ [Nm]	99010	119598
Nom. torque $s_F = 1$ at $n = 1$ rpm	$M_{d nom}$ [Nm]	99010	119598
Maximum holding torque*	$M_h$ [Nm]	99010	119598
Static load rating, radial	$C_{o rad}$ [kN]	2775	2775
Static load rating, axial	$C_{o ax}$ [kN]	5662	5662
Dynamic load rating, radial	$C_{rad}$ [kN]	502	502
Dynamic load rating, axial	$C_{ax}$ [kN]	707	707
Weight	[kg]	400	400

\*Optional with brake  
\*\*See technical data

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor DT-46

Pressure differential	$\Delta p$ [bar]	190	170
Oil flow	Q [l/min]	106	132
Output speed	n [rpm]	1	1
Maximum achievable torque	$M_d$ [Nm]	99010	119598

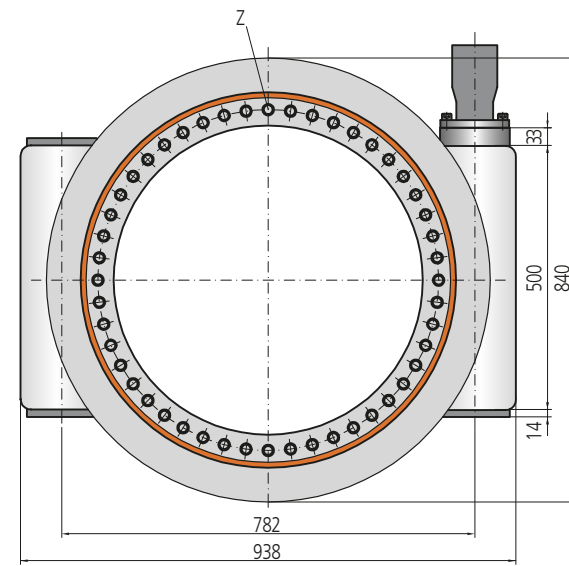
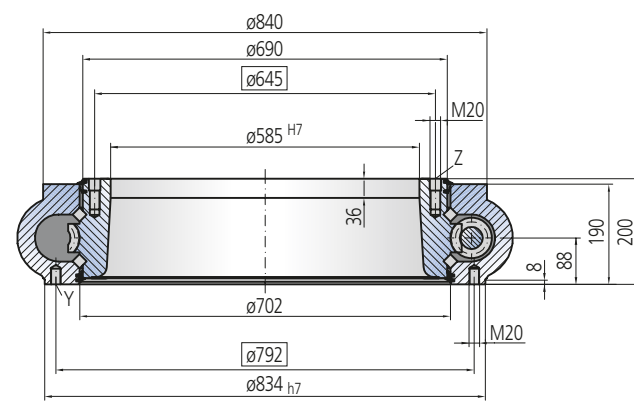
### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!



## Size 0645 / single drive



### Mounting holes

Y = 48 Holes M20-30 deep, equally spaced  
Z = 48 Holes ø22-22 deep / M20-36 deep, equally spaced

### Lubrication ports

1 Taper type grease nipple on the outside of the housing on the right side  
3 Taper type grease nipples on the outside of the housing on the left side

Slew Drive supplied pre-lubricated

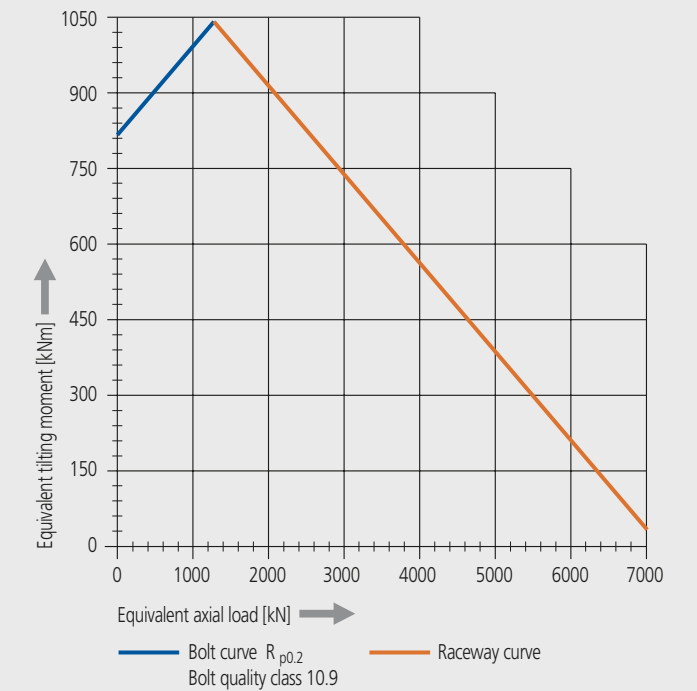
Drawing reference number WD-H 0645/3-00014			
Drawing reference number WD-H 0645/3-00020			
Module	m	[mm]	7 8
Number of starts of the worm	-		2 1
Gear ratio	i	-	51 90
Self-locking gears**			no no
Maximum torque $s_{FS} = 1$	$M_{d\ max}$	[Nm]	63220 76310
Nom. torque $s_{FS} = 1$ at $n = 1$ rpm	$M_{d\ nom}$	[Nm]	63220 76310
Maximum holding torque*	$M_h$	[Nm]	63220 76310
Static load rating, radial	$C_{o\ rad}$	[kN]	3528 3528
Static load rating, axial	$C_{o\ ax}$	[kN]	7199 7199
Dynamic load rating, radial	$C_{rad}$	[kN]	570 570
Dynamic load rating, axial	$C_{ax}$	[kN]	803 803
Weight		[kg]	440 440

\*Optional with brake  
\*\*See technical data

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor DT-56

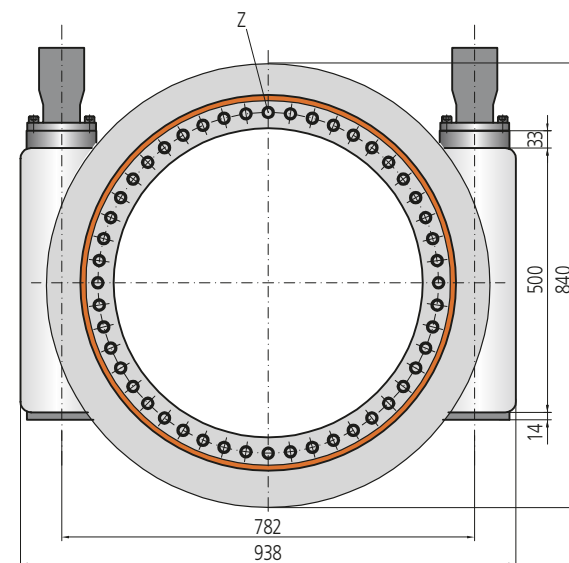
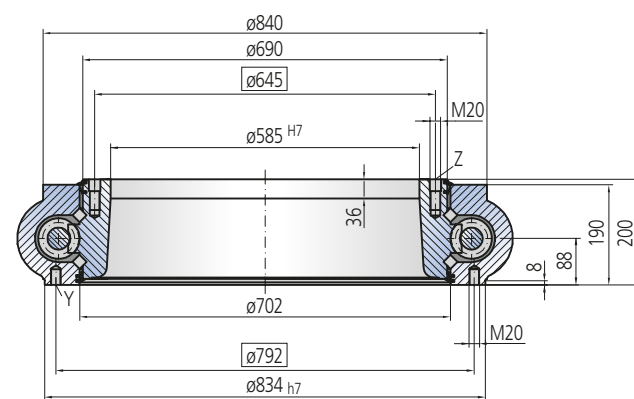
Pressure differential	$\Delta p$	[bar]	160 150
Oil flow	Q	[l/min]	62 95
Output speed	n	[rpm]	1 1
Maximum achievable torque	$M_d$	[Nm]	63220 76310

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0645 / twin drive



### Mounting holes

Y = 48 Holes M20-30 deep, equally spaced  
Z = 48 Holes ø22-22 deep / M20-36 deep, equally spaced

### Lubrication ports

1 Taper type grease nipple on the outside of the housing on the right side and on the left side

Slew Drive supplied pre-lubricated

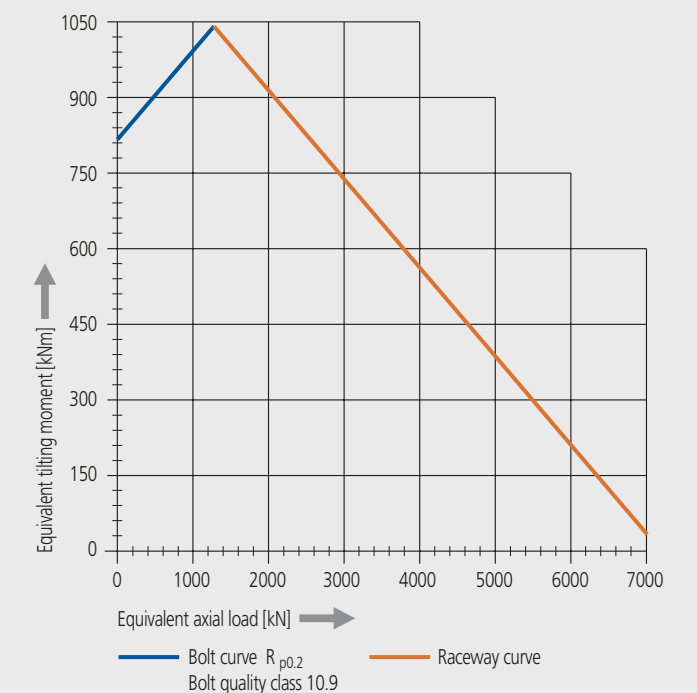
Drawing reference number WD-H 0645/3-00001			
Drawing reference number WD-H 0645/3-00021			
Module	m	[mm]	7 8
Number of starts of the worm	-		2 1
Gear ratio	i	-	51 90
Self-locking gears**			no no
Maximum torque $s_{FS} = 1$	$M_{d\ max}$	[Nm]	126440 152610
Nom. torque $s_{FS} = 1$ at $n = 1$ rpm	$M_{d\ nom}$	[Nm]	126440 152610
Maximum holding torque*	$M_h$	[Nm]	126440 152610
Static load rating, radial	$C_{o\ rad}$	[kN]	3528 3528
Static load rating, axial	$C_{o\ ax}$	[kN]	7199 7199
Dynamic load rating, radial	$C_{rad}$	[kN]	570 570
Dynamic load rating, axial	$C_{ax}$	[kN]	803 803
Weight		[kg]	480 480

\*Optional with brake  
\*\*See technical data

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor DT-56

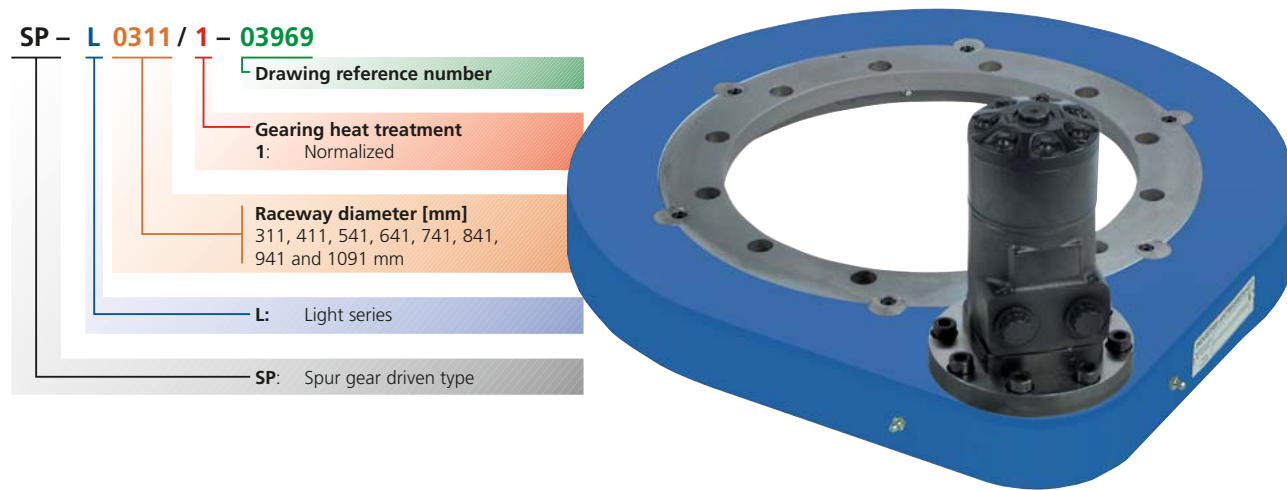
Pressure differential	$\Delta p$	[bar]	160 150
Oil flow	Q	[l/min]	124 190
Output speed	n	[rpm]	1 1
Maximum achievable torque	$M_d$	[Nm]	126440 152610

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Series Overview



### Verifying tooth base fatigue strength:

Valid for the following conditions:  
 - Output speed:  $n = 5.0$  rpm  
 - Repeated load  
 - Ambient temperature of  $20^\circ\text{C}$

$M_{dB}$ : Operation torque [Nm]  
 $M_{d\text{nom}}$ : Nominal torque [Nm] for  $SF = 1$  and  $n = 5.0$  rpm (see dimensions table)

If the following equation is met, the stress level of tooth base is below the endurance limit and fatigue is infinite:

$$M_{dB} \leq M_{d\text{nom}}$$

Fatigue stress of tooth base needs to be considered however, if the following equation is met (if so, refer to below additional steps to verify life):

$$M_{dB} > M_{d\text{nom}}$$

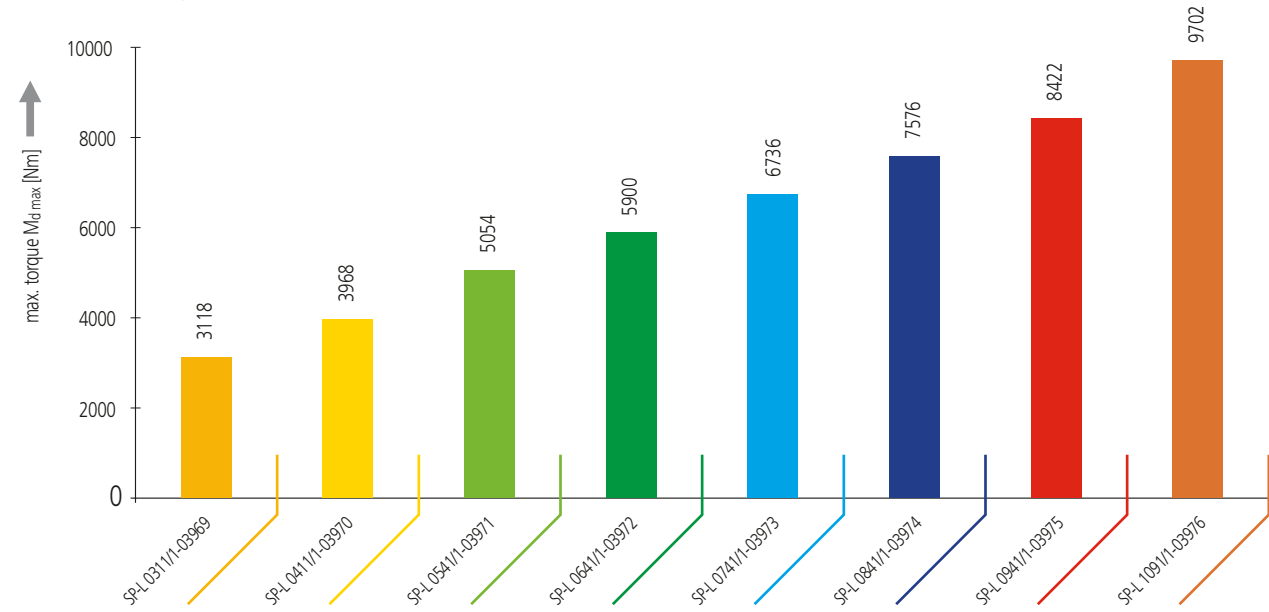
The operation is permissible as regards the fatigue stress of tooth base, if the following equation is fulfilled.

$$G_w \geq B_h \cdot \frac{ED_B}{100}$$

If this relationship is not fulfilled, then there is imminent danger of fatigue fracture of the tooth base.

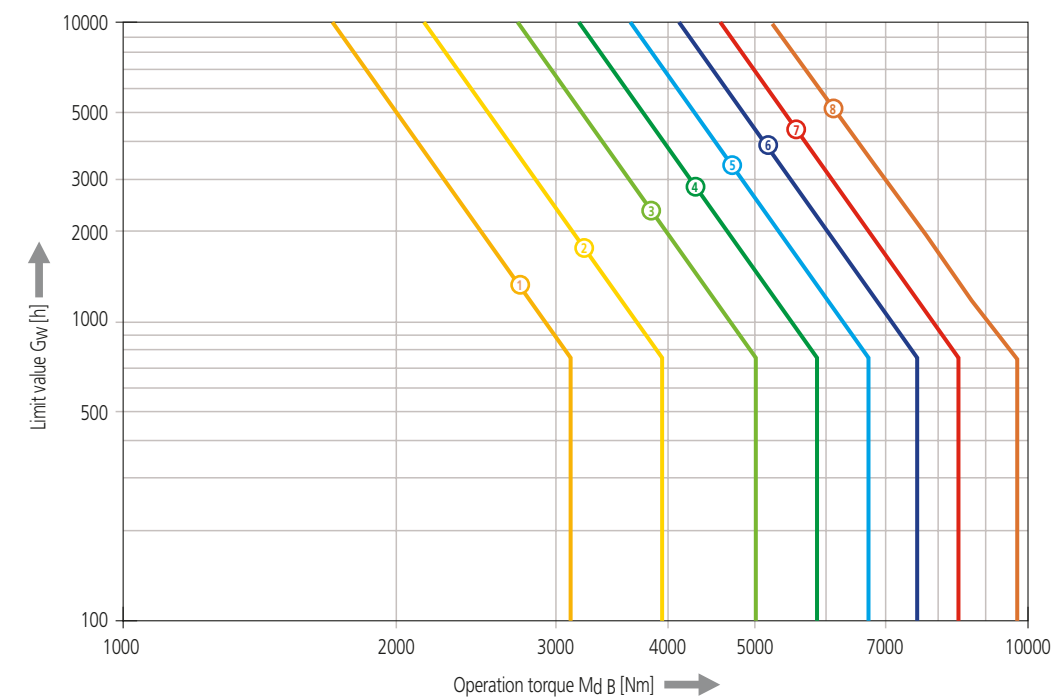
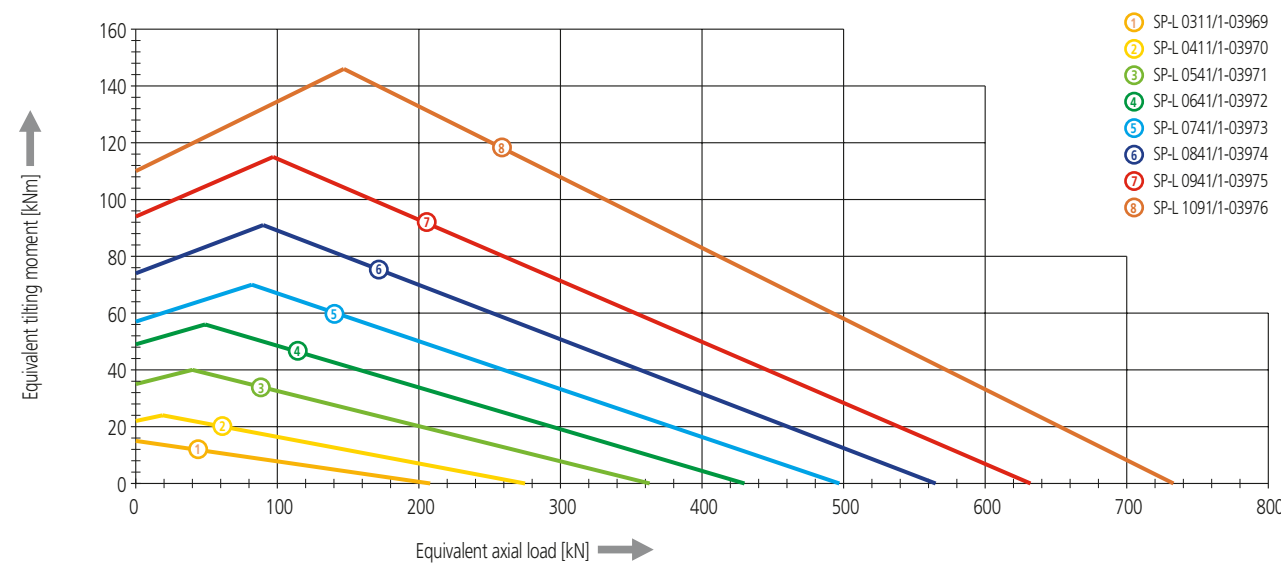
$G_w$ : Limit value from diagram [h]  
 $B_h$ : Operation time [h]  
 $ED_B$ : Duty [%]

### Maximum torque $M_{d\text{max}}$ of individual sizes



### Limiting load diagrams of individual sizes for "compressive" load

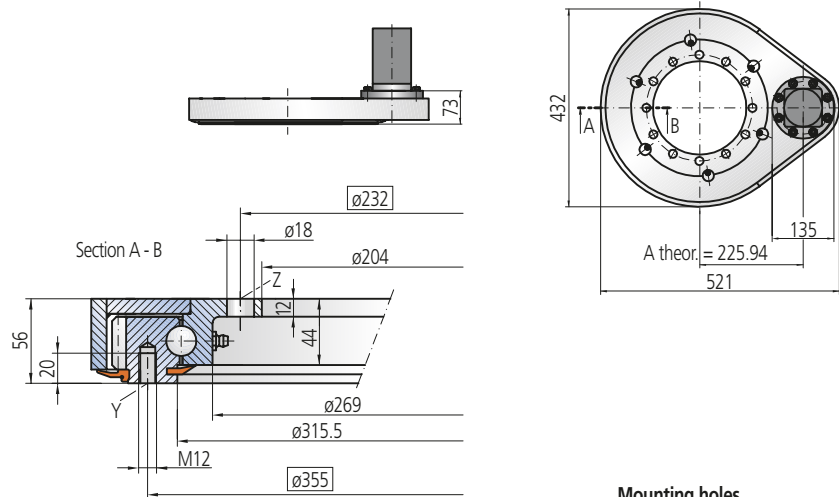
Please refer to the explanations in the Technical Information section of the catalog



Verification of the pitting and wear safety of tooth flanks must be done by the IMO Engineering Department!



Size 0311



**Mounting holes**

Y = 10 Holes M12-20 deep, equally spaced  
Z = 12 Holes  $\varnothing 18$ , equally spaced

**Lubrication ports**

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing  
Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\varnothing 311$ , minimum

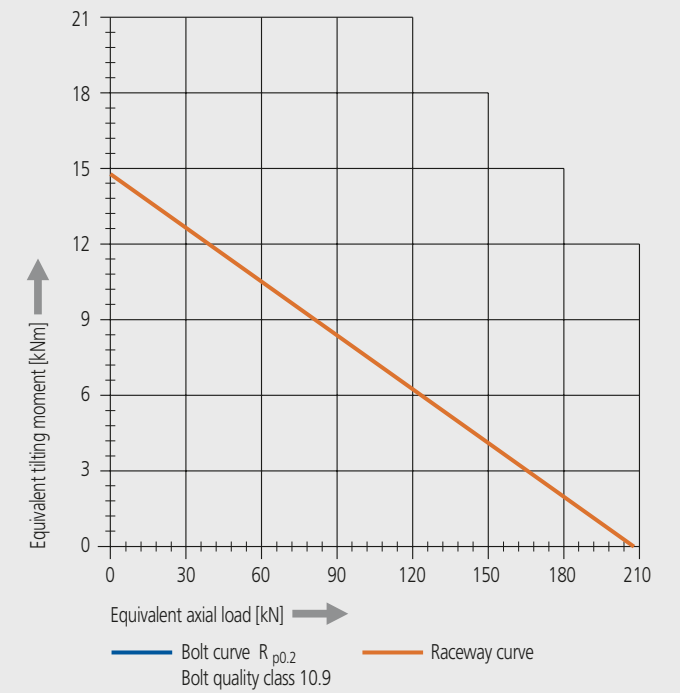
Drawing reference number SP-L 0311/1-03969		
Module	m [mm]	4
Number of teeth, wheel	$z_2$ [-]	99
Number of teeth, pinion	$z_1$ [-]	13
Overall gear ration	i [-]	7.61
Maximum torque $S_F = 1.75$	$M_{d max}$ [Nm]	3118
Nom. torque $S_F = 1$ at $n = 5$ rpm	$M_{d nom}$ [Nm]	1683
Maximum holding torque*	$M_h$ [Nm]	3118
Static load rating, radial	$C_{o rad}$ [kN]	89
Static load rating, axial	$C_{o ax}$ [kN]	208
Dynamic load rating, radial	$C_{rad}$ [kN]	140
Dynamic load rating, axial	$C_{ax}$ [kN]	140
Weight	[kg]	45

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

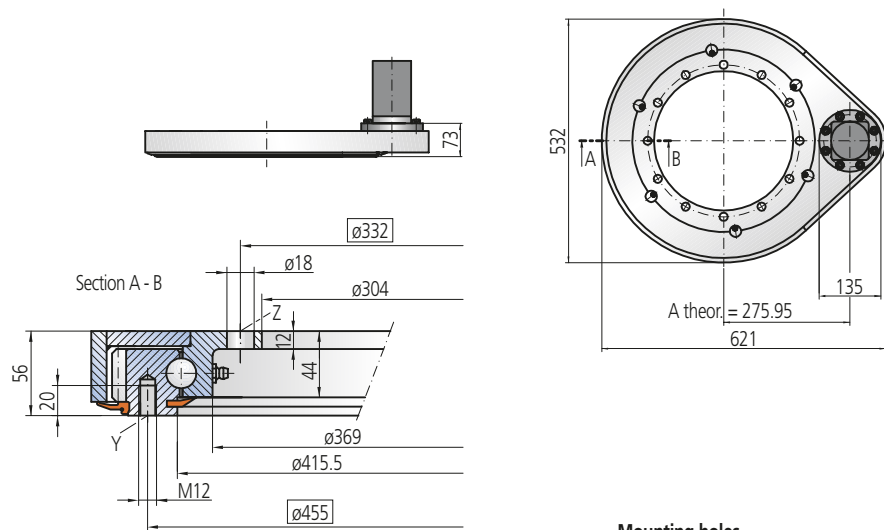
Pressure differential	$\Delta p$ [bar]	115
Oil flow	Q [l/min]	17
Output speed	n [rpm]	5
Maximum achievable torque	$M_d$ [Nm]	3118

Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

Size 0411



**Mounting holes**

Y = 10 Holes M12-20 deep, equally spaced  
Z = 12 Holes  $\varnothing 18$ , equally spaced

**Lubrication ports**

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing  
Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\varnothing 411$ , minimum

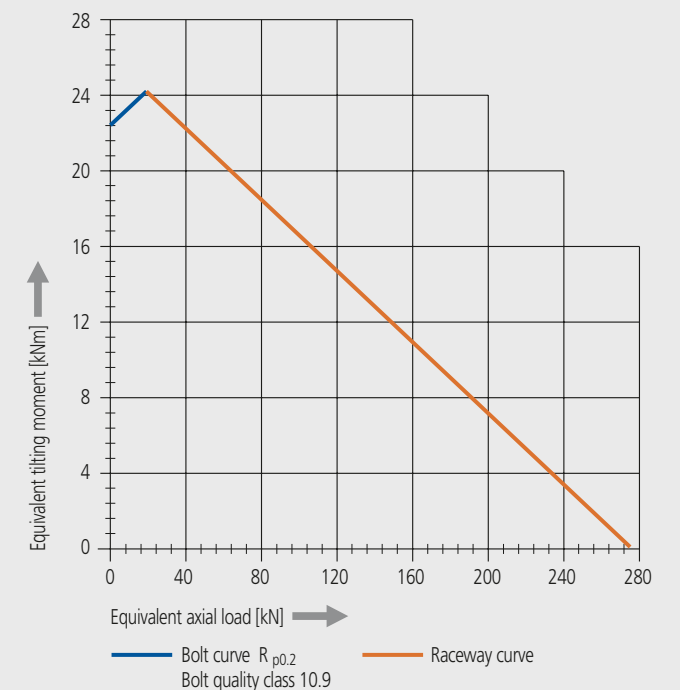
Drawing reference number SP-L 0411/1-03970		
Module	m [mm]	4
Number of teeth, wheel	$z_2$ [-]	124
Number of teeth, pinion	$z_1$ [-]	13
Overall gear ration	i [-]	9.53
Maximum torque $S_F = 1.75$	$M_{d max}$ [Nm]	3968
Nom. torque $S_F = 1$ at $n = 5$ rpm	$M_{d nom}$ [Nm]	2145
Maximum holding torque*	$M_h$ [Nm]	3968
Static load rating, radial	$C_{o rad}$ [kN]	118
Static load rating, axial	$C_{o ax}$ [kN]	275
Dynamic load rating, radial	$C_{rad}$ [kN]	155
Dynamic load rating, axial	$C_{ax}$ [kN]	156
Weight	[kg]	58

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

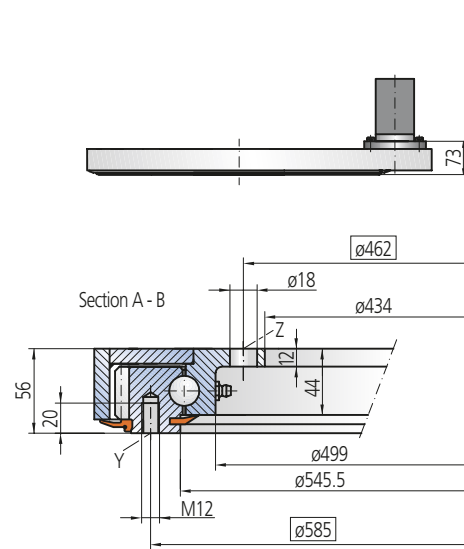
Pressure differential	$\Delta p$ [bar]	120
Oil flow	Q [l/min]	20
Output speed	n [rpm]	5
Maximum achievable torque	$M_d$ [Nm]	3968

Limiting load diagram for 'compressive' load

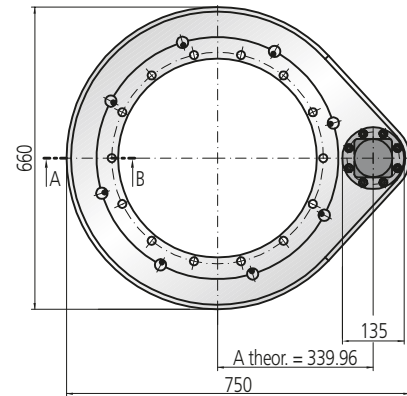


Please adhere strictly to the Technical Information section when using above graph!

## Size 0541



Note, mounting face against upper surface shall be  $\phi 541$ , minimum



### Mounting holes

Y = 14 Holes M12-20 deep, equally spaced  
Z = 14 Holes  $\phi 18$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

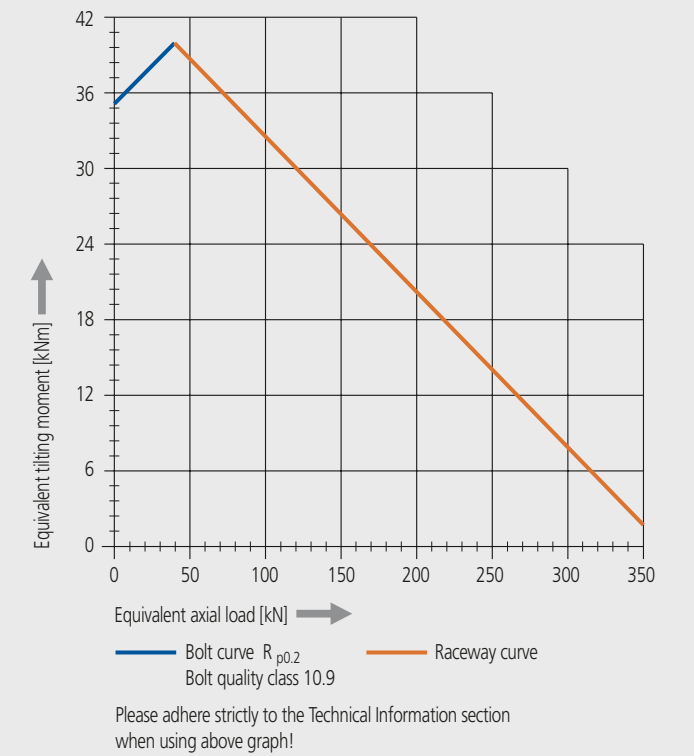
Drawing reference number SP-L 0541/1-03971			
Module	<b>m</b> [mm]	4	
Number of teeth, wheel	<b>z<sub>2</sub></b> [-]	156	
Number of teeth, pinion	<b>z<sub>1</sub></b> [-]	13	
Overall gear ration	<b>i</b> [-]	12	
Maximum torque $s_{FS} = 1.75$	<b>M<sub>d max</sub></b> [Nm]	5054	
Nom. torque $s_F = 1$ at $n = 5$ rpm	<b>M<sub>d nom</sub></b> [Nm]	2714	
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	5054	
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	155	
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	363	
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	173	
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	174	
Weight	[kg]	65	

\*Optional with brake

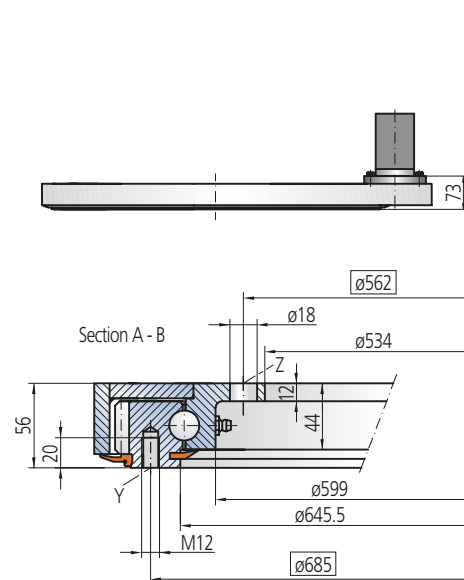
The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

Pressure differential	$\Delta p$ [bar]	120
Oil flow	<b>Q</b> [l/min]	23
Output speed	<b>n</b> [rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	5054

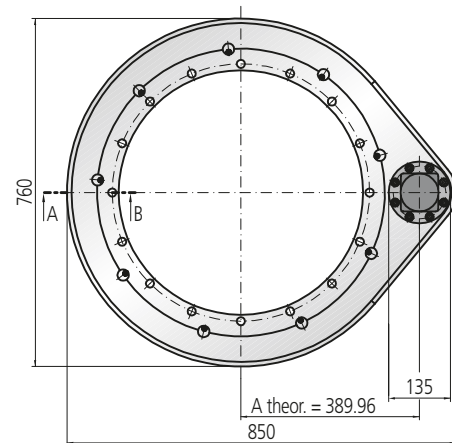
Limiting load diagram for 'compressive' load



## Size 0641



Note, mounting face against upper surface shall be  $\phi 641$ , minimum



### Mounting holes

Y = 16 Holes M12-20 deep, equally spaced  
Z = 16 Holes  $\phi 18$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

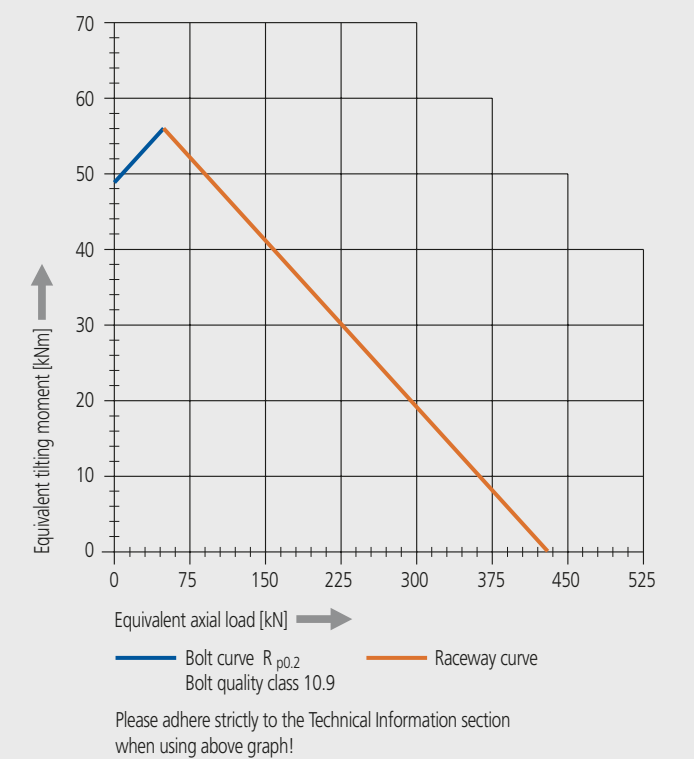
Drawing reference number SP-L 0641/1-03972			
Module	<b>m</b> [mm]	4	
Number of teeth, wheel	<b>z<sub>2</sub></b> [-]	181	
Number of teeth, pinion	<b>z<sub>1</sub></b> [-]	13	
Overall gear ration	<b>i</b> [-]	13.92	
Maximum torque $s_{FS} = 1.75$	<b>M<sub>d max</sub></b> [Nm]	5900	
Nom. torque $s_F = 1$ at $n = 5$ rpm	<b>M<sub>d nom</sub></b> [Nm]	3160	
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	5900	
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	184	
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	430	
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	184	
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	185	
Weight	[kg]	75	

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

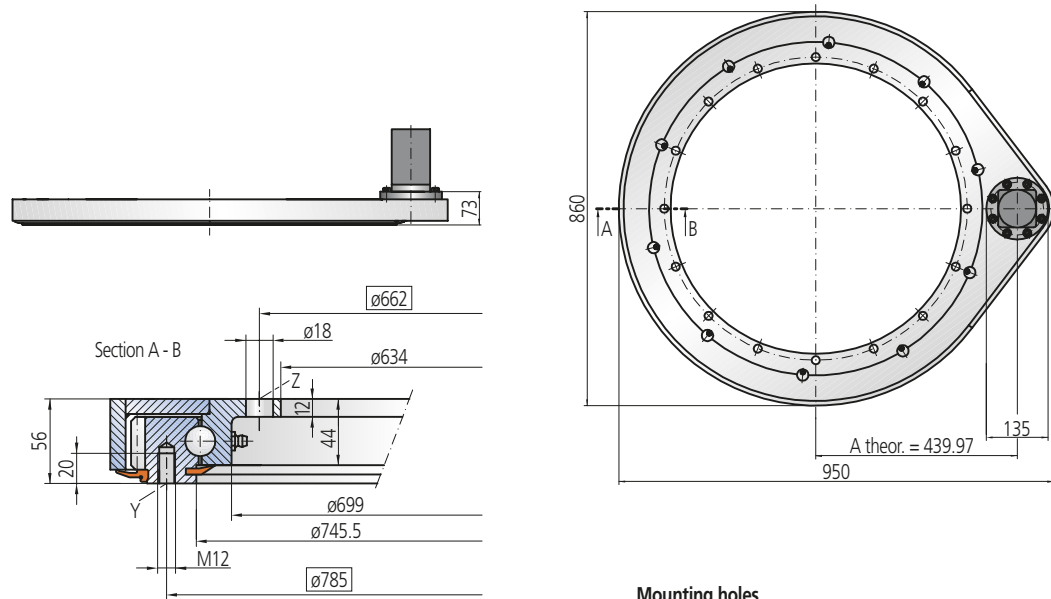
Pressure differential	$\Delta p$ [bar]	120
Oil flow	<b>Q</b> [l/min]	27
Output speed	<b>n</b> [rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	5900

Limiting load diagram for 'compressive' load





## Size 0741



Note, mounting face against upper surface shall be  $\phi 741$ , minimum

### Mounting holes

Y = 18 Holes M12-20 deep, equally spaced  
Z = 16 Holes  $\phi 18$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

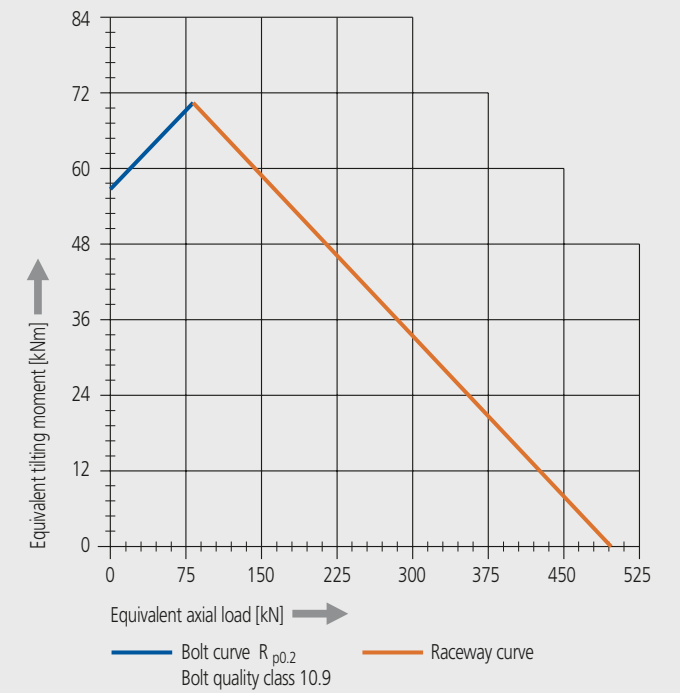
Drawing reference number SP-L 0741/1-03973			
Module	m	[mm]	4
Number of teeth, wheel	$z_2$	[-]	206
Number of teeth, pinion	$z_1$	[-]	13
Overall gear ration	i	[-]	15.84
Maximum torque $sfs = 1.75$	$M_{d\ max}$	[Nm]	6736
Nom. torque $sfs = 1$ at $n = 5$ rpm	$M_{d\ nom}$	[Nm]	3605
Maximum holding torque*	$M_h$	[Nm]	6736
Static load rating, radial	$C_{o\ rad}$	[kN]	213
Static load rating, axial	$C_{o\ ax}$	[kN]	497
Dynamic load rating, radial	$C_{rad}$	[kN]	194
Dynamic load rating, axial	$C_{ax}$	[kN]	195
Weight		[kg]	85

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

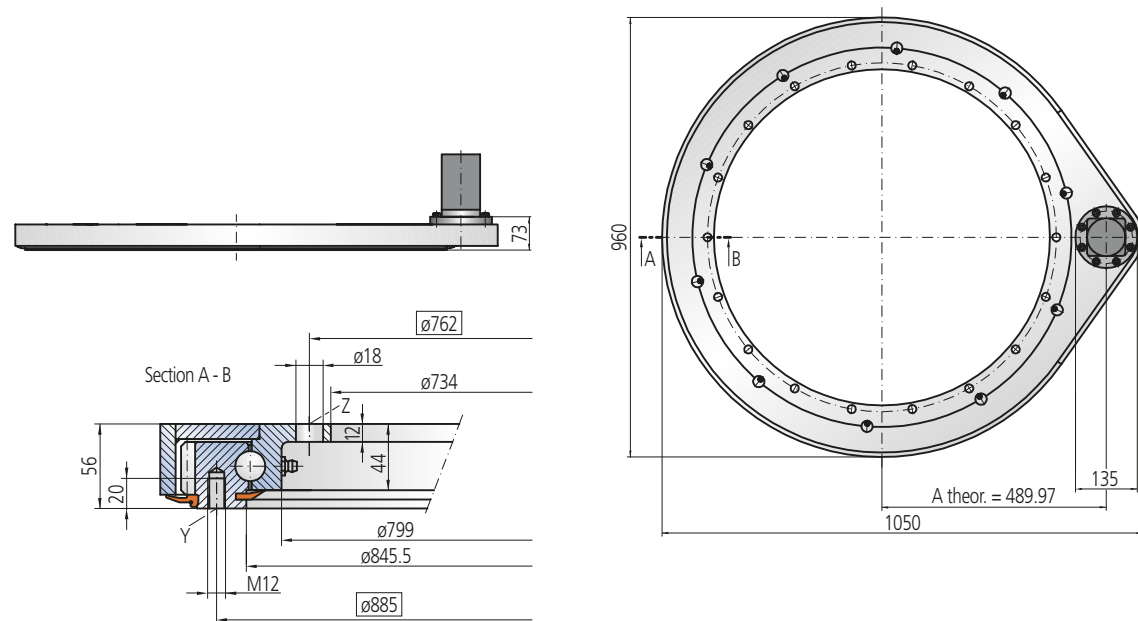
Pressure differential	$\Delta p$	[bar]	120
Oil flow	Q	[l/min]	30
Output speed	n	[rpm]	5
Maximum achievable torque	$M_d$	[Nm]	6736

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0841



Note, mounting face against upper surface shall be  $\phi 841$ , minimum

### Mounting holes

Y = 18 Holes M12-20 deep, equally spaced  
Z = 18 Holes  $\phi 18$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

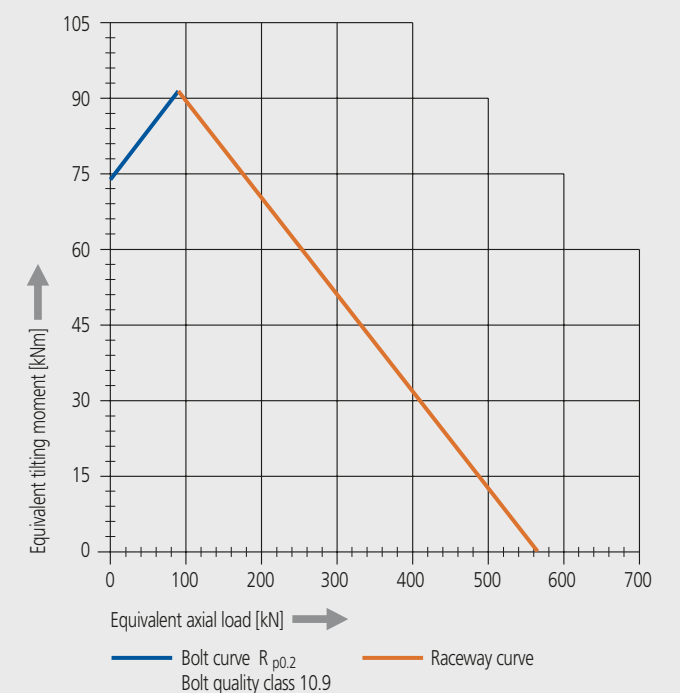
Drawing reference number SP-L 0841/1-03974			
Module	m	[mm]	4
Number of teeth, wheel	$z_2$	[-]	231
Number of teeth, pinion	$z_1$	[-]	13
Overall gear ration	i	[-]	17.76
Maximum torque $sfs = 1.75$	$M_{d\ max}$	[Nm]	7576
Nom. torque $sfs = 1$ at $n = 5$ rpm	$M_{d\ nom}$	[Nm]	4042
Maximum holding torque*	$M_h$	[Nm]	7576
Static load rating, radial	$C_{o\ rad}$	[kN]	241
Static load rating, axial	$C_{o\ ax}$	[kN]	565
Dynamic load rating, radial	$C_{rad}$	[kN]	204
Dynamic load rating, axial	$C_{ax}$	[kN]	206
Weight		[kg]	95

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

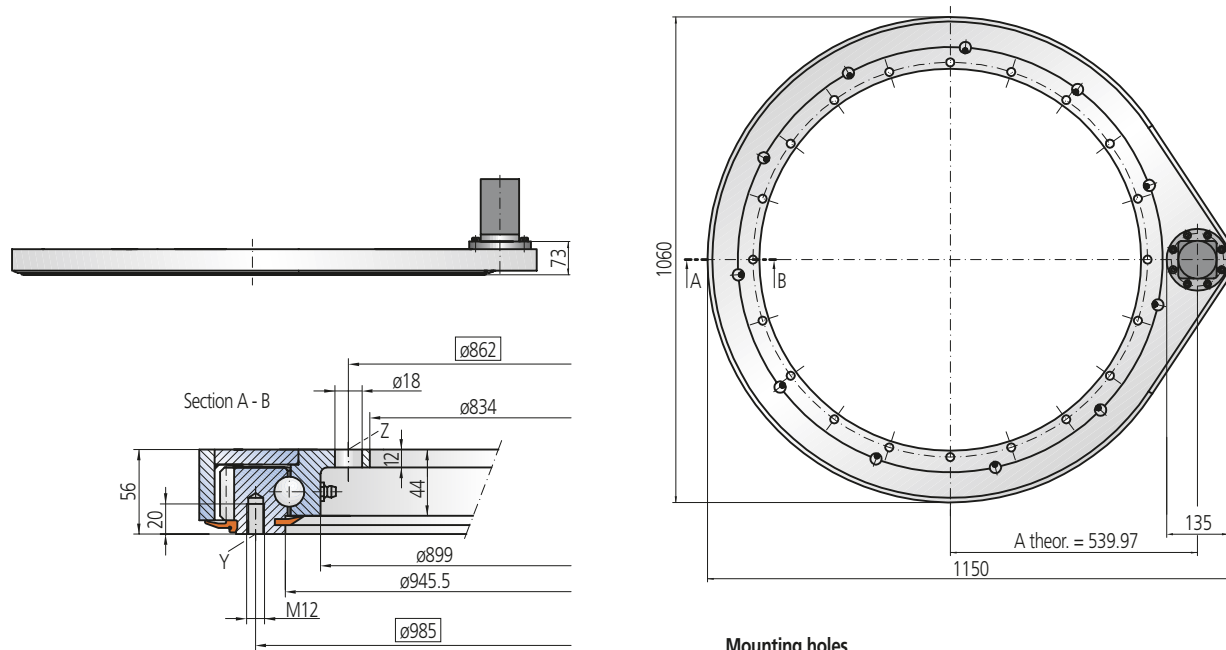
Pressure differential	$\Delta p$	[bar]	120
Oil flow	Q	[l/min]	32
Output speed	n	[rpm]	5
Maximum achievable torque	$M_d$	[Nm]	7576

### Limiting load diagram for thrust loading



Please adhere strictly to the Technical Information section when using above graph!

## Size 0941



Note, mounting face against upper surface shall be  $\varnothing 941$ , minimum

### Mounting holes

Y = 20 Holes M12-20 deep, equally spaced  
Z = 20 Holes  $\varnothing 18$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing  
Slew Drive supplied pre-lubricated

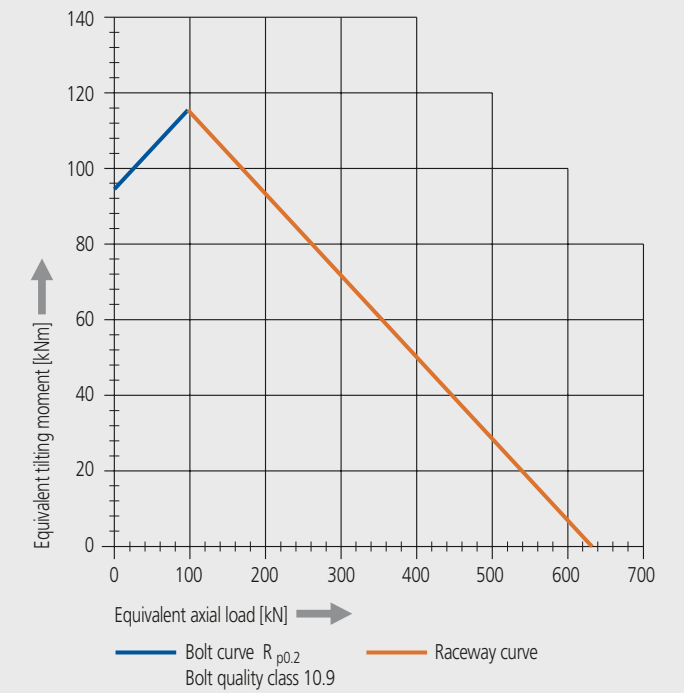
Drawing reference number SP-L 0941/1-03975			
Module	<b>m</b>	[mm]	4
Number of teeth, wheel	<b>z<sub>2</sub></b>	[-]	256
Number of teeth, pinion	<b>z<sub>1</sub></b>	[-]	13
Overall gear ration	<b>i</b>	[-]	19.69
Maximum torque sfs = 1.75	<b>M<sub>d max</sub></b>	[Nm]	8422
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b>	[Nm]	4480
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	8422
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	270
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	632
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	212
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	214
Weight		[kg]	105

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

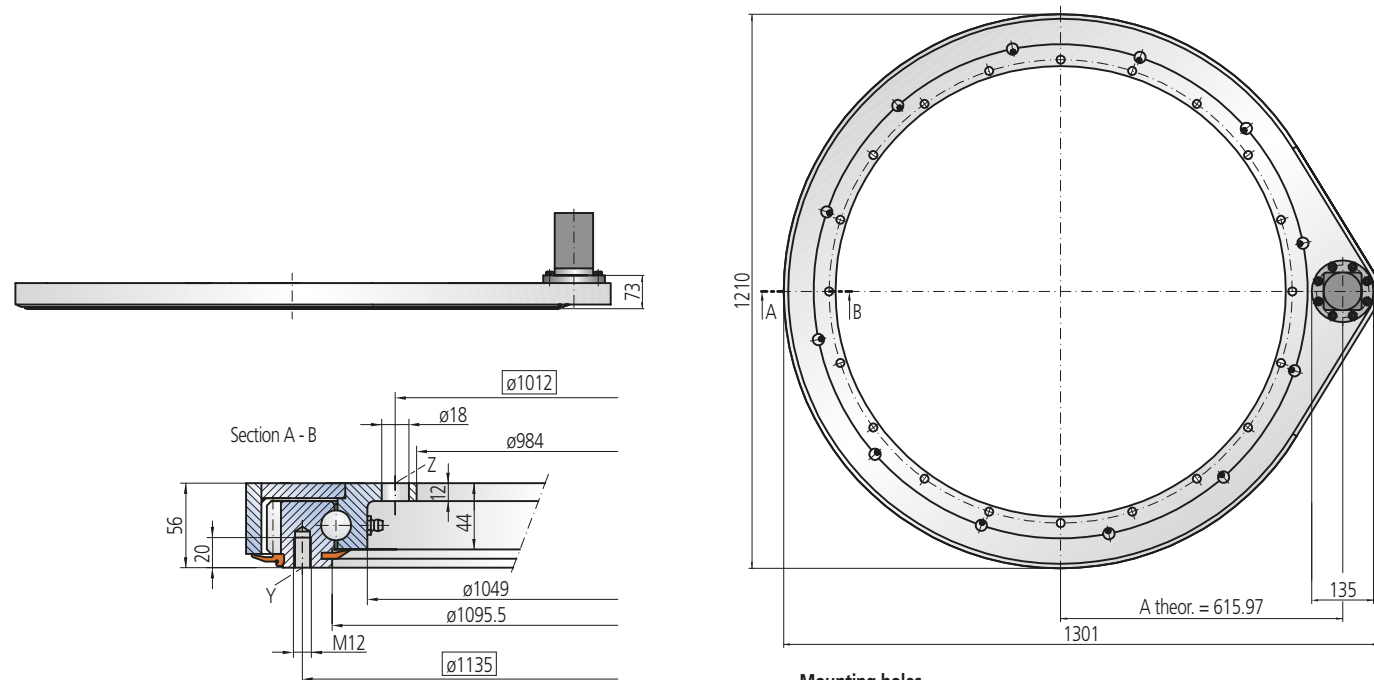
Pressure differential	$\Delta p$	[bar]	120
Oil flow	<b>Q</b>	[l/min]	36
Output speed	<b>n</b>	[rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	8422

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 1091



Note, mounting face against upper surface shall be  $\varnothing 1091$ , minimum

### Mounting holes

Y = 22 Holes M12-20 deep, equally spaced  
Z = 20 Holes  $\varnothing 18$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing  
Slew Drive supplied pre-lubricated

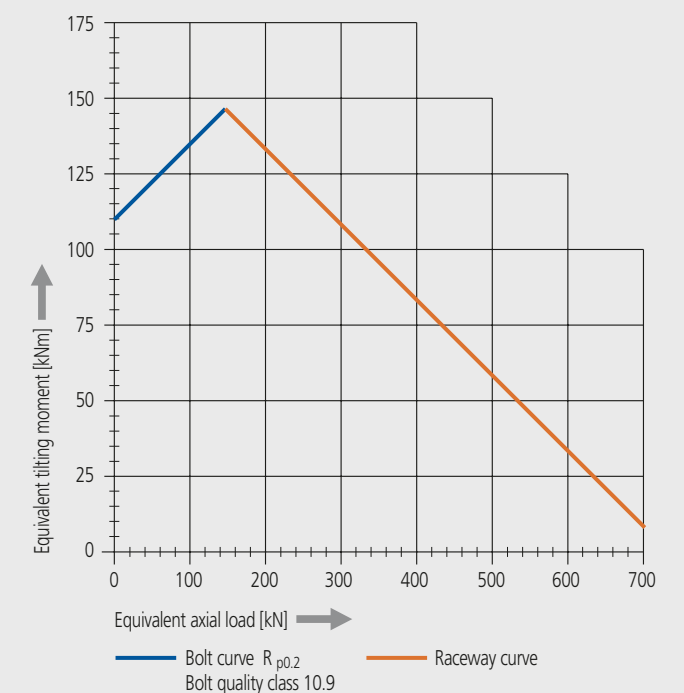
Drawing reference number SP-L 1091/1-03976			
Module	<b>m</b>	[mm]	4
Number of teeth, wheel	<b>z<sub>2</sub></b>	[-]	294
Number of teeth, pinion	<b>z<sub>1</sub></b>	[-]	13
Overall gear ration	<b>i</b>	[-]	22.61
Maximum torque sfs = 1.75	<b>M<sub>d max</sub></b>	[Nm]	9702
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b>	[Nm]	5174
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	9702
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	313
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	733
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	224
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	226
Weight		[kg]	120

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

Pressure differential	$\Delta p$	[bar]	120
Oil flow	<b>Q</b>	[l/min]	40
Output speed	<b>n</b>	[rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	9702

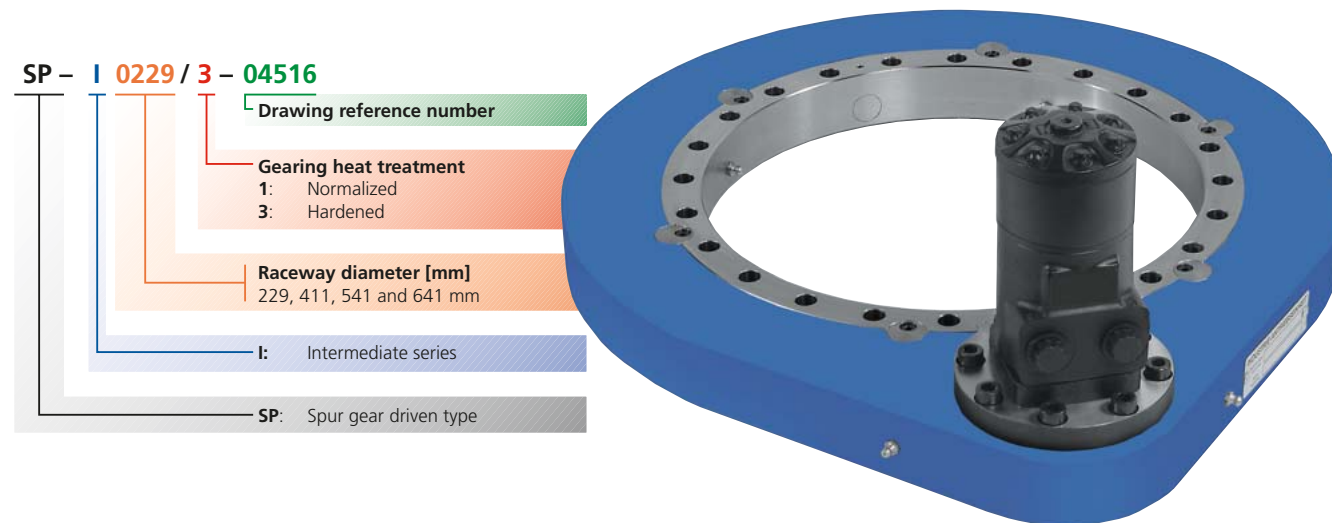
### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!



## Series Overview



### Verifying tooth base fatigue strength:

Valid for the following conditions:  
 - Output speed:  $n = 5.0$  rpm  
 - Repeated load  
 - Ambient temperature of  $20^\circ\text{C}$

$M_{dB}$ : Operation torque [Nm]  
 $M_{dnom}$ : Nominal torque [Nm] for  $SF = 1$  and  $n = 5.0$  rpm (see dimensions table)

If the following equation is met, the stress level of tooth base is below the endurance limit and fatigue is infinite:

$$M_{dB} \leq M_{dnom}$$

Fatigue stress of tooth base needs to be considered however, if the following equation is met (if so, refer to below additional steps to verify life):

$$M_{dB} > M_{dnom}$$

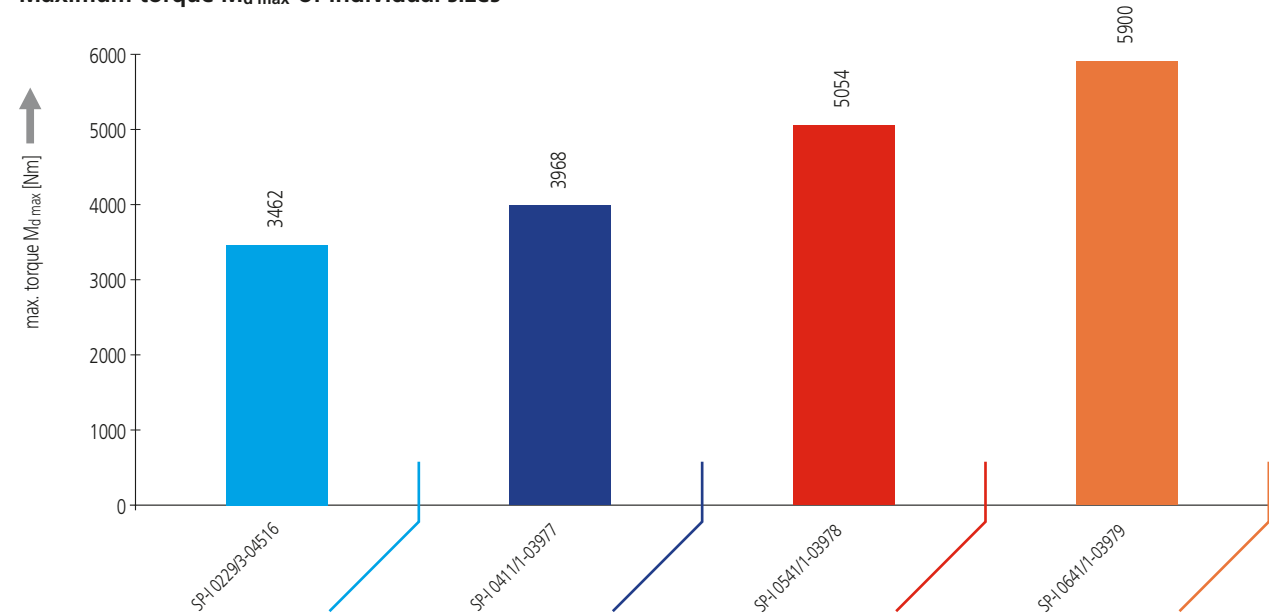
The operation is permissible as regards the fatigue stress of tooth base, if the following equation is fulfilled.

$$G_w \geq B_h \cdot \frac{ED_B}{100}$$

If this relationship is not fulfilled, then there is imminent danger of fatigue fracture of the tooth base.

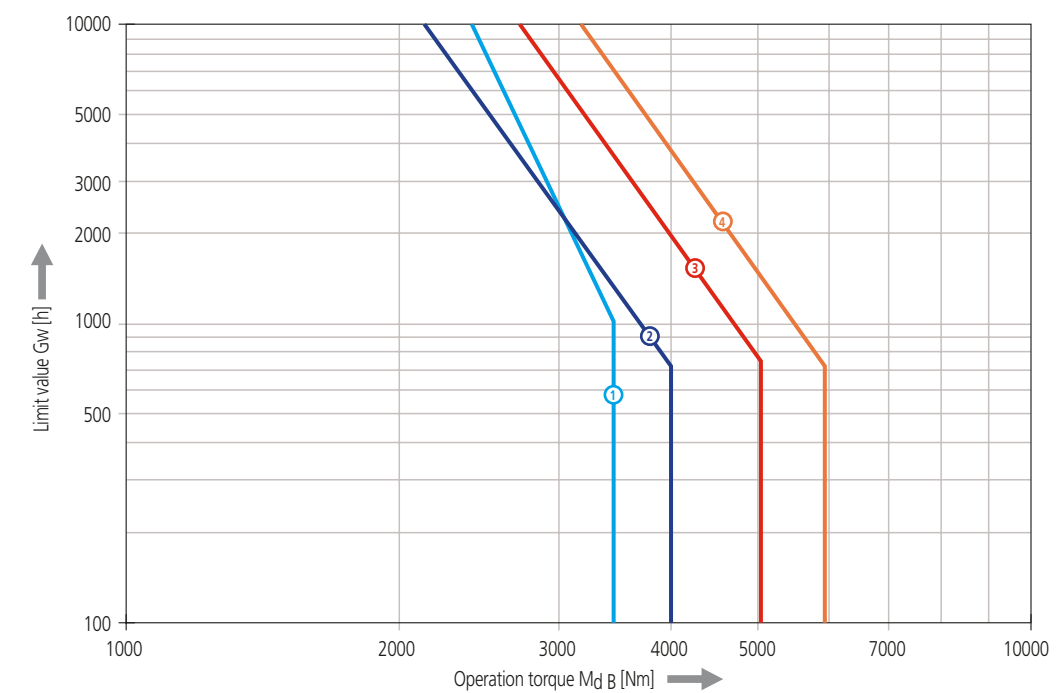
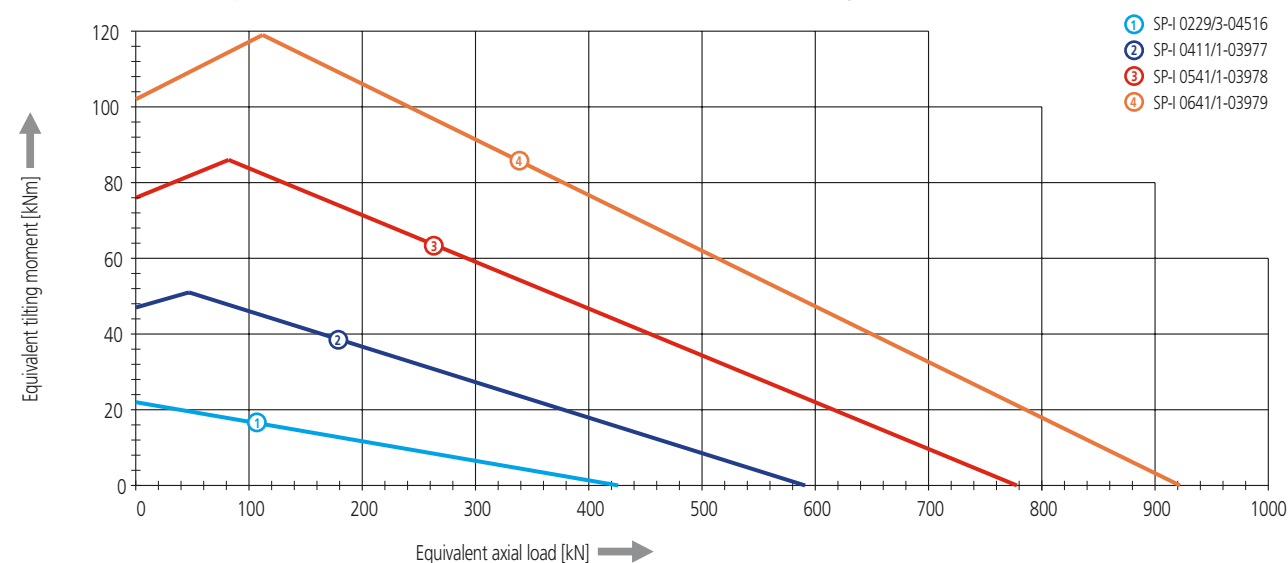
$G_w$ : Limit value from diagram [h]  
 $B_h$ : Operation time [h]  
 $ED_B$ : Duty [%]

### Maximum torque $M_{dmax}$ of individual sizes



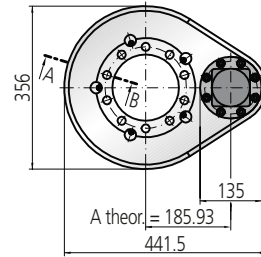
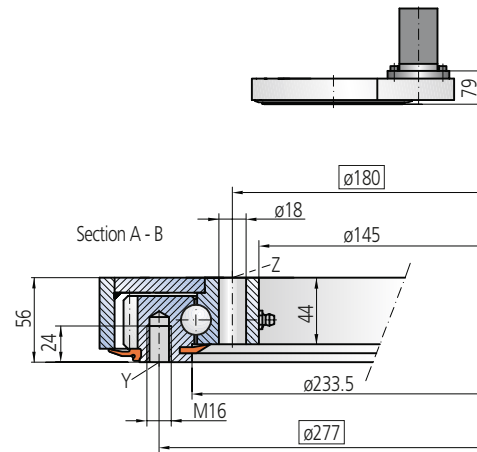
### Limiting load diagrams of individual sizes for "compressive" load

Please refer to the explanations in the Technical Information section of the catalog



Verification of the pitting and wear safety of tooth flanks must be done by the IMO Engineering Department!

## Size 0229



### Mounting holes

Y = 12 Holes M16-24 deep, equally spaced  
Z = 10 Holes  $\phi 18$ , equally spaced

### Lubrication ports

2 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 229$ , minimum

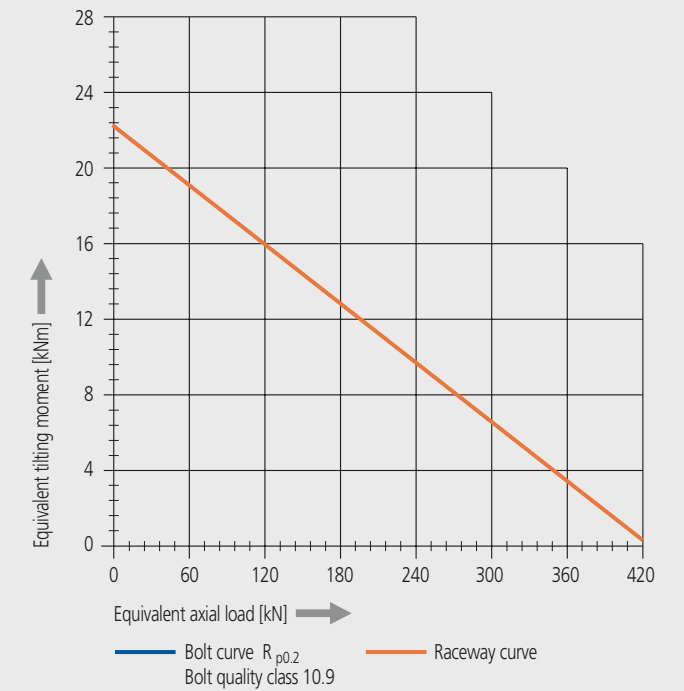
Drawing reference number SP-I 0229/3-04516			
Module	<b>m</b>	[mm]	4
Number of teeth, wheel	<b>z<sub>2</sub></b>	[-]	79
Number of teeth, pinion	<b>z<sub>1</sub></b>	[-]	13
Overall gear ration	<b>i</b>	[-]	6.07
Maximum torque	<b>M<sub>d max</sub></b>	[Nm]	3462
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b>	[Nm]	2370
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	3462
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	156
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	426
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	134
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	156
Weight		[kg]	42

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor OMR 315

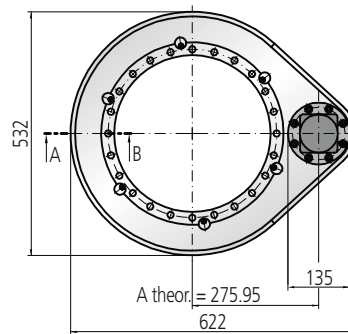
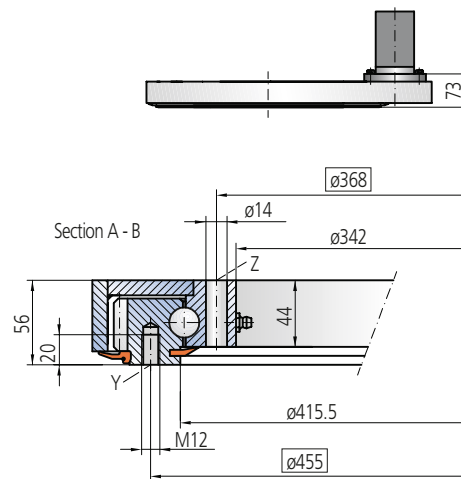
Pressure differential	<b><math>\Delta p</math></b>	[bar]	145
Oil flow	<b>Q</b>	[l/min]	15
Output speed	<b>n</b>	[rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	3462

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0411



### Mounting holes

Y = 20 Holes M12-20 deep, equally spaced  
Z = 24 Holes  $\phi 14$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 411$ , minimum

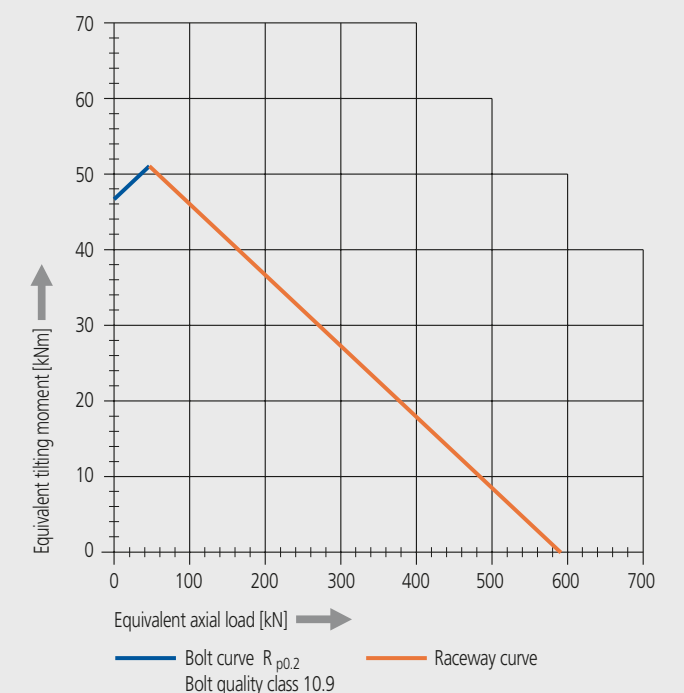
Drawing reference number SP-I 0411/1-03977			
Module	<b>m</b>	[mm]	4
Number of teeth, wheel	<b>z<sub>2</sub></b>	[-]	124
Number of teeth, pinion	<b>z<sub>1</sub></b>	[-]	13
Overall gear ration	<b>i</b>	[-]	9.54
Maximum torque SF = 1.75	<b>M<sub>d max</sub></b>	[Nm]	3968
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b>	[Nm]	2145
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	3968
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	253
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	591
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	155
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	156
Weight		[kg]	60

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

Pressure differential	<b><math>\Delta p</math></b>	[bar]	120
Oil flow	<b>Q</b>	[l/min]	20
Output speed	<b>n</b>	[rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	3968

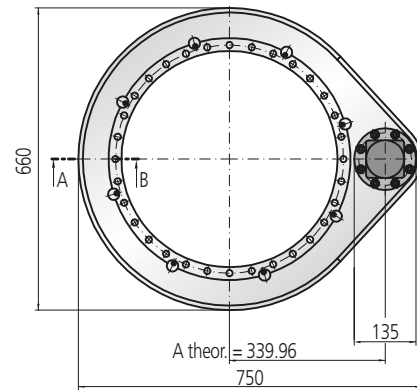
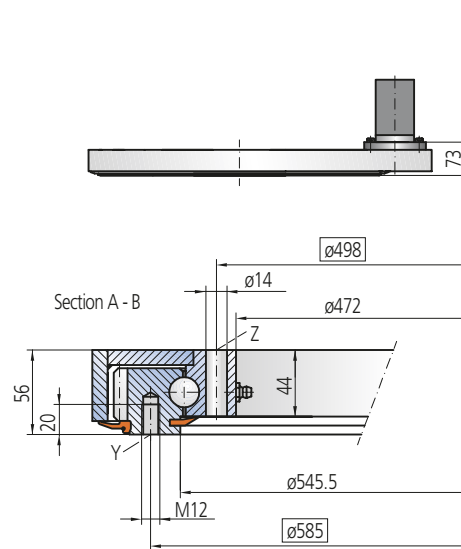
### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!



## Size 0541



### Mounting holes

Y = 28 Holes M12-20 deep, equally spaced  
Z = 32 Holes  $\phi 14$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 541$ , minimum

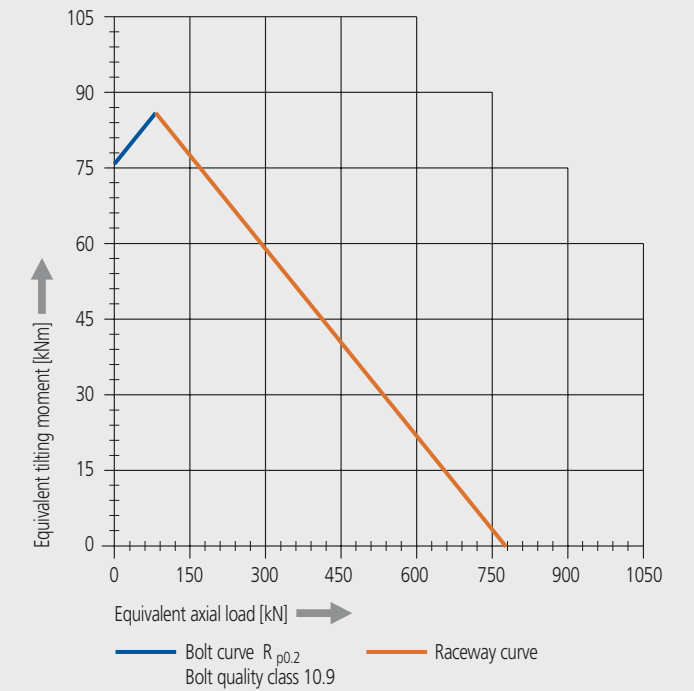
Drawing reference number SP-I 0541/1-03978			
Module	<b>m</b> [mm]	4	
Number of teeth, wheel	<b>z<sub>2</sub></b> [-]	156	
Number of teeth, pinion	<b>z<sub>1</sub></b> [-]	13	
Overall gear ration	<b>i</b> [-]	12	
Maximum torque $s_{FS} = 1.75$	<b>M<sub>d max</sub></b> [Nm]	5054	
Nom. torque $s_F = 1$ at $n = 5$ rpm	<b>M<sub>d nom</sub></b> [Nm]	2714	
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	5054	
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	155	
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	363	
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	173	
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	174	
Weight	[kg]	75	

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

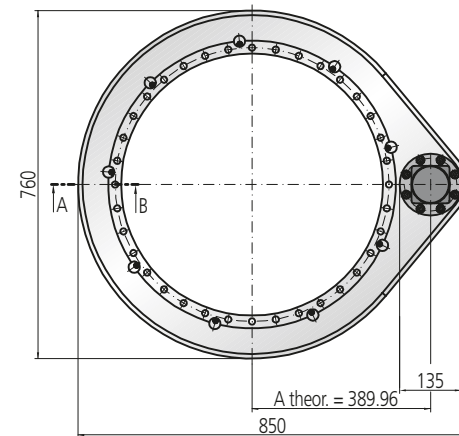
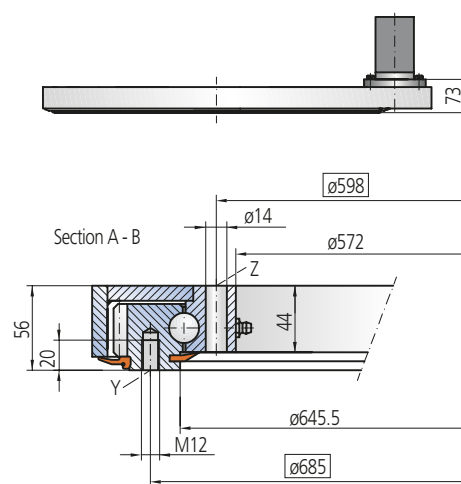
Pressure differential	<b><math>\Delta p</math></b> [bar]	120
Oil flow	<b>Q</b> [l/min]	23
Output speed	<b>n</b> [rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	5054

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0641



### Mounting holes

Y = 32 Holes M12-20 deep, equally spaced  
Z = 36 Holes  $\phi 14$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 641$ , minimum

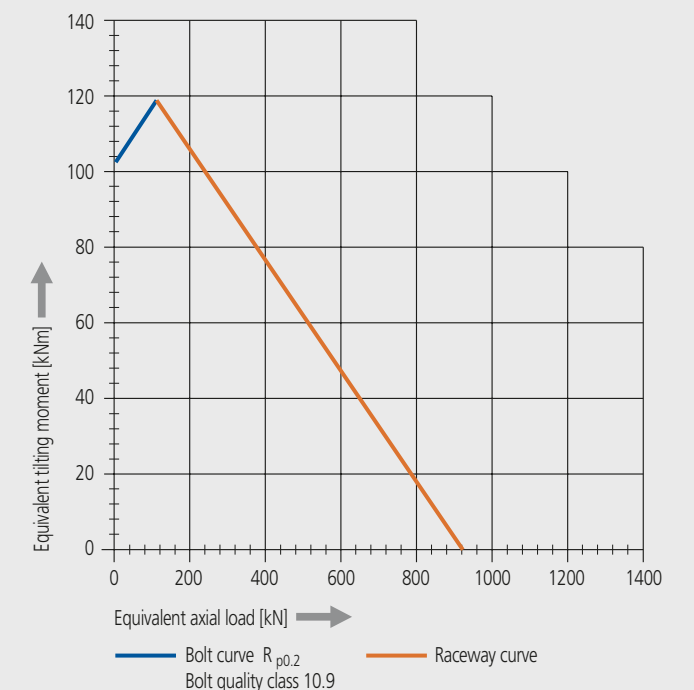
Drawing reference number SP-I 0641/1-03979			
Module	<b>m</b> [mm]	4	
Number of teeth, wheel	<b>z<sub>2</sub></b> [-]	181	
Number of teeth, pinion	<b>z<sub>1</sub></b> [-]	13	
Overall gear ration	<b>i</b> [-]	13.92	
Maximum torque $s_{FS} = 1.75$	<b>M<sub>d max</sub></b> [Nm]	5900	
Nom. torque $s_F = 1$ at $n = 5$ rpm	<b>M<sub>d nom</sub></b> [Nm]	3160	
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	5900	
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	394	
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	922	
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	184	
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	185	
Weight	[kg]	85	

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor H-300

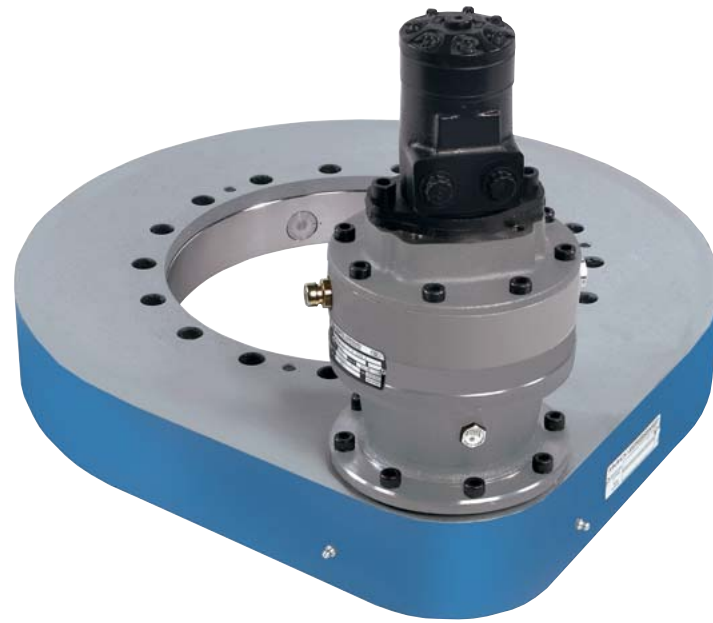
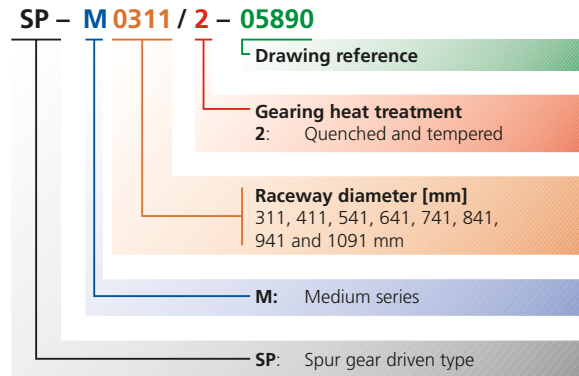
Pressure differential	<b><math>\Delta p</math></b> [bar]	120
Oil flow	<b>Q</b> [l/min]	27
Output speed	<b>n</b> [rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	5900

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Series Overview



### Verifying tooth base fatigue strength:

Valid for the following conditions:  
 - Output speed:  $n = 5.0$  rpm  
 - Repeated load  
 - Ambient temperature of  $20^\circ\text{C}$

$M_{dB}$ : Operation torque [Nm]  
 $M_{d\text{nom}}$ : Nominal torque [Nm] for  $SF = 1$  and  $n = 5.0$  rpm (see dimensions table)

If the following equation is met, the stress level of tooth base is below the endurance limit and fatigue is infinite:

$$M_{dB} \leq M_{d\text{nom}}$$

Fatigue stress of tooth base needs to be considered however, if the following equation is met (if so, refer to below additional steps to verify life):

$$M_{dB} > M_{d\text{nom}}$$

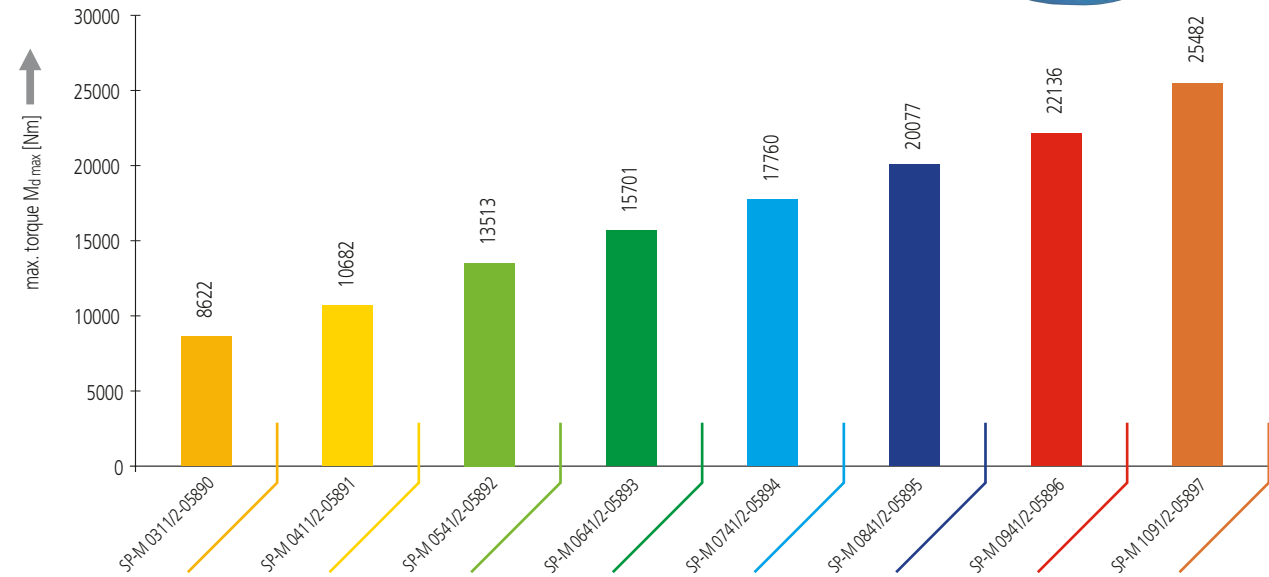
The operation is permissible as regards the fatigue stress of tooth base, if the following equation is fulfilled.

$$G_w \geq B_h \cdot \frac{ED_B}{100}$$

If this relationship is not fulfilled, then there is imminent danger of fatigue fracture of the tooth base.

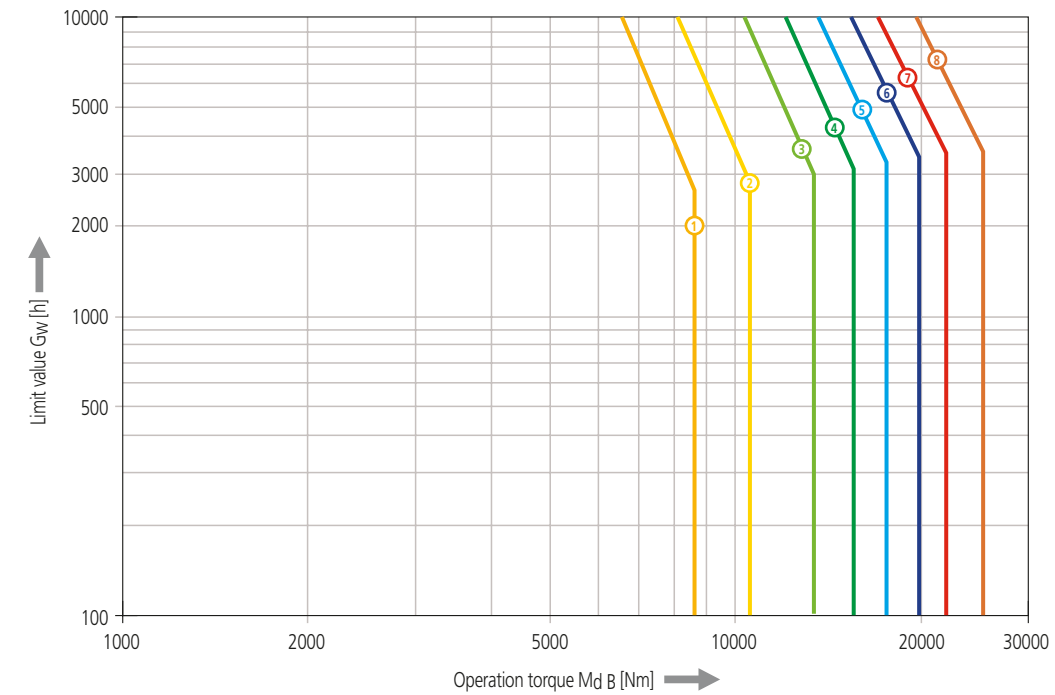
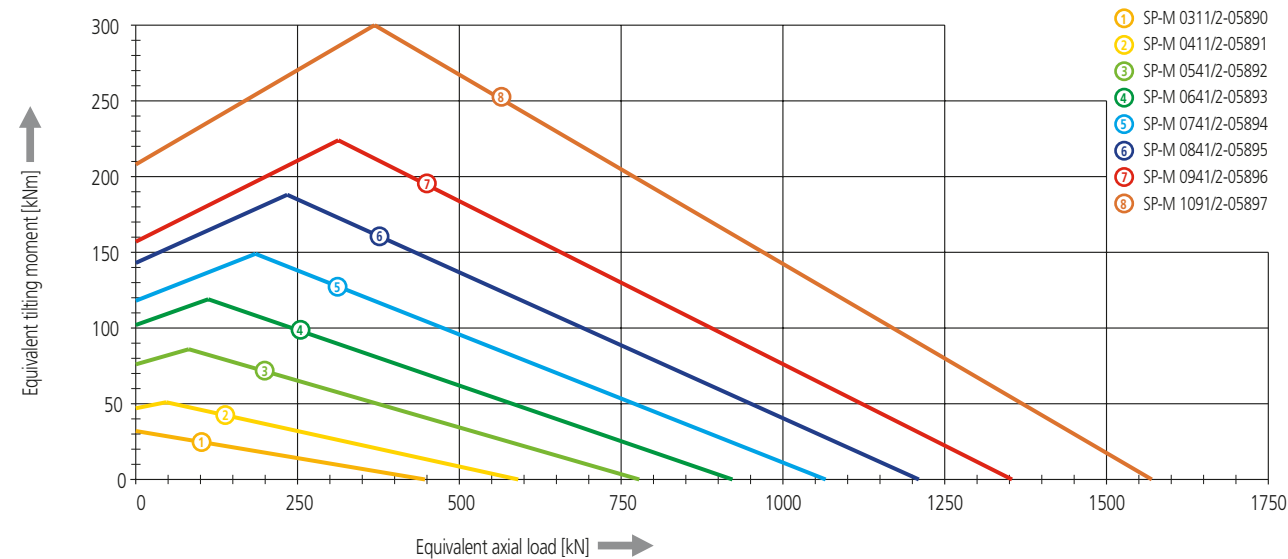
$G_w$ : Limit value from diagram [h]  
 $B_h$ : Operation time [h]  
 $ED_B$ : Duty [%]

### Maximum torque $M_{d\text{max}}$ of individual sizes



### Limiting load diagrams of individual sizes for "compressive" load

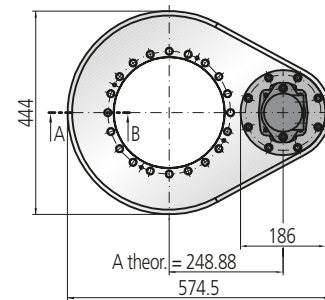
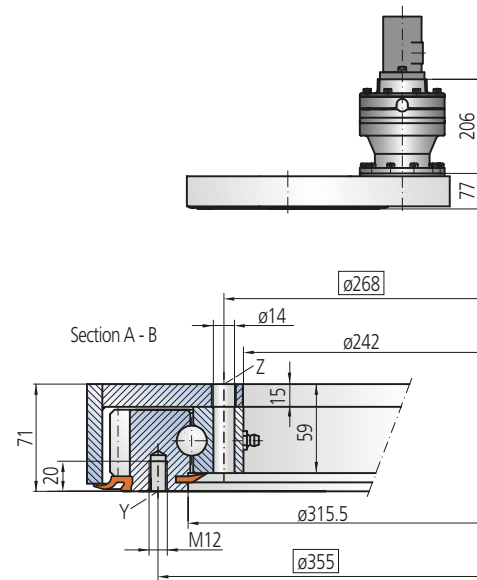
Please refer to the explanations in the Technical Information section of the catalog



Verification of the pitting and wear safety of tooth flanks must be done by the IMO Engineering Department!



## Size 0311



### Mounting holes

Y = 20 Holes M12-20 deep, equally spaced  
Z = 20 Holes  $\phi 14$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 308$ , minimum

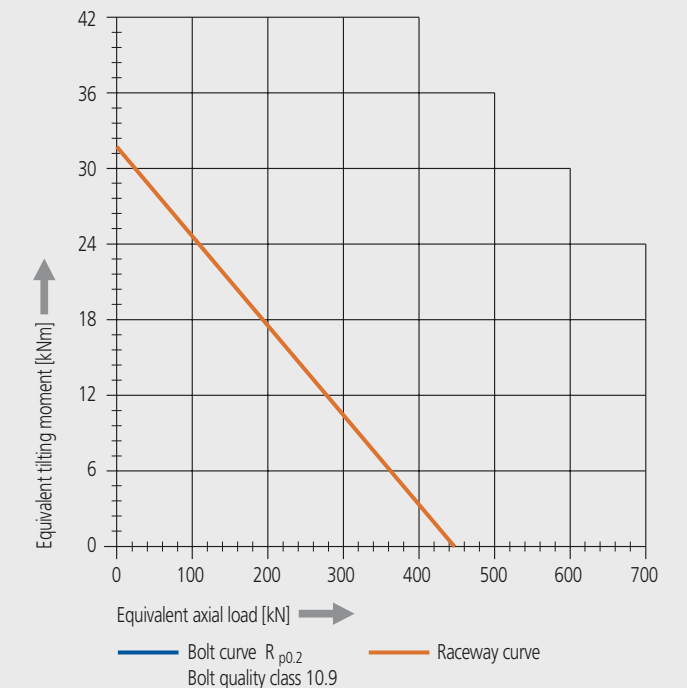
Drawing reference number SP-M 0311/2-05890			
Module	<b>m</b> [mm]	6	
Number of teeth, wheel	<b>z<sub>2</sub></b> [-]	67	
Number of teeth, pinion	<b>z<sub>1</sub></b> [-]	15	
Overall gear ration	<b>i</b> [-]	19.02	
Maximum torque	<b>M<sub>d max</sub></b> [Nm]	8622	
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b> [Nm]	6462	
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	8622	
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	191	
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	447	
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	140	
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	140	
Weight	[kg]	80	

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor T-306

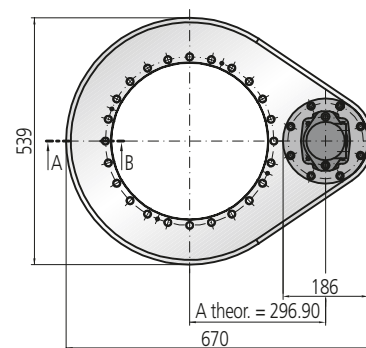
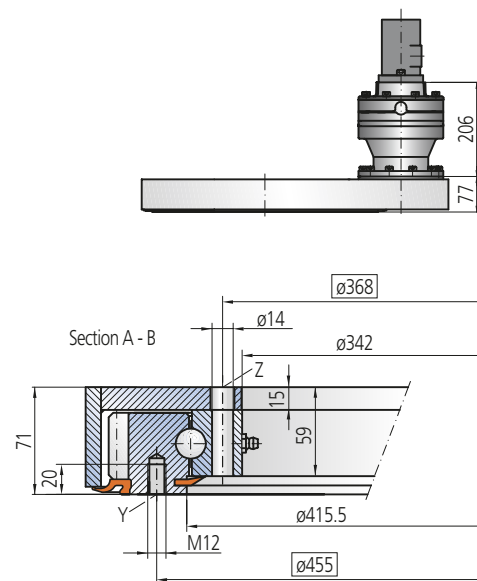
Pressure differential	<b><math>\Delta p</math></b> [bar]	124
Oil flow	<b>Q</b> [l/min]	39
Output speed	<b>n</b> [rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	8622

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0411



### Mounting holes

Y = 20 Holes M12-20 deep, equally spaced  
Z = 24 Holes  $\phi 14$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 405$ , minimum

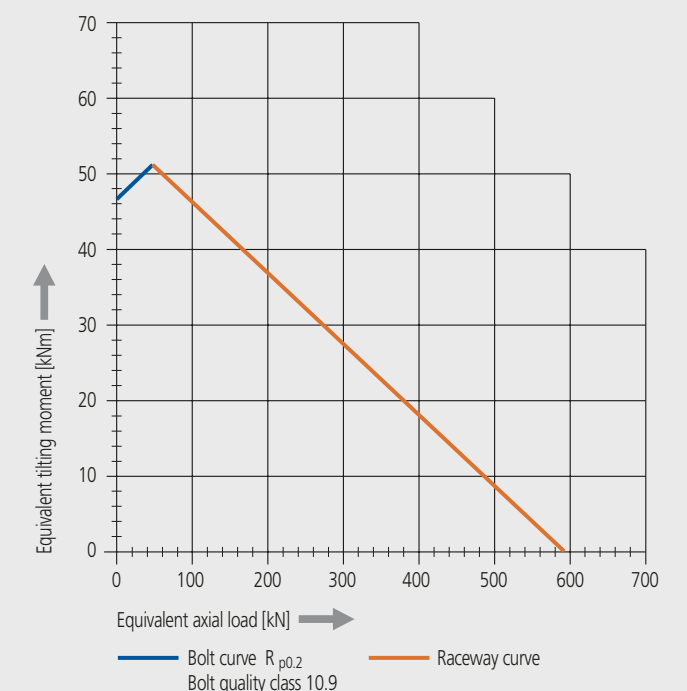
Drawing reference number SP-M 0411/2-05891			
Module	<b>m</b> [mm]	6	
Number of teeth, wheel	<b>z<sub>2</sub></b> [-]	83	
Number of teeth, pinion	<b>z<sub>1</sub></b> [-]	15	
Overall gear ration	<b>i</b> [-]	23.57	
Maximum torque	<b>M<sub>d max</sub></b> [Nm]	10682	
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b> [Nm]	8092	
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	10682	
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	253	
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	591	
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	155	
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	156	
Weight	[kg]	95	

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-200

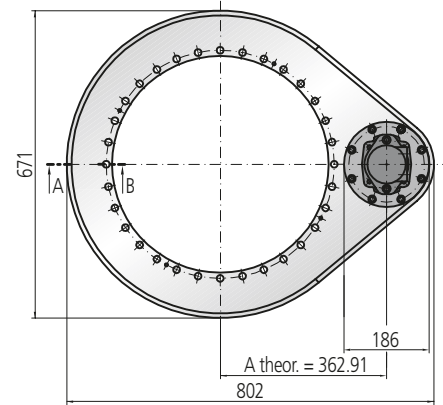
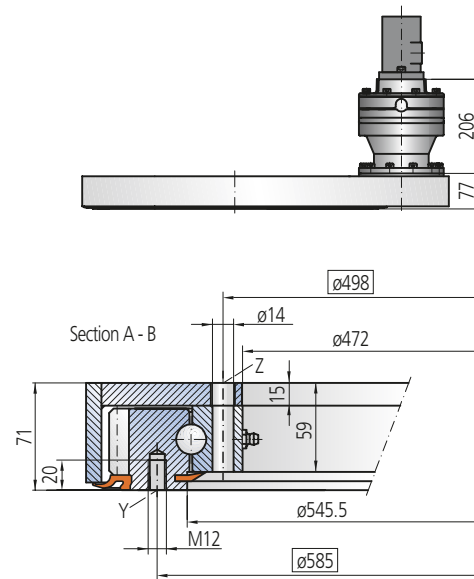
Pressure differential	<b><math>\Delta p</math></b> [bar]	190
Oil flow	<b>Q</b> [l/min]	28
Output speed	<b>n</b> [rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	10682

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0541



### Mounting holes

Y = 28 Holes M12-20 deep, equally spaced  
Z = 32 Holes  $\phi 14$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 537$ , minimum

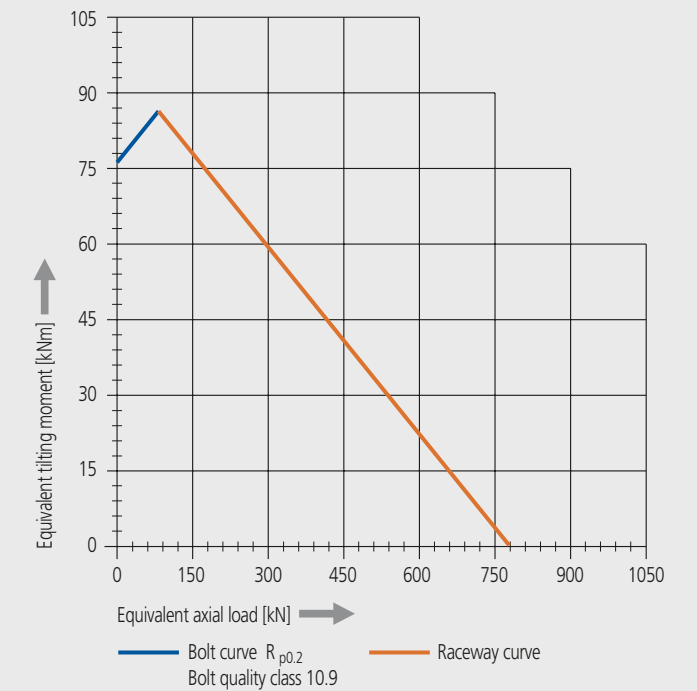
Drawing reference number SP-M 0541/2-05892			
Module	<b>m</b>	[mm]	6
Number of teeth, wheel	<b>z<sub>2</sub></b>	[-]	105
Number of teeth, pinion	<b>z<sub>1</sub></b>	[-]	15
Overall gear ration	<b>i</b>	[-]	29.82
Maximum torque	<b>M<sub>d max</sub></b>	[Nm]	13513
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b>	[Nm]	10363
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	13513
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	333
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	778
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	173
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	174
Weight		[kg]	110

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-200

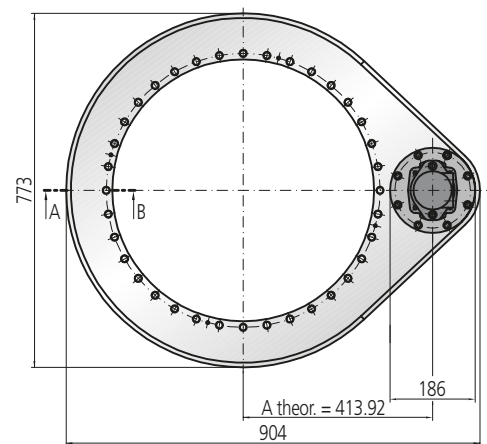
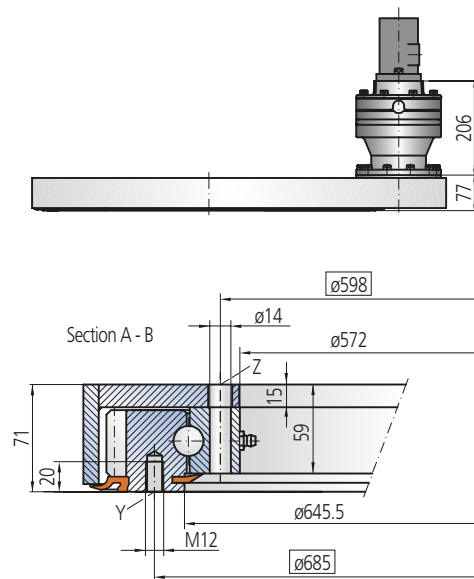
Pressure differential	<b><math>\Delta p</math></b>	[bar]	190
Oil flow	<b>Q</b>	[l/min]	34
Output speed	<b>n</b>	[rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	13513

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0641



### Mounting holes

Y = 32 Holes M12-20 deep, equally spaced  
Z = 36 Holes  $\phi 14$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 639$ , minimum

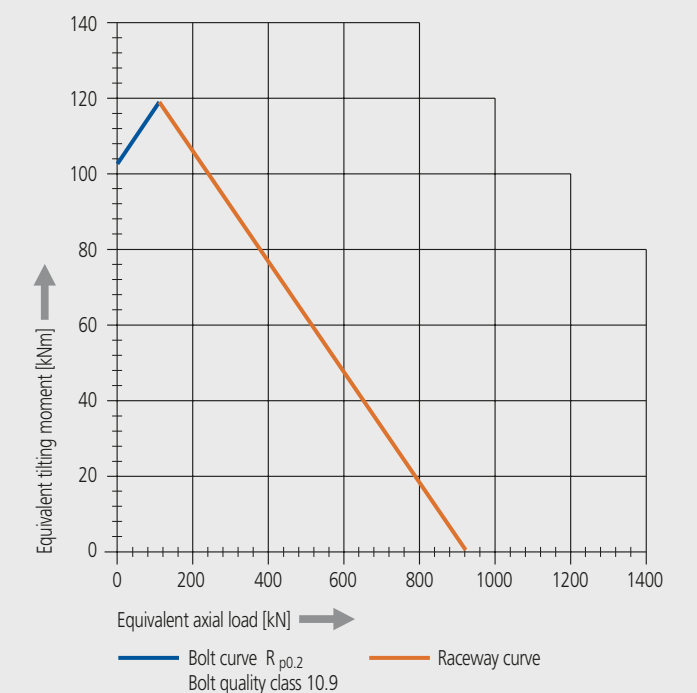
Drawing reference number SP-M 0641/2-05893			
Module	<b>m</b>	[mm]	6
Number of teeth, wheel	<b>z<sub>2</sub></b>	[-]	122
Number of teeth, pinion	<b>z<sub>1</sub></b>	[-]	15
Overall gear ration	<b>i</b>	[-]	34.64
Maximum torque	<b>M<sub>d max</sub></b>	[Nm]	15701
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b>	[Nm]	12114
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	15701
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	394
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	922
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	184
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	185
Weight		[kg]	125

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-200

Pressure differential	<b><math>\Delta p</math></b>	[bar]	190
Oil flow	<b>Q</b>	[l/min]	38
Output speed	<b>n</b>	[rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	15701

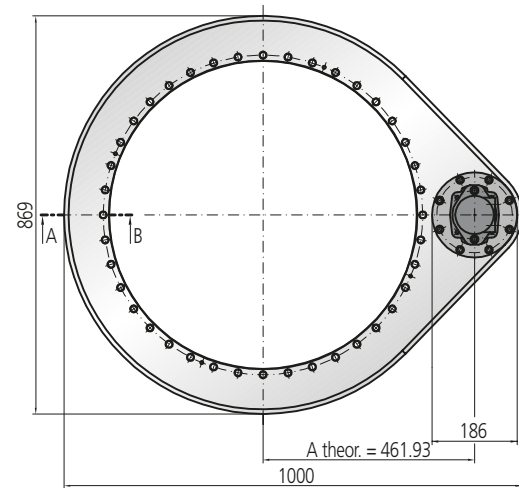
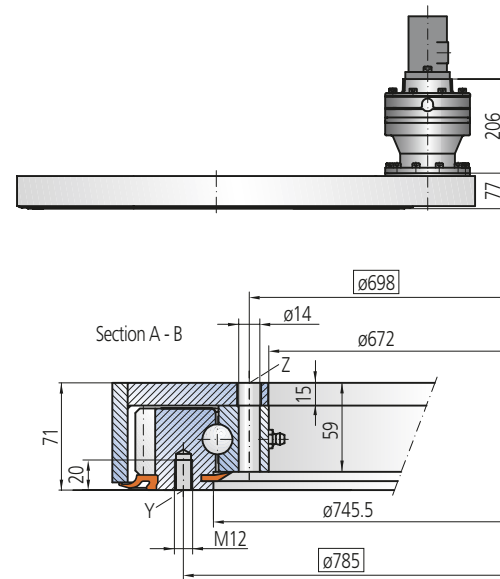
### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!



## Size 0741



### Mounting holes

Y = 36 Holes M12-20 deep, equally spaced  
Z = 40 Holes  $\phi 14$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 739$ , minimum

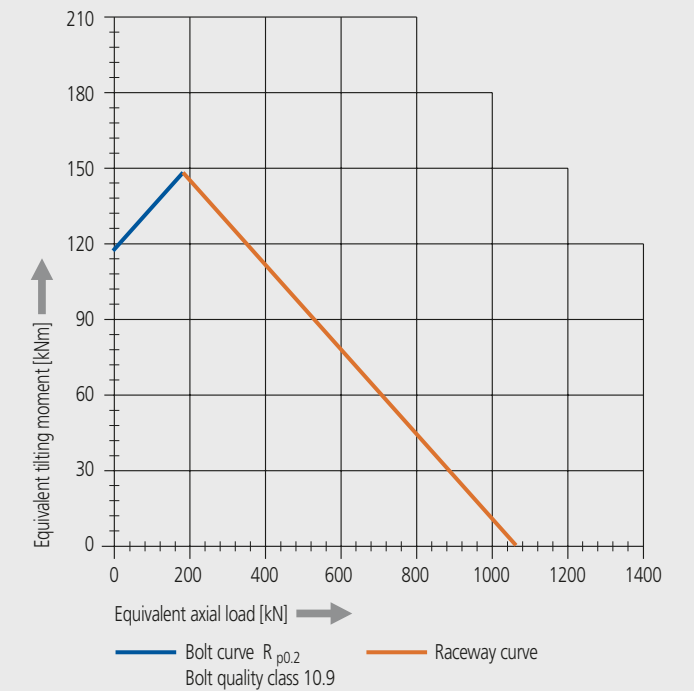
Drawing reference number SP-M 0741/2-05894			
Module	<b>m</b>	[mm]	6
Number of teeth, wheel	<b>z<sub>2</sub></b>	[-]	138
Number of teeth, pinion	<b>z<sub>1</sub></b>	[-]	15
Overall gear ration	<b>i</b>	[-]	39.19
Maximum torque	<b>M<sub>d max</sub></b>	[Nm]	17760
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b>	[Nm]	13744
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	17760
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	456
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	1066
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	194
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	195
Weight		[kg]	140

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-200

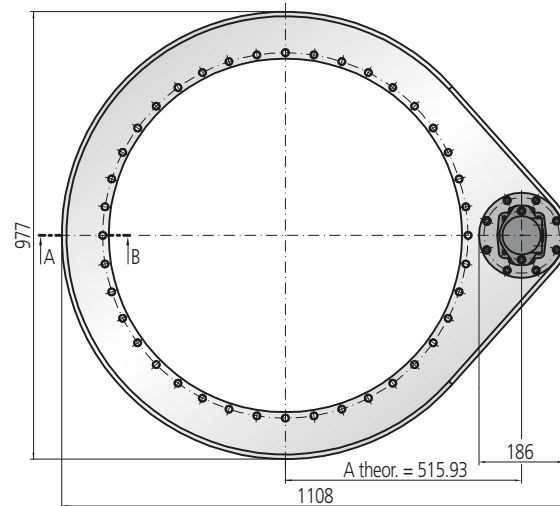
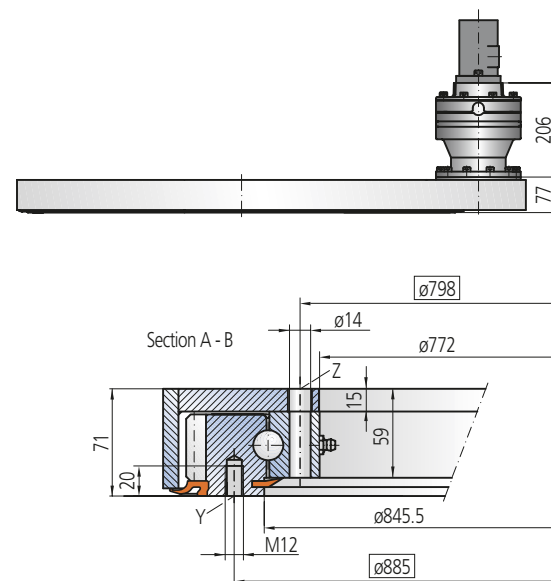
Pressure differential	<b><math>\Delta p</math></b>	[bar]	190
Oil flow	<b>Q</b>	[l/min]	43
Output speed	<b>n</b>	[rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	17760

### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!

## Size 0841



### Mounting holes

Y = 36 Holes M12-20 deep, equally spaced  
Z = 40 Holes  $\phi 14$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 841$ , minimum

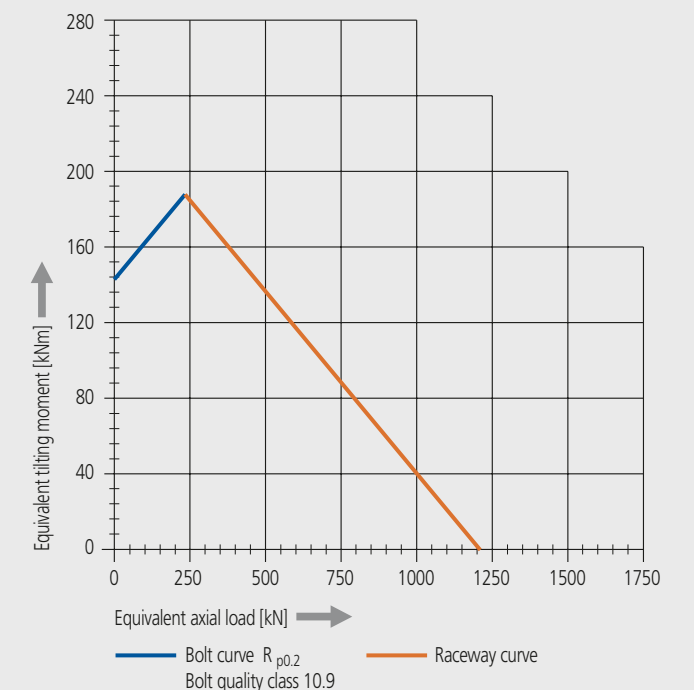
Drawing reference number SP-M 0841/2-05895			
Module	<b>m</b>	[mm]	6
Number of teeth, wheel	<b>z<sub>2</sub></b>	[-]	156
Number of teeth, pinion	<b>z<sub>1</sub></b>	[-]	15
Overall gear ration	<b>i</b>	[-]	44.30
Maximum torque	<b>M<sub>d max</sub></b>	[Nm]	20077
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b>	[Nm]	15584
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	20077
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	518
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	1210
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	204
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	206
Weight		[kg]	155

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-200

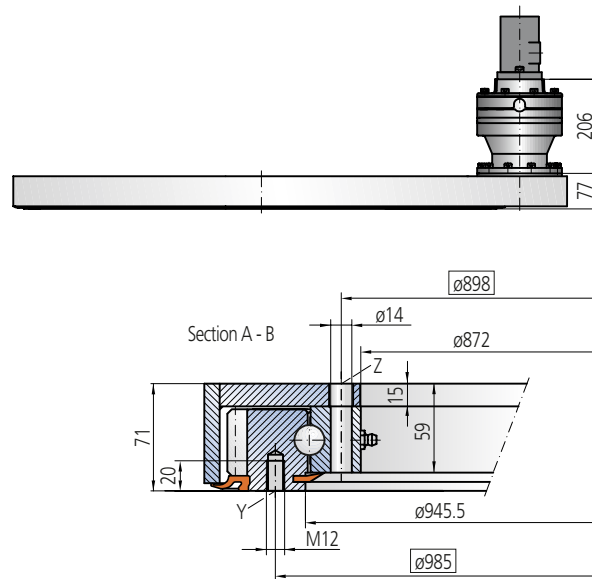
Pressure differential	<b><math>\Delta p</math></b>	[bar]	190
Oil flow	<b>Q</b>	[l/min]	48
Output speed	<b>n</b>	[rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	20077

### Limiting load diagram for 'compressive' load

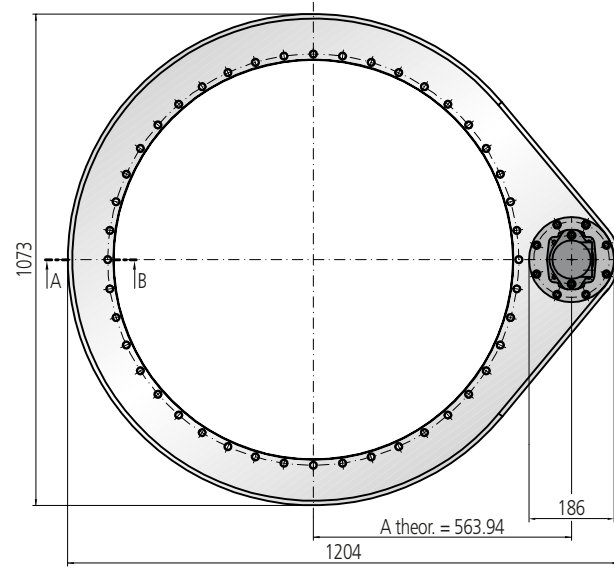


Please adhere strictly to the Technical Information section when using above graph!

## Size 0941



Note, mounting face against upper surface shall be 0941, minimum



### Mounting holes

Y = 40 Holes M12-20 deep, equally spaced  
Z = 44 Holes 14, equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

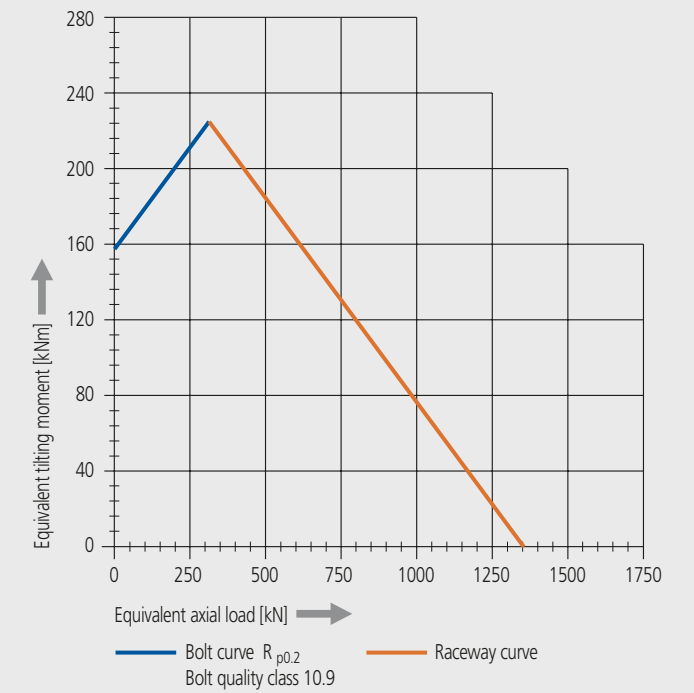
Drawing reference number SP-M 0941/2-05896			
Module	<b>m</b>	[mm]	6
Number of teeth, wheel	<b>z<sub>2</sub></b>	[-]	172
Number of teeth, pinion	<b>z<sub>1</sub></b>	[-]	15
Overall gear ration	<b>i</b>	[-]	48.84
Maximum torque	<b>M<sub>d max</sub></b>	[Nm]	22136
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b>	[Nm]	17182
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	22136
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	579
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	1354
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	212
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	214
Weight		[kg]	170

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-200

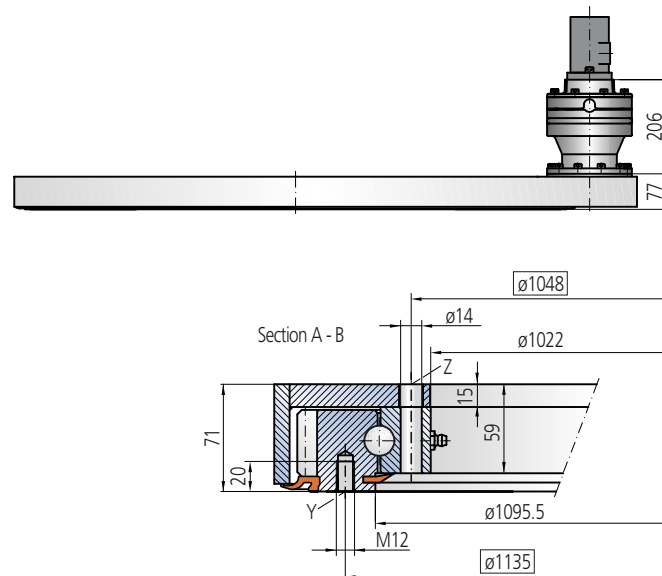
Pressure differential	<b>Δp</b>	[bar]	190
Oil flow	<b>Q</b>	[l/min]	51
Output speed	<b>n</b>	[rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	22136

### Limiting load diagram for 'compressive' load

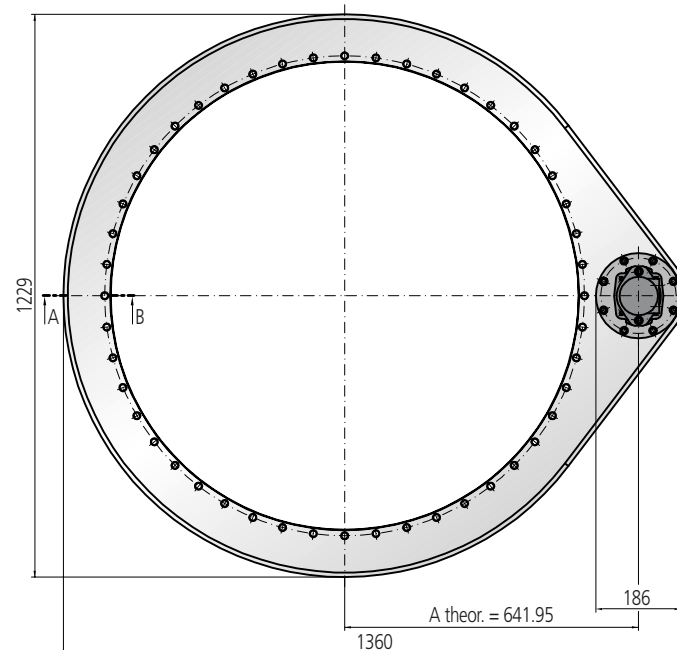


Please adhere strictly to the Technical Information section when using above graph!

## Size 1091



Note, mounting face against upper surface shall be 1091, minimum



### Mounting holes

Y = 44 Holes M12-20 deep, equally spaced  
Z = 48 Holes 14, equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing

Slew Drive supplied pre-lubricated

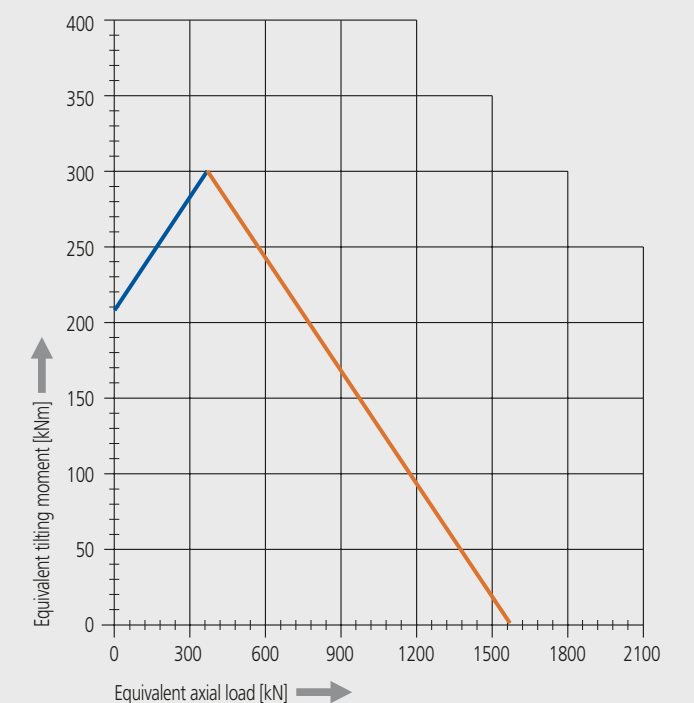
Drawing reference number SP-M 1091/2-05897			
Module	<b>m</b>	[mm]	6
Number of teeth, wheel	<b>z<sub>2</sub></b>	[-]	198
Number of teeth, pinion	<b>z<sub>1</sub></b>	[-]	15
Overall gear ration	<b>i</b>	[-]	56.23
Maximum torque	<b>M<sub>d max</sub></b>	[Nm]	25482
Nom. torque SF = 1 at n = 5 rpm	<b>M<sub>d nom</sub></b>	[Nm]	19839
Maximum holding torque*	<b>M<sub>h</sub></b>	[Nm]	25482
Static load rating, radial	<b>C<sub>o rad</sub></b>	[kN]	672
Static load rating, axial	<b>C<sub>o ax</sub></b>	[kN]	1570
Dynamic load rating, radial	<b>C<sub>rad</sub></b>	[kN]	224
Dynamic load rating, axial	<b>C<sub>ax</sub></b>	[kN]	226
Weight		[kg]	200

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-200

Pressure differential	<b>Δp</b>	[bar]	190
Oil flow	<b>Q</b>	[l/min]	62
Output speed	<b>n</b>	[rpm]	5
Maximum achievable torque	<b>M<sub>d</sub></b>	[Nm]	25482

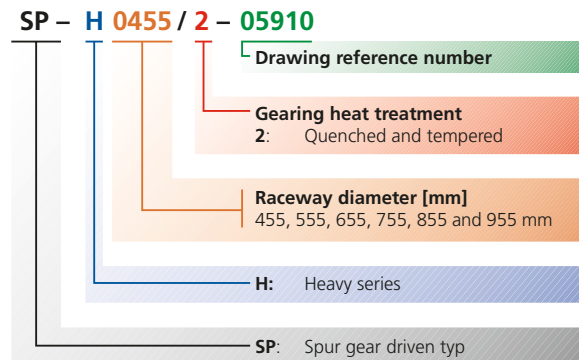
### Limiting load diagram for 'compressive' load



Please adhere strictly to the Technical Information section when using above graph!



## Series Overview



### Verifying tooth base fatigue strength:

Valid for the following conditions:  
 - Output speed:  $n = 3.0$  rpm  
 - Repeated load  
 - Ambient temperature of  $20^{\circ}\text{C}$

$M_{dB}$ : Operation torque [Nm]  
 $M_{d\text{nom}}$ : Nominal torque [Nm] for  $SF = 1$  and  $n = 3.0$  rpm (see dimensions table)

If the following equation is met, the stress level of tooth base is below the endurance limit and fatigue is infinite:

$$M_{dB} \leq M_{d\text{nom}}$$

Fatigue stress of tooth base needs to be considered however, if the following equation is met (if so, refer to below additional steps to verify life):

$$M_{dB} > M_{d\text{nom}}$$

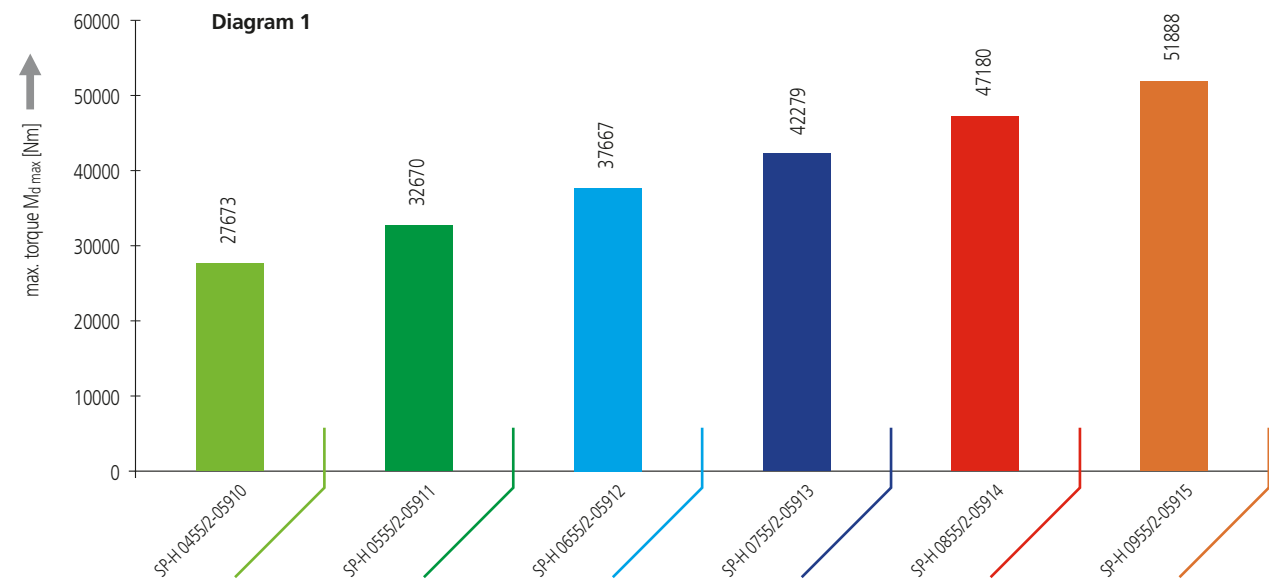
The operation is permissible as regards the fatigue stress of tooth base, if the following equation is fulfilled.

$$G_w \geq B_h \cdot \frac{ED_B}{100}$$

If this relationship is not fulfilled, then there is imminent danger of fatigue fracture of the tooth base.

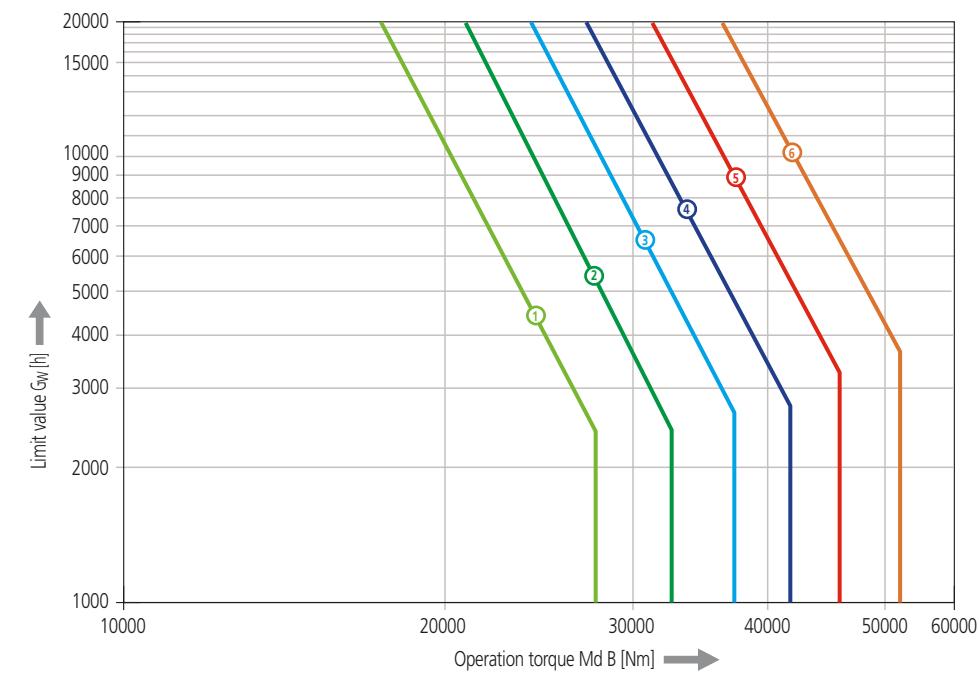
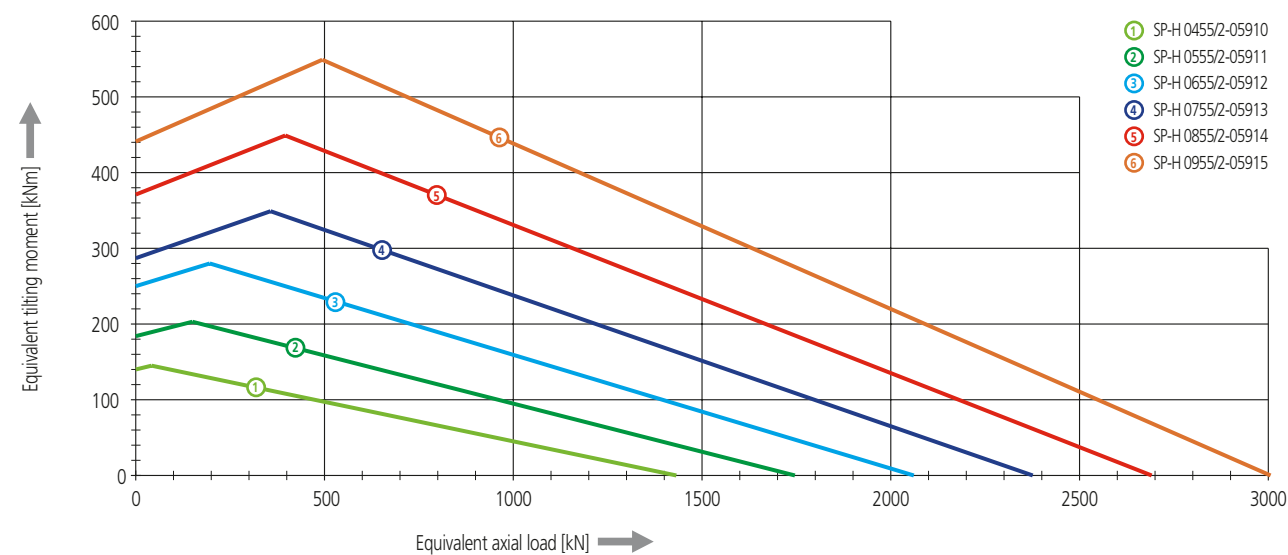
$G_w$ : Limit value from diagram [h]  
 $B_h$ : Operation time [h]  
 $ED_B$ : Duty [%]

### Maximum torque $M_{d\text{max}}$ of individual sizes



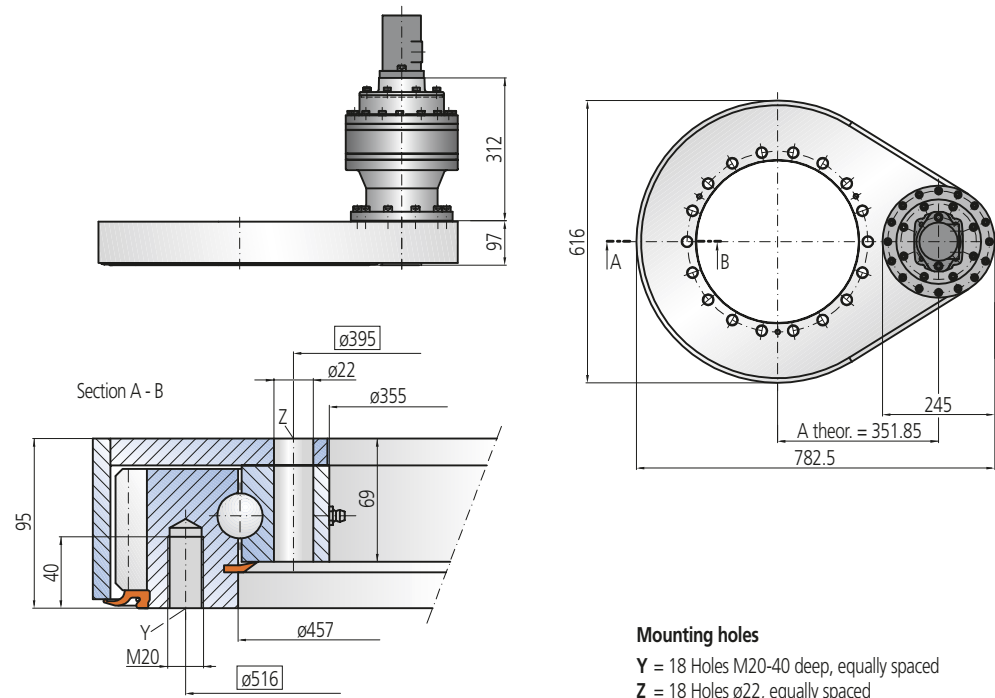
### Limiting load diagrams of individual sizes for "compressive" load

Please refer to the explanations in the Technical Information section of the catalog



Verification of the pitting and wear safety of tooth flanks must be done by the IMO Engineering Department!

## Size 0455



### Mounting holes

Y = 18 Holes M20-40 deep, equally spaced  
Z = 18 Holes  $\phi 22$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing  
Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 455$ , minimum

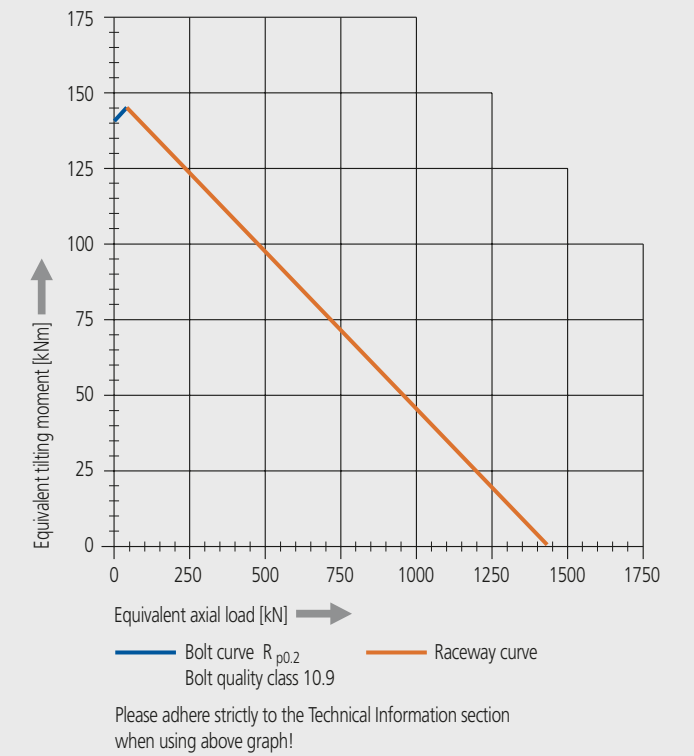
Drawing reference number SP-H 0455/2-05910			
Module	<b>m</b> [mm]	8	
Number of teeth, wheel	<b>z<sub>2</sub></b> [-]	72	
Number of teeth, pinion	<b>z<sub>1</sub></b> [-]	15	
Overall gear ration	<b>i</b> [-]	86.88	
Maximum torque	<b>M<sub>d max</sub></b> [Nm]	27673	
Nom. torque SF = 1 at n = 3 rpm	<b>M<sub>d nom</sub></b> [Nm]	18115	
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	27673	
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	535	
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	1432	
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	249	
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	290	
Weight	[kg]	190	

\*Optional with brake

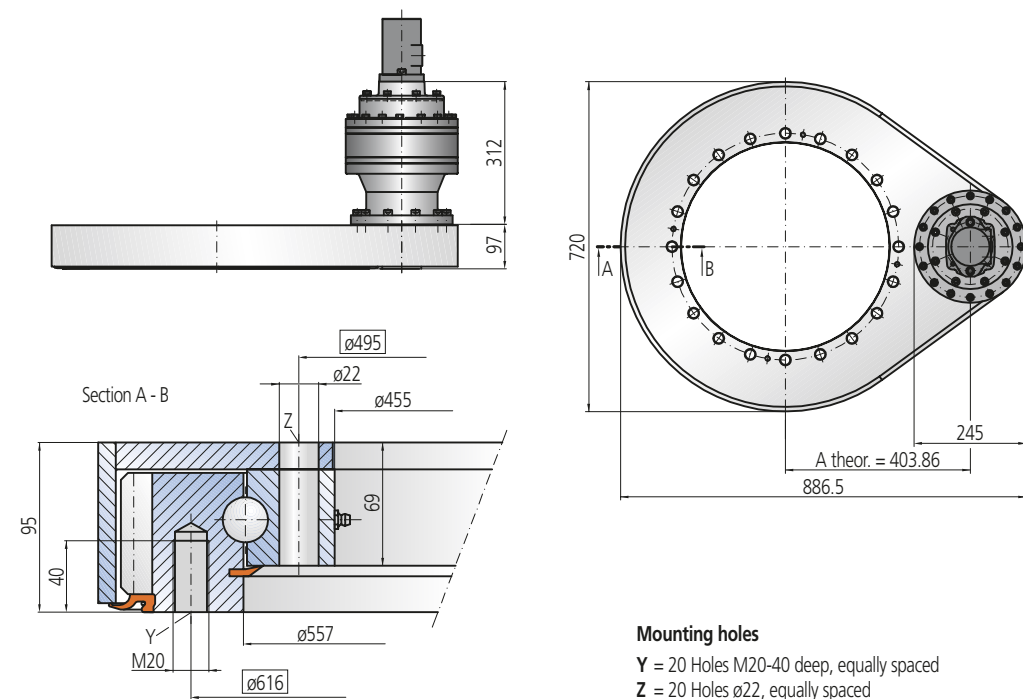
The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-132

Pressure differential	<b><math>\Delta p</math></b> [bar]	195
Oil flow	<b>Q</b> [l/min]	38
Output speed	<b>n</b> [rpm]	3
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	27673

### Limiting load diagram for 'compressive' load



## Size 0555



### Mounting holes

Y = 20 Holes M20-40 deep, equally spaced  
Z = 20 Holes  $\phi 22$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing  
Slew Drive supplied pre-lubricated

Note, mounting face against upper surface shall be  $\phi 555$ , minimum

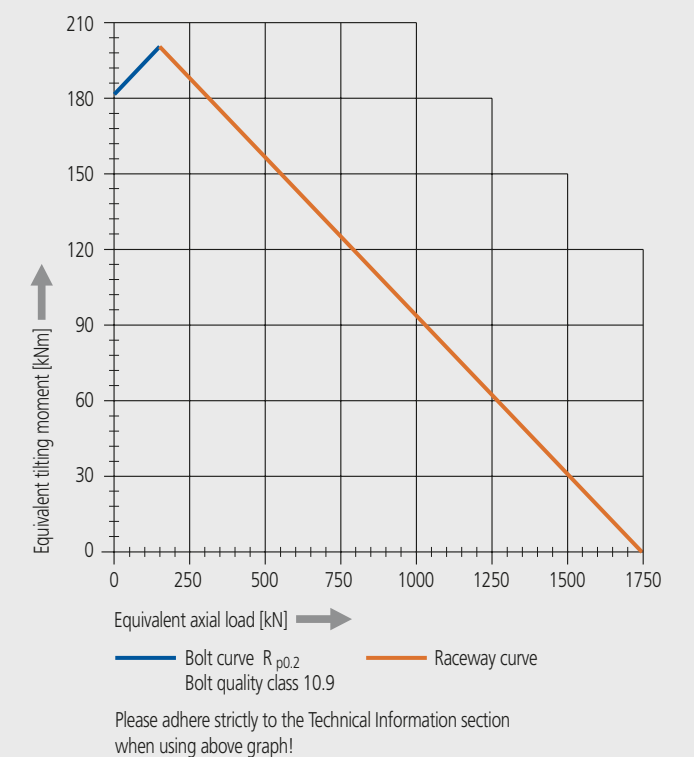
Drawing reference number SP-H 0555/2-05911			
Module	<b>m</b> [mm]	8	
Number of teeth, wheel	<b>z<sub>2</sub></b> [-]	85	
Number of teeth, pinion	<b>z<sub>1</sub></b> [-]	15	
Overall gear ration	<b>i</b> [-]	102.56	
Maximum torque	<b>M<sub>d max</sub></b> [Nm]	32670	
Nom. torque SF = 1 at n = 3 rpm	<b>M<sub>d nom</sub></b> [Nm]	21590	
Maximum holding torque*	<b>M<sub>h</sub></b> [Nm]	32670	
Static load rating, radial	<b>C<sub>o rad</sub></b> [kN]	652	
Static load rating, axial	<b>C<sub>o ax</sub></b> [kN]	1746	
Dynamic load rating, radial	<b>C<sub>rad</sub></b> [kN]	267	
Dynamic load rating, axial	<b>C<sub>ax</sub></b> [kN]	312	
Weight	[kg]	215	

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-132

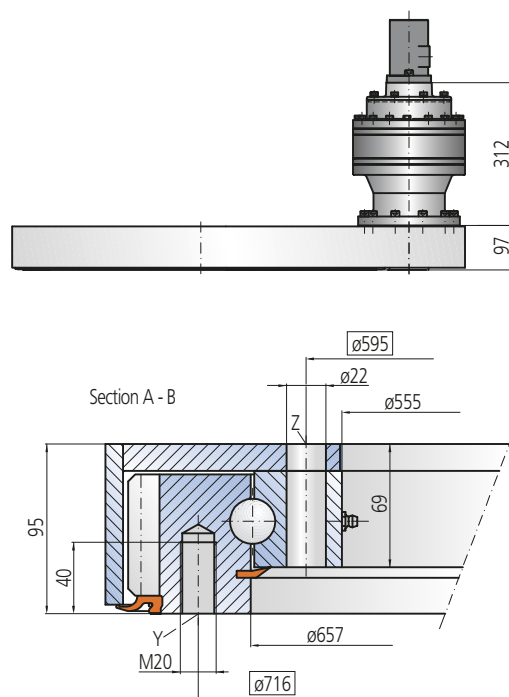
Pressure differential	<b><math>\Delta p</math></b> [bar]	195
Oil flow	<b>Q</b> [l/min]	45
Output speed	<b>n</b> [rpm]	3
Maximum achievable torque	<b>M<sub>d</sub></b> [Nm]	32670

### Limiting load diagram for 'compressive' load

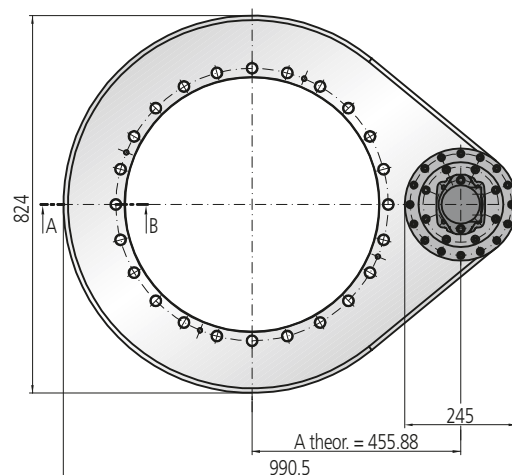




## Size 0655



Note, mounting face against upper surface shall be  $\phi 655$ , minimum



### Mounting holes

Y = 24 Holes M20-40 deep, equally spaced  
Z = 24 Holes  $\phi 22$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing  
Slew Drive supplied pre-lubricated

Drawing reference number SP-H 0655/2-05912			
Module	m	[mm]	8
Number of teeth, wheel	$z_2$	[-]	98
Number of teeth, pinion	$z_1$	[-]	15
Overall gear ratio	i	[-]	118.25
Maximum torque	$M_{d\ max}$	[Nm]	37667
Nom. torque SF = 1 at n = 3 rpm	$M_{d\ nom}$	[Nm]	25048
Maximum holding torque*	$M_h$	[Nm]	37667
Static load rating, radial	$C_{o\ rad}$	[kN]	770
Static load rating, axial	$C_{o\ ax}$	[kN]	2061
Dynamic load rating, radial	$C_{rad}$	[kN]	284
Dynamic load rating, axial	$C_{ax}$	[kN]	331
Weight		[kg]	245

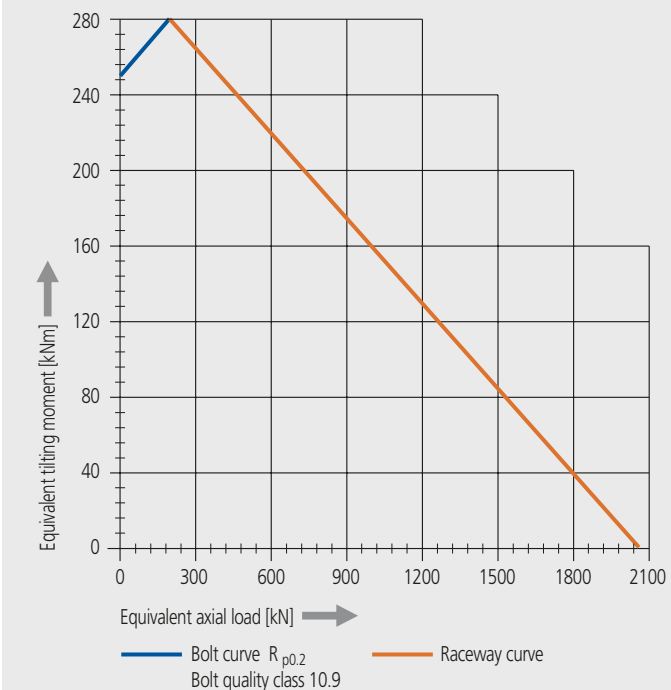
\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.

Selection example: performance data with hydraulic motor 2-132

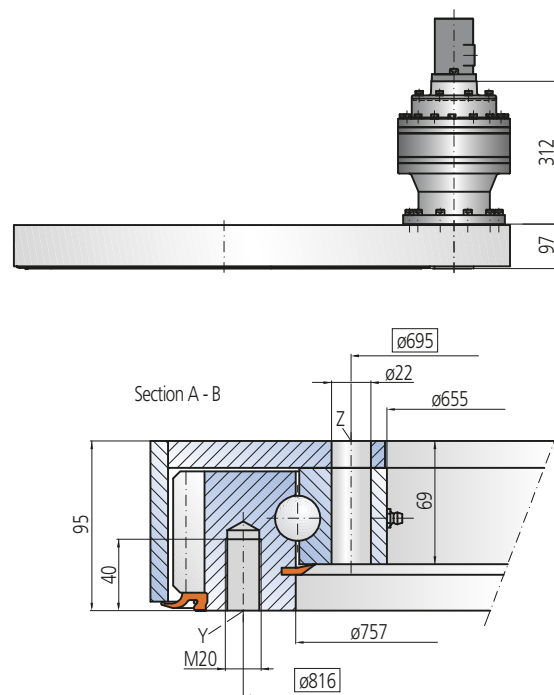
Pressure differential	$\Delta p$	[bar]	195
Oil flow	Q	[l/min]	52
Output speed	n	[rpm]	3
Maximum achievable torque	$M_d$	[Nm]	37667

### Limiting load diagram for 'compressive' load

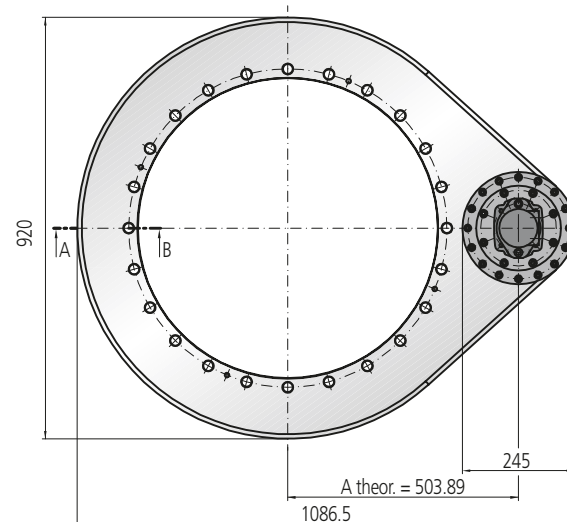


Please adhere strictly to the Technical Information section when using above graph!

## Size 0755



Note, mounting face against upper surface shall be  $\phi 755$ , minimum



### Mounting holes

Y = 24 Holes M20-40 deep, equally spaced  
Z = 24 Holes  $\phi 22$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing  
Slew Drive supplied pre-lubricated

Drawing reference number SP-H 0755/2-05913			
Module	m	[mm]	8
Number of teeth, wheel	$z_2$	[-]	110
Number of teeth, pinion	$z_1$	[-]	15
Overall gear ratio	i	[-]	132.73
Maximum torque	$M_{d\ max}$	[Nm]	42279
Nom. torque SF = 1 at n = 3 rpm	$M_{d\ nom}$	[Nm]	28204
Maximum holding torque*	$M_h$	[Nm]	42279
Static load rating, radial	$C_{o\ rad}$	[kN]	888
Static load rating, axial	$C_{o\ ax}$	[kN]	2376
Dynamic load rating, radial	$C_{rad}$	[kN]	299
Dynamic load rating, axial	$C_{ax}$	[kN]	349
Weight		[kg]	265

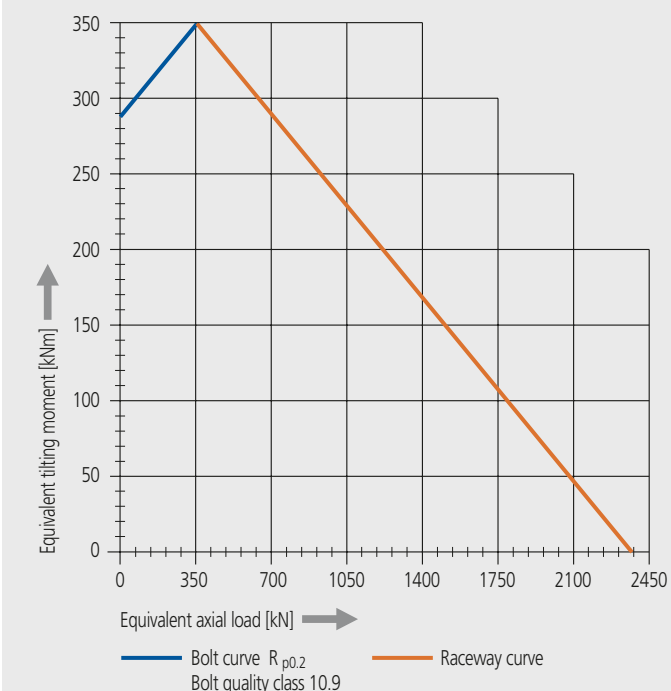
\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.

Selection example: performance data with hydraulic motor 2-132

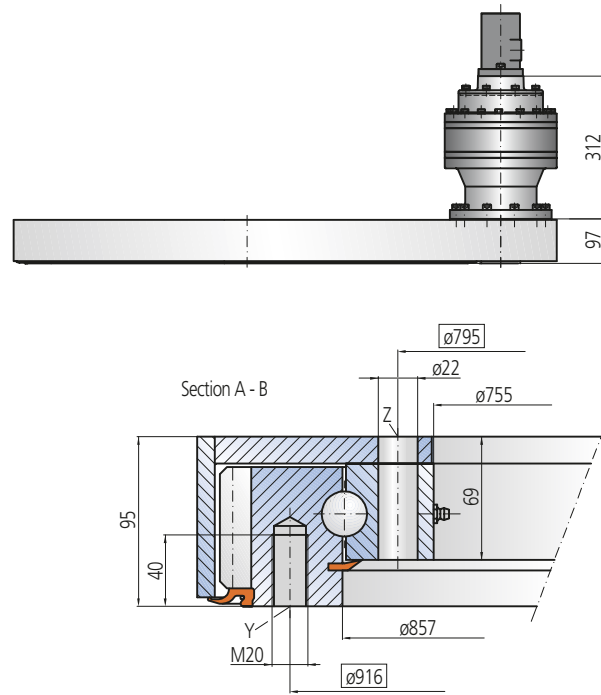
Pressure differential	$\Delta p$	[bar]	195
Oil flow	Q	[l/min]	57
Output speed	n	[rpm]	3
Maximum achievable torque	$M_d$	[Nm]	42279

### Limiting load diagram for 'compressive' load

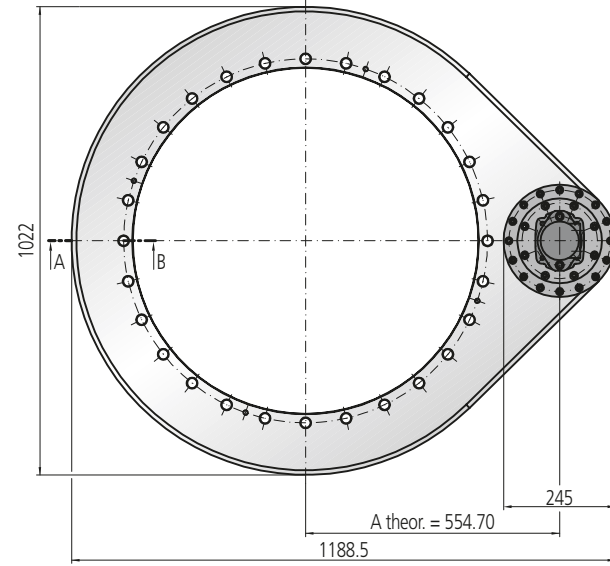


Please adhere strictly to the Technical Information section when using above graph!

## Size 0855



Note, mounting face against upper surface shall be  $\phi 855$ , minimum



### Mounting holes

Y = 28 Holes M20-40 deep, equally spaced  
Z = 28 Holes  $\phi 22$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing  
Slew Drive supplied pre-lubricated

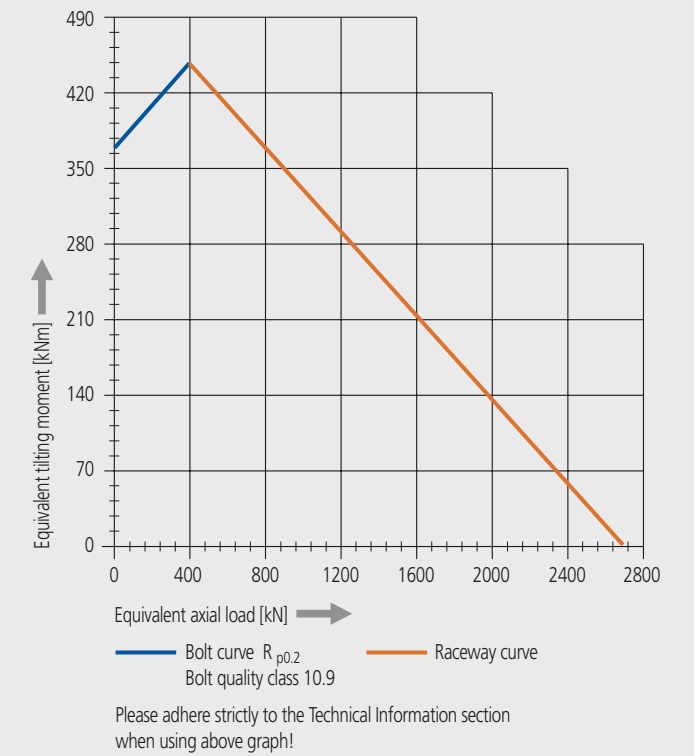
Drawing reference number SP-H 0855/2-05914			
Module	m	[mm]	8
Number of teeth, wheel	$z_2$	[-]	122
Number of teeth, pinion	$z_1$	[-]	15
Overall gear ration	i	[-]	147.21
Maximum torque	$M_{d \max}$	[Nm]	47180
Nom. torque SF = 1 at n = 3 rpm	$M_{d \text{ nom}}$	[Nm]	32749
Maximum holding torque*	$M_h$	[Nm]	47180
Static load rating, radial	$C_{o \text{ rad}}$	[kN]	1005
Static load rating, axial	$C_{o \text{ ax}}$	[kN]	2691
Dynamic load rating, radial	$C_{\text{rad}}$	[kN]	315
Dynamic load rating, axial	$C_{\text{ax}}$	[kN]	368
Weight		[kg]	295

\*Optional with brake

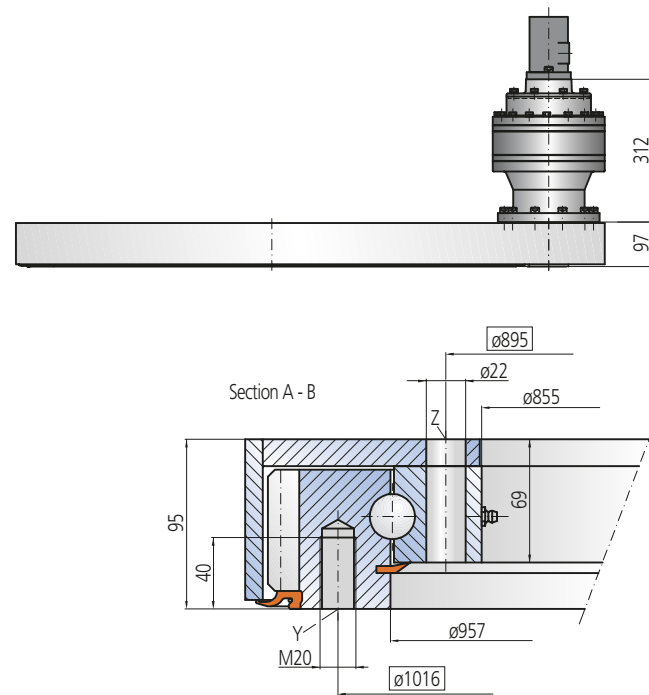
The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-132

Pressure differential	$\Delta p$	[bar]	195
Oil flow	Q	[l/min]	64
Output speed	n	[rpm]	3
Maximum achievable torque	$M_d$	[Nm]	47180

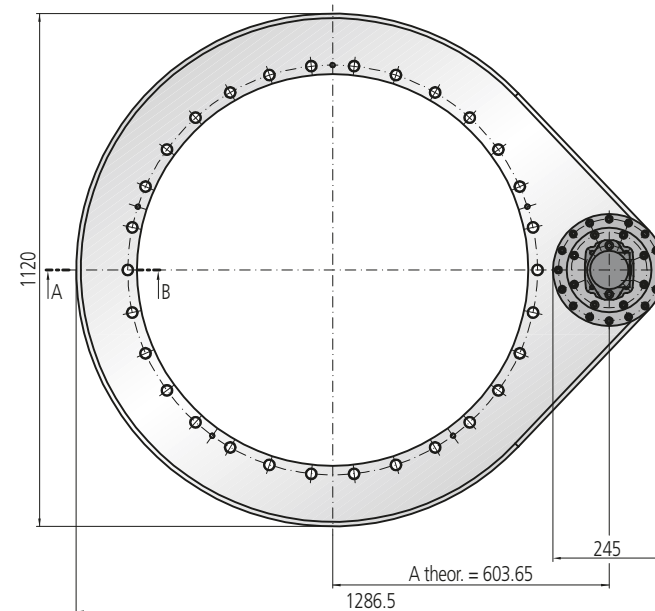
### Limiting load diagram for 'compressive' load



## Size 0955



Note, mounting face against upper surface shall be  $\phi 955$ , minimum



### Mounting holes

Y = 30 Holes M20-40 deep, equally spaced  
Z = 30 Holes  $\phi 22$ , equally spaced

### Lubrication ports

4 Taper type grease nipples on the internal diameter  
2 Taper type grease nipples on the outside of the housing  
Slew Drive supplied pre-lubricated

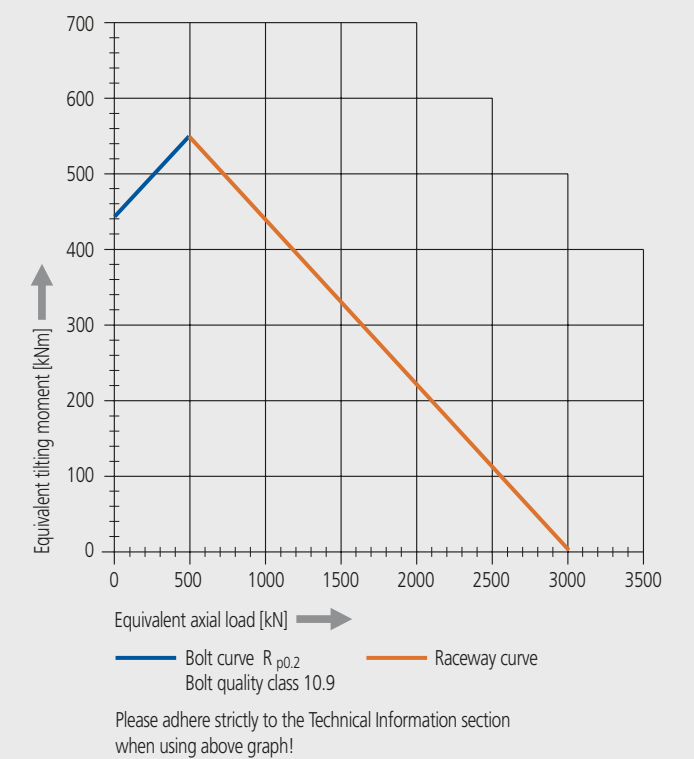
Drawing reference number SP-H 0955/2-05915			
Module	m	[mm]	8
Number of teeth, wheel	$z_2$	[-]	134
Number of teeth, pinion	$z_1$	[-]	15
Overall gear ration	i	[-]	161.69
Maximum torque	$M_{d \max}$	[Nm]	51888
Nom. torque SF = 1 at n = 3 rpm	$M_{d \text{ nom}}$	[Nm]	36342
Maximum holding torque*	$M_h$	[Nm]	51888
Static load rating, radial	$C_{o \text{ rad}}$	[kN]	1123
Static load rating, axial	$C_{o \text{ ax}}$	[kN]	3006
Dynamic load rating, radial	$C_{\text{rad}}$	[kN]	328
Dynamic load rating, axial	$C_{\text{ax}}$	[kN]	383
Weight		[kg]	320

\*Optional with brake

The selection of the hydraulic / electric motor depends on actual customer requirements and specifications.  
Selection example: performance data with hydraulic motor 2-132

Pressure differential	$\Delta p$	[bar]	195
Oil flow	Q	[l/min]	70
Output speed	n	[rpm]	3
Maximum achievable torque	$M_d$	[Nm]	51888

### Limiting load diagram for 'compressive' load





## Application Data Sheet - Slew Drives

Please copy, fill in and send to: IMO Antriebseinheit GmbH  
Gewerbepark 16 - 91350 Gremsdorf/Germany - Fax: +49-9193/50818-40

Alternatively, you can fill in this sheet online at  
[www.goimo.com](http://www.goimo.com)

### 1. Contact:

Firm: \_\_\_\_\_ Homepage: \_\_\_\_\_  
Contact person: \_\_\_\_\_ Email: \_\_\_\_\_  
Address: \_\_\_\_\_ Phone: \_\_\_\_\_  
City: \_\_\_\_\_ Fax: \_\_\_\_\_  
Zip Code: \_\_\_\_\_

### 2. Application description (please attach additional sketch):

New Application: No  Yes

Exchangeable with existing solution: No  Yes  If yes: what should be considered? Replacement for: pls fill in below!

### Position of rotation axis:

Vertical  Horizontal  Inclined/Changing

$\alpha$   Degrees Middle position of rotation axis  
 $\pm\beta$   Degrees Angle range

### Type of load:

"Compressive" axial load  "Suspended" axial load

Ambient temperature: minimum  °C normal  °C maximum  °C  
Do shocks or vibrations occur? No  Yes   
Self-locking/brake required? No  Yes   
Special seals required? No  Yes  \* against: \_\_\_\_\_  
Works Certificate? No  Yes  \* type: \_\_\_\_\_ (e.g. ISO 10474 3.1B according to EN 10204)  
Test certificate from authority required? No  Yes  \* type: \_\_\_\_\_ (e.g. ISO 10474 3.2 according to EN 10204)  
Special conditions or specifications to be considered? No  Yes  \* which: \_\_\_\_\_ (e.g. Lloyds; ABS; API; BV; DNV etc.)

\*Please provide specific requirements.

### 3. Drive concept:

With hydraulic motor  with electric motor  without motor

max. available pressure differential  $\Delta p$   bar rated voltage  Volt  
max. available oil flow Q  l/min main frequency  Hz

Peculiarities: \_\_\_\_\_

## Application Data Sheet - Slew Drives

### 4. Load parameters:

			Operating load		Test load	Extreme load
			Normal	Maximum		
(Equivalent) axial load	$F_{ax}$	kN				
(Equivalent) radial load	$F_{rad}$	kN				
(Equivalent) tilting moment	$M_k$	kNm				
Operating torque	$M_{dB}$	Nm				
Holding torque	$M_h$	Nm				
Accelerating torque	$M_b$	Nm				
Moment of inertia about rotation axis	J	kg • m <sup>2</sup>				
Duty (% of rotation)	$ED_B$	%				
Duty per minute (% of rotation)	$ED_B \cdot$	%/min				
Continuous rotation or slewing without interruption (continuous operation)		<input type="checkbox"/>				
Rotational speed	n	rpm				
if: interrupted rotation or slewing (intermittent operation)		<input type="checkbox"/>				
then: fill additional cycle description						
Slewing angle	$\delta_{s1}$	degrees				
Slewing time	$t_{s1}$	s				
Interruption time	$t_{u1}$	s				
Angular acceleration	$\alpha_b$	rad/s <sup>2</sup>				

Slewing direction: One direction only  Alternating directions

Peculiarities: \_\_\_\_\_

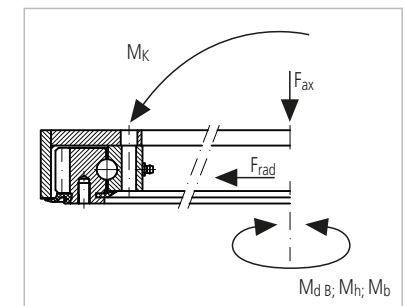
Any additional application service factor?  No  Yes Which one: \_\_\_\_\_

Equipment utilization time in years:  yrs

Average operating hours per year:  hrs

### 5. Offer data:

Yearly usage:  pieces per year  
Lot size:  pieces per delivery lot  
Required delivery time:  weeks  
Proposal required by:  date  
Target price:  price per unit



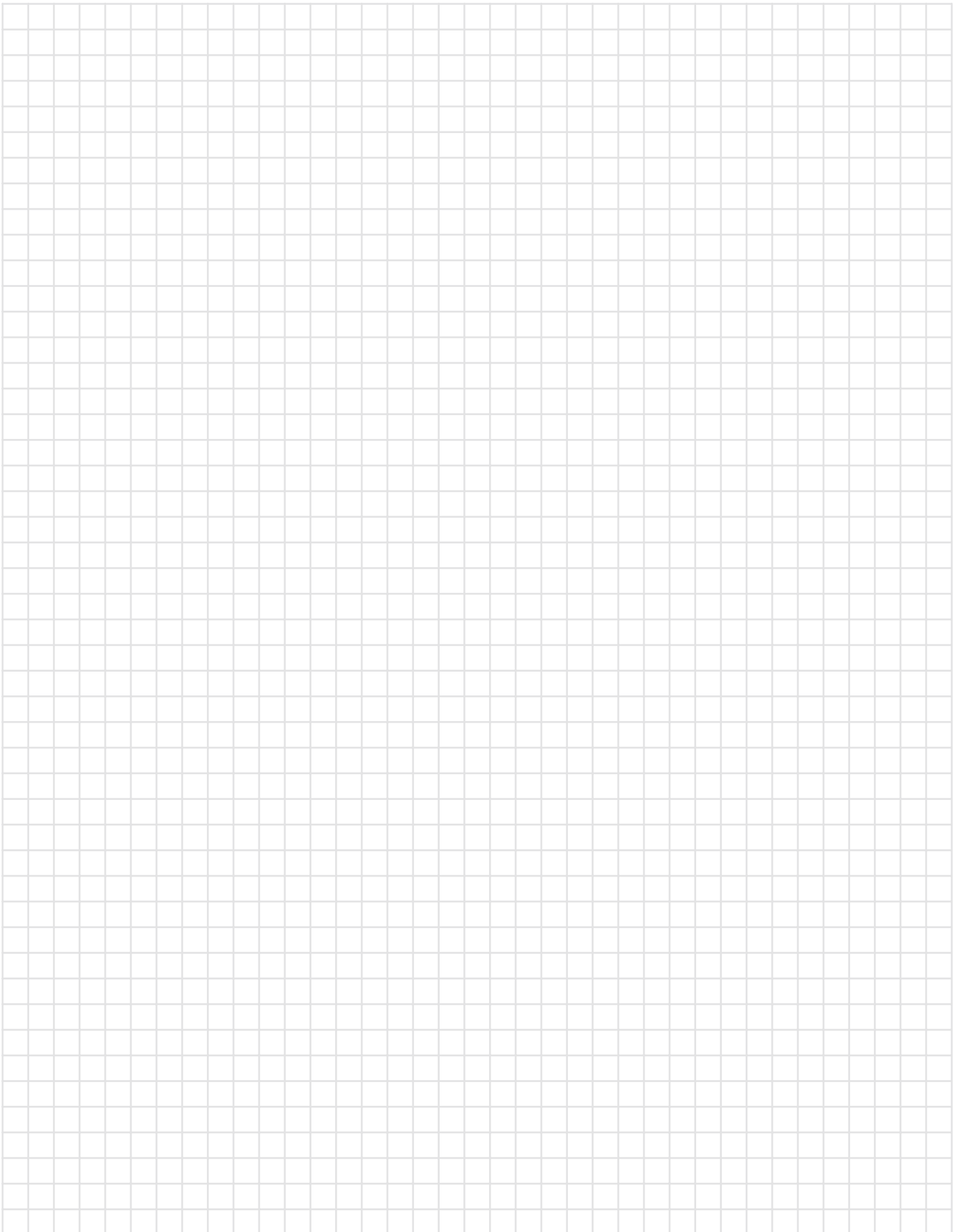
### 6. Remarks:

Date: \_\_\_\_\_

Processed by: \_\_\_\_\_

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## Notes





For custom configurations, we also supply material certificates according to EN 10204-3.1. B. This certificate logs the actual values of material characteristics such as tensile strength, apparent yielding point, notched bar impact work, extension and chemical analysis.

Material tests are performed according to the latest industry recognized methods (i.e. ultrasonic testing-developed by the Fraunhofer Institute).



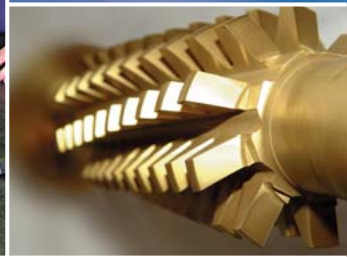


# Quality Assurance

EN ISO 9001:2000 certified

***We want  
you to be  
satisfied!***

IMO Slew Drives have to meet the highest quality requirements because they are often used as safety critical components. Development, design, calculation and sales are performed strictly according to EN ISO 9001:2000 certified procedures.



The quality chain starts with the choice of the raw material (i.e. for the production of seamless rolled rings of the SP-series) and is continuous, including the ongoing testing of the current production series.





IMO Holding GmbH  
IMO Energy GmbH & Co. KG  
IMO Momentenlager GmbH & Co. KG



IMO Antriebseinheit GmbH & Co. KG

### Headquarters

#### Slew Drives

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Fax +49 9193 6395-2140  
E-Mail [schwenktriebe@imo.de](mailto:schwenktriebe@imo.de)  
[www.imo.de](http://www.imo.de)

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Fax +49 9193 6395-4140  
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[www.imo.de](http://www.imo.de)

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Fax +49 9193 6395-3140  
E-Mail [energy@imo.de](mailto:energy@imo.de)  
[www.imo.de](http://www.imo.de)

Contact details of our global partners  
are to be found at: [www.goimo.com](http://www.goimo.com)