

TOL. SYSTEM ACC. TO ISO	General tol. for dimensions
Surface roughness R _a in µm	Machining ISO 2768 tol-class, Welding ISO 13920 tol-class, Therm. cut ISO 9013 tol-class

20 smörnipplor CM10x1 DIN 71412 jämnt fördelade
20 grease nipples CM10x1 DIN 71412 equivalent grade

- Crane type: shipboard crane, cargo handling
- Designed acc. to DIN 15018. FEM sec. I
- Deck crane. Grab duty
- Load data acc. to technical proposal
- Certificate acc. to purchase order

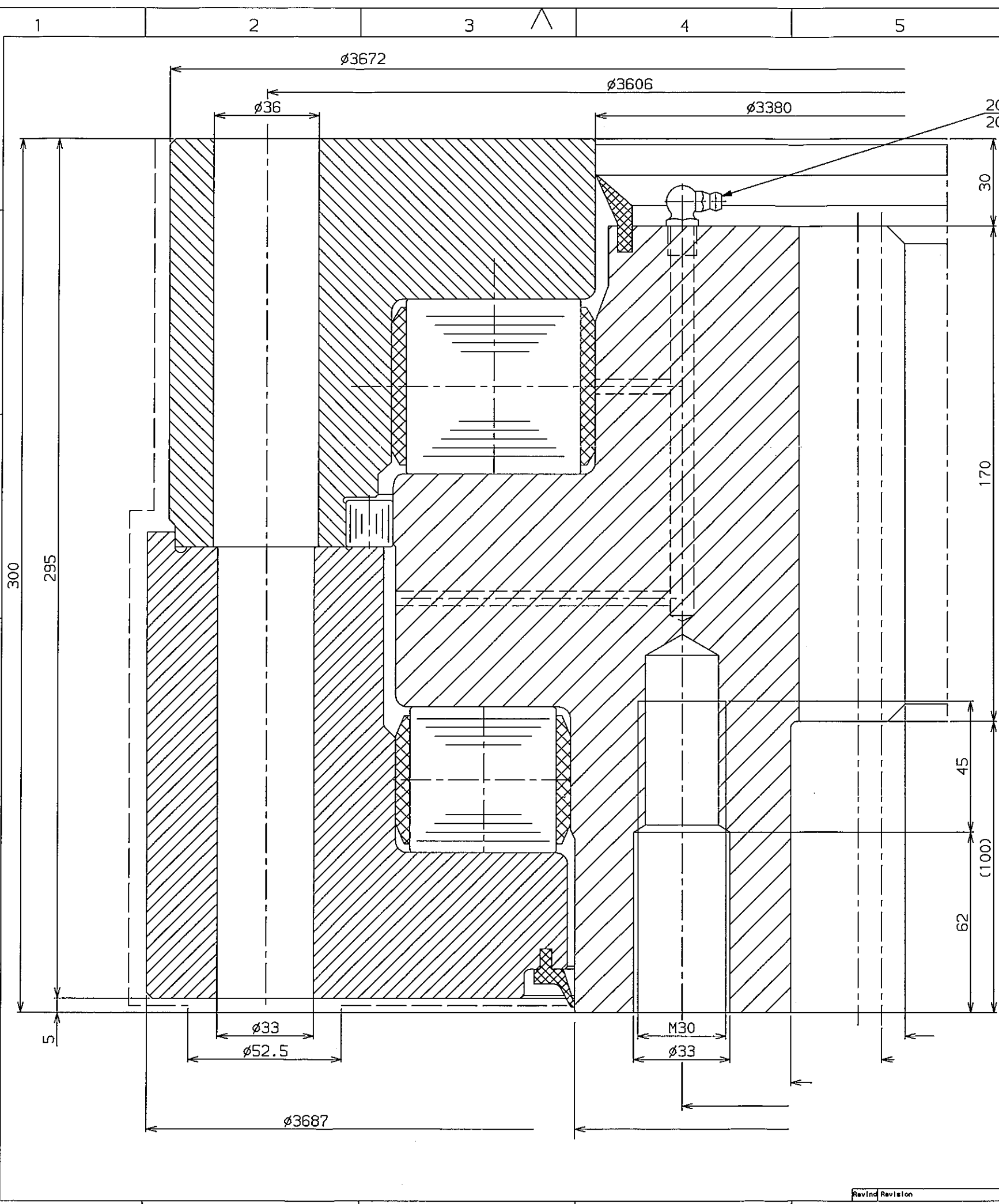
----- Goteplast 400, RAL 9005 min.125 microns.

Yttre hålcirkel: 96 frigående hål för skruv M30 jämnt fördelade
Outer circle of hole: 96 clearance hole for screw M30 equivalent grade
Inre hålcirkel: 96 hål M30 jämnt fördelade
Inner circle of hole: 96 holes M30 equivalent grade

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Reference
KR 03062

SimLar drawing No.
289 1350



Item No.	Qty / 601	Article No.	Description (own language)	Dimensions	Description (English)
Drawing checked by BNG			Specification		
Drawn by Bengt Westberg			Year Week 03 36	Description (English) Slewing bearing	
				Scale 1:1	
				Weight kg 5057	
				Rev ind Sheet 1	
				No of sh 1	
			MacGREGOR		
			289 3013		

Rev ind Revision Appd Year Week

Dragföljd/Tightening sequence

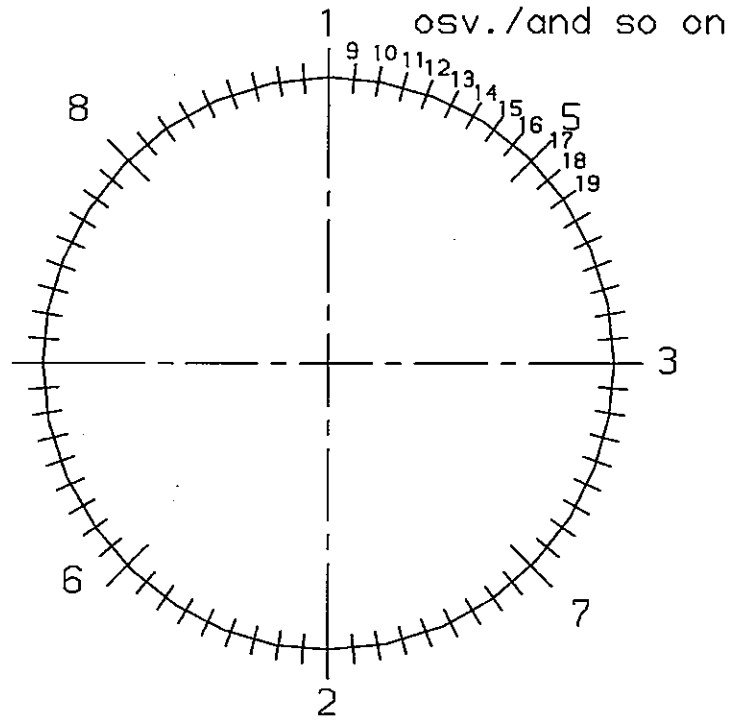
Kranens framsida/Front of the crane

Krantyp/Crane type

K 3030-4

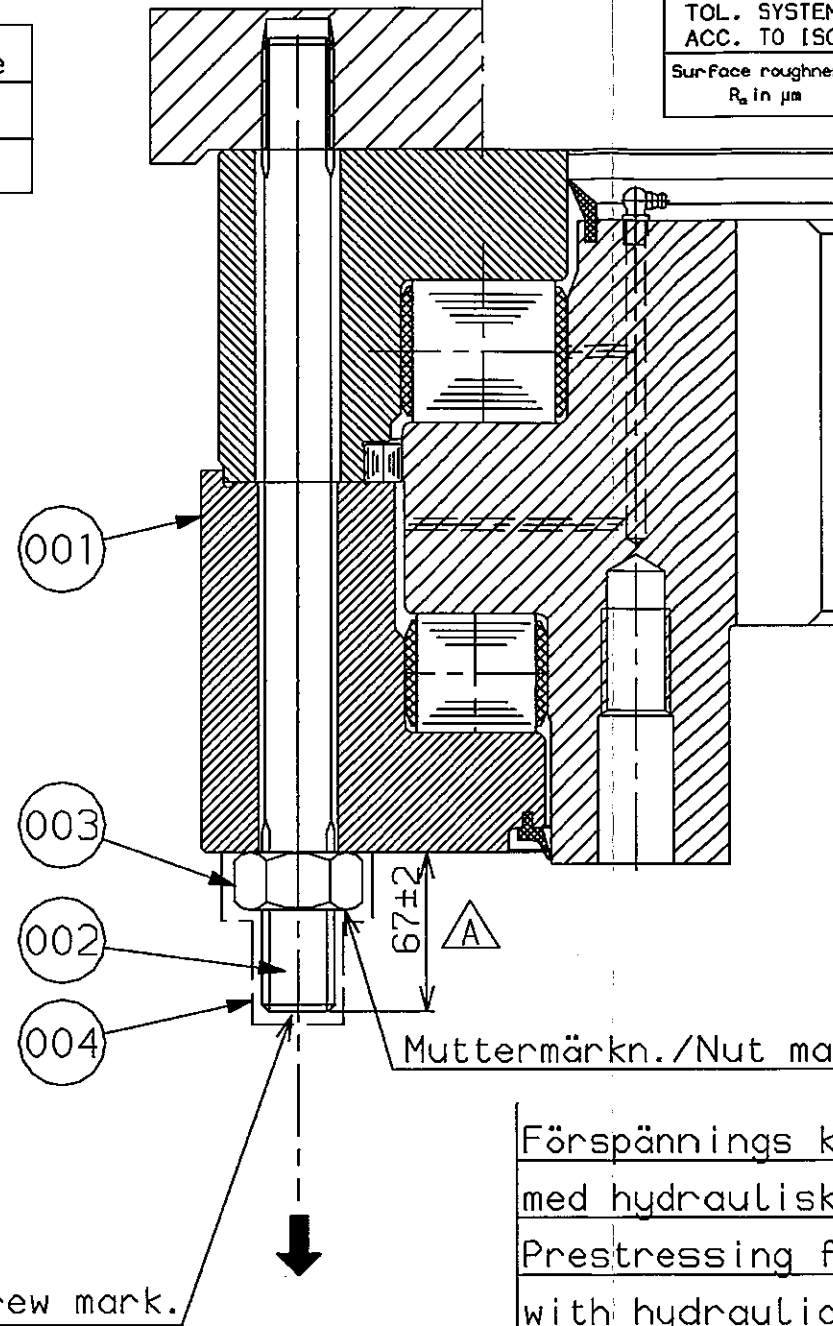
TOL. SYSTEM ACC. TO ISO	General tol. for dimensions
Surface roughness R _a in µm	Machining ISO 2768 tol-class, Welding ISO 13920 tol-class, Therm. cut ISO 9013 tol-class.

Scale 1:3



MONTERINGSANVISNING/ASSEMBLY INSTRUCTION

1. Kontaktytorna rengjorda före montering
Skruvmärkning i mutterända
Contact surfaces cleaned before mounting
Screw mark at nut end
2. Skruvarna dragna med hydraulisk skruvsträckare, dragföljd enl. fig.
The bolts loaded with a hydraulic tensioner, tightening sequence acc. to fig.
3. Dragningen upprepad på de först dragna bultarna tills alla bultarna har rätt spännkraft
The tightening repeated at first tensioned bolts until all bolts have the correct prestressing force
4. Placering av härdsläpp (S) alt kulvändkrans med pluggat hål
Placing of hardening stress (S) alt slewing bearing with plugged hole
5. General instruction: Acc. to MGC M2096-017E



Förspännings kraft 454 kN
med hydraulisk skruvsträckare
Prestressing force 454 kN
with hydraulic screw tensioner

Item No.	Qty/801	Article No.	Description (own language)	Dimensions	Description (English)
004	xx	1176 2060-001	Hempinol 10220		Paint
003	96	2126 2039-130	M6M 30-10-spec		Hexagon nut
002	96	388 7132-033	Pinnskruv L=410		Stud
001	1	289 3013-801	Vändkranslager		Slewing bearing

Drawing checked by		Specification		
BWG				
Drawn by		Year Week	Description (English)	Scale
Bengt Westberg		03 36	Slewing bearing mount.	1:20
		Description (own language)		Weight kg
		Vändkranslager mont.		5265
		Drwg No.		Rev Ind Sheet
		390 6013		A 1

MacGREGOR

A	387937	BWG	03 49
Rev Ind	Revision	Appd	Year Week

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Reference

KR 03062

Similar drawing no.

390 2113

Krantyp/Crane type
K 3030-4

TOL. SYSTEM ACC. TO ISO	General tol. for dimensions
Surface roughness R _a in µm	Machining ISO 2768 tol-class, Welding ISO 13920 tol-class, Therm. cut ISO 9013 tol-class,

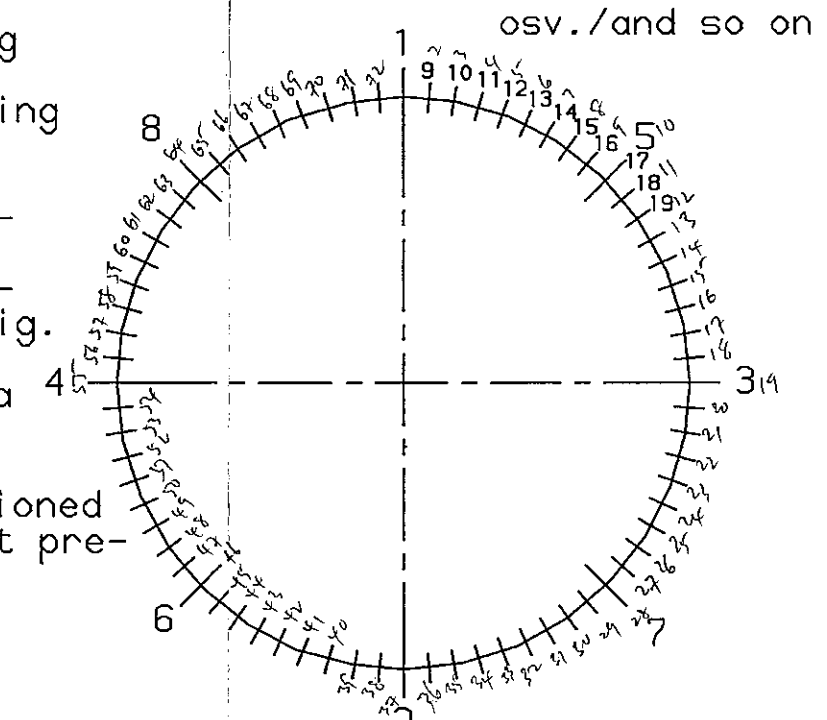
Dragföljd/Tightening sequence

MONTERINGSANVISNING / ASSEMBLY INSTRUCTION

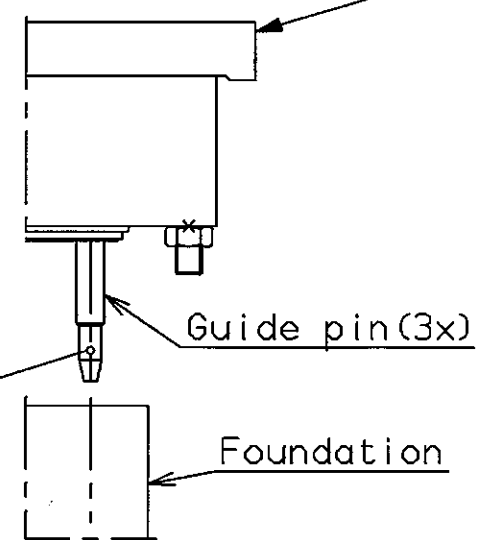
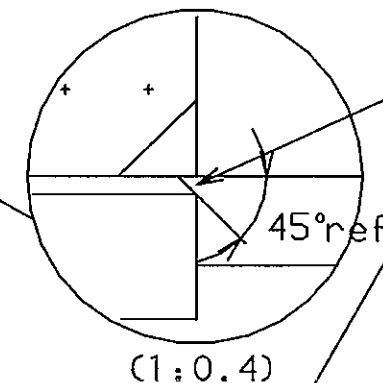
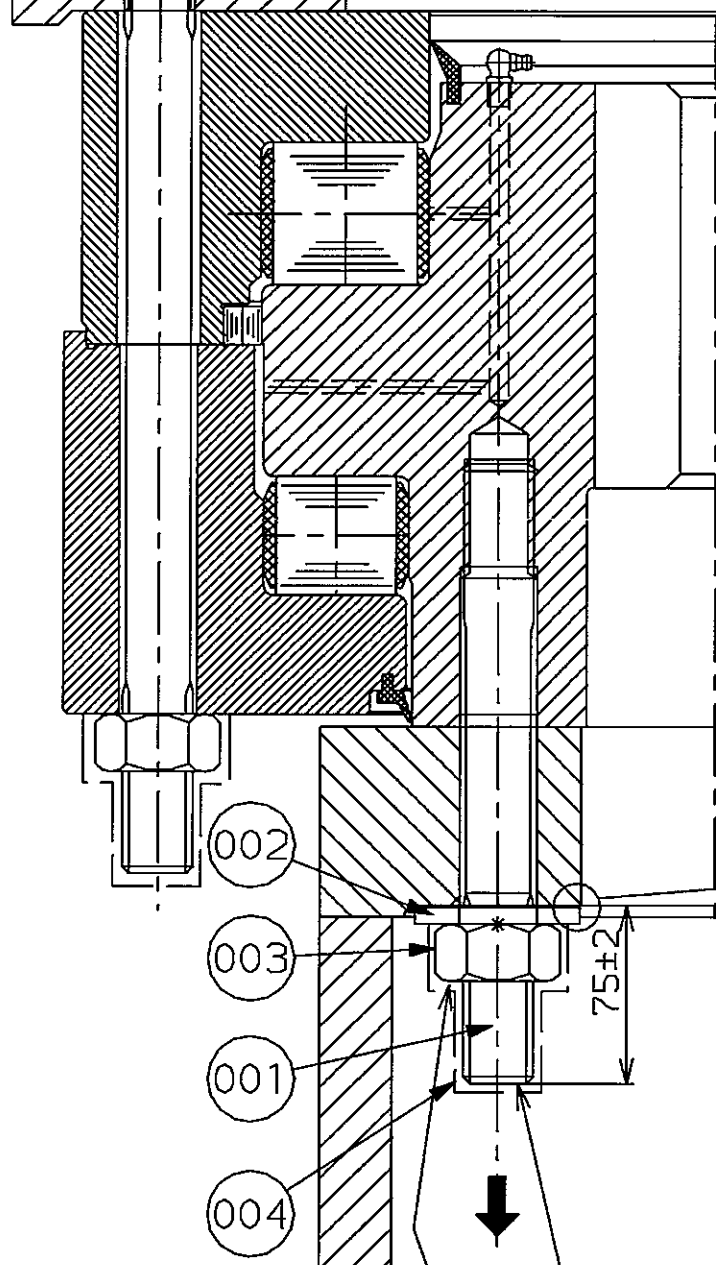
Kontaktytorna rengjorda före montering
Skruvmärkning i mutterända
Contact surfaces cleaned before mounting
Screw mark at nut end

2. Skruvarna dragna med hydraulisk skruvsträckare, dragföljd enl. fig.
The bolts loaded with a hydraulic tensioner, tightening sequence acc. to fig.

Dragningen upprepad på de först dragna bultarna tills alla bultarna har rätt spännkraft
The tightening repeated at first tensioned bolts until all bolts have the correct prestressing force



Scale 1:3



Muttermärkn./Nut mark.
Skruvmärkn./Screw mark.

Förspännings kraft 454 kN
med hydraulisk skruvsträckare
Prestressing force 454 kN
with hydraulic screw tensioner

Item No.	Qty/801	Article No.	Description (own language)	Dimensions	Description (English)
006	X	387 4402-011	Styrpinne		Guide pin
005	X	387 4402-002	Styrpinne		Guide pin
004	xx	1176 2060-001	Hempinol 10220		Paint
003	96	2126 2039-130	M6M 30-10-spec		Hexagon nut
002	96	489 3000-003	Bricka		Washer
001	96	388 7132-002	Pinnskruv	L=260	Stud

Drawing checked by BWG		Specification		
Drawn by Bengt Westberg		Description (English) Slewing bearing yard mount.		
Year Week 03 36		Description (own language) Vändkranslager varvmont.		Scale 1:5
Drwg No. 390 6014		Rev ind Sheet 1		Weight kg 160
No of sh 1				

MacGREGOR

Rev	Ind	Revision	Appd	Year	Week
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Reference
KR 03062
Similar drawing no.
390 2114