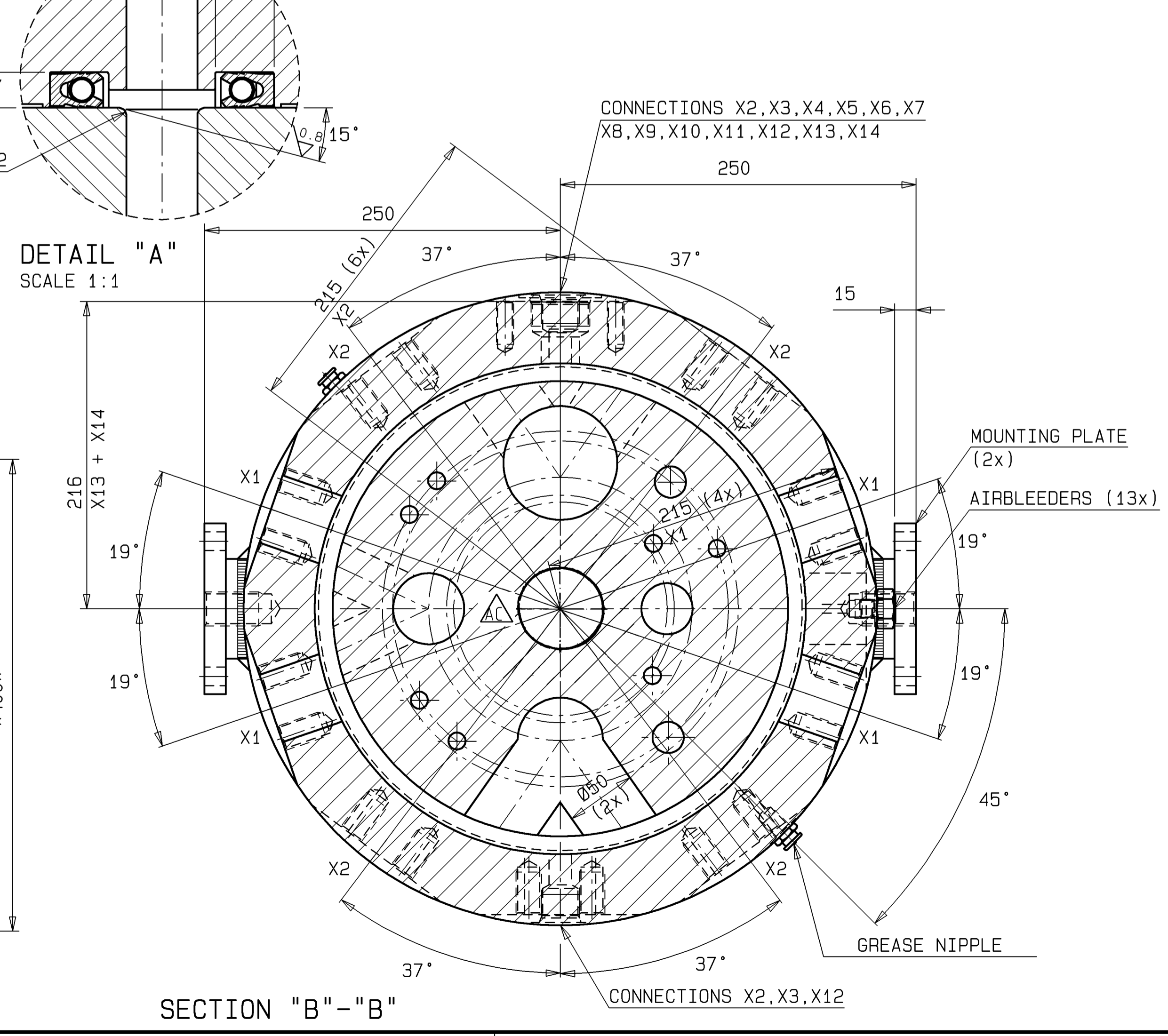
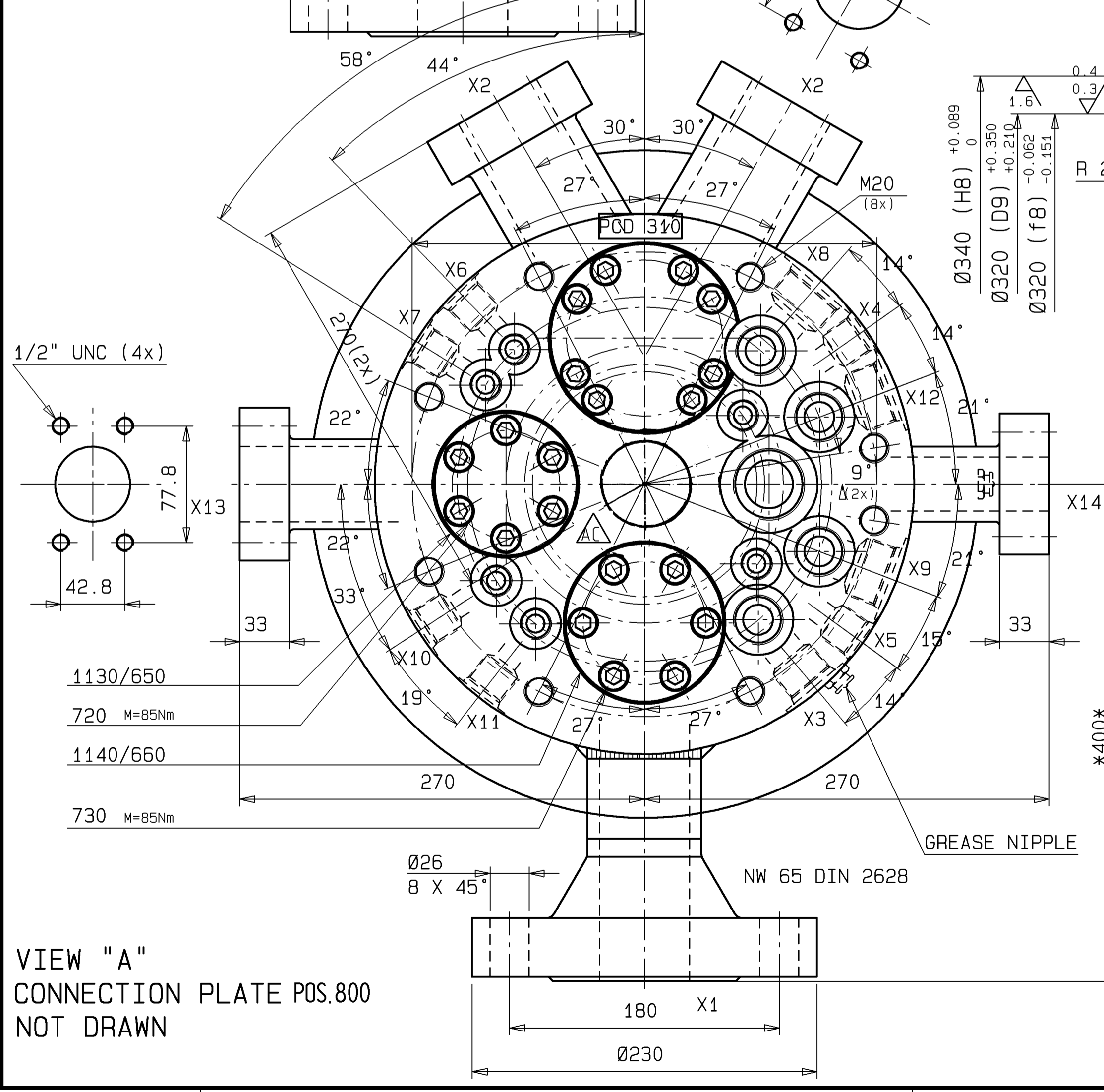
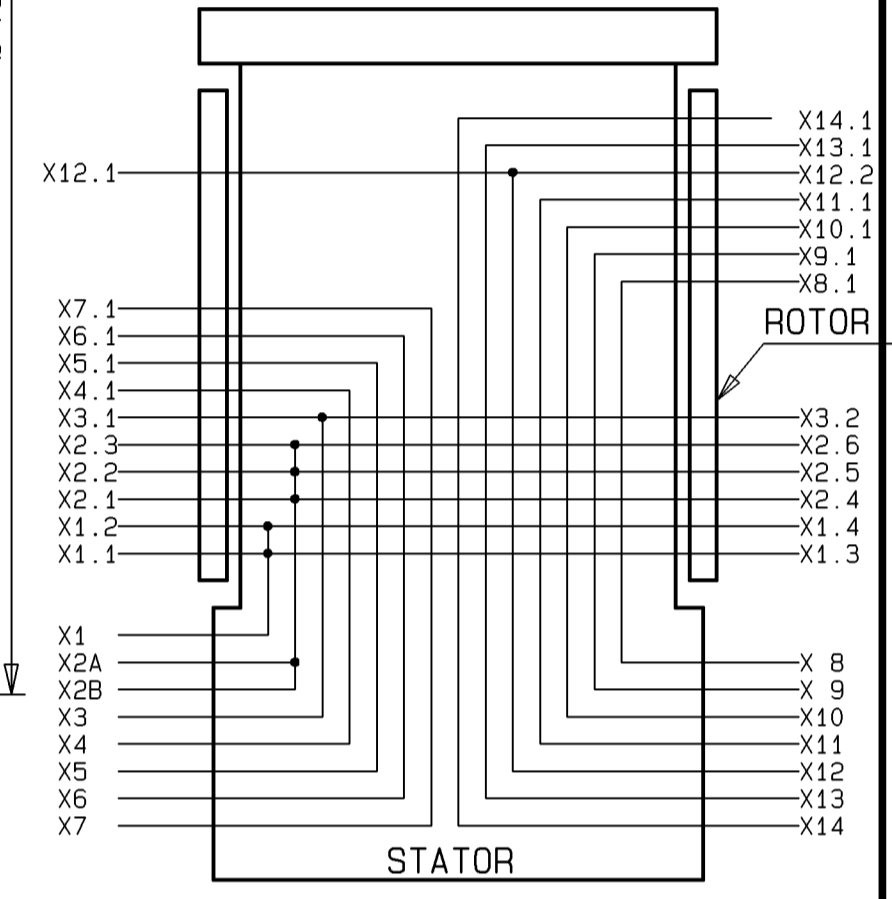
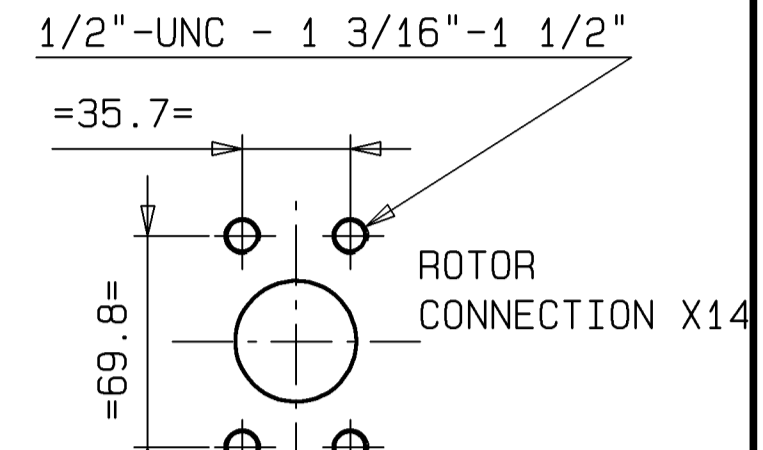
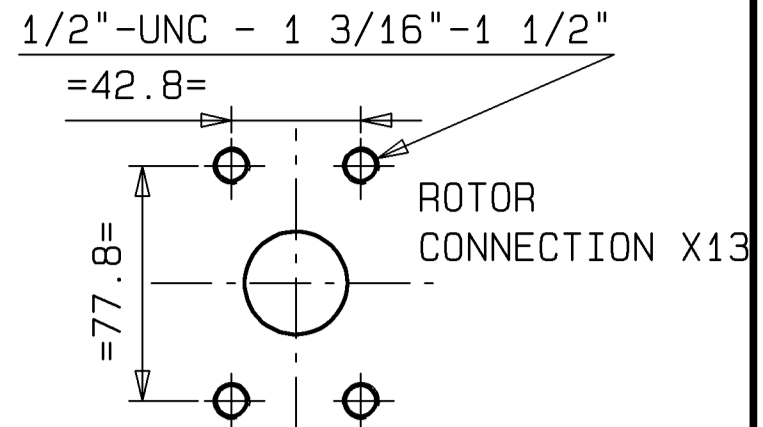
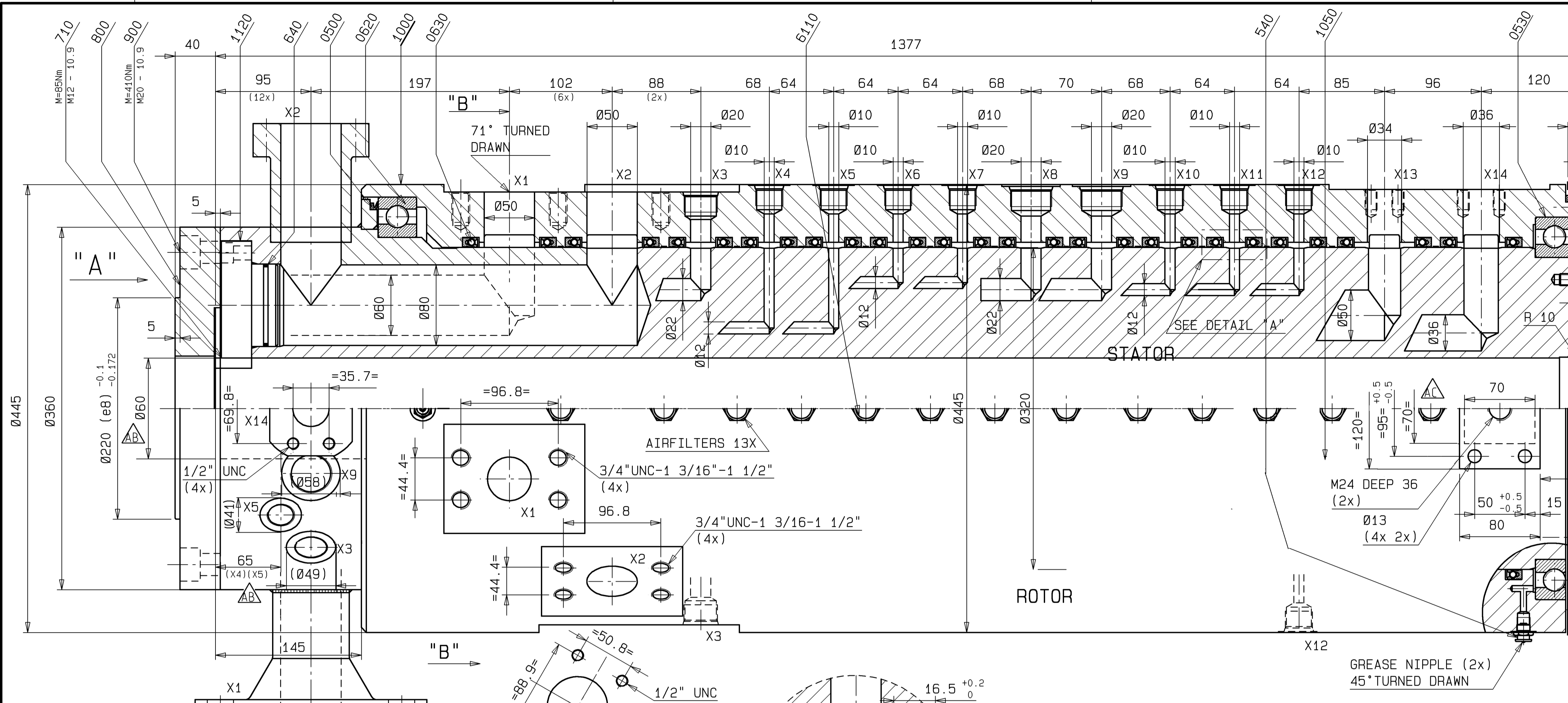


REV.	DESCRIPTION	DATE	DRN.	CHK.
AB	HOLE 60 WAS 100, 60 WAS 160 AND X5 WAS 120	20-08-2019	KEESKELD	GEROVLGH
AC	POSITION AIRFILTER 1Y1 CHANGED	03-09-2019	KEESKELD	GEROVLGH



SWIVEL SPECIFICATION : 14 CHANNELS DIAM. 320 SINGLE ROTOR

MAX. ROTATIONAL SPEED IN BOTH DIRECTIONS	4 /min	CORROSION PROTECTION:	- STATOR HARDCHROMIUM PLATED 35 µm - ROTOR NICKLE PLATED 50-55 µm PRESERVATION OF NICKLEPLATED SURF.
MAX. ENVIRONMENTAL TEMPERATURE	-20/+100 C		
MAX. MEDIUM TEMPERATURE	+70 C		
MAX. TORQUE:			
- STATIC, DRY	56 kNm		- ROUGHENED BY HAND - 20 µm PRIMER
- DYNAMIC, LUBRICATED	31 kNm		- 30 µm TOPCOAT ALKYD RAL 8002

NO RADIAL OR AXIAL FORCES ALLOWED TO ACT ON THE ROTOR CONNECTIONS

BEARINGS MUST BE LUBRICATED EVERY 3 MONTHS

STATOR-CONNECTIONS	ROTOR-CONNECTIONS	MEDIUM	DESIGN PRESSURE
X 1 1	NW 65 DIN 2628	4 SAE 2"-6000 PSI	MINERAL OIL 250 bar
X 2 2	SAE 2.5"3000 PSI	6 SAE 2"-6000 PSI	MINERAL OIL 250 bar
X 3 1	1 5/16"-12UN	2 1 5/16"-12UN	MINERAL OIL 250 bar
X 4 1	1 1/16"-12UN	1 1 1/16"-12UN	PHOSPH. EST. 250 bar
X 5 1	1 1/16"-12UN	1 1 1/16"-12UN	PHOSPH. EST. 250 bar
X 6 1	1 1/16"-12UN	1 1 1/16"-12UN	PHOSPH. EST. 250 bar
X 7 1	1 1/16"-12UN	1 1 1/16"-12UN	PHOSPH. EST. 250 bar
X 8 1	1 5/8"-12UN	1 1 5/8"-12UN	MINERAL OIL 250 bar
X 9 1	1 5/8"-12UN	1 1 5/8"-12UN	MINERAL OIL 250 bar
X 10 1	1 1/16"-12UN	1 1 1/16"-12UN	GREASE 400 bar
X 11 1	1 1/16"-12UN	1 1 1/16"-12UN	GREASE 400 bar
X 12 1	1 5/8"-12UN	2 1 1/16"-12UN	ARGON 26 bar
X 13 1	SAE 2"-3000PSI	1 SAE 2"-3000PSI	PRESS. AIR 16 bar
X 14 1	SAE 1 1/2"-3000	1 SAE 1 1/2"-3000	ARGON 26 bar

SWIVEL FILLED WITH OIL : 10% SHELL S2 M32 AND SUPPLEMENTED WITH N2

REL. FOR PROD.	DATE	ASSEMBLY DRAWING
UNTOLERANCED DIMENSIONS: FOR STEEL - MACHINED CAST-IRON STROKE TOL.	TOLERANCES OF FORM AND POSITION ACC. TO DIN-ISO 1101. INDICATION OF SURFACE ROUGHNESSES ACC. TO DIN-ISO 1302. TOLERANCES ACC. TO DIN 7150/7172. UNLESS OTHERWISE SPECIFIED: - ALL EXTERNAL EDGES BREAK WITH 0.5xR5 - ALL INTERNAL EDGES R = 0.5 ± 0.2 - TOLERANCES ON METRIC TAPPED THREAD 6H/9g ACC. TO DIN 13 - TOLERANCES ON CUTTED METRIC THREAD 7H/6e ACC. TO DIN 13	MATERIAL: FOR MATERIAL, STOCK DIMENSIONS AND OTHER MATERIAL SPECIFICATIONS SEE PARTSLIST ITEM NO. : SPECIFICATIONS FOR SUBCONTRACTING WHEN DELIVERY OF MATERIAL IS INCLUDED SEE PARTSLIST ITEM NO. : ORIGINAL DRAWING: 3-004434 / 3-05424 ARTICLE NUMBER: R987483759 STANDARD: NO
DIM. TOL. DIM. TOL.		TITLE: ROTARY JOINT 14 CHANNELS DIAMETER 320 SINGLE ROTOR
15000 ±7	8000 ±3	SCALE: 1:2.5
12000 ±5	4000 ±2	PROJ.
8000 ±3	2000 ±1	MASS (kg): 1500
4000 ±2	1000 ±0.5	DIMENSIONS: mm
2000 ±1	400 ±0.2	DATE: 01-07-2019
1000 ±0.5	120 ±0.1	DRAWN: KEESKELD
400 ±0.2	60 ±0.1	CHECKED: FRANDRIE
120 ±0.1	60 ±0.1	DATE: 01-07-2019
		ORDER NO.:
		DRAWING NO. RA78214-286
		SIZE: A1
		REV. AC

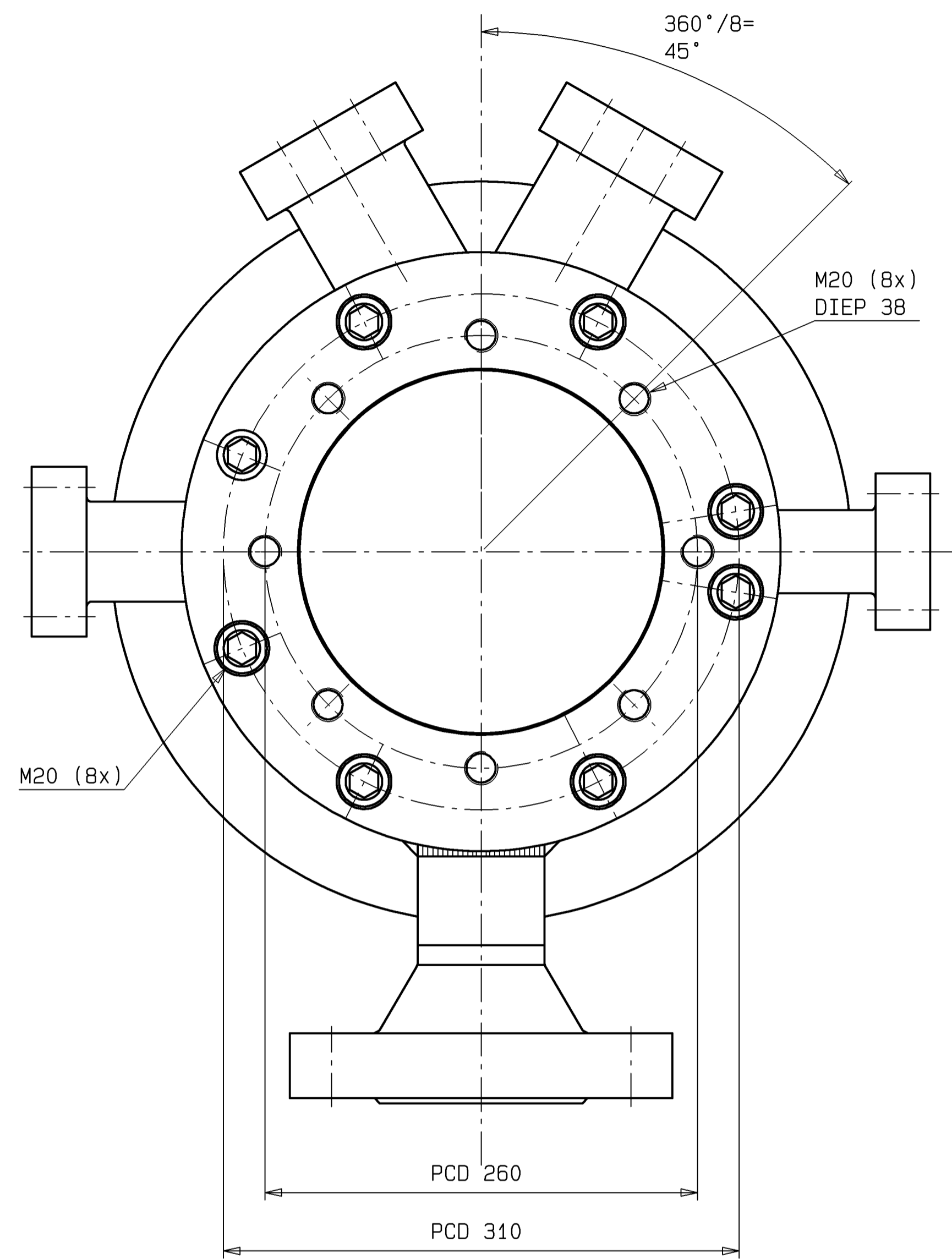
EIGENOM VAN HYDRAULISCHE BOXTEL, NETHERLANDS
 VERBODEN VOOR ANDERE TOEGANGSRECHTEN IN
 IN WELKE WERK DAN OOK, IS ZONDER SCHRIFTELIJKE
 TOESTEMMING VAN EIGENARES NIET GEDEELT.
 PROPERTY OF HYDRAULISCHE BOXTEL, NETHERLANDS
 PROHIBITED FOR OTHER ACCESS RIGHTS IN
 ANY FORM WHATSOEVER, NOT ALLOWED WITHOUT
 WRITTEN CONSENT OF THE PROPRIETORS.

VIEW "A"
CONNECTION PLATE POS.800
NOT DRAWN

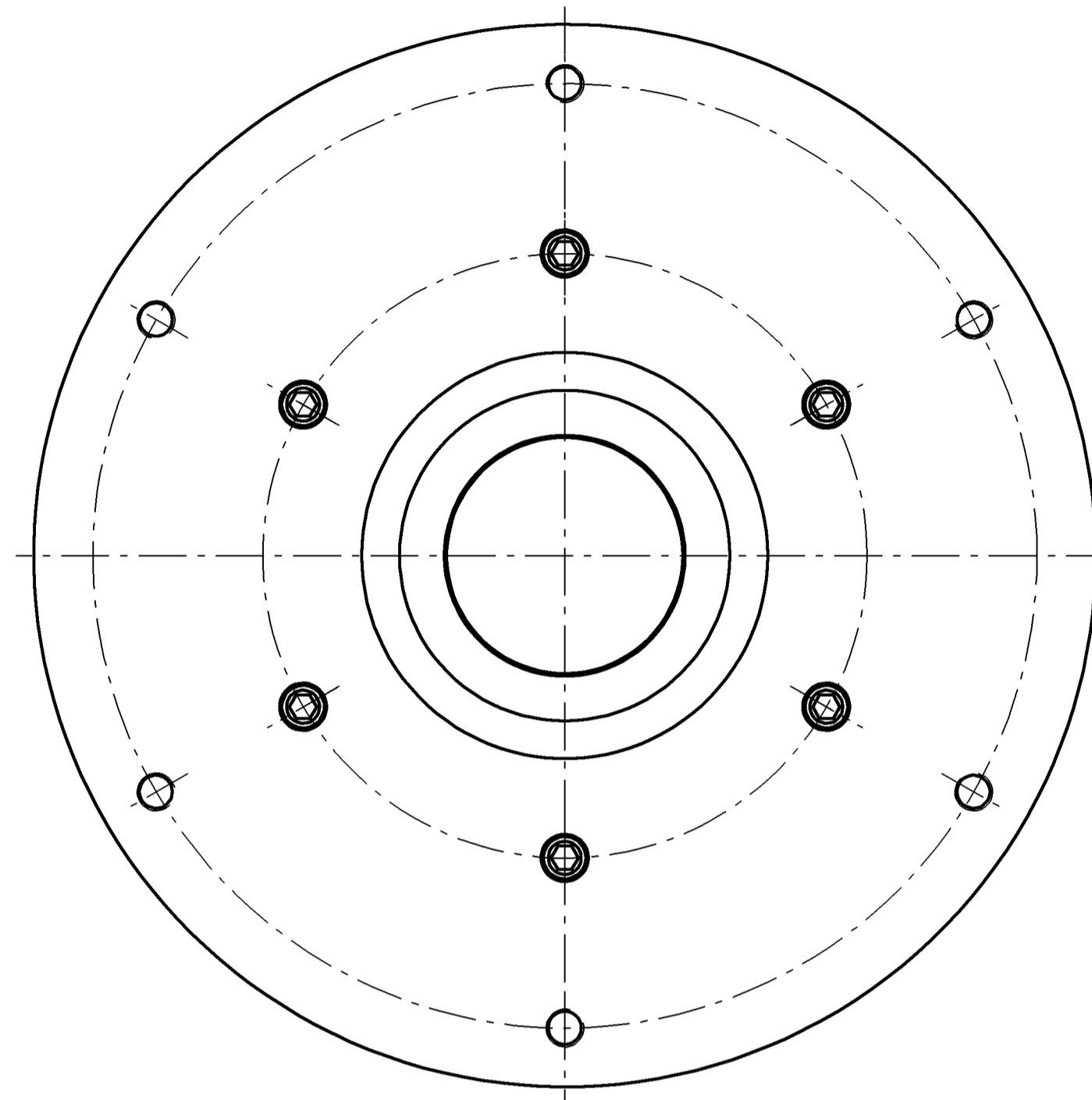
rexroth
A Bosch Company

P.O. BOX 32 5280 AA BOXTEL, THE NETHERLANDS
SHEET 01 OF 03

REV.	DESCRIPTION	DATE	DRN.	CHK.



VIEW "A"
WITH CONNECTION PLATE



VIEW "C"

REL. FOR PROD.	DATE	ASSEMBLY DRAWING
UNTOLERANCED DIMENSIONS: FOR STEEL - MACHINED CAST- CONSR 7 IRON STROKE TOL. DIM. TOL. DIM. TOL. 15000 ±7 8000 ±3 12000 ±5 4000 ±2 8000 ±5 2000 ±1 4000 ±4 1000 ±0.5 2000 ±3 400 ±0.3 1000 ±2 120 ±0.15 400 ±1.2 30 ±0.05 120 ±0.6 6 ±0.1	TOLERANCES OF FORM AND POSITION ACC. DIN-ISO 1101. INDICATION OF SURFACE ROUGHNESSES ACC. DIN-ISO 1302. TOLERANCES ACC. DIN 7150/7172. UNLESS OTHERWISE SPECIFIED: - ALL EXTERNAL EDGES BREAK WITH 0.5x45° - ALL INTERNAL EDGES R = 0.6 ±0.2 - TOLERANCES ON METRIC TAPPED THREAD 6H/6g ACC. DIN 13 - TOLERANCES ON CUTTED METRIC THREAD 7H/6e ACC. DIN 13	MATERIAL: FOR MATERIAL, STOCK DIMENSIONS AND OTHER MATERIAL SPECIFICATIONS SEE PARTSLIST ITEM NO.: SPECIFICATIONS FOR SUBCONTRACTING WHEN DELIVERY OF MATERIAL IS INCLUDED SEE PARTSLIST ITEM NO.: ORIGINAL DRAWING: 3-004434 / 3-054124 ARTICLE NUMBER: R987483759 STANDARD: NO
TITLE ROTARY JOINT 14 CHANNELS DIAMETER 320 SINGLE ROTOR		SCALE 1:2.5
DIMENSIONS : mm		PROJ.
DRAWN KEESKELD		MASS (kg) 1500
CHECKED FRANDRIE		DATE 01-07-2019
ORDER NO.		REV. AC
rexroth A Bosch Company		DRAWING NO. RA78214286
P.O. BOX 32 5280 AA BOXTEL THE NETHERLANDS		SIZE A1
SHEET 02 OF 03		DATE 01-07-2019

EIGENDOM VAN HYDRAULISCHE BOXTEL. NIET VERMEDELING VAN DEERDEN IN WELKE WERK DAN OOK, IS ZONDER SCHRIFTTELLING TOESTEMMING VAN EIGENARES NIET GEVOLGDOFT.

EIGENDOM VAN HYDRAULISCHE BOXTEL. NIET VERMEDELING VAN DEERDEN IN WELKE WERK DAN OOK, IS ZONDER SCHRIFTTELLING TOESTEMMING VAN EIGENARES NIET GEVOLGDOFT.

RELEASED / released RA78214286_001 | Rotary Joint | AC.1 | 1

PROPERTY OF REXROTH HYDRAUDYNE B.V. BOXTEL, NETHERLANDS.
REPRODUCTION, OR DISCLOSURE TO THIRD PARTIES IN
ANY FORM WHATSOEVER, NOT ALLOWED WITHOUT
WRITTEN CONSENT OF THE PROPRIETORS.

EIGENDOM VAN REXROTH HYDRAUDYNE B.V. BOXTEL.
VERNIJGULDIGING OF MEDELING AAN DERDEN
IN WELKE FORM DAN OOK, IS ZONDER SCHRIFTELIJKE
TOESTEMMING VAN EIGENARES NIET GEEORLOOFD.

REV.	DESCRIPTION	DATE	DRN.	CHK.

TORQUE CONTROL REPORT

SALES ORDER:	QUANTITY	HYCYL NR	UNIQUE NUMBER
/			

TESTCONDITIONS

SUPERFICIAL TEMPERATURE ON DRUM	BEGIN [°C]		END [°C]	
ROTATION SPEED	REV/MIN.			

OIL AND GREASE CHANNELS ARE TESTED WITH SHELL TELLUS 32

GASS CHANNELS ARE TESTED WITH NITROGEN

CORE IS ROTATING

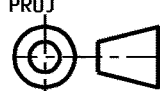
TORQUE

CHANNEL NUMBER:	PRESSURE [BAR]	MEASURED TORQUE ON DRUM [KG*METER]					
		ROTATION CLOCK WISE			ROTATION ANTI CLOCK WISE		
		AT START	AFTER 1 MIN.	AFTER ... MIN.	AT START	AFTER 1 MIN.	AFTER ... MIN.
1							
2							
3							
4							
5							
6							
7							
8							
9							
10							
11							
12							
13							
14							

NON-CONFORMING DIMENSIONS: SEE NCR NR:

REMARKS:

QUALITY SUPPORT: DATE:

REL. FOR PROD.	DATE	ASSEMBLY DRAWING
<p>UNTOLERANCED DIMENSIONS: FOR STEEL- MACHINED CAST- CONSTR. / STROKE TOL. IRON</p> <p>DIM. TOL. DIM. TOL.</p> <p>16000 ±7 8000 ±3 12000 ±6 4000 ±2 8000 ±5 2000 ±1.2 4000 ±4 1000 ±0.8 2000 ±3 400 ±0.5 1000 ±2 120 ±0.3 400 ±1.2 30 ±0.2 120 ±0.8 6 ±0.1</p> <p>ACCORDING DIN 1685/1686</p>	<p>TOLERANCES OF FORM AND POSITION ACC. DIN-ISO 1101. INDICATION OF SURFACE ROUGHNESSES ACC. DIN-ISO 1302. TOLERANCES ACC. DIN 7150/7172. UNLESS OTHERWISE SPECIFIED: - ALL EXTERNAL EDGES BREAK WITH 0.5x45° - ALL INTERNAL EDGES R = 0.6 ±0.2 - TOLERANCES ON METRIC TAPPED THREAD 6H/6g ACC. DIN 13 - TOLERANCES ON CUTTED METRIC THREAD 7H/6e ACC. DIN 13</p>	<p>MATERIAL: FOR MATERIAL, STOCK DIMENSIONS AND OTHER MATERIAL SPECIFICATIONS SEE PARTSLIST ITEM NO.:</p> <p>SPECIFICATIONS FOR SUBCONTRACTING WHEN DELIVERY OF MATERIAL IS INCLUDED SEE PARTSLIST ITEM NO.:</p> <p>ORIGINAL DRAWING: 3-004434 / 3-054124 ARTICLE NUMBER: R987483759 STANDARD: NO</p> <p>SCALE: - PROJ:  MASS (kg): -</p> <p>DIMENSIONS: mm DATE: 01-07-2019 DRAWN: KEESKELD CHECKED: FRANDRIE</p> <p>ORDER NO.:</p> <p>DRAWING NO. RA78214286 SIZE A3 REV. AC</p> <p>SHEETS 3 OF 3</p>
<p>TITLE</p> <p>Koppel meting rapport Torque Control Report</p> <p>rexroth A Bosch Company</p> <p>P.O. BOX 32 5280 AA BOXTEL THE NETHERLANDS</p>		

RELEASED / released RA78214286_001 | Rotary Joint | AC.1 | 1