ROCKINGER®

Member of JOST-World

Montage- und Betriebsanleitung (D)

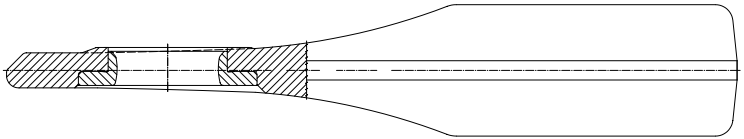
Installation and operating instructions (GB)

Monterings- och driftanvisning (S)

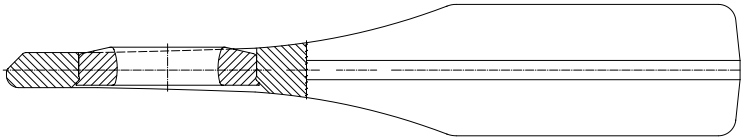
Monterings- og bruksanvisning (N)

Modell / Series / Serie / Serie

RO*ZE-57 R



RO*ZE-57 V



Einschweißzugöse
Drawbar eye for welding
Svetsbara dragöglor
Sveisbare trekkøyer

Typ RO✶ZE 57 R
Approval code: e1 00-1658

Typ RO✶ZE 57 V
Approval code: e1 00-1659

Drawbar eye for welding
Suitable for bolt couplings in accordance with Swedish standards
Nominal bolt diameter 57 mm

The drawbar eye may only be welded on to the drawbar by an authorised workshop.

The technical regulations for welding must be observed.

Official note
In fitting the drawbar eye, the EU directive 94/20, in particular Annex VII, and the relevant national regulations must be observed.

We reserve the right to make technical alterations.

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1.1 Use

The drawbar eye is approved:

- for welding onto the drawbar facility on trailers
- for connection with trailer couplings with nominal bolt diameter of ∅57 mm (e.g RO✶57, test code e1 00-1361 or similar trailer couplings) which ensure the necessary pivoting angle.

The drawbar eye is designed for use on

- articulated drawbar trailers
- dollys
- central axis trailers

1.2 Drawbar homologation

- The drawbar eyes for welding RO✶ZE 57 R and RO✶ZE 57 V have been tested and homologated in accordance with the technical data.
- The homologation values apply based on compliance with welding specifications.

The combination of drawbar with welded-on drawbar eye requires its own homologation.

Fig. 1

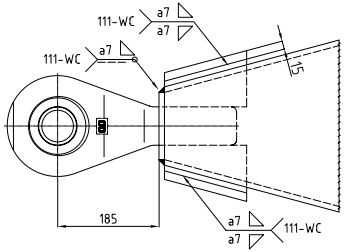


Fig. 2

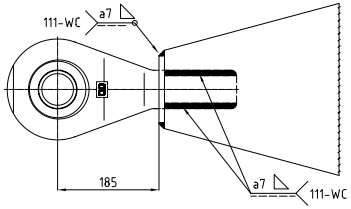
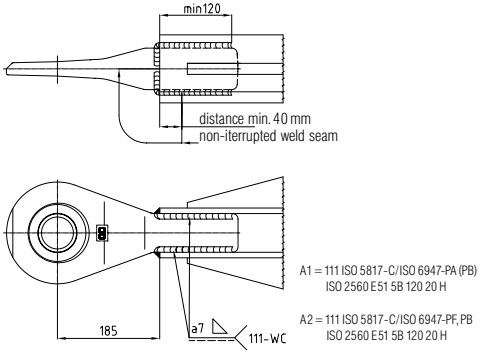


Fig. 3



Attention:

When carrying out welding work on the vehicle, make sure that none of the welding currents flow through the vehicle wiring. The wiring and other components could be damaged by the high currents.

The earth connection of the welding current source should be placed as near as possible to the welding point.

1.3 Welding instructions

The load-bearing weld seams should have a minimum length of 4 x 120 mm in the longitudinal direction. The weld seam should be 7 mm thick.

Minimum requirements for the weld seam quality: DIN EN ISO 5817-C
Welding method: manual arc welding
(Process DIN EN ISO 4063-111) filler material:
DIN EN ISO 2560 E 51 5 B 120 20 H or AWS E 7018

The sheet or wall thickness of the connection part should be at least 10 mm corresponding to the weld seam thickness.

Fig. 1 The wings must have a minimum projection of 15 mm over the weld seam

Fig. 2 The gap width between drawbar eye and connection plate may not exceed 0.8 mm

Fig. 3 In the marked area (minimum: 40 mm) the weld seam must be brought around the corner without interrupting the welding process.

The seams are represented in accordance with the general rule for technical drawings DIN EN 22553

Normative references: JOST works standards JWN 001
Welding technique: unalloyed and low-alloy structural steels – close-grained steels

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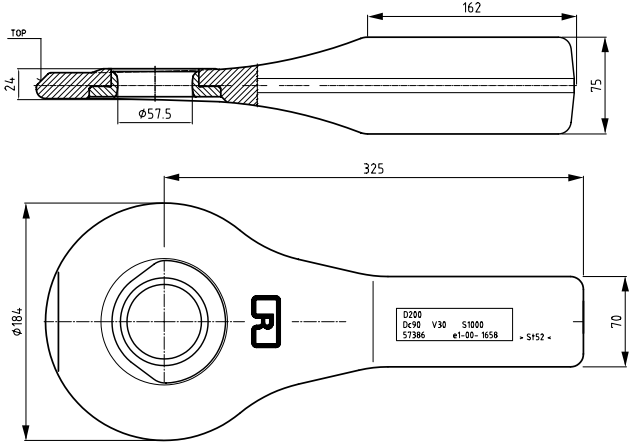
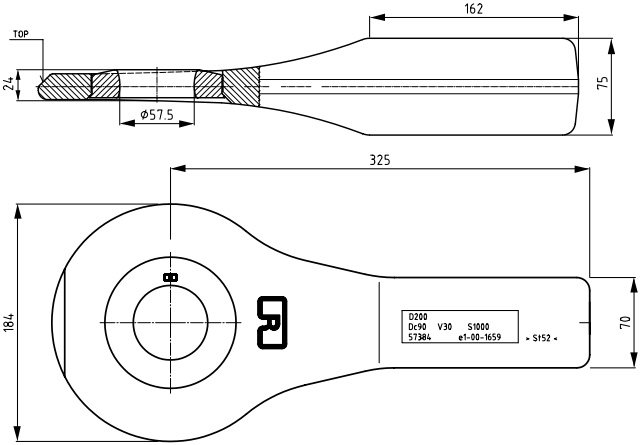
2.1 RO✶ZE 57 R e1 00-1658

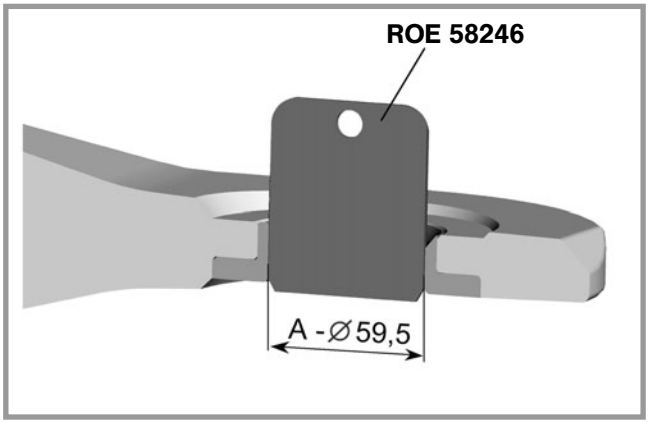


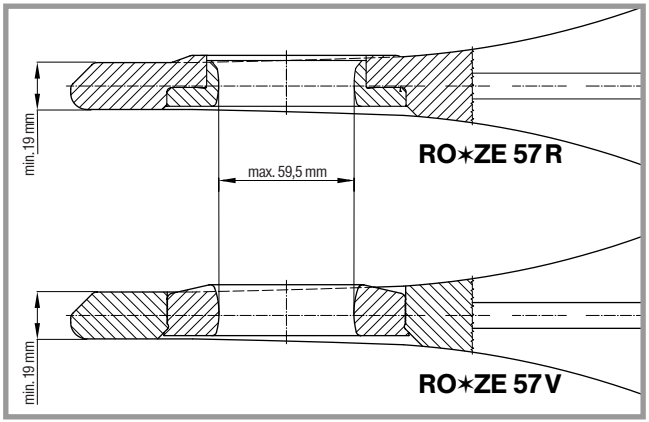
ROCKINGER Article no.	D (kN)	Dc (kN)	V (kN)	S (kN)	Approval code EG	Type	Class
57386	200	90	30	1000	e1 00-1658	RO✶ZE 57 R	S

2.2 RO✶ZE 57 V e1 00-1659



ROCKINGER Article no.	D (kN)	Dc (kN)	V (kN)	S (kN)	Approval code EG	Type	Class
57384	200	90	30	1000	e1 00-1659	RO✶ZE 57 V	S





3. Maintenance

The drawbar eye with the coupling bolt and the bearing rings are an open joint. In order to protect the components in operation, it is necessary to coat the contact points with a viscous grease of consistency 3 EP.

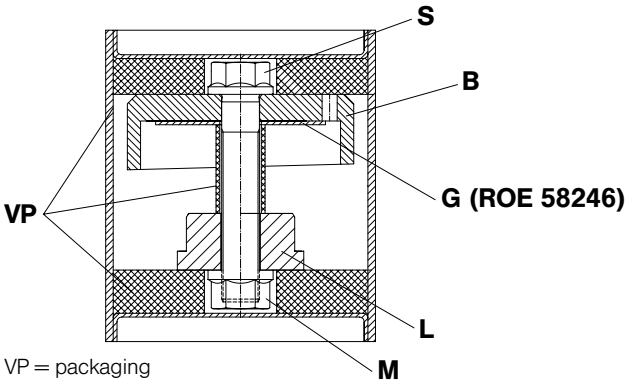
3.1 Wear information

The drawbar eye socket must be replaced at the latest when an inner diameter **A** of **59,5 mm** is reached.

The test gauge **ROE 58246** is available for testing the degree of wear.

Drawbar eye thickness wear limit is 19 mm

3.2 socket replacement tool kit ROE 57397



VP = packaging

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RO✶ZE 57 R

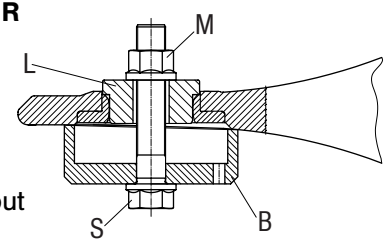


Fig. 1
Pressing out

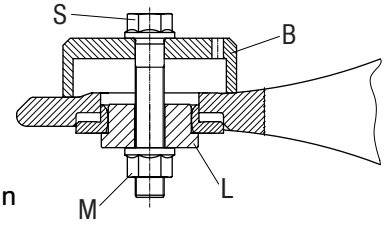
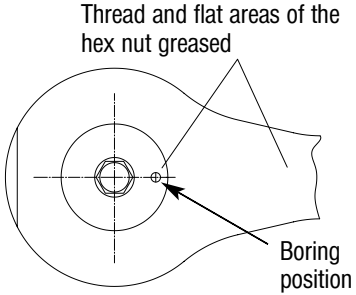


Fig. 2
Pressing in



3.3 Socket replacement in the RO✶ZE 57 R

Use the tool kit ROE 57397 to remove and replace the drawbar eye socket.

3.3.1 Pressing out the drawbar eye socket

Connect socket **B** + **L** with the bolt **S** and the nut **M** as shown in **Fig. 1** The boring in socket **B** must be aligned in the direction of the drawbar eye shaft centre.

Hold the head of the bolt with a spanner and tighten the flange nut **M** until the drawbar eye socket has been pressed out fully.

3.3.2 Pressing in the drawbar eye socket

The drawbar eye does not have to be heated up to press in the drawbar eye socket.

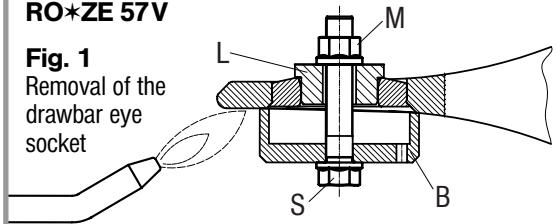
Connect socket **B** + **L**with the bolt **S** and flange nut **M** as shown in **Fig. 2**

Make sure that the new drawbar eye socket remains centred with the drawbar eye boring when the central bolt is tightened.

While tightening the bolt make sure that the drawbar eye socket does not tilt. Tighten the flange nut **M** while holding the bolt **S** until the drawbar eye socket is fully pressed in.

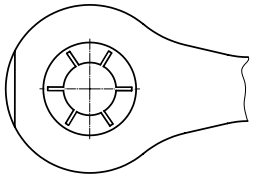
RO✶ZE 57 V

Fig. 1
Removal of the drawbar eye socket

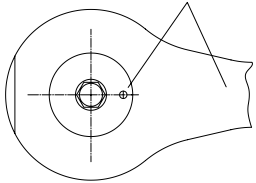


Thread and flat areas of the hex nut greased

Slot the drawbar eye socket 5 - 6 times



Boring position



3.4 Socket replacement in the RO✶ZE 57 V

Use the tool kit ROE 57397 to remove and replace the drawbar eye socket.

3.4.1 Removing the drawbar eye socket

Use suitable means (e.g. welding torch) to make 5 – 6 slots in the drawbar eye in order to reduce the tension of the socket in the boring.

Attention:
Do not damage the body of the drawbar eye when making the slots.

Connect socket **B** + **L** with the bolt **S** and the flange nut **M** as shown in **Fig. 1**. The boring in socket **B** must be aligned in the direction of the drawbar eye shaft centre. Tighten the bolt until the drawbar eye socket is fully pulled out.

Attention: Under no circumstances should the heated drawbar eye be cooled using water or compressed air.

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RO⋆ZE 57V

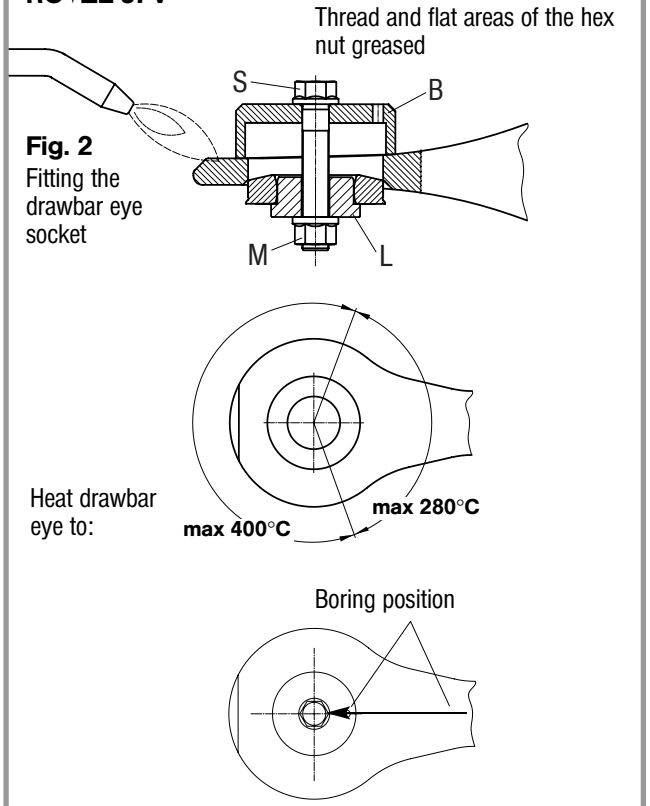

Fig. 2
Fitting the drawbar eye socket

3.4.2 Fitting the drawbar eye socket

Use a suitable heat source to bring the drawbar eye to a specified, regular temperature (**see fig. 2**).
Check the temperature using a suitable temperature measurement device.

Connect socket **B** + **L** with the bolt **S** and the flange nut **M** as shown in **Fig. 2**

Make sure that the new drawbar eye socket is centred with the boring while tightening.

Hold the flange nut **M** and tighten the bolt **S** until the drawbar eye has been completely drawn in

Attention: Under no circumstances should the heated drawbar eye be cooled using water or compressed air.

88232-0-020 D/GB/S/N / KEMA 0307

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