

thyssenkrupp rothe erde

rothe erde[®] turntables

Built for the road.

Uncompromising quality,
made in Germany.



thyssenkrupp



Technology made-to-measure



Each turntable consists of two steel rings designed for flange mounting. The raceways are machined in order to ensure that the loads are properly transferred between the profiled rings and the rolling elements. The turn tables are delivered with both a surface preservation and the raceway filled with grease.



rothe erde® slewing bearings

Our product range comprises ball bearings and roller bearings, turntables and seamless rolled rings. We at thyssenkrupp rothe erde put quality first. All of our activities from application engineering to design and production, including comprehensive customer service, are based on the following international quality standards:

- Quality assurance system acc. to DIN EN ISO 9001
- Environmental protection acc. to DIN EN ISO 14 001
- Industrial safety acc. to OHSAS 18 001

rothe erde® turntables – Products of proven quality have been developed for use in transport vehicles. Their purpose is to safely transmit the loads and tilting moment during operation of the vehicle. The standard series turntables shown here are the result of many years' design and manufacturing experience in the field of trailer steering systems for road truck trailers, positively steered semi-trailers, fifth wheel couplings, heavy goods vehicles and special vehicles. rothe erde® turntables are produced to exacting standards and are designed to meet high performance requirements.

Types 16 L – 16 – 80 – 80 S

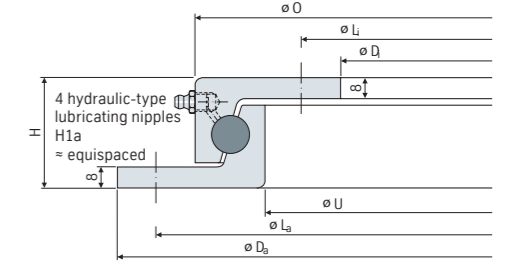
	Track diameter	Weight (approx.)	Outer diameter	Inner diameter	Overall height	Outer bolt circle diameter	Inner bolt circle diameter	Bore diameter	Number of grease nipples	Diameter	Diameter
Drawing No. · Type	D _L mm	kg	D _a mm	D _i mm	H mm	L _a mm	L _i mm	B mm	n ₁ mm	D _{a1} mm	O mm
Type 16 L undrilled											
16L 310.16.0300.000 · Type 16 L /400	320.0	11.0	404	236.0	42	375	260	–	4	–	346
310.16.0400.000 · Type 16 L /500	420.0	15.0	504	336.0	42	475	360	–	4	–	446
310.16.0500.000 · Type 16 L /650	570.0	20.0	654	486.0	42	625	510	–	4	–	596
310.16.0600.000 · Type 16 L /750	670.0	23.0	754	586.0	42	725	610	–	4	–	696
310.16.0700.000 · Type 16 L /850	770.0	27.0	854	686.0	42	825	710	–	4	–	796
310.16.0800.000 · Type 16 L /950	870.0	30.0	954	786.0	42	925	810	–	4	–	896
310.16.0900.000 · Type 16 L /1050	970.0	34.0	1054	886.0	42	1025	910	–	4	–	996
Type 16 undrilled											
16 320.16.0400.000 · Type 16/500	407.5	17.0	500	315.0	48	475	340	–	4	–	434
320.16.0500.000 · Type 16/650	557.5	23.0	650	465.0	48	625	490	–	4	–	584
320.16.0600.000 · Type 16/750	657.5	26.0	750	565.0	48	725	590	–	4	–	684
320.16.0700.000 · Type 16/850	757.5	30.0	850	665.0	48	825	690	–	4	–	784
320.16.0800.000 · Type 16/950	857.5	34.0	950	765.0	48	925	790	–	4	–	884
320.16.0900.000 · Type 16/1050	957.5	39.0	1050	865.0	48	1025	890	–	4	–	984
Type 80 undrilled											
80 330.16.0500.000 · Type 80/685	598.5	38.0	721	567.0	80	671	657	–	4	696	–
330.16.0700.000 · Type 80/880	793.5	48.0	916	762.0	80	866	852	–	4	891	–
330.16.0900.000 · Type 80/1000	913.5	58.0	1036	882.0	80	984	970	–	4	1011	–
330.16.1000.000 · Type 80/1090	1003.5	63.0	1126	972.0	80	1074	1060	–	4	1101	–
Type 80 drilled											
80 330.16.0700.010 · Type 80/880	793.5	48.0	916	762.0	80	866	852	16	4	891	–
330.16.1000.010 · Type 80/1090	1003.5	63.0	1126	972.0	80	1074	1060	18	4	1101	–
Type 80 S undrilled											
80S 350.16.0500.000 · Type 80 S /660	562.5/552.5	40.6	664	519.5	80	–	–	–	6	650	–
350.16.0700.000 · Type 80 S /890	792.5/782.5	57.0	894	749.5	80	–	–	–	6	880	–
350.16.1000.000 · Type 80 S /1100	1002.5/992.5	73.0	1108	959.5	80	–	–	–	6	1095	–
Type 80S drilled											
80S 350.16.0500.010 · Type 80 S /660	562.5/552.5	40.4	664	519.5	80	636	622	14	6	650	–
350.16.0700.010 · Type 80 S /890	792.5/782.5	56.8	894	749.5	80	866	852	16	6	880	–
350.16.0710.010 · Type 80 S /890 A	792.5/782.5	56.7	894	749.5	80	866	852	16	6	880	–
350.16.1000.010 · Type 80 S /1100	1002.5/992.5	72.8	1108	959.5	80	1074	1060	16	6	1095	–

* For other axle combinations or other uses, please contact us
 ** Type 80 S/890 A: Permissible load valid for fifth wheel couplings

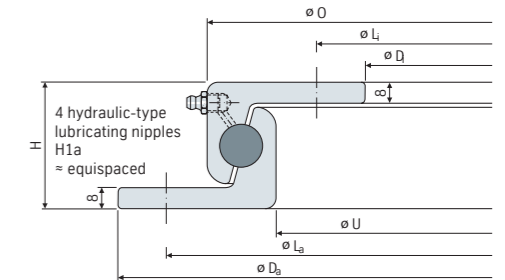
Trailer load

Diameter	Ball Diameter	Permissible axial load*		Permissible acceleration or deceleration	Maximum bearing clearances	
U mm	d mm	2 axles kN	more than 2 axles kN	m/s ²	axial mm	radial mm
294	16	7.5	–	4	1.0	0.7
394	16	9.0	–	4	1.0	0.7
544	16	15.0	–	4	1.0	0.7
644	16	18.0	–	4	1.0	0.7
744	16	25.0	–	4	1.0	0.7
844	16	30.0	–	4	1.0	0.7
944	16	35.0	–	4	1.0	0.7
Trailer load (continued)						
583	16	35.0	30.0	7	1.0	0.7
778	16	55.0	50.0	7	1.0	0.7
898	16	65.0	60.0	7	1.0	0.7
988	16	70.0	65.0	7	1.0	0.7
Trailer load (continued)						
554	16/14	50.0	50.0	7	1.0	0.7
784	16/14	80.0	80.0	7	1.0	0.7
994	16/14	100.0	100.0	7	1.0	0.7
Trailer load (continued)						
554	16/14	50.0	50.0	7	1.0	0.7
784	16/14	80.0	80.0	7	1.0	0.7
784	16/14	160.0**	160.0**	7	1.0	0.7
994	16/14	100.0	100.0	7	1.0	0.7

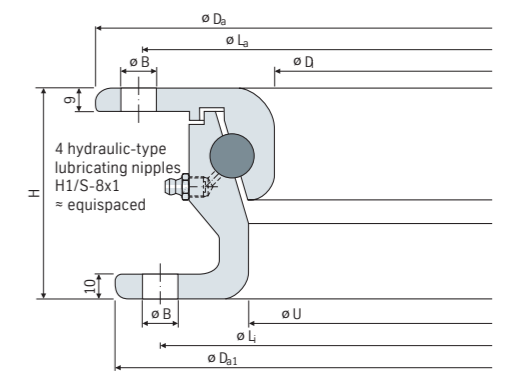
Type 16 L for farm trucks and carts



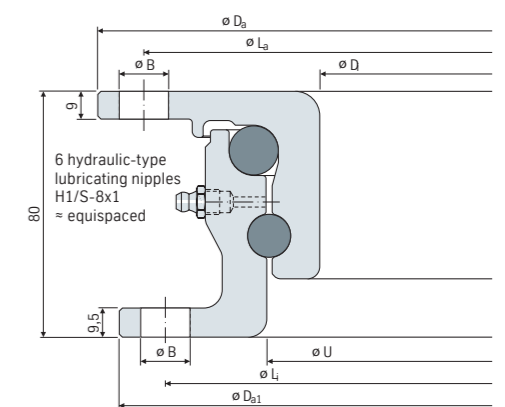
Type 16 for lightweight truck trailers and farm trucks



Type 80 for two and three-axle trailers



Type 80 S for two and three-axle trailers



Types 90 – 90 WA – 90 S

	Track diameter	Weight (approx.)	Outer diameter	Inner diameter	Overall height	Outer bolt circle diameter	Inner bolt circle diameter	Bore diameter	Number of grease nipples	Diameter	Diameter
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Drawing No. · Type	D _L mm	kg	D _a mm	D _i mm	H mm	L _a mm	L _i mm	B mm	n ₁ mm	D _{a1} mm	O mm
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Type 90 undrilled											
360.18.0800.000 · Type 90/1000.18	894	64	1008	854	90	974	960	–	6	1000	–
360.20.0800.000 · Type 90/1000.20	894	64	1008	854	90	974	960	–	6	1000	–
360.22.0800.000 · Type 90/1000.22	894	64	1008	854	90	974	960	–	6	1000	–
360.24.0800.000 · Type 90/1000.24	894	64	1008	854	90	974	960	–	6	1000	–
360.18.0900.000 · Type 90/1100.18	994	71	1108	954	90	1074	1060	–	6	1100	–
360.20.0900.000 · Type 90/1100.20	994	71	1108	954	90	1074	1060	–	6	1100	–
360.22.0900.000 · Type 90/1100.22	994	71	1108	954	90	1074	1060	–	6	1100	–
360.24.0900.000 · Type 90/1100.24	994	71	1108	954	90	1074	1060	–	6	1100	–
360.22.1000.000 · Type 90/1200.22	1094	79	1208	1054	90	1174	1160	–	6	1200	–
360.24.1000.000 · Type 90/1200.24	1094	79	1208	1054	90	1174	1160	–	6	1200	–
360.22.1100.000 · Type 90/1300.22	1194	87	1308	1154	90	1274	1260	–	6	1300	–

Type 90 drilled											
360.18.0900.010 · Type 90/1100.18	994	71	1108	954	90	1074	1060	18	6	1100	–
360.20.0900.010 · Type 90/1100.20	994	71	1108	954	90	1074	1060	18	6	1100	–
360.22.0900.010 · Type 90/1100.22	994	71	1108	954	90	1074	1060	18	6	1100	–
360.24.0900.010 · Type 90/1100.24	994	71	1108	954	90	1074	1060	18	6	1100	–
360.22.1000.010 · Type 90/1200.22	1094	79	1208	1054	90	1174	1160	18	6	1200	–
360.24.1000.010 · Type 90/1200.24	1094	79	1208	1054	90	1174	1160	18	6	1200	–
360.22.1100.010 · Type 90/1300.22	1194	87	1308	1154	90	1274	1260	18	6	1300	–

Type 90 WA drilled											
360.22.0955.010 · Type 90/1100.22 WA	994	71	1108	954	90	1074	1060	18	6	1100	–
360.24.0955.010 · Type 90/1100.24 WA	994	71	1108	954	90	1074	1060	18	6	1100	–
360.22.1055.010 · Type 90/1200.22 WA	1094	79	1208	1054	90	1174	1160	18	6	1200	–
360.24.1055.010 · Type 90/1200.24 WA	1094	79	1208	1054	90	1174	1160	18	6	1200	–
360.22.1155.010 · Type 90/1300.22 WA	1194	87	1308	1154	90	1274	1260	18	6	1300	–

Type 90 S undrilled											
370.20.0804.000 · Type 90 S /1000	880/870	82	1000	834	90	966	952	–	6	987	–
370.20.0904.000 · Type 90 S /1100	988/978	92	1108	942	90	1074	1060	–	6	1095	–
370.20.1004.000 · Type 90 S /1200	1088/1078	101	1208	1042	90	1174	1160	–	6	1195	–
370.24.1004.000 · Type 90 S /1200.SP	1087/1078	101	1208	1042	90	1174	1160	–	6	1195	–

Type 90 S drilled											
370.20.0804.010 · Type 90 S /1000	880/870	82	1000	834	90	966	952	18	6	987	–
370.20.0904.010 · Type 90 S /1100	988/978	92	1108	942	90	1074	1060	18	6	1095	–
370.20.1004.010 · Type 90 S /1200	1088/1078	101	1208	1042	90	1174	1160	18	6	1195	–
370.20.1004.030 · Type 90 S /1200.12	1088/1078	101	1208	1042	90	1174	1160	18	6	1195	–
370.24.1004.010 · Type 90 S /1200.SP	1087/1078	101	1208	1042	90	1174	1160	18	6	1195	–

* For other axle combinations or other uses, please ask us

Anhängerbelastung

Diameter	Ball Diameter	Permissible axial load*		Permissible acceleration or deceleration	Maximum bearing clearances	
U mm	d mm	2 axles kN	more than 2 axles kN	m/s ²	axial mm	radial mm

885	18	75	70	7	1.0	0.7
885	20	90	80	7	1.0	0.7
885	22	110	100	7	1.0	0.7
885	24	160	140	7	1.0	0.7
985	18	90	80	7	1.0	0.7
985	20	110	100	7	1.0	0.7
985	22	130	120	7	1.0	0.7
985	24	180	160	7	1.0	0.7
1085	22	160	140	7	1.0	0.7
1085	24	200	180	7	1.0	0.7
1185	22	180	160	7	1.0	0.7

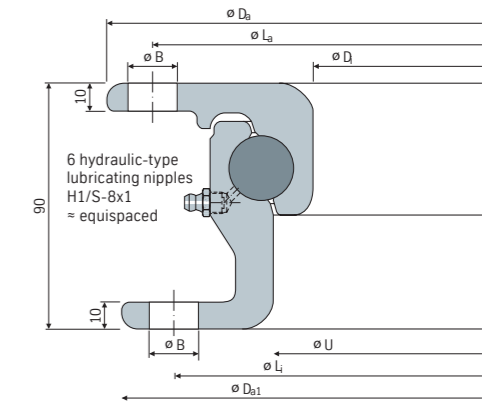
985	18	90	80	7	1.0	0.7
985	20	110	100	7	1.0	0.7
985	22	130	120	7	1.0	0.7
985	24	180	160	7	1.0	0.7
1085	22	160	140	7	1.0	0.7
1085	24	200	180	7	1.0	0.7
1185	22	180	160	7	1.0	0.7

985	22	130	120	7	0.8	0.6
985	24	180	160	7	0.8	0.6
1085	22	160	140	7	0.8	0.6
1085	24	200	180	7	0.8	0.6
1185	22	180	160	7	0.8	0.6

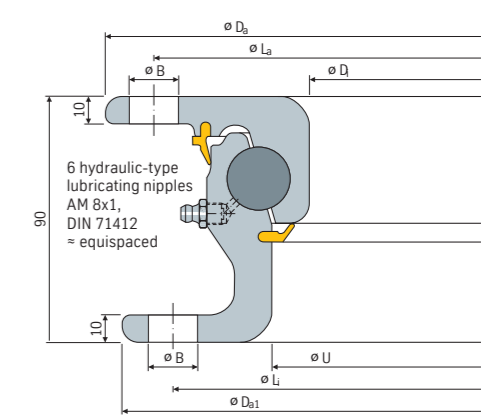
871	20/16	160	160	7	1.0	0.7
979	20/16	200	200	7	1.0	0.7
1079	20/16	200	200	7	1.0	0.7
1079	24/16	300	300	7	1.0	0.7

871	20/16	160	160	7	1.0	0.7
979	20/16	200	200	7	1.0	0.7
1079	20/16	200	200	7	1.0	0.7
1079	24/16	300	300	7	1.0	0.7

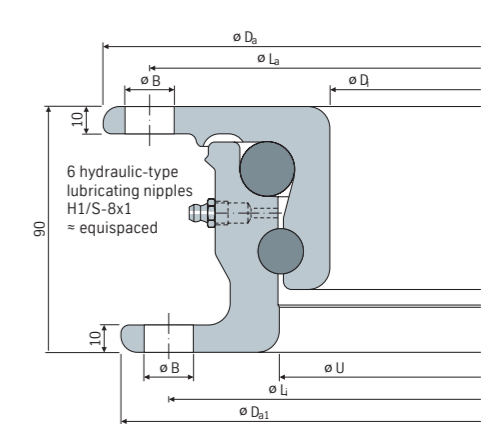
Type 90 for two and three-axle trailers



Type 90 WA for two and three-axle trailers



Type 90 S for two and three-axle trailers



Type 90 WA: Low-maintenance version

- Raceway system protected by seals at upper and lower bearing gap.
- Low-maintenance for a minimum of 3 years or a mileage of 300,000 kms under normal operating conditions. Should the turntable be exposed to unusual operating conditions or should the turntable be directly cleaned with a highpressure equipment, it is necessary to re-grease the turntable immediately. Take care that the companion structure protects the turntable in order to prevent any water and dirt from entering the raceway system.
- Re-greasing and inspection is necessary after the low-maintenance operating period has elapsed.
- Frictional torque: Due to the seals at the bearing gaps, higher frictional torque may exist as compared to the standard version. Operation is not impaired by this when used in vehicle trailers.
- Mounting dimensions, permissible loads, weights, and drilling plans are the same as the standard design type 90.



Delivery

The turntables are supplied as standard type being filled with lithium-saponified grease of penetration grade 2 or as a low-maintenance type being filled with Gleitmo 585 K. The turntables are supplied with a surface preservation. This preservation is only a temporary protection against corrosion which can be overpainted with any commercial finishing paints (such as acrylic resins, onecomponent and two-component acrylic varnishes, twocomponent PU varnishes, two-component epoxy varnishes) and with bituminous paint. (Attention: Do not overpaint the seals.)

The user should check in each individual case if overpainting is possible by applying a trialcoat and conducting an adherence test. Any coating older than 3 months must be sanded down prior to further surface treatment. Without adequate surface preparation – sandblasting for example the applied protective painting does not provide improved protection against corrosion. Storage of the turntables is possible for periods of up to 6 months in roofed storage areas. Storage of up to 12 months is possible, provided that the turntables are kept in a climate controlled environment.

Cathodic dip coating

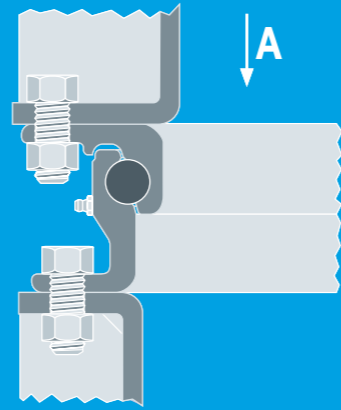
The long lasting preservation method

The choice of the right corrosion protection has a direct impact on the service life of your rothe erde® turntables and profile bearings. Cathodic dip coating (CDC) increases the corrosion resistance of your products. This is a process-safe method with the best environmental compatibility for products that require excellent corrosion resistance. This applies in particular when the material is subjected to high stresses due to environmental influences or when painting complicated geometries.

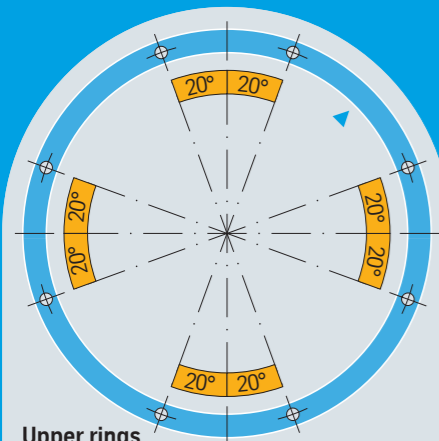


Mounting holes

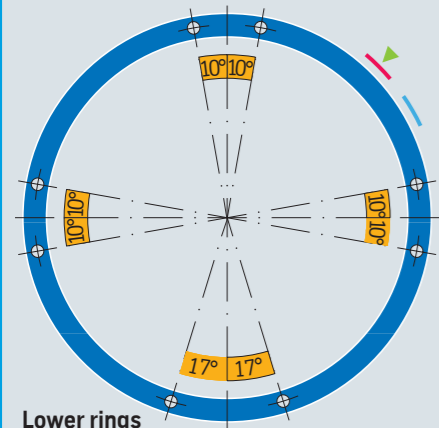
Turntables can be delivered either drilled or undrilled. If the customer elects to drill the holes themselves, they must allow for positioning of the nameplate / filler plug lateral to the direction of travel outside the main load-carrying area. It is also necessary to drill one mounting hole approximately 70mm right or left off the nameplate.



Views in direction A



Upper rings

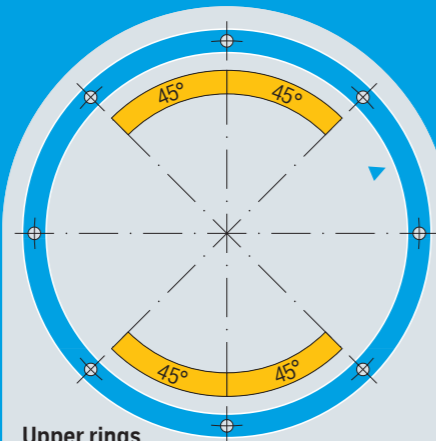


Lower rings

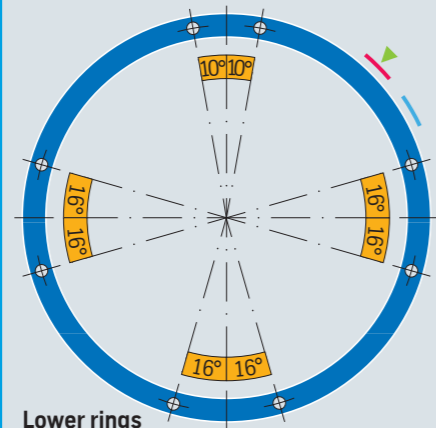
Typ 80/880
Typ 80 S/890
Drilled holes according to the table
Special drilled holes upon request

- ▲ Filler plug
- Nameplate
- ▲ Filler plug (applies to Type 80 S)
- Nameplate (applies to Type 80 S)

Views in direction A



Upper rings

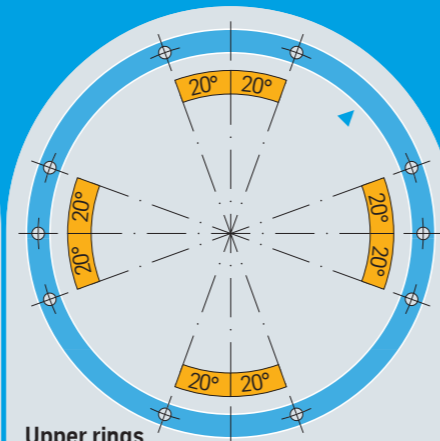


Lower rings

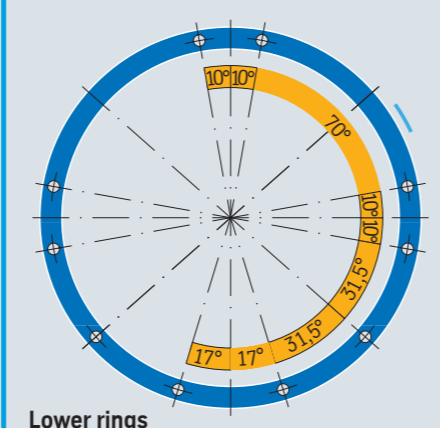
Typ 80/1090
Typ 80 S/660
Typ 80 S/1100
Typ 90/1100.18 up to Typ 90/1300.22
Drilled holes according to the table
Special drilled holes upon request

- ▲ Filler plug
- Nameplate
- ▲ Filler plug (applies to Type 80 S)
- Nameplate (applies to Type 80 S)

Views in direction A



Upper rings

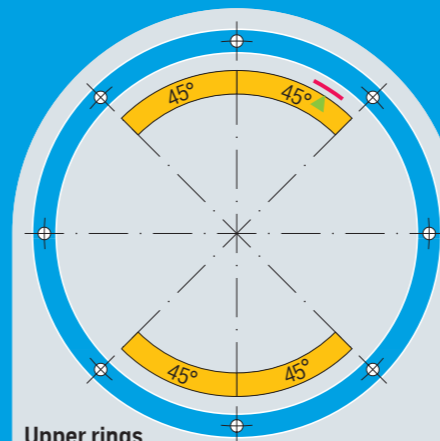


Lower rings

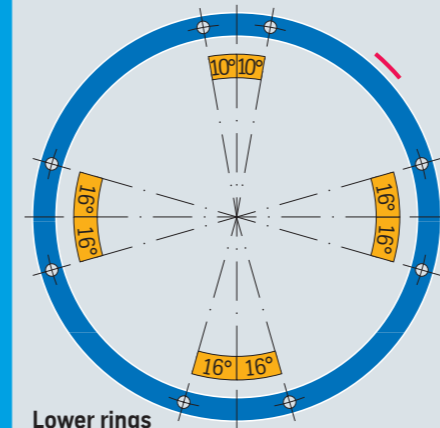
Typ 80 S/890 A
Drilled holes according to the table
Special drilled holes upon request

- ▲ Filler plug
- Nameplate

Views in direction A



Upper rings

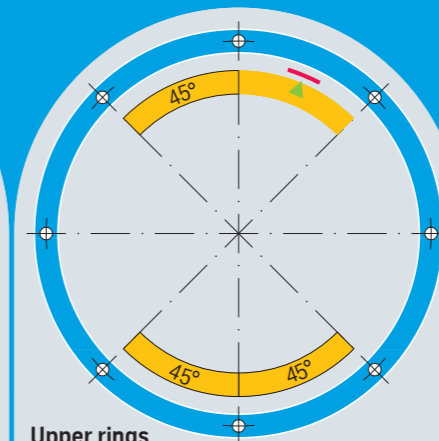


Lower rings

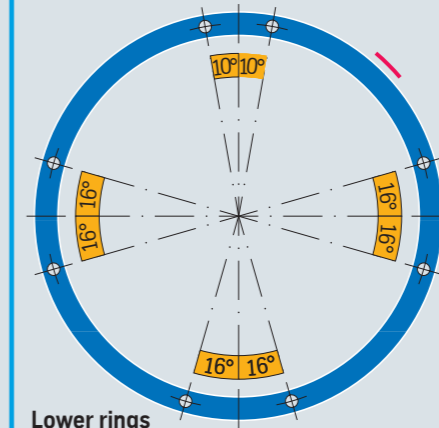
Typ 90/1100.22 WA up to Typ 90/1300.22 WA
Drilled holes according to the table
Special drilled holes upon request

- ▲ Filler plug
- Nameplate

Views in direction A



Upper rings

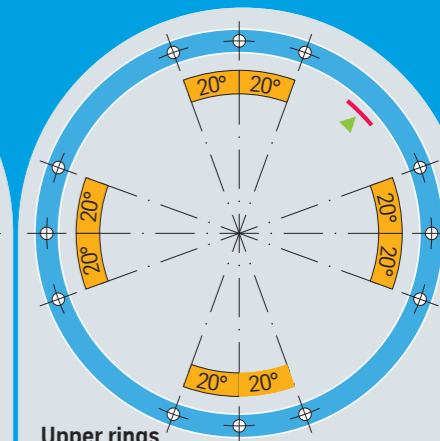


Lower rings

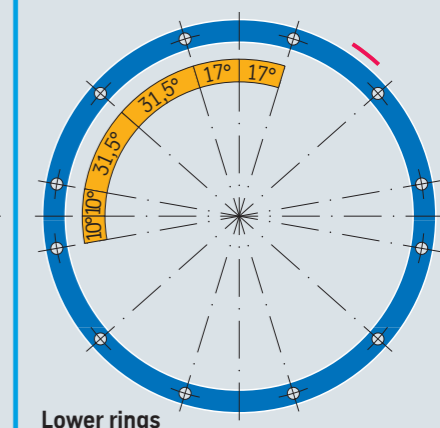
Typ 90 S/1000
Typ 90 S/1100
Typ 90 S/1200
Drilled holes according to the table
Special drilled holes upon request

- ▲ Filler plug
- Nameplate

Views in direction A



Upper rings

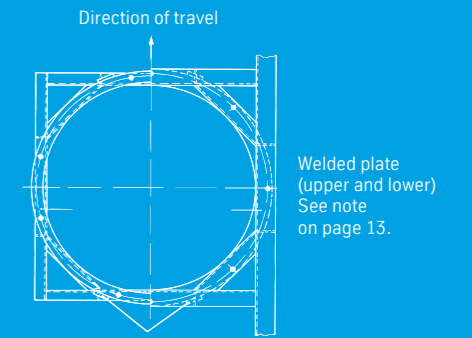


Lower rings

Typ 90 S/1200.12
Typ 90 S/1200 SP
Drilled holes according to the table
Special drilled holes upon request

- ▲ Filler plug
- Nameplate

This nameplate is fixed at the upper ring (inner diameter) of bearing type 90 S and 90 WA. When using undrilled types take care to prevent any chips from entering the raceway system and that the turntable, as well as the seals (90 WA types), are not damaged when drilling the mounting holes. Holes adjacent to the nameplate are not permitted.





Installation

Turntables must be mounted on a flat and torsion-resistant frame structure. It is essential that at least 50 % of the peripheral surface of the flanges are supported load-bearing zones that are roughly equally spaced in the direction of travel and at right angles to this.

The essential factor here is to support the profiled rings of the turntable thus assuring that the forces are directly transmitted into the raceways. Total out-of-flatness 1.3mm,

permissible are for example 0.8mm up and 0.5mm down. Larger out-of-flatnesses have to be compensated by suitable measures (machining of the contact surfaces or use of captive shims in the respective contact area).

To secure drilled versions of the turntable, high-strength bolts of quality grade 10.9 as well as high tensile washers must be used in all the mounting holes. On undrilled versions we recommend using at least 8 high-

strength bolts of quality grade 10.9 as well as high tensile washers for optimal load transfer. Care should be taken in order to prevent any chips from entering the raceway system and that the turntable, as well as the seals (WA types), are not damaged when drilling the mounting holes.

The size and distribution of the bolts must be calculated based on the load. The bolt locking system must comply with the TÜV's (German Technical Control Board's) requirements or with the prevailing approval regulations.

The turntable must be mounted to the companion structures so that the horizontal forces from acceleration and deceleration are transmitted and the bolts are relieved in radial direction. To prevent distortion from occurring, turntables must never be attached to the companion structure by welding.

The load details and bolt connections are only valid for operation on paved roads and under transport conditions as usual in Western Europe.

Under special operating conditions, e.g. forestry work, the companion structure has to protect the turntable in a way that it cannot be damaged by branches or other foreign objects.

The nameplate / filler plug has to be positioned 90 degrees to the direction of travel, i.e. outside the main load-carrying area.

Table of tolerances

Type	H mm	Flange thickness mm	D _a mm	D _{a1} mm	D _i mm	0 mm	U mm
16L and	Type 16 L /400	± 3	± 2,0	+ 8	-	+ 4	± 3
	Type 16 L /500			- 5		- 10	
up to	Type 16 L /650	± 3	± 1,5	+ 8	-	+ 4	± 3
	Type 16 L /1050			- 4		- 10	
16	Type 16/500	± 3	± 2,0	+ 8	-	+ 4	± 3
				- 5		- 10	
	Type 16/650	22	130	+ 8	-	+ 4	± 3
up to	Type 16 L /1050	24	180	- 4		- 10	
80	Type 80/685	22	160	+ 8	+ 8	± 3	-
	Type 80/1090	24	200	- 4	- 4		± 3
80S	Type 80 S /660	± 3	± 1,5	- 0,8	- 0,8	± 3	-
	Type 80 S /890			- 0,9	- 0,9		± 3
	Type 80 S /1100		- 1,1	- 1,1			
90	Type 90/1000.18	± 3	± 1,5	+ 8	+ 8	± 3	-
	Type 90/1300.22			- 4	- 4		± 3
90 WA	Type 90/1100.22 WA	± 3	± 1,5	+ 8	+ 8	± 3	-
	Type 90/1300.22 WA			- 4	- 4		± 3
90 S	Type 90 S /1000	± 3	± 1,5	- 1,6	- 1,6	± 3	-
	Type 90 S /1200.SP						± 3

Lubrication and maintenance

Other conditions of use Warranty

Lubrication and maintenance of standard turntables

Prior to installation, the turntable has to be re-greased while turning the upper ring until a collar of grease appears at around the entire circumference of the bearing gaps. A penetration grade 2 lithium-sapinified grease should be used for re-greasing. Regreasing should also be carried out after installation, rotating or slewing the turntable through at least $\pm 30^\circ$ to achieve uniform grease distribution. Re-greasing is required at least once a month. It must be warranted that a sufficient amount of bolt preload is maintained throughout the complete life time of the turntable. Practical experience has shown that it is necessary to re-tighten the bolts with the required tightening torque in order to compensate the settling phenomenon of the bolted connections. The "as-supplied" bearing clearances shown in the bearing tables are permitted to increase through wear by a maximum of 3mm axially and radially. Thereafter, the turntable must be replaced.

Maintenance of type 90 WA turntables – low-maintenance design

90 WA turntables are provided with a long-term lubrication for a low-maintenance period of at least 3 years or a mileage of 300,000 kms. The precondition is a protection at the companion structure to prevent water from entering there. Should exceptional environmental conditions prevail or should the turntable be directly cleaned with a high-pressure equipment, it is necessary to re-grease the turntable immediately. It is recommended that the companion structure protects the turntable in order to prevent any water and dirt from entering the raceway system. This service period can be extended by relubrication with Gleitmo 585 K (Fuchs Lubritech, Weilerbach). Regreasing should be carried out while turning or slewing the turntable

through at least $\pm 30^\circ$ in order to guarantee a uniform distribution of the grease.

For applications with extreme environmental conditions, specific maintenance instructions have to be established for each individual case. The turntables are equipped with grease fittings. Once the low-maintenance operating period has elapsed, it is necessary to re-grease through all grease fittings. Re-greasing should be carried out while turning or slewing the turntable through at least $\pm 30^\circ$ in order to guarantee a uniform distribution of the grease. It must be warranted that a sufficient amount of bolt preload is maintained throughout the complete life time of the turntable. Practical experience has shown that it is necessary to re-tighten the bolts with the required tightening torque in order to compensate the settling phenomenon.

We recommend that axial movement measurements are undertaken in conjunction with acceptance procedures by the German TÜV or other accredited testing agencies. If the measurement shows an axial or radial clearance in excess of 3mm, the turntable will have to be replaced.

Brief description of how to measure the axial movement measurement

- Check the bolt connections.
- Position the dial gauge with integrated magnets between the superstructure and the undercarriage in axial direction close to the raceway and a bolted area.
- Set the dial gauge to zero.
- Lift the superstructure by a forklift or lifting tackle until the under-carriage is freely suspended.
- Read the dial gauge to observe the axial movement
- Position the dial gauge on the other side and repeat the above sequence of steps.

Other conditions of use

- Should turntables be applied in vehicles with less accelerations or decelerations than indicated, the permissible axial load can be increased.
- rothe erde® turntables are suitable only for turning movements of $\pm 180^\circ$.

For other fields of application and load scenarios please contact thyssenkrupp rothe erde Germany GmbH for further evaluation.

Warranty

thyssenkrupp rothe erde Germany GmbH warrants that the products and material characteristics will be free from defects for a period of 12 months as from commissioning or, as applicable, a maximum period of 18 months as from delivery. This depends on proper installation, observance of the applicable maintenance instructions as well as on the suitability of the product for the selected application. Our General Terms of Sale are generally applicable. The warranty claims cover rework or substitute delivery. Consequential damages due to defects are excluded. Damage resulting from product modifications or improper cleaning is not covered by this warranty.



Europe

thyssenkrupp rothe erde Germany GmbH
Headquarter
Tremoniastraße 5 – 11
44137 Dortmund
Germany
P: +49 (0) 231 1 86 0
M: rotheerde@thyssenkrupp.com
www.thyssenkrupp-rotheerde.com

Plant Lippstadt
Beckumer Str. 87
59555 Lippstadt
Germany
P: +49 (0) 29 41 7 41 0
M: rotheerde@thyssenkrupp.com

thyssenkrupp rothe erde Italy S.p.A.
Viale Kennedy, 56
25010 Visano (Brescia)
Italy
P: +39 342 866 00 10
M: mri@thyssenkrupp.com

thyssenkrupp rothe erde UK Ltd.
Peterlee, Co. Durham, SR8 2HR
Great Britain
P: +44 (0) 191 518 5600
M: sales@roballo.co.uk

thyssenkrupp rothe erde Slovakia a.s.
Robotnícka ul.
01701 Považská Bystrica
Slovakia
P: +421 42 4371 111
M: pslpb@pslas.com

thyssenkrupp rothe erde Spain S.A.
Carretera Castellón, km. 7
Polígono Industrial "La Cartuja"
50720 Zaragoza
Spain
P: +34 (9 76) 50 04 80
M: rotheerspains@thyssenkrupp.com

Asia

thyssenkrupp rothe erde (Xuzhou)
Ring Mill Co. Ltd.
No. 6, Luoshan Road
Xuzhou Economic and Technological
Development Zone
Jiangsu, 221004
China
P: +86 (516) 87 98 01 63
M: sales@xrem.cn

Xuzhou rothe erde
Slewing Bearing Co. Ltd.
No. 15, Luoshan Road
Xuzhou Economic and Technological
Development Zone
Jiangsu, 221004
China
P: +86 (516) 87 76 71 70
M: sales@xreb.com

Rothe Erde India Private Ltd.
Gat No. 429,
Village: Wadivarhe, Post: Gonde,
Taluka: Igatpuri, District: Nashik,
Maharashtra, PIN 422 403
India
P: +91 (25 53) 30 22 31
M: info.rotheerdeindia@thyssenkrupp.com

thyssenkrupp rothe erde Japan Ltd.
Kyobashi Takaracho PREX 7F,
3-5 Hacchobori 4-chome,
Chuo-ku ,Tokyo 104-0032
Japan
P: +81 (0) 3 6228 3388
M: info@roballo.co.jp

America

thyssenkrupp Brasil Ltda. –
Division rothe erde
Rua Lidia Blank, No. 48
CEP 09913-010 Diadema, São Paulo
Brazil
P: +55 (11) 40 55 84 00
M: vendas.tkgb@thyssenkrupp.com

thyssenkrupp rothe erde USA Inc.
1400 South Chillicothe Rd.
P.O. Box 312
Aurora, Ohio 44202
USA
P: +1 (3 30) 5 62 40 00
M: sales@tkreusa.com