

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	K-8501	HOUSING, 8.5 RTRY TABLE
2	1	K-8502	PLATE, TOP COVER, 8.5 RTRY TA
3	1	K-8811	PLATE, BOTTOM SEAL
4	1	K-8750	HOUSING, PINION BRG
5	1	K-8751	PLATE, PINION SEAL
6	1	K-8506	NUT, MASTER DRIVE
7	1	K-8507	BOX, DRIVE-8.50 ROTARY
8	1	K-8053	RING, SEAL WEAR
9	1	K-8749	SPACER, 2.750 X 1.756 X2.830
10	1	K-8511	RING, PINION SEAL
11	1	K-8508	RING, BEARING SHOULDER
12	1	K-8576	WASHER, FLANGE RETAINING
13	1	K-8810	RING, MUD SLINGER
14	1	400F449	SPACER, 2.250 X 1.825 X2.000
15	1	XTH1E170975	CONE, BRG - 8.750 X 2.000
16	1	XTH171450	CUP, BRG - 14.50 X 1.312
17	1	XTH1E126097	CONE, BRG - 8.625 X 3.000
18	1	XTH126150	CUP, BRG - 15.00 X 2.250
19	1	XTH553-X	CONE, BRG - 4.812 X 1.187
20	1	XTH555-S	CONE, BRG - 2.250 X 1.444
21	1	XTH45280	CONE, BRG - 1.750 X 1.218
22	1	XTH45221	CUP, BRG - 4.125 X 0.937
23	1	XNC-415482	SEAL, 11,000 X 13,010 X .750
24	2	XCR-90245	SEAL, 9,825 X 11,625 X .625
25	1	XCR-23093	SEAL, 2.313 X 3.256 X .503
26	4	K-8524-05	SHIM, .005 X15.03 X17.00-12/
27	1	K-8752-S-05	SHIM, RD 2.750 X 2.250 X .005
28	2	K-8523-05	SHIM, .005 X 5.53 X 7.50-8/
29	1	145F351	SET, R-GEAR & PINION - 8143
30	1	D-1750-G	NUT, TAPER SHAFT
31	12	8F8-C	BOLT, 1/2 NF SOC HD X 1
32	24	8F10-C	BOLT, 1/2 NF SOC HD X 1-1/4
33	6	8F12-C	BOLT, 1/2 NF SOC HD X 1-1/2
34	2	K-15M3077	PNL, DOWEL-.82 X 1.37
35	1	XAC-300805	VALVE, AIR VENT - 1/8
36	2	XAC-1634	FITTING, GREASE-1/8 NPT STR
37	1	XLM-402-XQ	PLUG, 1/2 -SQ HD MAGNETIC
38	1	144F489	PLUG, 3/4 -SQ HD - 3000LB
39	5	K-8811-G	SHIM, .005 X15.00 X17.00-12/
40	1	4CP-32	PNL, 1/8 X 2 COTTER
41	4	14C1248	BOLT, 7/8 NC HEX HD X 1-1/2
42	4	14-LW	WASHER, 7/8 LOCK
43	2	K-8523-10	SHIM, .010 X 5.53 X 7.50-8/
44	2	K-8523-15	SHIM, .030 X 5.53 X 7.50-8/
45	4	K-8524-10	SHIM, .010 X15.03 X17.00-12/
46	2	K-8524-30	SHIM, .030 X15.03 X17.00-12/
47	2	K-8752-G-10	SHIM, RD 2.750 X 2.250 X .010
48	1	K-8752-G-20	SHIM, RD 2.750 X 2.250 X .020

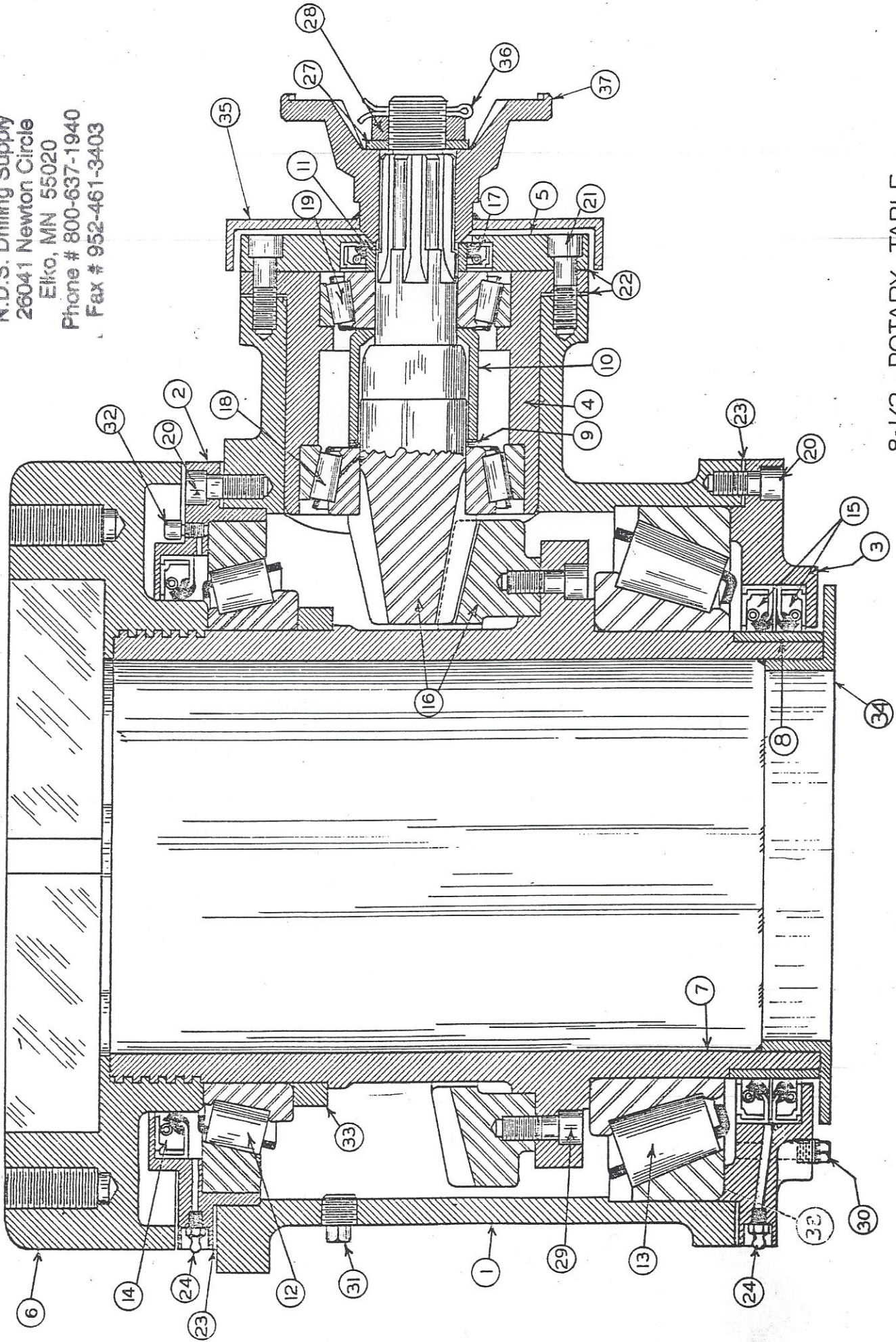
NOTE: PART NUMBERS SHOWN ARE FOR REFERENCE ONLY. COMPARE THIS PARTS LIST WITH THE CURRENT BILL OF MATERIALS TO ENSURE CORRECT PARTS ARE USED.

INSTRUCTION
START WITH 3 SHIMS, BETWEEN LOWER SEAL PLATE (ITEM 3) & CUP (ITEM 18) TRIM SHIM OD TO FIT INSIDE HOUSING

INSTRUCTION
SET BEARING RACE (18) 3/32" BELOW UPPER SHOULDER

- NOTES:
- 1) LUBRICATION 1-1/2 GALLON OF 80/90 WEIGHT OIL
 - 2) TOP SEAL 5 SHOTS GUN GREASE.
 - 3) BOTTOM SEAL 10 SHOTS GUN GREASE.
 - 4) RUN ON TEST STAND 1 HOUR, CHECK TEMPERATURE EVERY FIFTEEN MINUTES. TEMPERATURE SHOULD STABILIZE AT 150 TO 170° F.
 - 5) RUN UNIT IN 2ND GEAR 850 RPM FOR 30 MINUTES
 - 6) RUN UNIT IN 4TH GEAR 1765 RPM FOR 30 MINUTES

N.D.S. Drilling Supply
26041 Newton Circle
Elko, MN 55020
Phone # 800-637-1940
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8-1/2 ROTARY TABLE

ASSEMBLY

13020

MODEL 8½" Rotary Table Assembly 13020

ITEM	PART NUMBER	QTY.	DESCRIPTION
1.	8501	1	Table Housing
2.	8502	1	Bearing Housing
3.	8811	1	Lower Seal Plate
4.	8750	1	Pinion Bearing Housing
5.	8571	1	Pinion Seal Plate
6.	8506	1	Mud Nut
7.	8507	1	Drive Box
8.	8683	1	Grease Seal Wear Ring
9.	8752-S	8	Pinion Shims 2-3/4" x 2¼" x .005
10.	8749	1	Pinion Bearing Spacer
11.	8511	1	Pinion Seal Ring
12.	845111900	1	Upper Bearing Cone
	845112901	1	Upper Bearing Cup
13.	845111901	1	Lower Table Bearing Cone
			Lower Table Bearing Cup
14.	8514	1	Upper Grease Seal
15.	8515	2	Lower Grease Seal
16.	8690	1	Ring Gear & Pinion Set 7.71 to 1 Ratio
17.	855023022	1	Pinion Grease Seal
18.	845111219	1	Inner Pinion Bearing Cone
	845112407	1	Inner Pinion Bearing Cup
19.	845111122	1	Outer Pinion Bearing Cone
	845112406	1	Outer Pinion Bearing Cup
20.	8521	24	Allen Head Cap Screws ½" x 1¼" NF Nylock
21.	8522	6	Allen Head Cap Screws ½" x 1½" NF Nylock
22.	8523	1	Pinion Spacer Shims .030 (Approximately)
23.	8524	1	Table Bearing Adjusting Shims .120 (Approx.)
24.	88Y0100	2	Grease Zerk 1/8" NPT Straight
25.	8526	1	Master Drive Bushing 6½" Sq. (Not Shown)
25A.	8526-A	1	Master Drive Bushing 5¼" Sq. (Not Shown)
27.	8576	1	Flange Retaining Washer 1¼" Hole 3/16" Thick
28.	8577	1	Flange Retaining Nut 1¼" 20 Thd.
29.	8531	12	Allen Head Cap Screws ½" x 1" NF Nylock
30.	853210318	1	Magnetic Pipe Plug
31.	853210309	1	Filler Plug 3/4" NPT
32.	4700	1	Vent Plug
33.	8508	1	Bearing Shoulder Ring
34.	8810	1	Dust Deflector Ring (Tack Welds in Drive Box)
35.	8816	1	Pinion Dust Shield (Tack Weld to U-Joint)
36.		1	Cotter Pin 1/8" x 2"
37.	8686	1	U-Joint Yoke (Mechanical Drive)
38.	8811-S	1	Bearing Shim 15" x 13½" ID (.010 Thick)

NOTE: Delete U-Joint Yoke #8686 for Hydro Drive use #16D4508 Flange Type Yoke