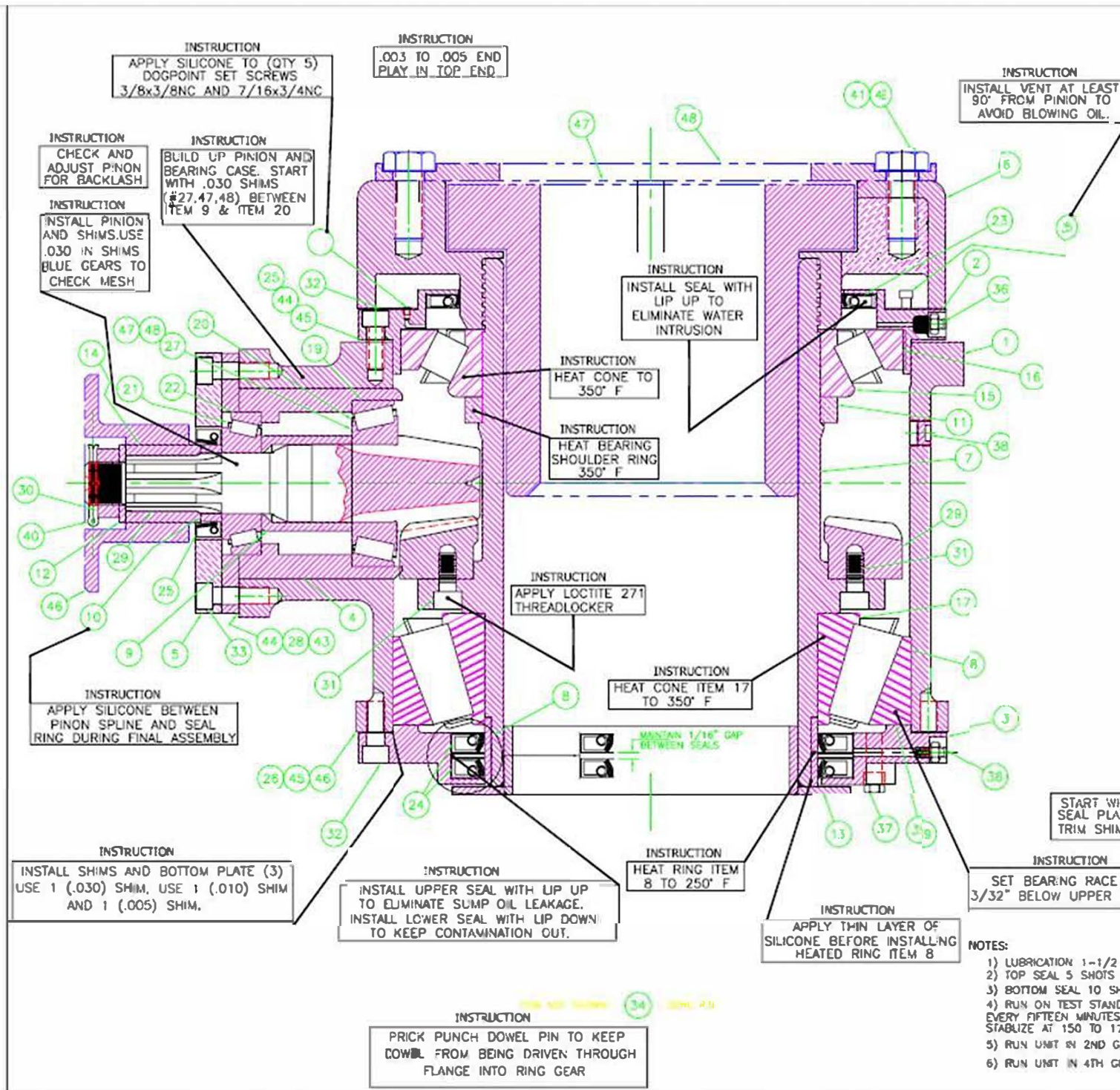


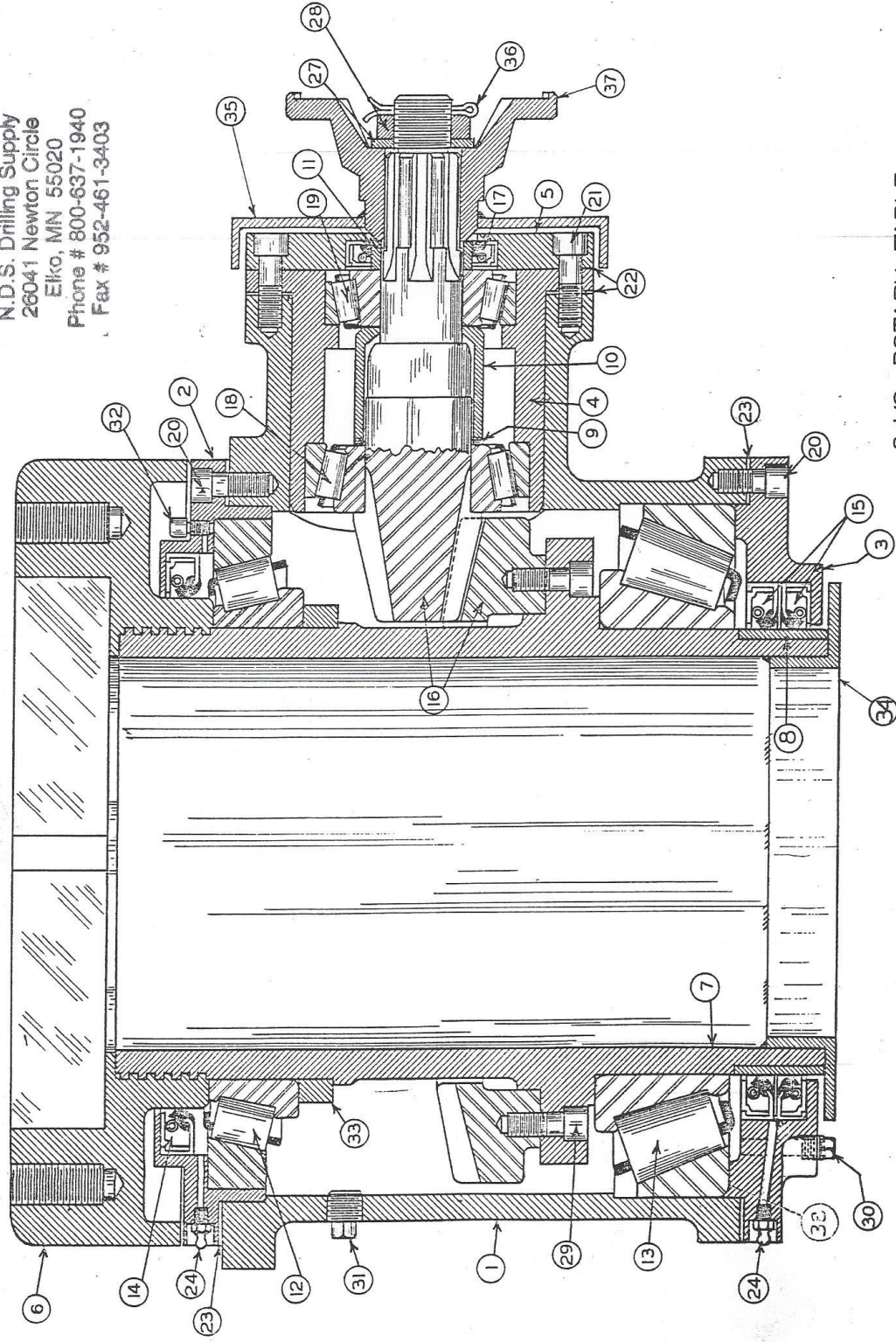


ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	K-8501	HOUSING, B5 RTTRY TABLE
2	1	K-8502	PLATE, TOP COVER, B5 RTTRY TA
3	1	K-8811	PLATE, BOTTOM SEAL
4	1	K-8750	HOUSING, PINION BRG
5	1	K-8751	PLATE, PINION SEAL
6	1	K-8506	NUT, MASTER DRIVE
7	1	K-8507	BOX, DRIVE-8.50 ROTARY
8	1	K-8623	RING, SEAL WEAR
9	1	K-8749	SPACER, 2.750 X 1.750 X2.630
10	1	K-8511	RING, PINION SEAL
11	1	K-8508	RING, BEARING SHOULDER
12	1	K-8578	WASHER, FLANGE RETAINING
13	1	K-8810	RING, MUD SLINGER
14	1	400F-449	SPACER, 2.250 X 1.825 X2.000
15	1		CONE, BRG - 9.750 X 2.000
16	1		CUP, BRG - 14.50 X 1.312
17	1		CONE, BRG - 9.825 X 3.000
18	1		CUP, BRG - 15.00 X 2.250
19	1		CUP, BRG - 4.812 X 1.187
20	1		CONE, BRG - 2.250 X 1.444
21	1		CONE, BRG - 1.750 X 1.218
22	1		CUP, BRG - 4.125 X 0.937
23	1	X02-415482	SEAL, 11.000 X 13.010 X .750
24	2	XCR-28245	SEAL, 9.625 X 11.825 X .825
25	1	XCR-22083	SEAL, 2.313 X 3.256 X .500
26	4	K-8524-05	SH-IM, .005 X15.03 X17.00-12"
27	1	K-8752-S-05	SH-IM, RD 2.750 X 2.250 X .005
28	2	K-8523-05	SH-IM, .005 X 5.53 X 7.50-8"
29	1	145F351	SET, PL-GEAR & PINION - 643
30	1	D-1750-G	NUT, TAPER SHAFT
31	12	EFB-C	BOLT, 1/2 NF SOCHD X 1
32	24	EF10-C	BOLT, 1/2 NF SOCHD X 1-1/4
33	6	EF12-C	BOLT, 1/2 NF SOCHD X 1-1/2
34	2	K-860077	PN, DOWEL .62 X 1.37
35	1	XAC-300805	VALVE, AIR VENT - 1/8
36	2	XAC-834	FITTING, GREASE-1/8 NPT STR
37	1	XLM-402-60	PLUG, 1/2 - SQ HD MAGNETIC
38	1	144F489	PLUG, 3/4 - SQ HD - 300CLB
39	5	K-8811-S	SH-IM, .005 X15.00 X17.00-12"
40	1	4CP-32	PN, 1/8 X2 COTTER
41	4	14C12-B	BOLT, 7/8 NC HEX HD X 1-1/2
42	4	144W	WASHER, 7/8 LOCK
43	2	K-8523-10	SH-IM, .010 X 5.53 X 7.50-8"
44	2	K-8622-15	SH-IM, .030 X 5.53 X 7.50-8"
45	4	K-8524-10	SH-IM, .010 X15.03 X17.00-12"
46	2	K-8524-30	SH-IM, .030 X15.03 X17.00-12"
47	2	K-8752-S-10	SH-IM, RD 2.750 X 2.250 X .010
48	1	K-8752-S-20	SH-IM, 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.

- 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 1785 RPM FOR 30 MINUTES

N.D.S. Drilling Supply
 26041 Newton Circle
 Elko, MN 55020
 Phone # 800-637-1940
 Fax # 952-461-3403



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 2½" 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 1½" 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 1½" 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			