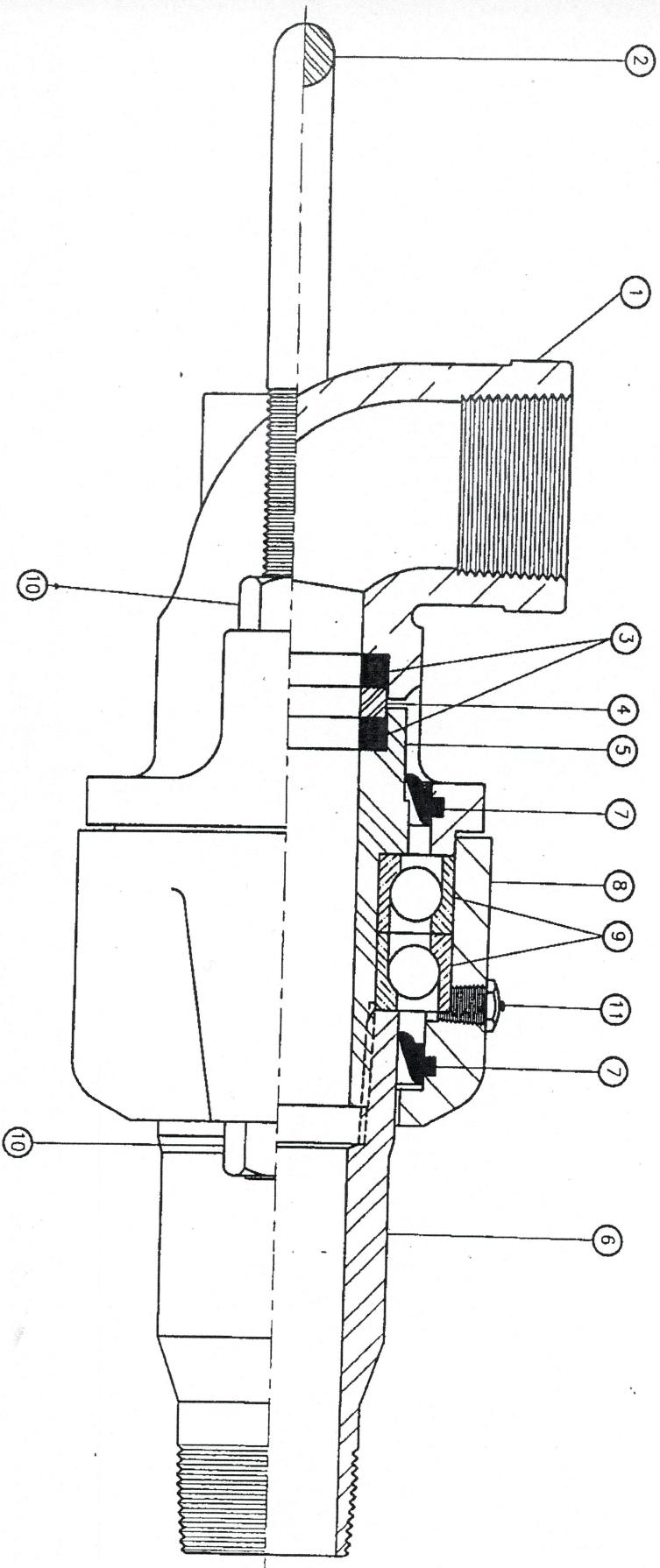


RE: Disassembly instructions for the 2J King Swivel

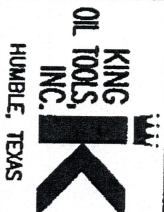
1. Unscrew and remove bolts on bottom of the bail.
2. Unscrew bolts on top of bail, slide gooseneck down and off of the bail.
3. Slide bearing housing down and off of spindle.
4. The top portion of the spindle is now exposed along with the bearings. Use a pipe wrench to break out spindle from the lower connection. This is a LEFT HAND THREAD – IT WILL BREAK TO THE RIGHT.
5. Remove packing, wearbushing and housing seals.
6. Remove/replace bearings. The bearing arrangement will be ONE UP AND ONE DOWN – WIDE SIDE OF BEARING RACE DETERMINES DIRECTION. Tighten snugly so that bearings rotate together as one bearing.

ASSEMBLY

7. Reverse the order of disassembly.
8. Take care to ensure that bail bolts are at equal height on bail so that gooseneck is not cocked on the bail. (Correct fit can be seen along seam between gooseneck and bearing housing).
9. Locate grease fitting and pump housing with quality grade bearing grease. A bit of grease will ooze from top housing seal. If any grease squeezes out bottom seal, the seal has been placed in backwards. Please note drawing for correct placement.
10. Check swivel for rotation. Swivel should rotate by hand; if it is too tight, bleed off grease from grease fitting using a nail or other pointed instrument.



UNSPECIFIED TOLERANCES	
MACHINING	$\pm .005$
FABRICATION	$\pm .01$
MACH. FINISH	125
MACHINING CONVENTIONS: DIMS PER ALL DIMENSIONS IN INCHES UNLESS OTHERWISE SPECIFIED	



PART:	1J & 2J SWIVEL	DATE:	6-7-54
MATERIAL:		DRWN.:	WEK
REVISIONS:		APPR.:	FRB
A: ECN #265	7/12/96	SCALE:	.95
B:		PIWS. NO.	M-408
D:			

