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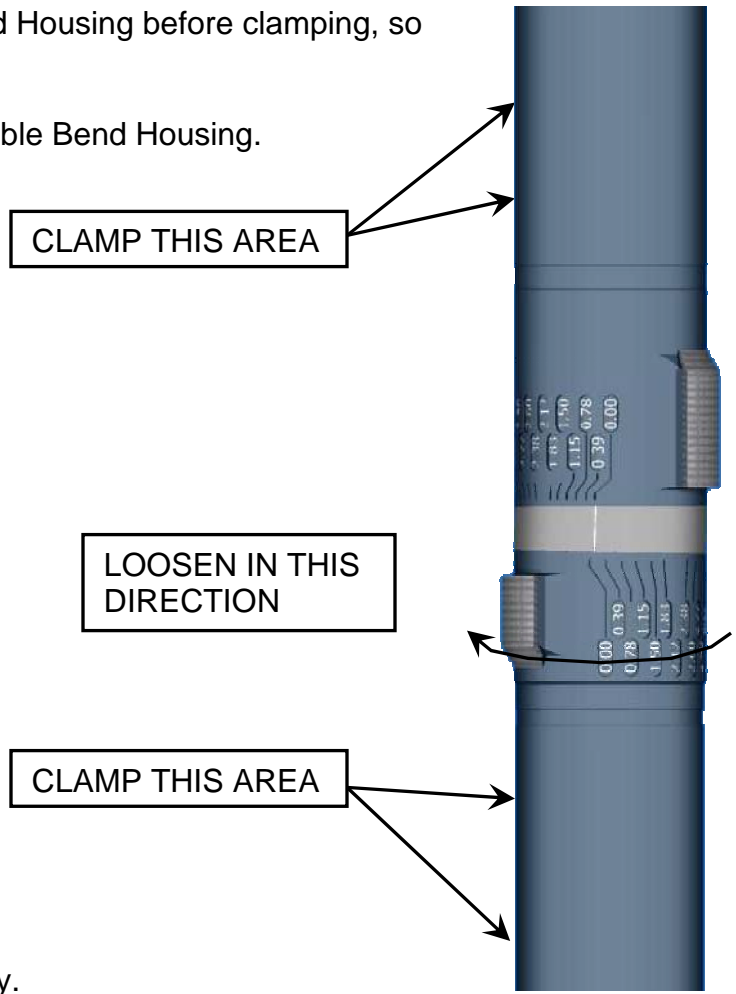
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ABH Model B has angle markings on both the housings
 ABH Model A has angle markings on the upper housing and the adjustment ring.

1. Preparations for Adjustment of ABH

Clean exterior of Adjustable Bend Housing before clamping, so markings are clearly visible.

Clamp indicated areas of Adjustable Bend Housing.



Note: Blank ABH shown for clarity.

Figure 1: Adjustable bend housing set at a bend of 0 degrees.

2. Directions to Adjust ABH Angle

1. Rotate Lower Adjustable Bend Housing and Bearing Section 3 - 4 full rotations. The Shoulder will be separated by 0.75 to 1.00 inch. See Figure 2A

NOTE: THIS IS A RIGHT HAND THREAD



FIG 2A



FIG 2B

Figure 2: A) Lower housing separated from spacer ring, initial setting of 0 degrees. B) Spacer ring separated from lower housing, ready for adjustment to new setting.

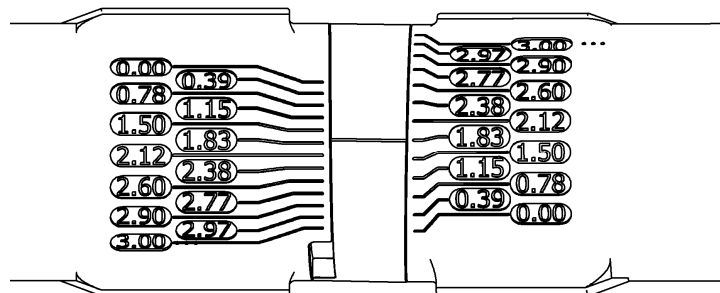
2. Lift Spacer/Adjustment Ring up towards upper Adjustable Bend Housing. As seen in Figure 2B
3. Clean all mud and dirt off Lower Housing to Spacer shoulder area including o-ring, if visible.

4. Coat the area from the Spacer Ring to Lower Housing shoulder with thread anti-seize compound. See Figure 3
5. Rotate Spacer ring until the scribe line on the Spacer ring aligns with the scribe line for the desired angle, on the Lower Housing. See Table 1 for possible settings



Figure 3: A) Spacer ring ready for engagement at 3 degrees. B) Spacer ring engaged at 3 degrees

6. Lower the Spacer ring towards the Lower Housing, engaging internal spline.
7. Coat the area between Spacer Ring and the Lower Housing Shoulder with thread anti-seize compound. See Figure 3B.
8. Tighten ABH until angle setting adjustment marks are aligned.



3. Settings of Adjustable Bend Housing

| 3 DEGREE |
|-----------------|
| 0.00 |
| 0.39 |
| 0.78 |
| 1.15 |
| 1.50 |
| 1.83 |
| 2.12 |
| 2.38 |
| 2.60 |
| 2.77 |
| 2.90 |
| 2.97 |
| 3.00 |

Table 1: ABH settings

4. Make-up Torques

| MOTOR SIZE | MAKE-UP TORQUE RANGE (FT-LBS) | MAKE-UP TORQUE RANGE (Nm) |
|-------------------|--------------------------------------|----------------------------------|
| 313 | 3,400 – 4,200 | 4,600 – 5,700 |
| 475 | 7,000 – 13,000 | 9,500 – 17,700 |
| 625 | 21,000 – 26,000 | 28,000 – 35,000 |
| 675 | 25,500 – 33,000 | 34,600 – 44,800 |
| 800 | 40,000 – 52,000 | 54,000 – 70,000 |
| 962 | 56,000 – 69,000 | 76,000 – 93,000 |

Table 2: ABH make-up torques