

Torque Chart

Motor support/bonnet to main body	1100 ft lb
Main body to motor support/bonnet	1100 ft lb
Bull gear to hub	580 ft lb
Lower gearcase to main body	250 ft lb
Rotating head to lower gearcase	250 ft lb
Brake adapter ring to motor	250 ft lb
Brake to brake adapter plate	50 ft lb
Brake drum to hub	250 ft lb
Brake cover to brake	50 ft lb

Installing the TDS motor pinion



Installing a pinion gear can be dangerous to personnel installing it as well as anyone witnessing the procedure. Exercise caution at all times.

Use the following procedure to install a TDS motor pinion:

1. Clean the motor shaft by hand and cover with a thin layer of Engineer's Blue.
2. Firmly install the pinion on the motor shaft by hand. Mark reference lines on the pinion and the shaft to ensure identical angular orientation each time.
3. There must be a minimum of 75% surface contact between the pinion and motor shaft. Dress the motor shaft/pinion very lightly with a fine emery cloth and repeat the "bluing" procedure if necessary until there is at least 75% surface contact between the pinion and motor shaft.
4. After thoroughly cleaning all bluing, oil, and/or grease from the pinion bore and shaft, trial mount the cold pinion gear on the motor shaft, lining up the reference marks.

Varco Tds Manual

ML Yell



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