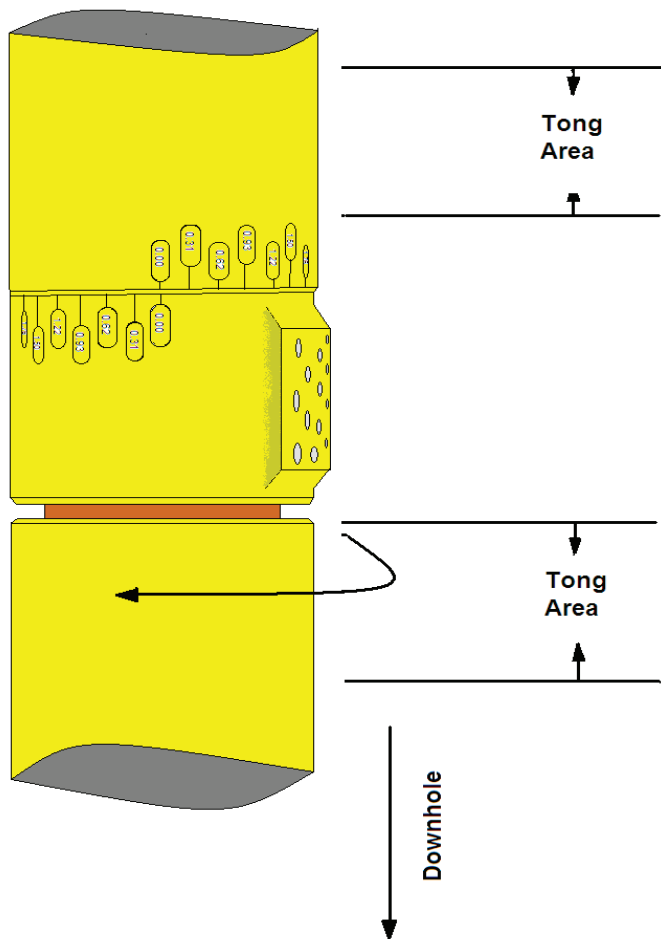


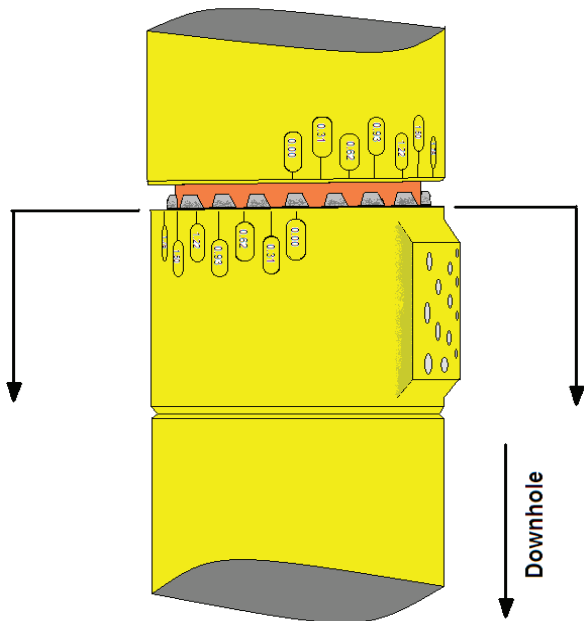
Setting the Adjustable Bend Housing (ABH)

Follow these steps to set the adjustable bend angle. The bend angle can be adjusted from 0 to 3 degrees on standard motors, with a 0 to 4 degree option available.

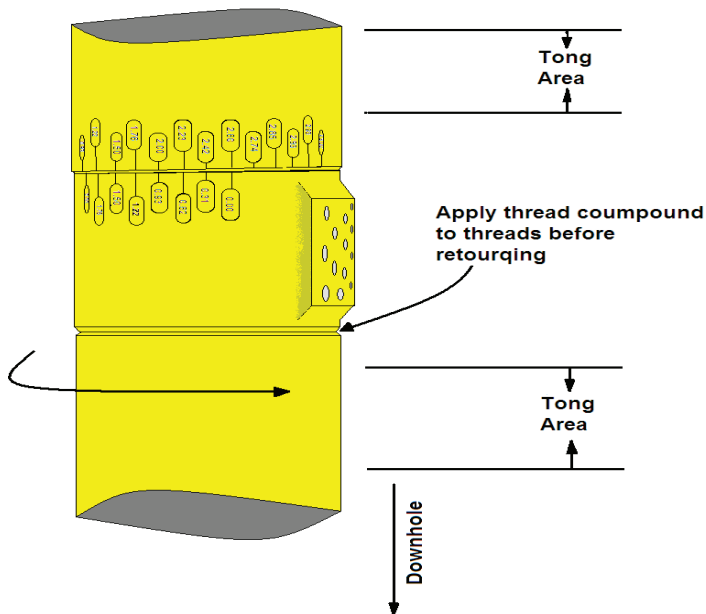
1. Place the tongs on the areas shown in the illustration, and break the tool joint.
2. Unscrew the lower housing in the direction shown in illustration.
3. While keeping the position sleeve engaged with the upper housing, unscrew the lower housing three to four complete turns, as shown in illustration



- Slide the position sleeve down to disengage it from the upper housing.
- While holding a back-up on the upper housing, turn the position sleeve clockwise until the desired angle marking on the position sleeve is lined up with the same mark on the upper housing.



- Engage the teeth of the position sleeve and the upper housing at the desired bend angle.
- Screw the lower housing until it is shouldered to the position sleeve. Use the Torque Guide table below. The matching markings on the upper housing and the position sleeve indicate the desired bend angle and the high side of the tool.



Adjustable Torque Guide Table

Motor Size	Torque Amount (English)	Torque Amount (Metric)
1-11/16 (170)	Fixed Only	Fixed Only
2-1/8 (213)	Fixed Only	Fixed Only
2-7/8 (287)	2,200 lbs-ft	3,000 N-m
3-1/8 (313)	2,700 lbs-ft	3,600 N-m
3-1/2 (350)	3,800 lbs-ft	5,100 N-m
3-3/4 (375)	4,600 lbs-ft	6,300 N-m
4-3/4 (475)	9,500 lbs-ft	12,700 N-m
6-1/2 (650)	23,000 lbs-ft	31,000 N-m
6-3/4 (675)	27,000 lbs-ft	37,000 N-m
7-3/4 (775)	29,000 lbs-ft	39,000 N-m
8-1/2 (850)	38,000 lbs-ft	51,000 N-m
9-5/8 (962)	61,000 lbs-ft	83,000 N-m
11-1/4 (1125)	100,000 lbs-ft	135,600 N-m