

NOTES: UNLESS OTHERWISE SPECIFIED
 1. CRITICAL LOAD PATH, LOW TEMP ITEM. MAINTAIN TRACEABILITY PER ID00100.

2. USE "ANTI-SIEZE" ON BOLTS & CROSS-TORQUE PER DS00008.

3. SHRINK FIT ITEMS 28 AND 29 INTO ITEM 1.

4. GREASE AFTER ASSEMBLY.

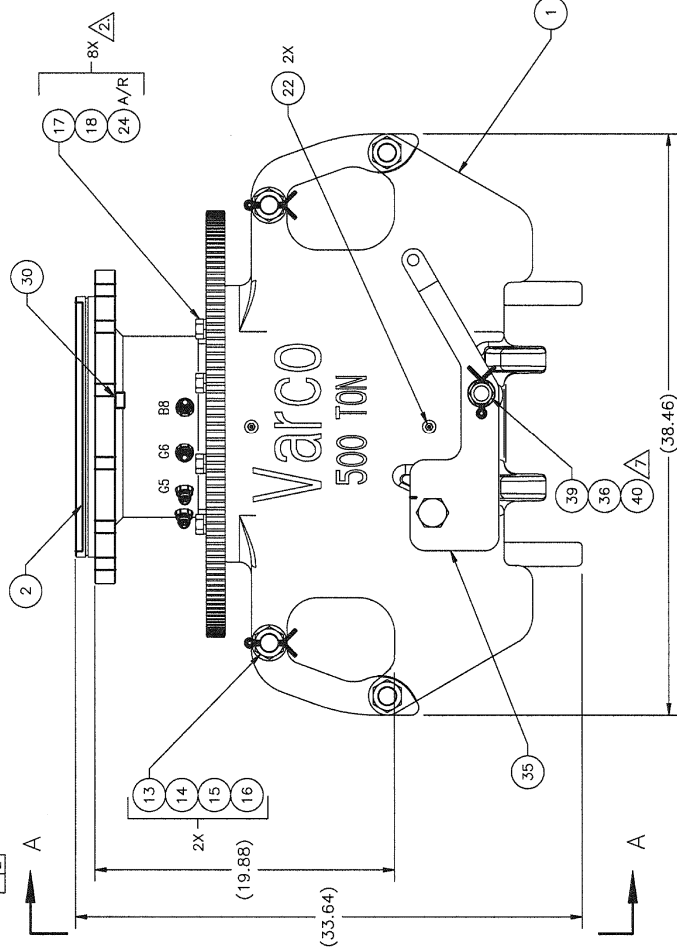
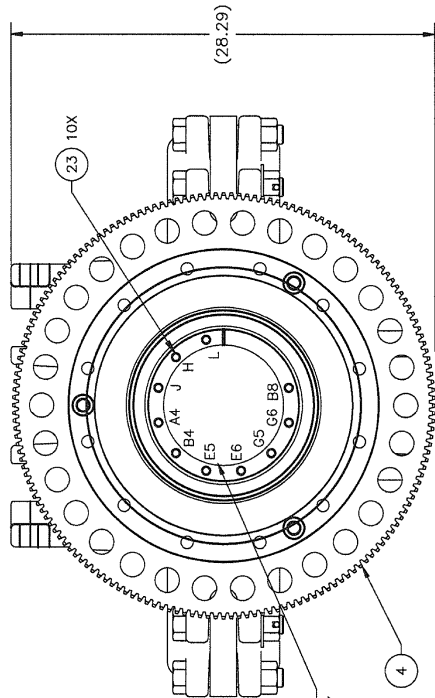
5. PRESSURE TEST ALL PORTS PER TS00465.

6. INSTALL ITEM 32, USE LOCKING COMPOUND (ITEM 34), MATCH DRILL USING $\phi 1.87$ x 1.0 DP. PRESS FIT SPIRAL PIN (ITEM 33) INTO ITEM 1 AND 32.

7. INSTALL ITEM 39, TORQUE TO 20-22 ft-lbs, MATCH DRILL USING $\phi .250$. INSTALL COTTER PIN (ITEM 40).

8. DO NOT INTERCHANGE ITEM 46 (RELIEF VALVE) AND ITEM 22 (GREASE FITTING).

PORT CALLOUTS ARE FOR REFERENCE ONLY



QTY	REQD	PART NO.	DESCRIPTION	MATERIAL	ITEM NO.
1		53250-5	RELIEF VALVE		46
1		53405	CAP		45
7		53406	CAP		44
2		56519-8-6-S	ELBOW, O-RING BOSS/37		43
1		56529-8-4-S	CONNECTOR, O-RING BOSS/37		42
5		56529-8-6-S	CONNECTOR, O-RING BOSS/37		41
1		51437-20-S	PIN, COTTER		40
1		50516-C	NUT, HEX-SLOTTED		39
1		50320-C	NUT, HEX-JAM		38
1		50020-24-C5D	SCREW, CAP-HEX HD		37
1		112754-116	BUSHING, FLANGED		36
1		119124	STOP		35
A/R		53200-271	LOCKING, COMPOUND (RED)		34
1		51222-05-12	PIN, SPIRAL		33
1		124029	SHAFT, PIVOT-LOCKING PIN		32
1		119359	RETAINER, OIL SEAL		31
1		53002-12-C	PLUG, PIPE, SQ. HEAD		30
2		112754-130	BEARING, FLANGED		29
2		115176	BUSHING		28
7		56531-8-S	PLUG, O-RING BOSS		27
7		53408	CAP	(NOT SHOWN)	26
7		56529-8-8-S	CONNECTOR, O-RING BOSS/37		25
A/R		Z6001	LOCKWIPE, $\phi .051$		24
10		53000-4-C	PLUG, PIPE, C'SUNK HEX		23
2		53201	FITTING, GREASE		22
2		119358	BUSHING, TURCITE		21
1		30117775	RETAINER RING		20
1		119547	SEAL, WIPER		19
8		50912-C	WASHER, LOCK		18
8		50012-20-C5D	SCREW, HEX. HD		17
2		51405-24	PIN, COTTER		16
2		50820-R-C	WASHER, FLAT		15
2		50520-C	NUT, HEX-SLOTTED		14
2		114594	BOLT, CATCH LINK		13
1		77039	SEAL		12
10		116375	GLYD RING ROTARY 10.000 ROD		11
1		30119143	GLYD RING ROTARY 11.500 ROD		10
1		117826	PISTON RING		9
1		30119357	RING, THRUST		8
1		30119319	GLYD RING ROTARY 11.000 ROD		7
1		51300-361-B	O-RING		6
1		51300-273-B	O-RING		5
1		117829	GEAR, ROTATING LINK ADAPTER		4
2		51216-12	DOWEL $\phi 1.0$ X 1.50		3
1		117833-500	STEM		2
1		121340	ROTATING LINK ADAPTER 500 TON		1

LIST OF MATERIALS

VARCO SYSTEMS

ROTATING LINK ADAPTER ASSEMBLY, 500 TON

DATE: 02/05/2004

REV: 1

APPROVED BY: [Signature]

DESIGNED BY: [Signature]

CHECKED BY: [Signature]

PREPARED BY: [Signature]

DATE: 02/05/07

SCALE: 1/4

REV: 1

ITEM NO. 1

ITEM NO. 2

ITEM NO. 3

ITEM NO. 4

ITEM NO. 5

ITEM NO. 6

ITEM NO. 7

ITEM NO. 8

ITEM NO. 9

ITEM NO. 10

ITEM NO. 11

ITEM NO. 12

ITEM NO. 13

ITEM NO. 14

ITEM NO. 15

ITEM NO. 16

ITEM NO. 17

ITEM NO. 18

ITEM NO. 19

ITEM NO. 20

ITEM NO. 21

ITEM NO. 22

ITEM NO. 23

ITEM NO. 24

ITEM NO. 25

ITEM NO. 26

ITEM NO. 27

ITEM NO. 28

ITEM NO. 29

ITEM NO. 30

ITEM NO. 31

ITEM NO. 32

ITEM NO. 33

ITEM NO. 34

ITEM NO. 35

ITEM NO. 36

ITEM NO. 37

ITEM NO. 38

ITEM NO. 39

ITEM NO. 40

ITEM NO. 41

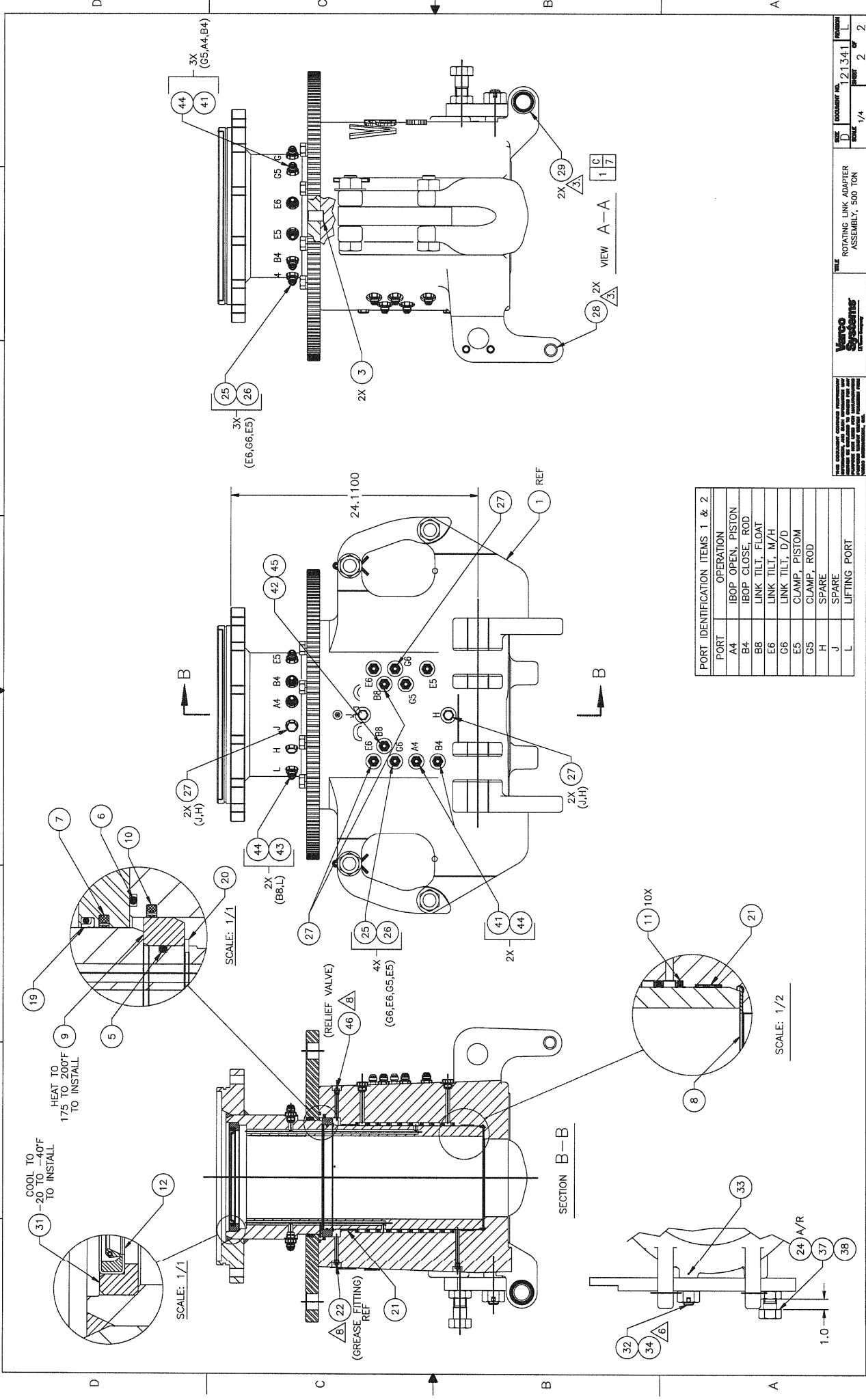
ITEM NO. 42

ITEM NO. 43

ITEM NO. 44

ITEM NO. 45

ITEM NO. 46



PORT	OPERATION
A4	IBOP OPEN, PISTON
B4	IBOP CLOSE, ROD
B8	LINK TILT, FLOAT
G6	LINK TILT, M/H
E5	LINK TILT, D/D
E5	CLAMP, PISTON
G5	CLAMP, ROD
H	SPARE
J	SPARE
L	LIFTING PORT

WATCO
WATSON
WATSON

REVISIONS

REV	DESCRIPTION	DATE
D	121341	12/03/2002
C	17	11/13/07A
B	1/4	11/13/07A
A	2	11/13/07A

UNCONTROLLED - 12/03/2002 1111337A

Doc#0022 (REV B)