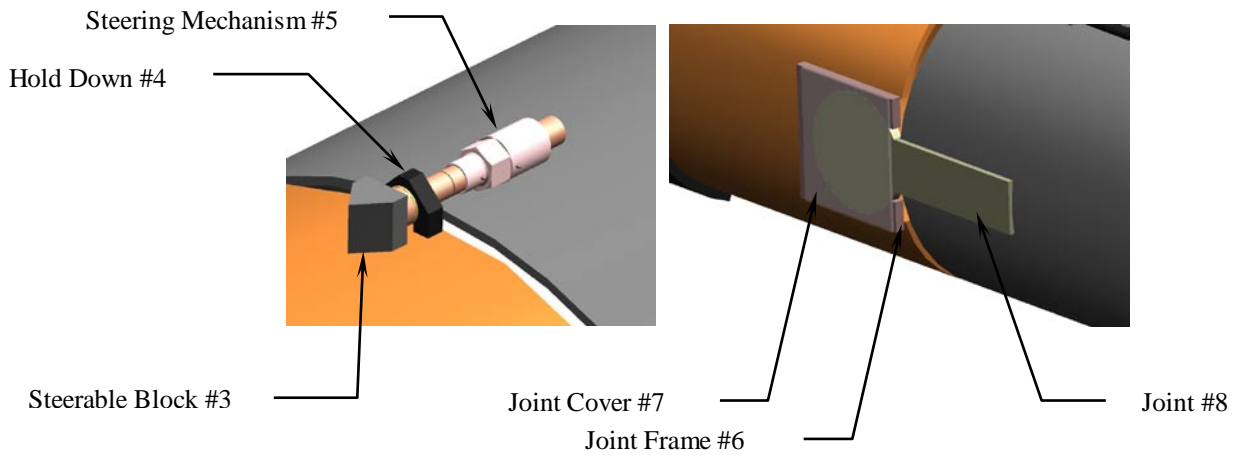
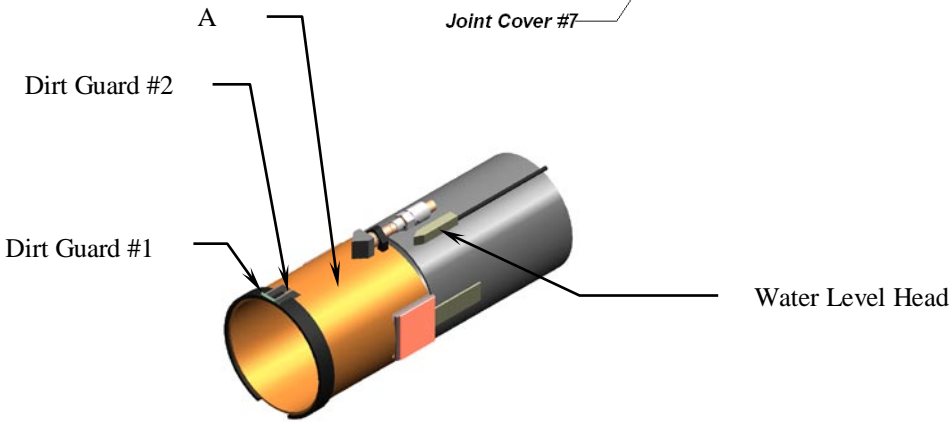
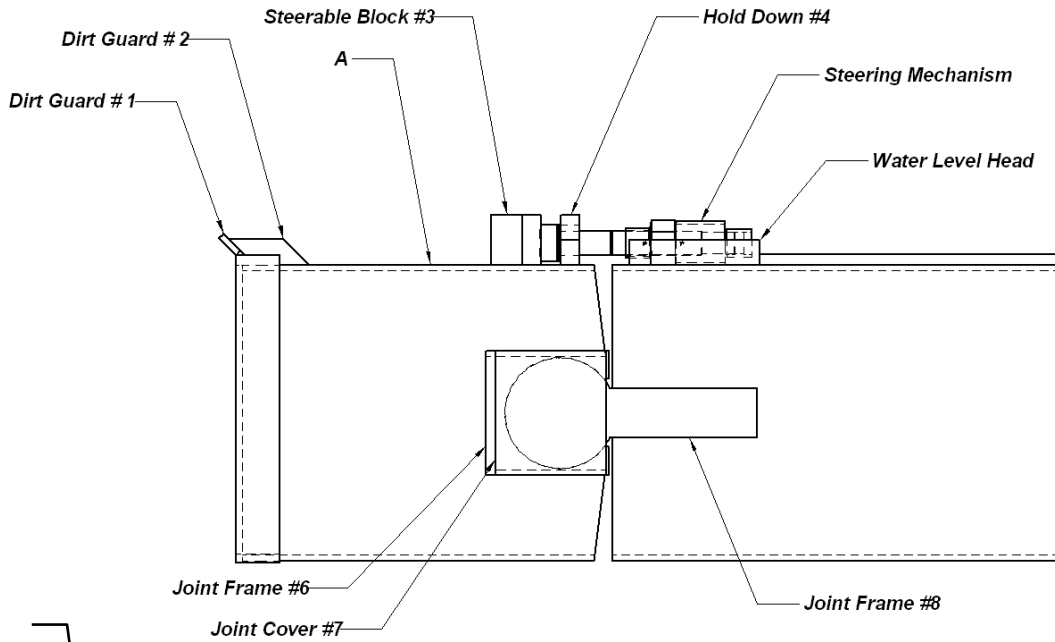


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### Instructions For Mounting Steerable Casing Compnents



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### ***Instructions For Mounting Steerable Casing Compnets***

1. Cut a pieces of casing (see below) long Part A. this piece must meet with part B at the 3 and 9 o'clock positions having a  $\frac{3}{4}$ " gap at the fit in the 12 and 6 o'clock positions. Next, torch out A and B so that 6 & 8 will fit in the casing and then weld flush with the inside of the casing. Weld both on inside and outside however, do not weld 6 & 8 together. Take part 7 and weld over part 6.
2. With casing straight and the adjusting unit in the center of adjustment position weld parts 4 & 5 on both sides on top center of casing. 4 should be welded to A. 5 should be welded to B. Part 3 should be welded to A  $\frac{1}{32}$ " in front of adjusting unit.
3. **To make the friction ring.** Cut a 3" wide section from casing. Cut out 8" from the ring. Open section should go on bottom of casing. Weld solid on inside of ring and then skip weld on outside of ring. Mount parts 1 & 2 on top center of friction ring.

Note :

Torch a  $\frac{3}{4}$ " diameter hole through wall of casing and position the hole in the water level head over the hole in the casing and weld water level head to casing next to part 5 of the adjusting unit.

1. Dirt Guard
2. Dirt Guard
3. Steering Block
4. Hold Down
5. Adjusting Unit
6. Joint Frame
7. Joint Cover
8. Joint

#### Part "A" Length Dimensions

22" Lg. For 24" Casing	20" Lg. For 20" Casing
26" Lg. For 30" Casing	18" Lg. For 18" Casing
32" Lg. For 36" Casing	16" Lg. For 16" Casing
36" Lg. For 42" Casing	14" Lg. For 14" Casing
42" Lg. For 48" Casing	12" Lg. For 12" Casing
46" Lg. For 54" Casing	