



CANRIG DRILLING TECHNOLOGY LTD

PRODUCT BULLETIN NUMBER: 07

DATE: May 17, 1993

SUBJECT: Air Duct Connection Clamp

SERIAL NUMBERS: 002, 003, 004, 006, 007, 008

DISCUSSION:

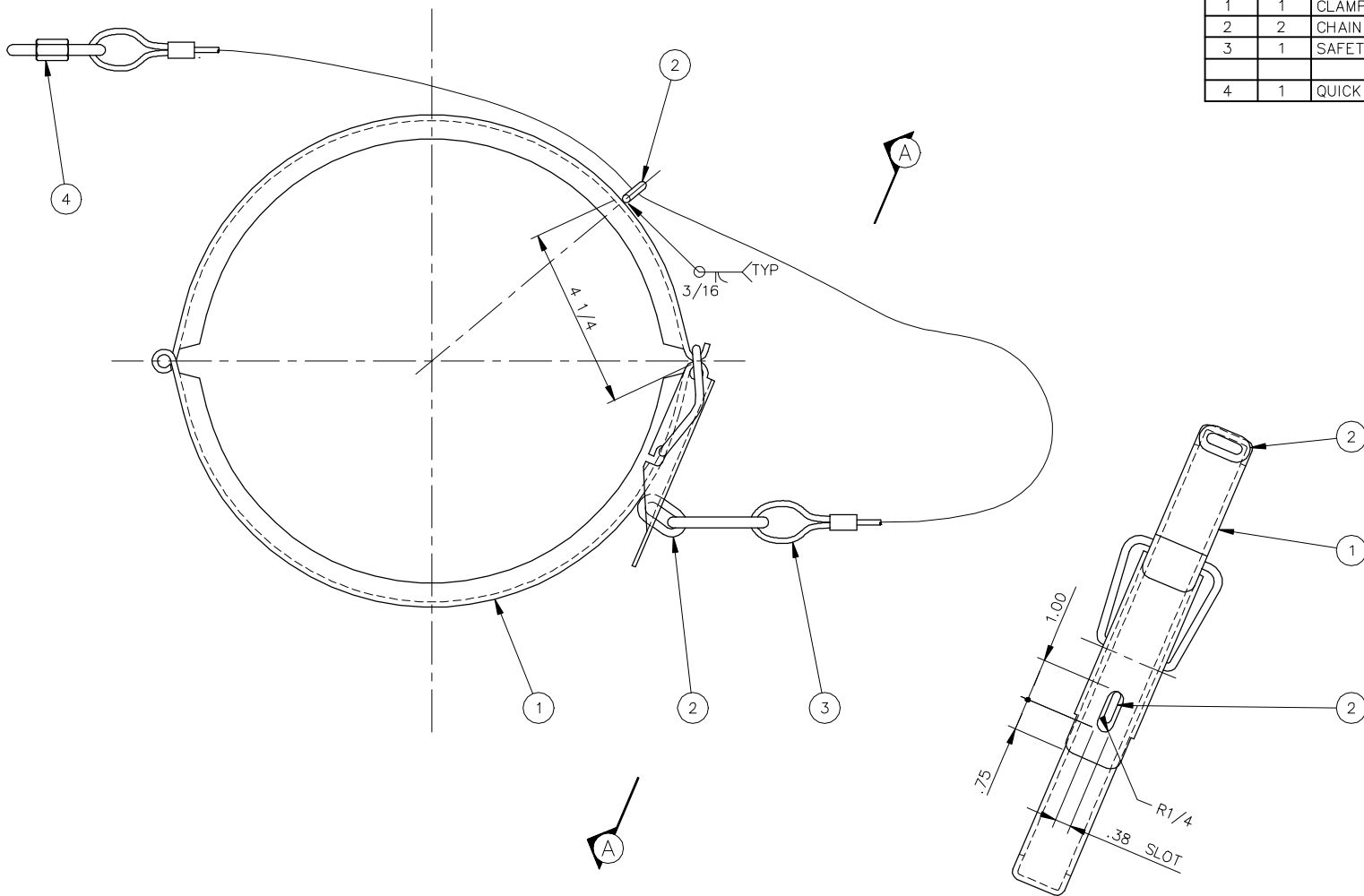
1. The air duct quick connect clamp rings have normally been safety wired to prevent inadvertent opening and falling. A new safety cable arrangement has been developed for improved retention to the clamp- See attached Assembly No.C-3-787-15-0 or C-3-696-16-0. New clamp and safety cables are being shipped to each of the subject units.
2. While awaiting delivery of the new style clamp, please ensure that the quick connect clamp on the air duct is safety wired.
3. A safety cable should also be used to retain the air duct to the top drive unit. See attached Assembly Drawing No. C-2-787-01-3 or C-2-696-01-3.
4. **It is important that both the duct and clamp ring be retained for safety.**

INFORMATION :

For further information contact:

Field Operations Manager
Canrig Drilling Technology Ltd.
14703 FM 1488
Magnolia, Texas 77354
Phone: 281.259.8887
Fax: 281.259.8158

ITEM	QTY	DESCRIPTION
1	1	CLAMP 10" RINGLOCK RL/WHPRLC 1000
2	2	CHAIN LINK 3/16"
3	1	SAFETY RETAINING CABLE 1/8 DIA x 44 O.L. C/W FIREMAN' SNAP 2" x 1/4" DIA
4	1	QUICK LINK 1/4"

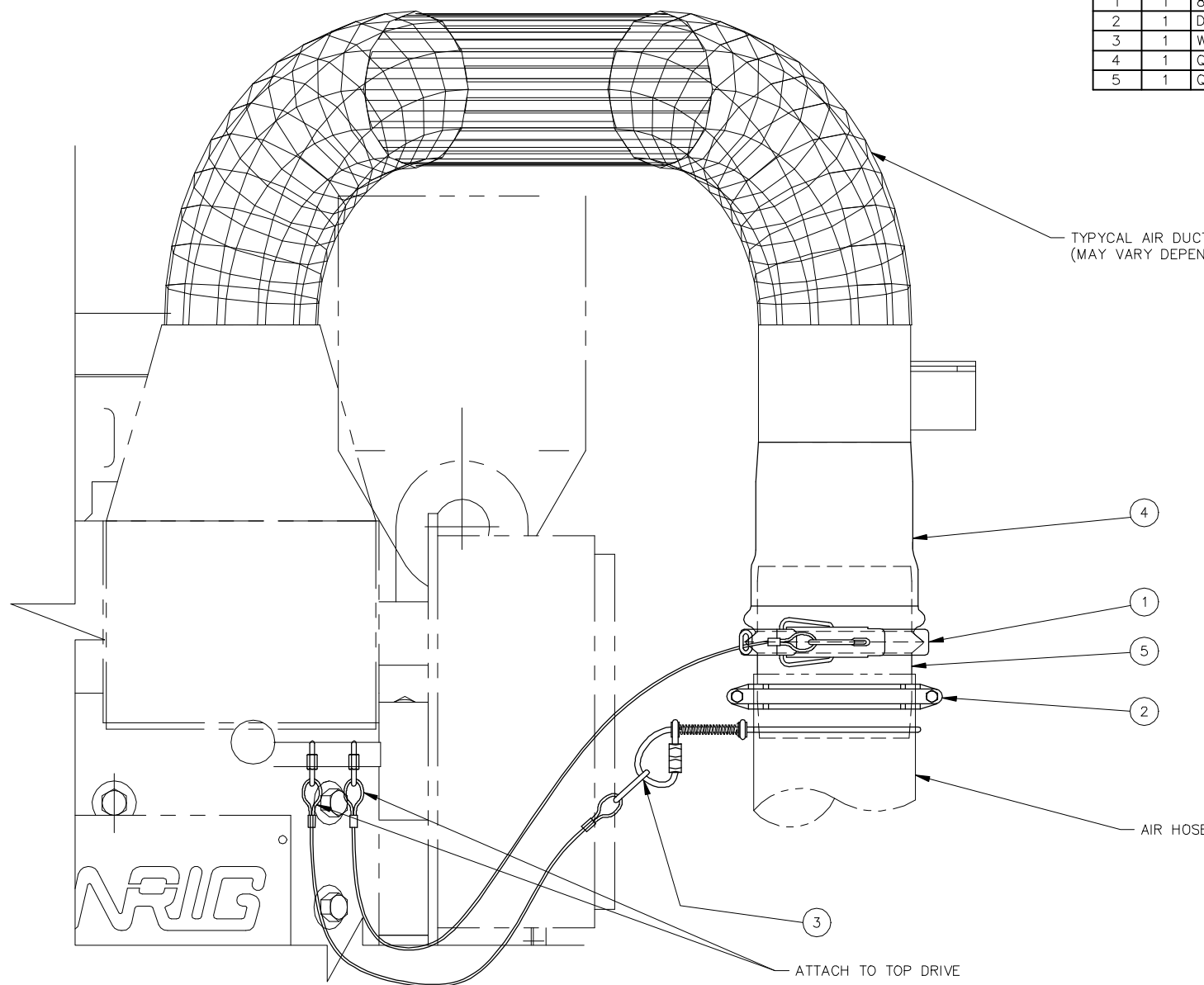


VIEW A-A
CLAMP ONLY FOR CLARITY

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TOLERANCE - UNLESS OTHERWISE SPECIFIED					DRAWN	SM	93/5/13	CANRIG DRILLING TECHNOLOGY LTD.			
REMOVE SHARP CORNERS AND BURRS					CHECKED				10" QUICK CONNECT CLAMP AIR DUCT		
CASTING ± 1/16					APPR'VD						
⊙ CONCENTRICITY ±.005 TIR — STRAIGHTNESS ±.005 IN 5 INCHES ⊥ SQUARENESS ±.010 IN 5 INCHES PARALLELISM ±.010 IN 5 INCHES ⊕ TRUE POSITION .005					MATERIAL	BY	Y/M/D				
No.	Y/M/D	BY	REVISION	REFERENCE DWGS				EST. WEIGHT	SCALE	PROJECT	C-3-696-16-0 REV

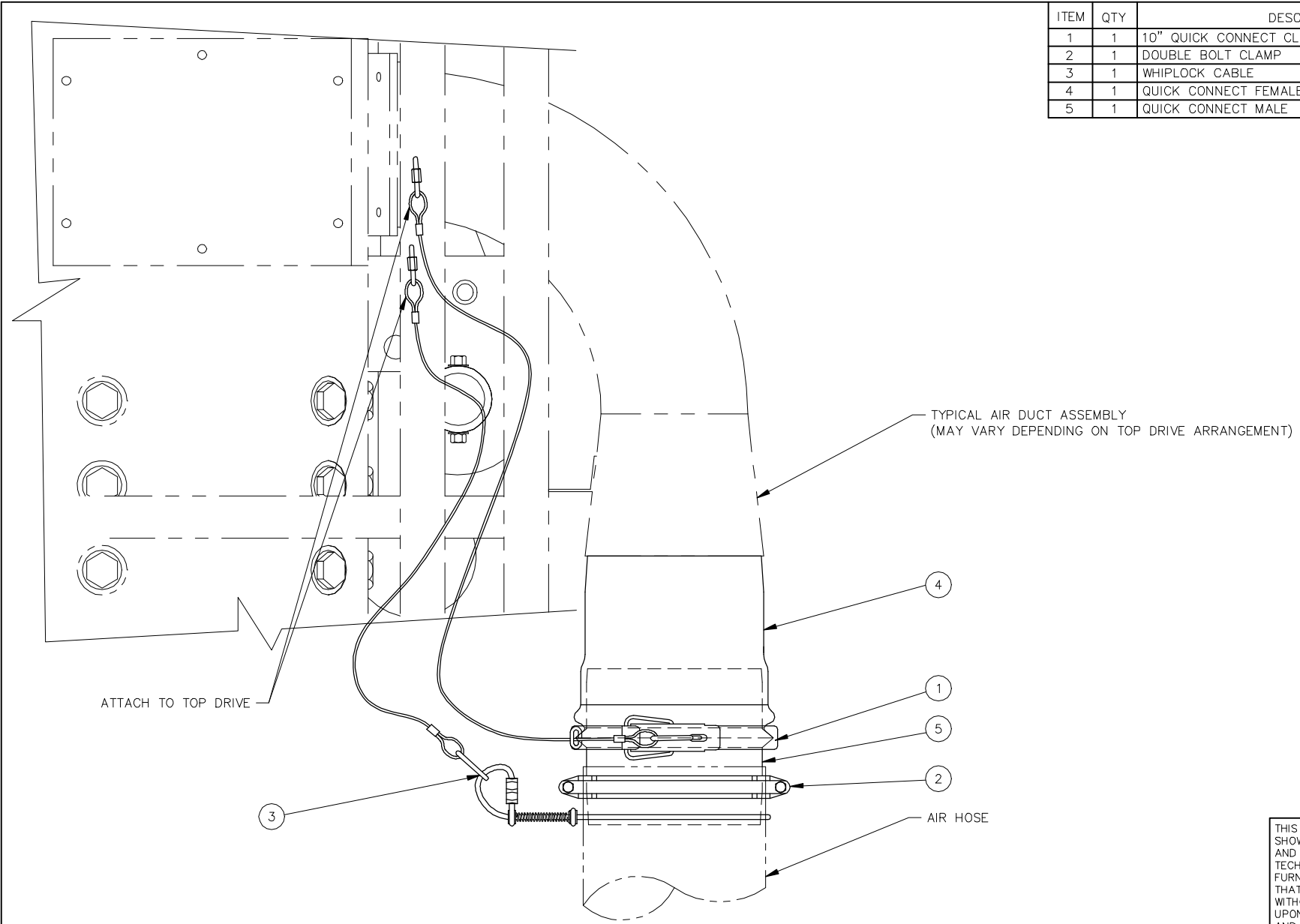
ITEM	QTY	DESCRIPTION
1	1	8" QUICK CONNECT CLAMP DWG #C-3-787-15-0
2	1	DOUBLE BOLT CLAMP PARKER 750-M-875
3	1	WHIPLOCK CABLE DWG #C-3-787-16-0
4	1	QUICK CONNECT FEMALE RL/SRL-F800
5	1	QUICK CONNECT MALE RL/SRL-M800




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TOLERANCE - UNLESS OTHERWISE SPECIFIED					DRAWN	D.P.	93/05/19	CANRIG DRILLING TECHNOLOGY LTD.	
REMOVE SHARP CORNERS AND BURRS					CHECKED				QUICK CONNECT ASSEMBLY 8" AIR DUCT
CASTING ± 1/16					APPRVD				
○ CONCENTRICITY ±.005 TIR — STRAIGHTNESS ±.005 IN 5 INCHES ⊥ SQUARENESS ±.010 IN 5 INCHES ∥ PARALLELISM ±.010 IN 5 INCHES ⊕ TRUE POSITION .005					MATERIAL	BY	Y/M/D		
No.	Y/M/D	BY	REVISION	REFERENCE DWGS	EST. WEIGHT		SCALE	PROJECT	
							1:4	C-2-787-01-3 REV	

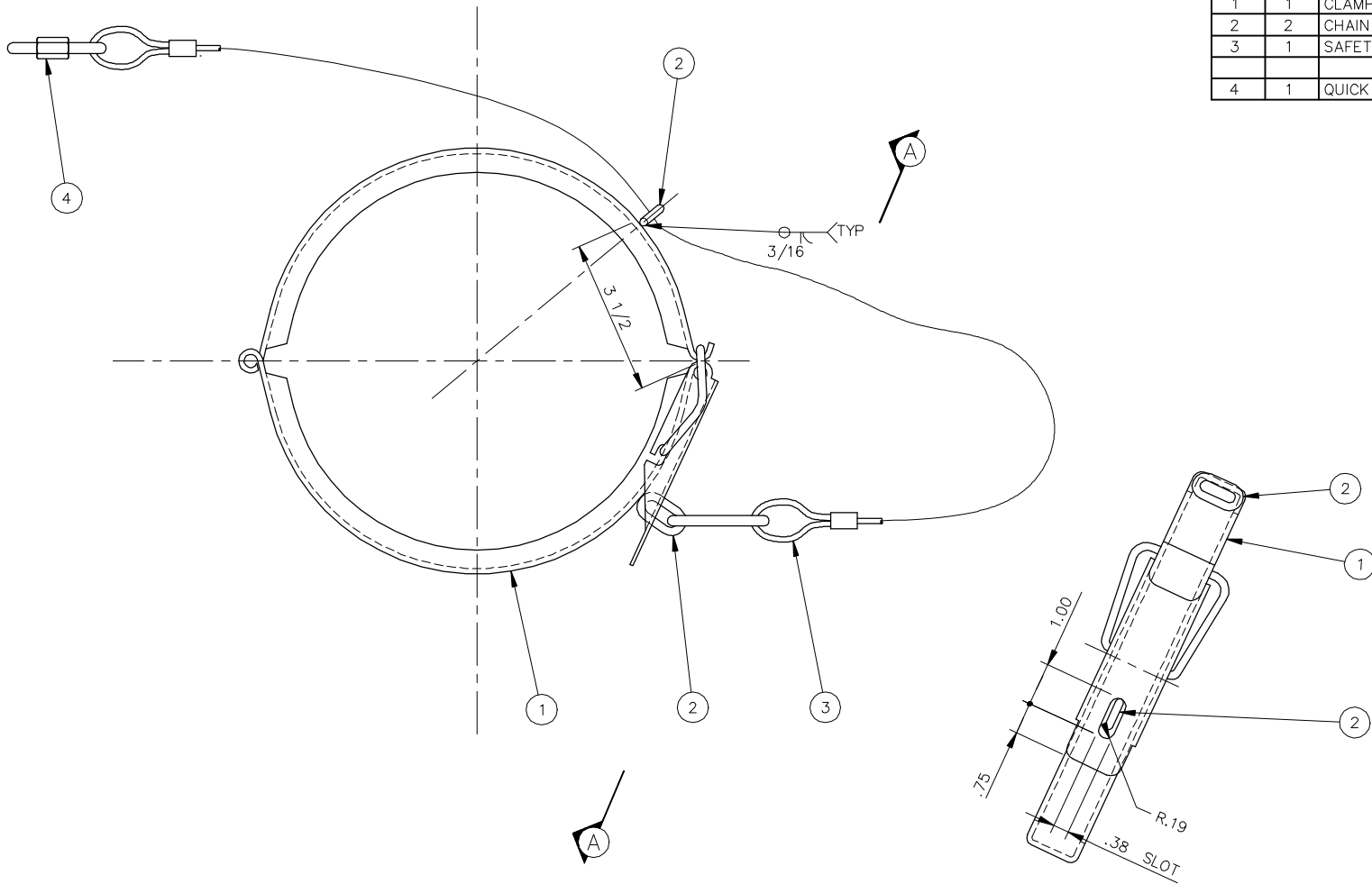
ITEM	QTY	DESCRIPTION
1	1	10" QUICK CONNECT CLAMP DWG #C-3-696-16-0
2	1	DOUBLE BOLT CLAMP PARKER 750-M-1125
3	1	WHIPLOCK CABLE DWG #C-3-696-17-0
4	1	QUICK CONNECT FEMALE RL/SRL-F1000
5	1	QUICK CONNECT MALE RL/SRL-M1000



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TOLERANCE - UNLESS OTHERWISE SPECIFIED					DRAWN	D.P.	93/05/18	 CANRIG DRILLING TECHNOLOGY LTD.	
REMOVE SHARP CORNERS AND BURRS					CHECKED				QUICK CONNECT ASSEMBLY 10" AIR DUCT
CASTING ± 1/16 ⊙ CONCENTRICITY .005 TIR - STRAIGHTNESS ±.005 IN 5 INCHES ⊥ SQUARENESS ±.010 IN 5 INCHES PARALLELISM ±.010 IN 5 INCHES ⊕ TRUE POSITION .005 MACHINED SURFACES 125 ✓					APPR'VD				
No.	Y/M/D	BY	REVISION	REFERENCE DWGS	FRACTIONAL MACHINING 0 TO 24 ± 1/16 FRACTIONAL ± 1/32 > 24 ± 1/8 DECIMAL .x ± .030 DECIMAL .xx ± .015 0 TO 24 ± .06 .xxx ± .005 > 24 ± .12 ANGULAR ± 1' ANGULAR ± 2'		MATERIAL	BY	Y/M/D

ITEM	QTY	DESCRIPTION
1	1	CLAMP 10" RINGLOCK RL/WHPRLC 800
2	2	CHAIN LINK 3/16"
3	1	SAFETY RETAINING CABLE 1/4 DIA x 44 O.L. C/W FIREMAN'S SNAP 2" x 1/4" DIA
4	1	QUICK LINK 1/4"



VIEW A-A
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					TOLERANCE - UNLESS OTHERWISE SPECIFIED				DRAWN	SM	93/5/13	CANRIG CANRIG DRILLING TECHNOLOGY LTD.
					REMOVE SHARP CORNERS AND BURRS				CHECKED			
					CASTING ± 1/16				APPRVD			
No.	Y/M/D	BY	REVISION	REFERENCE DWGS	CONCENTRICITY	FRACTIONAL	FRACTIONAL	DECIMAL	MATERIAL	BY	Y/M/D	8" QUICK CONNECT CLAMP AIR DUCT
					STRAIGHTNESS	0 TO 24	0 TO 24	.x	PLATE 3/16 M.S.			
					SQUARENESS	> 24	> 24	.xx	SCALE			PROJECT
					PARALLELISM	0 TO 24	0 TO 24	.xxx	1:2			
					TRUE POSITION	> 24	> 24	.005				
					MACHINED SURFACES	ANGULAR	ANGULAR	± 1'				

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