
DATE: 23-Aug-05

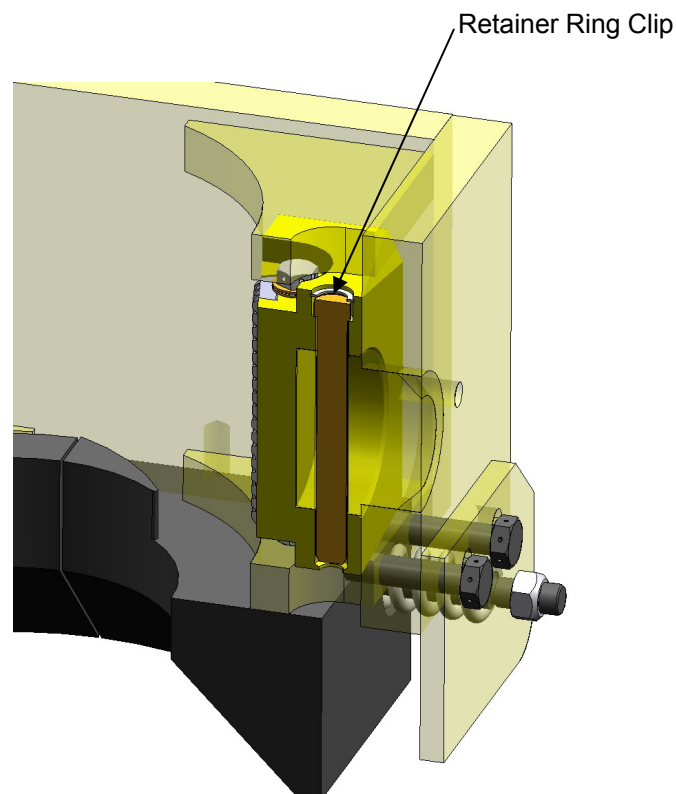
SUBJECT: Top Drive Backup Wrench Pin Retention

SERIAL NUMBERS: All

DISCUSSION: It has been reported that inserting and removing the clip ring that retains the pin holding the die block in place is a difficult task, especially when the proper tools are not available. CANRIG has created an upgrade kit that resolves this issue.

RECOMMENDATION:

- A. Inspect the Gripper Die Blocks as follows to ensure the pin is properly retained.
 - 1. Pin Retention uses a clip on the retainer to hold the pin in place. Ensure that the pin is installed the Die Block.
 - 2. Install the clip on the retainer pin.

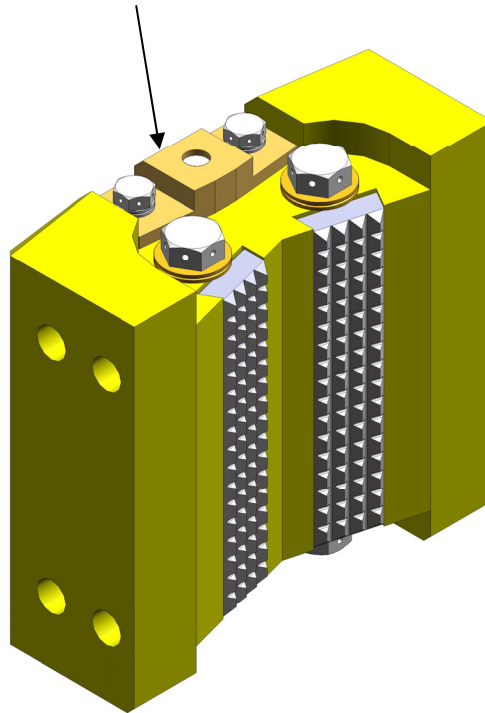


- B.** To make the retention of the Die Block more user friendly, CANRIG designed new Die Blocks and Die Block Retrofit Retainer Kits (AY12954 & AY12955). The new design Die Blocks include parts that are easier to handle and install. The new Die Blocks can be used on all BUW, but Top Drives presently in the field, will need the retrofit kit (DT14656) as well.

1. The new design for Pin Retention to be used on all new Back-up Wrench Die Blocks uses a retainer

plate to hold the pin in place.

(New Retainer Plate DT14335)



Old Die Block	Size	New Die Block
DT13716	5.75-9.00 DIA	DT14330
DT13717	3.75-7.00 DIA	DT14331
DT13718	2.50-5.75 DIA	DT14332
DT13719	3.25-6.50 DIA	DT14333
DT13734	4.50-7.00 DIA	DT14590

2. The hole on top of the Retainer Plate is to verify that the retainer pin is installed.

C. Installation of new design Die Blocks in the field is performed as follows:

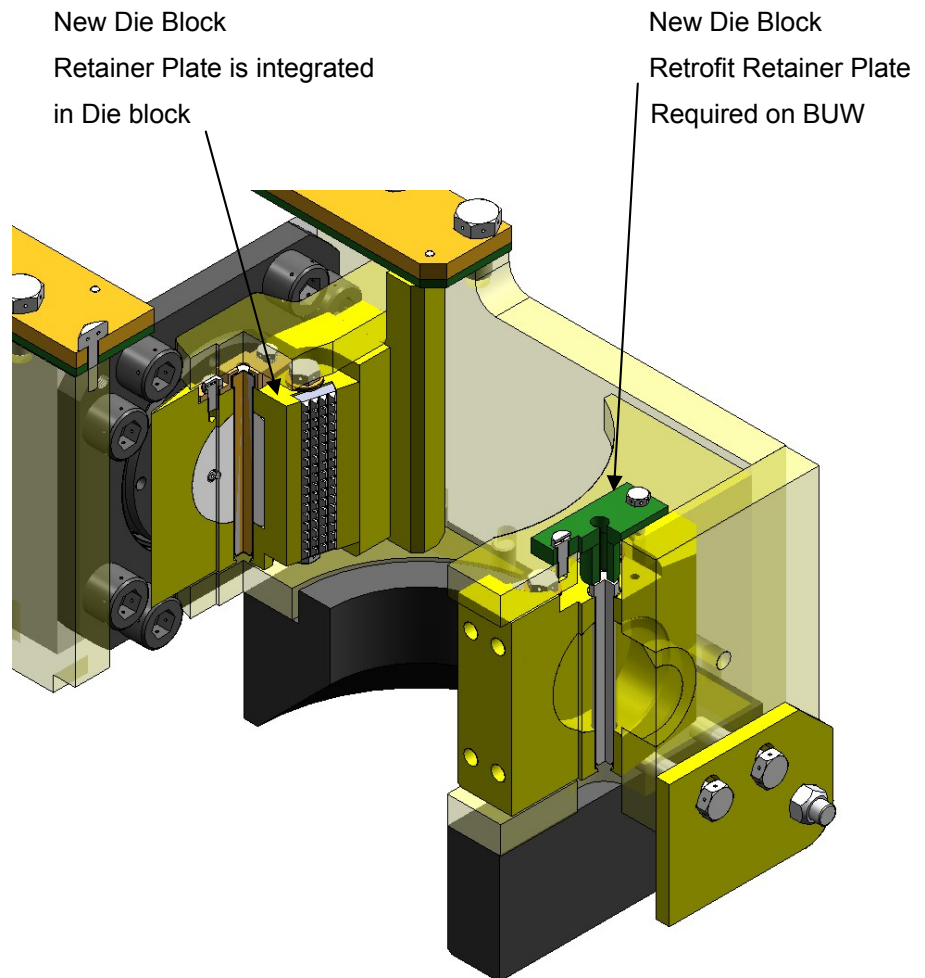
Stationary Die Block:

1. Modify the Back-up Wrench by drilling 2 tap holes on the location specified by Drawings AY12954 (see attached).
2. Insert the New Die Block Assy (AY12689).
3. Place the Die Block Retrofit Pin Retainer (P/N DT14656) on top of the Back-up Wrench aligning with the new tap holes.
4. Tighten, secure and wire the fasteners.

Moving Die Block:

1. Insert the New Die Block Assy (AY12689).
2. Install New Retainer Plate DT14335

NOTE: On the moveable side - no Retrofit Pin Retainer is required.



Proper operation of the Top Drive is the best way to prevent incidents of falling parts.

Should you have any questions or concerns, please do not hesitate to contact your CANRIG representative or the Field Operations Manager listed below.

INFORMATION:

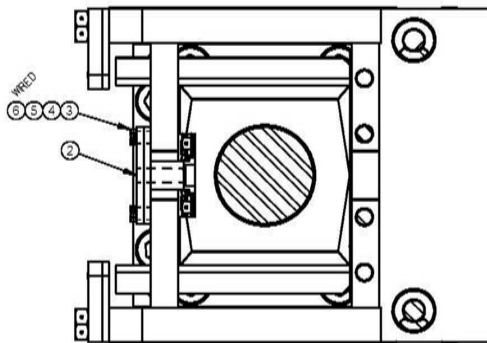
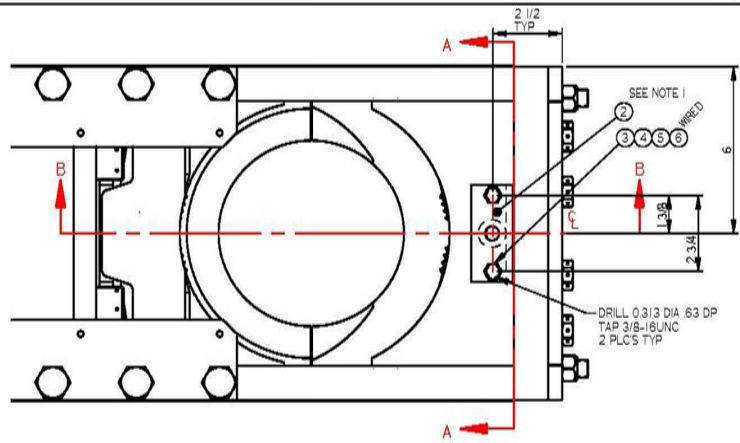
For further information contact:

Field Operations Manager
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14703 FM 1488
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Phone: 281.259.8887
Fax: 281.259.8158

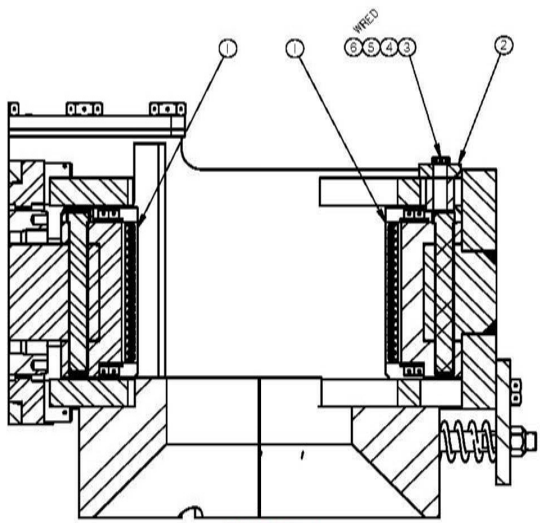
Attachment:

AY12954 (PDF)

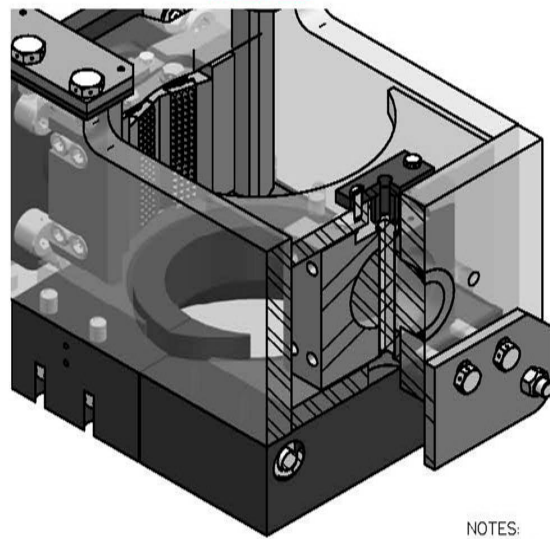
IF IN DOUBT...PLEASE ASK!



SECTION A-A



SECTION B-B



FRAME ASSY ISOMETRIC VIEW

NOTES:
1. ITEM 2 (RETROFIT PIN RETAINER) USED ON THIS SIDE DIE BLOCK ONLY.

				WELDING PROCEDURE AS PER CANRIG SPECIFICATION - ENG 704, UNLESS NOTED OTHERWISE				DRAWN	JSC	06/07/13
				TOLERANCES UNLESS OTHERWISE SPECIFIED				FABRICATING IMPERIAL	MACHINING IMPERIAL	
				RETROFIT SHARP CORNERS AND BURRS				3 TO 24"	± 1/16"	DECIMAL X ± 0.001
				CHAMFERS				1/16" ± 1/16"	± 1/16"	XX ± 0.010
				CONCENTRICITY				60° TO 120°	± 3/16"	XXX ± 0.050
				STRAIGHTNESS				120° TO 240°	± 1/16"	
				SQUARENESS				250° & OVER	± 1/2"	
				PARALLELISM				FABRICATING IMPERIAL		
				TRUE POSITION				5 TO 6 TO MM	± 1 mm	ANGULAR
				MACHINED SURFACES				6 TO 10 mm	± 0.1 mm	MACHINING
								11 TO 30 mm	± 0.2 mm	FABRICATION
								30 TO 100 mm	± 0.5 mm	
								100 TO 150 mm	± 1 mm	
								150 TO 250 mm	± 1.5 mm	
								250 TO 500 mm	± 2 mm	
								500 TO 1000 mm	± 3 mm	
								1000 TO 1500 mm	± 4 mm	
								1500 TO 2000 mm	± 5 mm	
								2000 TO 3000 mm	± 6 mm	
								3000 TO 4000 mm	± 7 mm	
								4000 TO 5000 mm	± 8 mm	
								5000 TO 6000 mm	± 9 mm	
								6000 TO 7000 mm	± 10 mm	
								7000 TO 8000 mm	± 11 mm	
								8000 TO 9000 mm	± 12 mm	
								9000 TO 10000 mm	± 13 mm	
								10000 TO 15000 mm	± 15 mm	
								15000 TO 20000 mm	± 18 mm	
								20000 TO 30000 mm	± 22 mm	
								30000 TO 40000 mm	± 27 mm	
								40000 TO 50000 mm	± 33 mm	
								50000 TO 60000 mm	± 40 mm	
								60000 TO 70000 mm	± 48 mm	
								70000 TO 80000 mm	± 57 mm	
								80000 TO 90000 mm	± 66 mm	
								90000 TO 100000 mm	± 76 mm	
								100000 TO 150000 mm	± 95 mm	
								150000 TO 200000 mm	± 115 mm	
								200000 TO 300000 mm	± 145 mm	
								300000 TO 400000 mm	± 180 mm	
								400000 TO 500000 mm	± 220 mm	
								500000 TO 600000 mm	± 270 mm	
								600000 TO 700000 mm	± 330 mm	
								700000 TO 800000 mm	± 400 mm	
								800000 TO 900000 mm	± 480 mm	
								900000 TO 1000000 mm	± 570 mm	
								1000000 TO 1500000 mm	± 710 mm	
								1500000 TO 2000000 mm	± 870 mm	
								2000000 TO 3000000 mm	± 1090 mm	
								3000000 TO 4000000 mm	± 1360 mm	
								4000000 TO 5000000 mm	± 1680 mm	
								5000000 TO 6000000 mm	± 2060 mm	
								6000000 TO 7000000 mm	± 2500 mm	
								7000000 TO 8000000 mm	± 3010 mm	
								8000000 TO 9000000 mm	± 3600 mm	
								9000000 TO 10000000 mm	± 4280 mm	
								10000000 TO 15000000 mm	± 5300 mm	
								15000000 TO 20000000 mm	± 6500 mm	
								20000000 TO 30000000 mm	± 8200 mm	
								30000000 TO 40000000 mm	± 10200 mm	
								40000000 TO 50000000 mm	± 12500 mm	
								50000000 TO 60000000 mm	± 15200 mm	
								60000000 TO 70000000 mm	± 18300 mm	
								70000000 TO 80000000 mm	± 21800 mm	
								80000000 TO 90000000 mm	± 26800 mm	
								90000000 TO 100000000 mm	± 32300 mm	
								100000000 TO 150000000 mm	± 39500 mm	
								150000000 TO 200000000 mm	± 48500 mm	
								200000000 TO 300000000 mm	± 61500 mm	
								300000000 TO 400000000 mm	± 76500 mm	
								400000000 TO 500000000 mm	± 94500 mm	
								500000000 TO 600000000 mm	± 116500 mm	
								600000000 TO 700000000 mm	± 142500 mm	
								700000000 TO 800000000 mm	± 173500 mm	
								800000000 TO 900000000 mm	± 209500 mm	
								900000000 TO 1000000000 mm	± 251500 mm	
								1000000000 TO 1500000000 mm	± 313500 mm	
								1500000000 TO 2000000000 mm	± 391500 mm	
								2000000000 TO 3000000000 mm	± 496500 mm	
								3000000000 TO 4000000000 mm	± 628500 mm	
								4000000000 TO 5000000000 mm	± 788500 mm	
								5000000000 TO 6000000000 mm	± 976500 mm	
								6000000000 TO 7000000000 mm	± 1192500 mm	
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								50000000000 TO 60000000000 mm	± 7682500 mm	
								60000000000 TO 70000000000 mm	± 9352500 mm	
								70000000000 TO 80000000000 mm	± 11252500 mm	
								80000000000 TO 90000000000 mm	± 13382500 mm	
								90000000000 TO 100000000000 mm	± 15742500 mm	
								100000000000 TO 150000000000 mm	± 19682500 mm	
								150000000000 TO 200000000000 mm	± 24982500 mm	
								200000000000 TO 300000000000 mm	± 31682500 mm	
								300000000000 TO 400000000000 mm	± 39882500 mm	
								400000000000 TO 500000000000 mm	± 49682500 mm	
								500000000000 TO 600000000000 mm	± 61082500 mm	
								600000000000 TO 700000000000 mm	± 74182500 mm	
								700000000000 TO 800000000000 mm	± 88982500 mm	
								800000000000 TO 900000000000 mm	± 105482500 mm	
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