

Safety Bulletin

SB No: SB016

Rev: A

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Description: External CDS Slip Recall



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BACKGROUND INFORMATION

The Tesco External Casing Drive System (ECDS) employs a three slip (die carrier) arrangement that is supported by the main external body. The original material selection criteria for these slips were based on strength and lubricity. Austempered Ductile Iron (ADI) was originally used in this application because it has the required properties. It has since been demonstrated that this material does not have the required ductility to react bending loads when the tool is accidentally closed on the casing coupling. Broken slips have resulted. The enveloping design of the external body in conjunction with a bolt on protector significantly reduces the risk of broken slip pieces escaping and falling. However, for new production the ADI material has been changed in favor of the more ductile AISI 4330. Testing has shown that the reduced lubricity of this new material will not gall when loaded on the external body. In addition, the likelihood of fracture when subjected to bending is greatly reduced.

AFFECTED COMPONENTS

Reference Part Number 15800 for a complete summary of the ECDS assembly. The ECDS is available in two casing size configurations, 4-1/2" to 7" and 7-5/8" to 8-3/4". Slips that were machined from the ADI material are identified with the part numbers show in the following table:

ECDS Tool	ADI Slip P/N
4-1/2" – 7"	15688
7-5/8" – 8-3/4"	17179

ACTION REQUIRED

1. Review all inventory of all ECDS slips and determine which have the part number **15688** or **17179**. **Affected CDS assemblies are not to be operated until defective parts are replaced.**
2. ADI slip part numbers listed above should be directly replaced with the following AISI 4330 slip components:

ECDS Tool	AISI 4330 Slip P/N
4-1/2" – 7"	15688-1
7-5/8" – 8-3/4"	17179-1

3. If at any time during operation it is suspected that any ECDS was accidentally closed on a casing coupling, remove, degrease and Magnetic Particle Inspect the following parts:

ECDS Tool	Slip P/N	Die P/N	Link P/N	Pin P/N
4-1/2" – 7"	15688 or 15688-1	Various	15693	15802
7-5/8" – 8-3/4"	17179 or 17179-1	Various	15693	15802

4. Document and report all indications and suspected damage to Tesco Engineering for disposition.

Please contact Tesco Corporation at the following email address on issues specific to this bulletin.

[Safety Technical Bulletins@TescoCorp.com](mailto:Safety_Technical_Bulletins@TescoCorp.com)

Contact your local Tesco Part Sales Center for supply of affected components as noted above.