



Technical Bulletin			 Tesco Corporation 5616 – 80th Avenue SE Calgary, Alberta, Canada T2C 4N5 Tel: 1-877-TESCO-77 (North America) Tel: 1 (713) 359-7195 (AMSS 24-hour support) Tel: 1 (713) 359-7295 (International) Email: bulletins@tescocorp.com www.tescocorp.com www.tescoparts.com
No: TB095	Rev: 1	Date: September 19, 2014	
ECI and HCI Torque Bushing Clevises			
<input type="checkbox"/> Internal Use Only <input checked="" type="checkbox"/> External Use			
			<input type="checkbox"/> Mandatory <input checked="" type="checkbox"/> Recommended

NOTE: All numbers in parentheses are TESCO part numbers unless otherwise noted.

BACKGROUND INFORMATION:

As the industry is demanding greater capacity and higher torque to drill long reach horizontal wells, the TESCO ECI and HCI Top Drive torque bushing clevises are exposed to more vibration and higher load than they were originally designed to handle. Consequently, TESCO is advising customers to increase the weld size of the torque bushing clevis to meet this higher demand. As a field retrofit procedure, TESCO is recommending to grind out the existing welds and replace them with a revised weld. A revised drawing of the torque bushing front plate (14728 Rev10) has been issued to assist in the rework of all affected units.

AFFECTED PRODUCTS:

TESCO torque bushings used for the 500/650TON ECI(S) 900/1350HP, 750TON ECIX 1350HP, and 500/650TON HCI(S) 750/1200/1205HP Top Drive Systems manufactured and delivered from 2002 to 2010.

ACTION RECOMMENDED:

1. The welds attaching the clevises to the torque bushing front plate (14728) are to be fully ground out and replaced with 3/4" fillet welds (Figure 1) under an approved weld procedure for A514 grade material (Quenched and Tempered 100 ksi yield plate), as specified in the drawing of the front plate (14728 Rev10).
2. Ensure that the rework is performed by a qualified welder using an approved weld procedure specification suitable for A514.

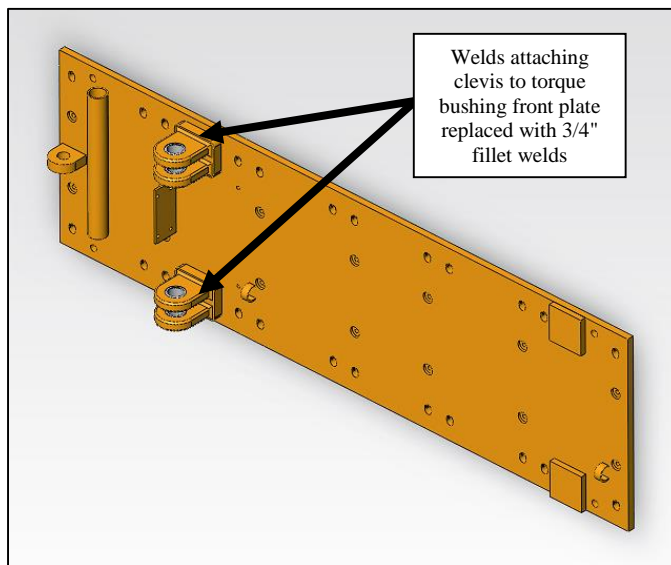


Figure 1: ECI/HCI torque bushing front plate

Version	Date (D/M/Y)	ECN	Description of changes
Rev 0	19/Feb/2013	097-0193	Initial release of document
Rev 1	19/Sep/2014	157-0055	Add unit models HCI/S 1205, HCI/S 1200 and HCI/S E6P to affected products

Copyright © 2014 Tesco Corporation. TESCO® is a registered trademark in the United States and Canada. Casing Drive System™, CDS™, Multiple Control Line Running System™ and MCLRS™ are trademarks in the United States. All information in this document is proprietary and confidential, and shall remain the sole property of Tesco Corporation. This document shall not be used, copied, or reproduced in whole or in part, nor shall be revealed in any manner to outside parties without prior written permission from Tesco Corporation.