



CANRIG DRILLING TECHNOLOGY LTD

PRODUCT BULLETIN NUMBER: 29

DATE: February 9, 1994

SUBJECT: Top Drive Maintenance

SERIAL NUMBERS: All

DISCUSSION: This bulletin Replaces Product Bulletin #22.

The torque values originally specified do not apply to all types of capscrews used on the top drive system. This bulletin specifies torque values for the different types of capscrews.

When doing maintenance or repairs to the top drive system it is important to reassemble parts to manufacturers specifications.

RECOMMENDATION: When assembling any top drive components it is important to install capscrews according to the attached instructions.

INFORMATION:

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CAPSCREW TORQUE VALUES





(Dec 20/93)

All capscrews and bolts used on a Canrig Top Drive meet or exceed ASTM Gr. 8 specifications. These must be torqued to the values shown on the assembly drawings or to the following values:

- All capscrew must be coated with Loctite 242 Threadlocker.
- This is a medium strength threadlocker that prevents rusting of threads and helps prevent loosening due to vibration.
- This threadlock can be sheared by normal hand tools.

- When using capscrews with locknuts, use only Grade C Stover locknuts or equivalent.
- These can be identified visually by eight raised dots.
- These are re-usable but after repeated removal and installation new nuts are recommended.

| HEX HEAD CAPSCREW   | | |
|--|-----------------|---------------|
| SOCKET HEAD CAPSCREW   | | |
| SIZE | TORQUE ft-lb | TORQUE N-m |
| 1/4 | 11 | 14.9 |
| 5/16 | 23 | 31.2 |
| 3/8 | 40 | 54.2 |
| 7/16 | 65 | 88.1 |
| 1/2 | 99 | 134 |
| 9/16 | 159 | 216 |
| 5/8 | 198 | 268 |
| 3/4 | 350 | 475 |
| 7/8 | 566 | 767 |
| 1 | 848 | 1150 |
| 1 1/8 | 1245 | 1688 |
| 1 1/4 | 1750 | 2373 |

| FLAT HEAD CAPSCREW   | | |
|--|-----------------|---------------|
| BUTTON HEAD CAPSCREW   | | |
| SIZE | TORQUE ft-lb | TORQUE N-m |
| 1/4 | 8 | 10.8 |
| 5/16 | 16 | 21.6 |
| 3/8 | 26 | 35.2 |
| 7/16 | 42 | 57 |
| 1/2 | 63 | 85.4 |
| 5/8 | 126 | 170 |
| 3/4 | 230 | 312 |