



CANRIG DRILLING TECHNOLOGY LTD

PRODUCT BULLETIN NUMBER: 59

DATE: May 30, 2000

SUBJECT: 275 TON HANDLER LOCK PIN (Model 6025, 6027)

SERIAL NUMBERS: 013, 030, 036, 041, 047, 049, 062, 071, 076, 092, 097, 111, 116, 123, 124, 132, 138, 139, 144, 145

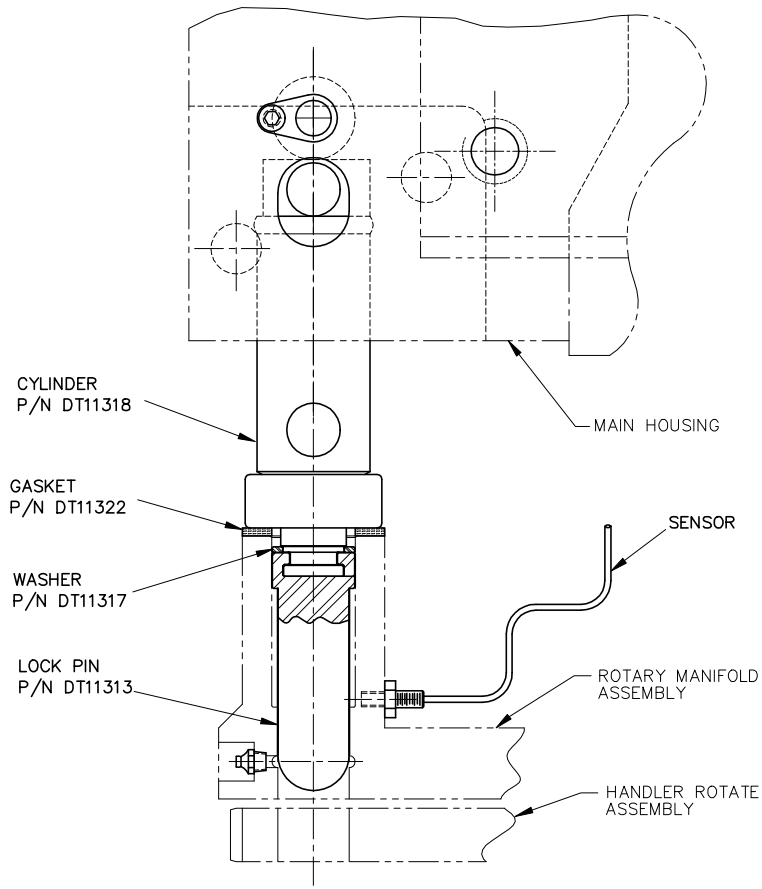
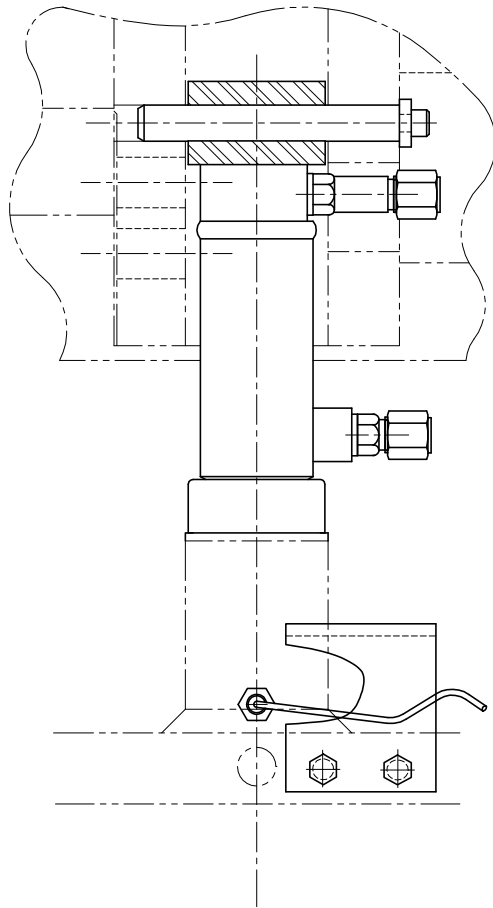
DISCUSSION: Over time, it may be possible for the Handler Lock Pin to become partially or fully unthreaded from the Handler Lock Cylinder rod. If the connection is not properly tightened, this could result in a failure of the pin to cylinder rod connection. It is then possible for the Lock Pin to fall from the Top Drive. The lock pin and bore can be modified to include a shoulder that would prohibit the pin from falling from the Top Drive in the event that the cylinder rod was to break. The cylinder rod has also been modified to reduce the stress where it connects to the lock pin. See assembly drawing PB59-D2.

RECOMMENDATION: The full modification should be completed at the earliest opportunity such as a rig move. The rotary manifold plate will have to be removed and the lock pin bore machined to include a shoulder as shown on drawing PB59-D1. A new pin (P/N DT11313) and cylinder (P/N DT11318) should then also be installed.
As a temporary measure until the full modification can be completed, a 1/8" hole can be drilled through the pin and cylinder rod and a roll pin installed to prevent the lock pin from unthreading (see drawing AY10986).

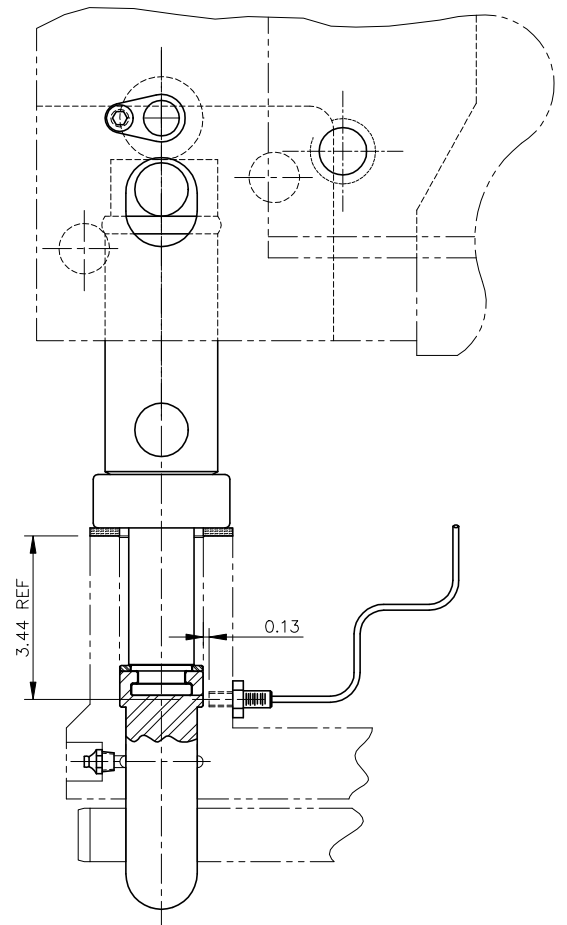
INFORMATION :

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Fax: 281.259.8158




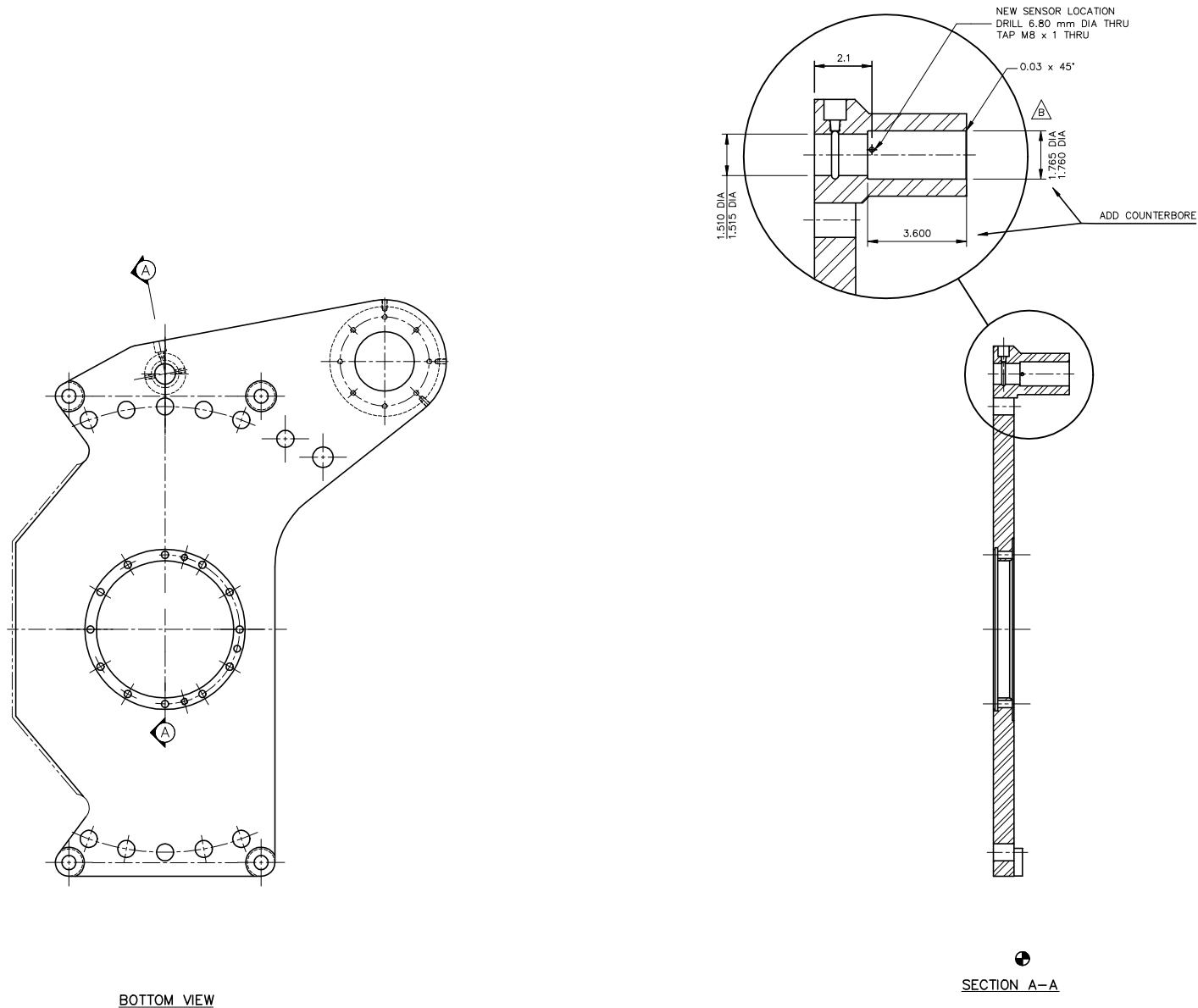
UNLOCKED POSITION



LOCKED POSITION

THIS PRINT AND DESIGN AND DETAIL SHOWN THEREON ARE THE PROPERTY AND INVENTION OF CANRIG DRILLING TECHNOLOGY LTD.. THIS PRINT IS FURNISHED WITH THE UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED WITHOUT PERMISSION AND RETURNED UPON DEMAND. ALL RIGHTS OF DESIGN AND INVENTION ARE RESERVED BY CANRIG DRILLING TECHNOLOGY LTD..

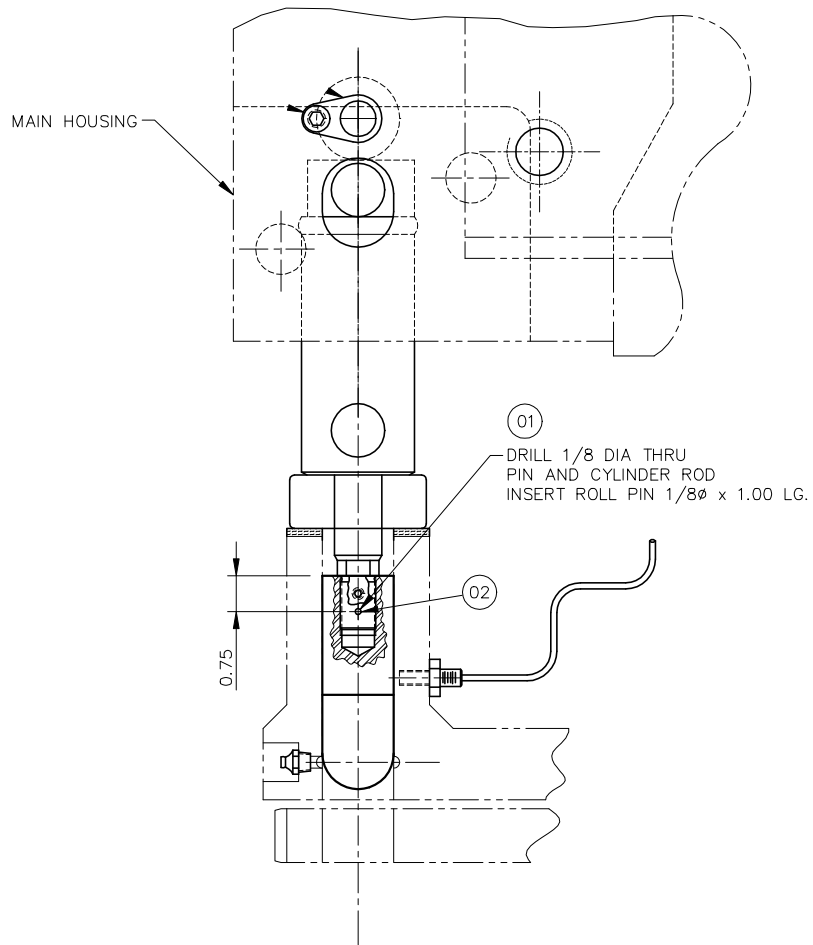
					TOLERANCE - UNLESS OTHERWISE SPECIFIED			DRAWN	DNC	98/09/02	 CANRIG DRILLING TECHNOLOGY LTD.	
					REMOVE SHARP CORNERS AND BURRS	FABRICATING [METRIC]	MACHINING IMPERIAL	CHECKED				
					CASTING ± 1/16	0 TO 600 mm ± 1 mm	DECIMAL .x ± .030"	APPR'VD				
					⊙ CONCENTRICITY ±.005 TIR — STRAIGHTNESS ±.005 IN 5 INCHES ⊥ SQUARENESS ±.010 IN 5 INCHES ∥ PARALLELISM ±.010 IN 5 INCHES ⊕ TRUE POSITION .005	> 600 mm ± 3 mm FABRICATING IMPERIAL 0 TO 24" ± .06" > 24" ± .12"	.xx ± .015" .xxx ± .005"	PLOTTED				
B	00/04/11	DC	ECN# 688, PIN HEAD MODIFICATION		MACHINED SURFACES 125/	ANGULAR ± 2°	ANGULAR ± 1°	MATERIAL				HANDLER LOCK ASSY 275 TON
A	99/12/20	DC	ECN# 652					EST. WEIGHT	SCALE 1:2	PROJECT 6027E		PB59-D2 REV 0



BOTTOM VIEW

SECTION A-A

			THIS PRINT AND DESIGN AND DETAIL SHOWN THEREON ARE THE PROPERTY AND INVENTION OF CANRIG DRILLING TECHNOLOGY LTD. THIS PRINT IS FURNISHED WITH THE UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED WITHOUT PERMISSION AND RETURNED UPON DEMAND. ALL RIGHTS OF DESIGN AND INVENTION ARE RESERVED BY CANRIG DRILLING TECHNOLOGY LTD.			TOLERANCE - UNLESS OTHERWISE SPECIFIED			<table border="1"> <tr> <td>DRAWN</td> <td>EMB</td> <td>05/00</td> </tr> <tr> <td>CHECKED</td> <td></td> <td></td> </tr> <tr> <td>APPROVED</td> <td></td> <td></td> </tr> </table>	DRAWN	EMB	05/00	CHECKED			APPROVED																												
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