PRODUCT BULLETIN NUMBER: 59

CANRIG DRILLING TECHNOLOGY LTD

DATE: May 30, 2000

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

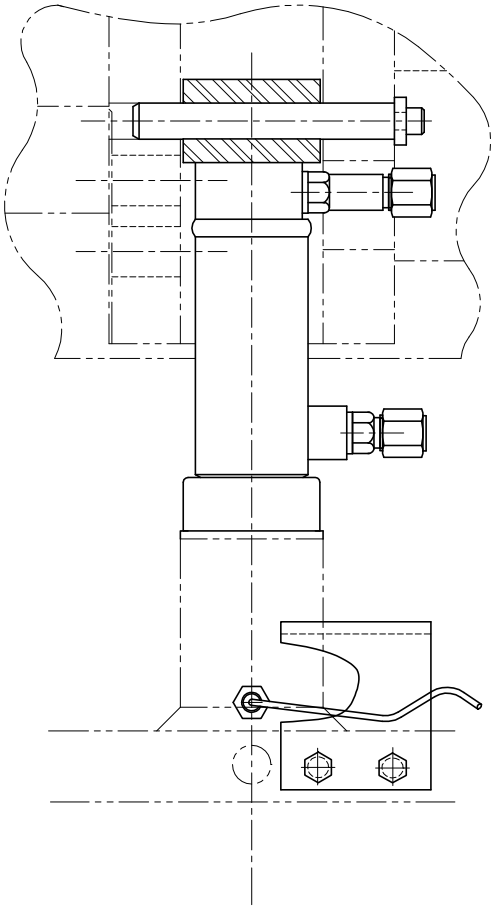
SERIAL NUMBERS: 013, 030, 036, 041, 047, 049, 062, 071, 076, 092, 097, 111, 116, 123, 124, 132, 138, 139, 144, 145

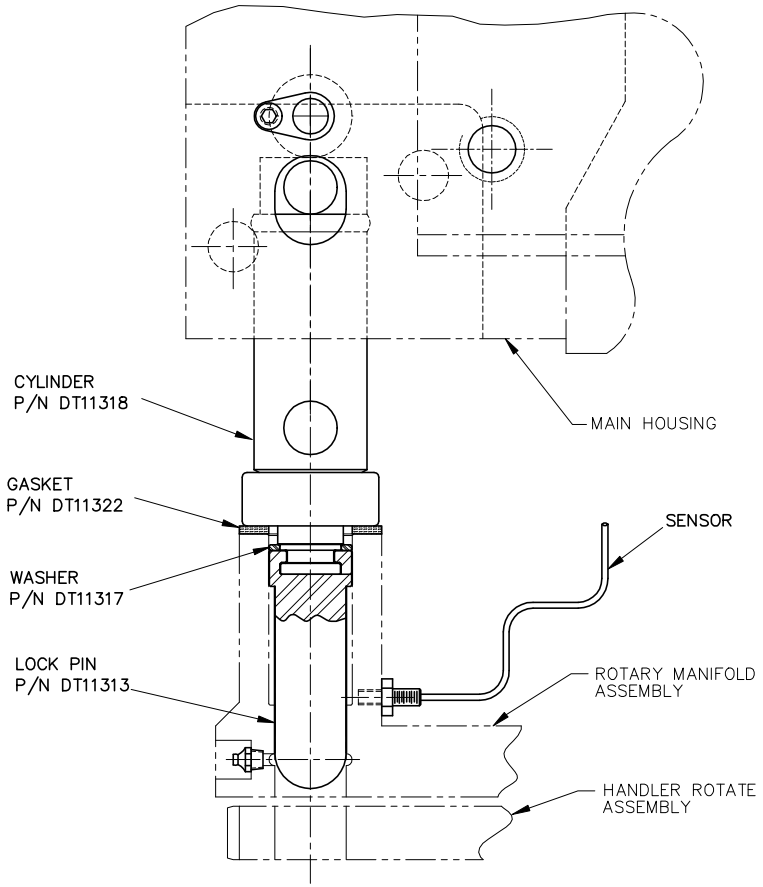
DISCUSSION: Over time, it may be possible for the Handler Lock Pin to become partially or fully unthreaded from the Handler Lock Cylinder rod. If the connection is not properly tightened, this could result in a failure of the pin to cylinder rod connection. It is then possible for the Lock Pin to fall 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).

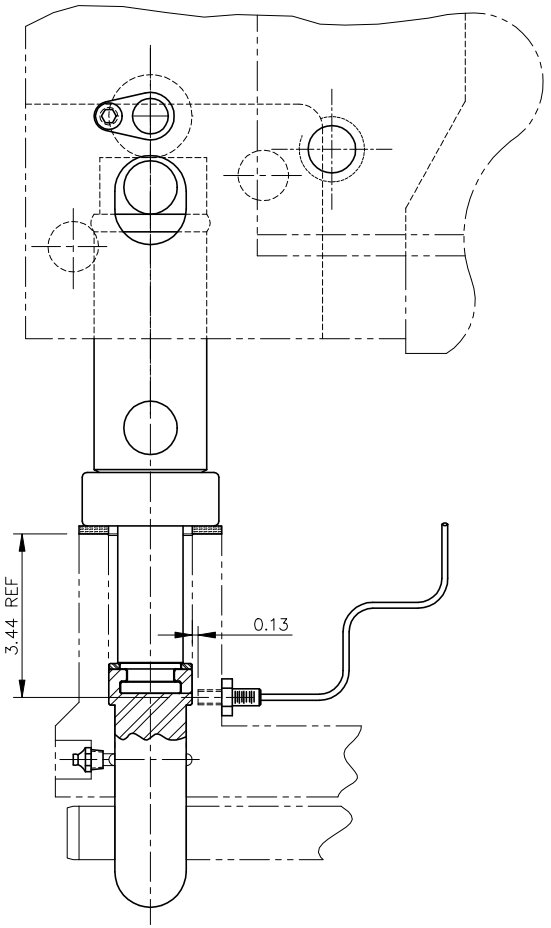
INFORMATION :
For further information contact:

Field Operations Manager
Canrig Drilling Technology Ltd.
14703 FM 1488
Magnolia, Texas 77354
Phone: 281.259.8887
Fax: 281.259.8158





UNLOCKED POSITION



LOCKED POSITION

No.	Y/M/D	BY	REVISION	REFERENCE DWGS
B	00/04/11	DC	ECN# 688, PIN HEAD MODIFICATION	
A	99/12/20	DC	ECN# 652	

TOLERANCE – UNLESS OTHERWISE SPECIFIED

REMOVE SHARP CORNERS AND BURRS

CASTING ± 1/16

⊙ CONCENTRICITY .005 TIR
— STRAIGHTNESS ±.005 IN 5 INCHES
⊥ SQUARENESS ±.010 IN 5 INCHES
|| PARALLELISM ±.010 IN 5 INCHES
⊕ TRUE POSITION .005

MACHINED SURFACES 125

FABRICATING [METRIC]	
0 TO 600 mm	± 1 mm
> 600 mm	± 3 mm

FABRICATING IMPERIAL	
0 TO 24"	± .06"
> 24"	± .12"
ANGULAR	± 2°

MACHINING IMPERIAL	
DECIMAL .x	± .030"
.xx	± .015"
.xxx	± .005"
ANGULAR	± 1°

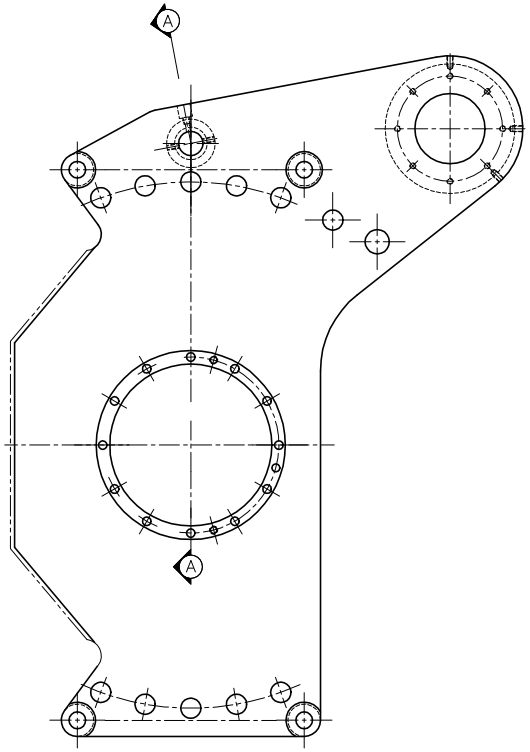
DRAWN	DNC	98/09/02
CHECKED		
APPRV'D		
PLOTTED		
MATERIAL		
EST. WEIGHT	SCALE 1:2	

CANRIG DRILLING TECHNOLOGY LTD.

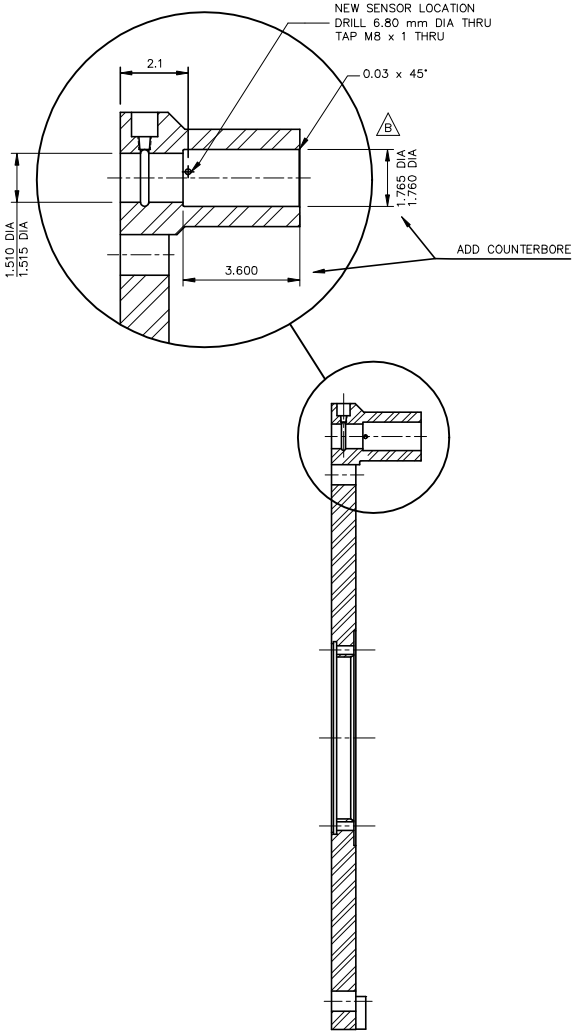
HANDLER LOCK ASSY 275 TON

PROJECT 6027E

PB59-D2 REV 0



BOTTOM VIEW



SECTION A–A

B	99/12/16	DC	ADDED COUNTERBORE
No.	Y/M/D	BY	REVISION

TOLERANCE – UNLESS OTHERWISE SPECIFIED

REMOVE SHARP CORNERS AND BURRS

CASTING ± 1/16

⊙ CONCENTRICITY .005 TIR
— STRAIGHTNESS ± .005 IN 5 INCHES
⊥ SQUARENESS ± .010 IN 5 INCHES
// PARALLELISM ± .010 IN 5 INCHES
⊕ TRUE POSITION .005

MACHINED SURFACES 125

FABRICATING [METRIC]
0 TO 600 mm ± 1 mm
> 600 mm ± 3 mm

FABRICATING IMPERIAL
0 TO 24" ± .06"
> 24" ± .12"

ANGULAR ± 2°

MACHINING IMPERIAL
DECIMAL .x ± .030"
.xx ± .015"
.xxx ± .005"

ANGULAR ± 1°

DRAWN	EMB	05/00
CHECKED		
APPRV'D		

MATERIAL 587–84–2

EST. WEIGHT 285 lb

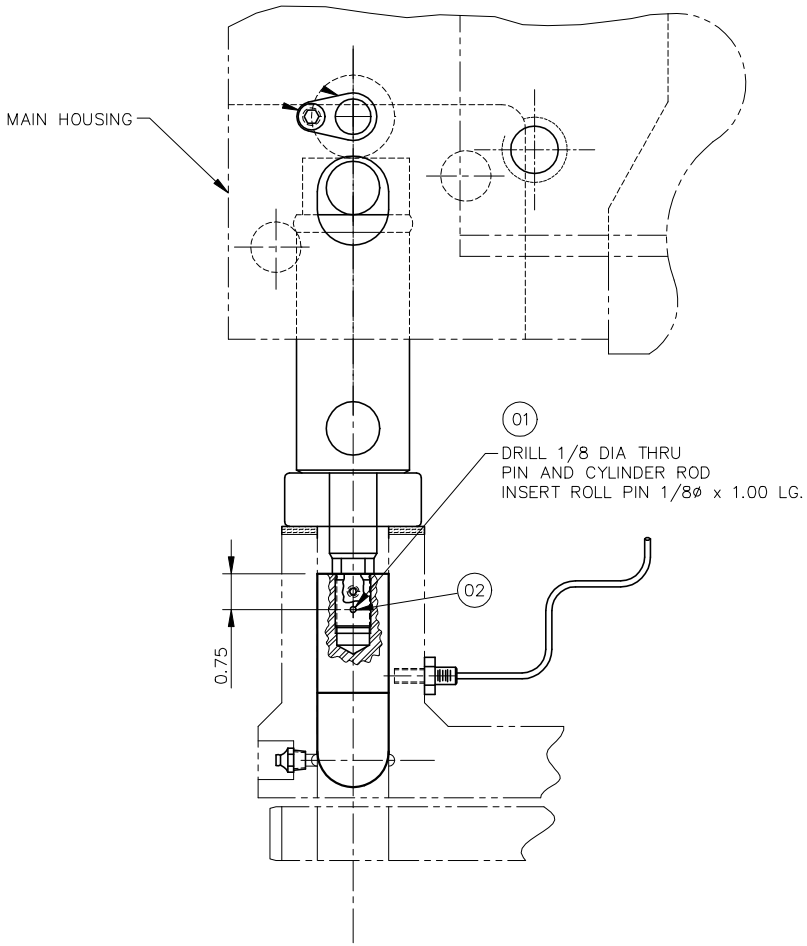
SCALE 1:4

CANRIG DRILLING TECHNOLOGY LTD.

ROTARY MANIFOLD PLATE LOCK PIN MODIFICATION

PROJECT 6025E

PB59–D1 REV 0



No.	Y/M/D	BY	REVISION	REFERENCE DWGS

TOLERANCE – UNLESS OTHERWISE SPECIFIED

REMOVE SHARP CORNERS AND BURRS

CASTING ± 1/16

⊙	CONCENTRICITY	.005 TIR
—	STRAIGHTNESS	±.005 IN 5 INCHES
⊥	SQUARENESS	±.010 IN 5 INCHES
//	PARALLELISM	±.010 IN 5 INCHES
⊕	TRUE POSITION	.005

MACHINED SURFACES 125

FABRICATING [METRIC]	
0 TO 600 mm	± 1 mm
> 600 mm	± 3 mm

FABRICATING IMPERIAL	
0 TO 24"	± .06"
> 24"	± .12"
ANGULAR	± 2°

MACHINING IMPERIAL	
DECIMAL .x	± .030"
.xx	± .015"
.xxx	± .005"
ANGULAR	± 1°

DRAWN	DC	00/05/08
CHECKED		
APPRV'D		
PLOTTED		
MATERIAL		
EST. WEIGHT	SCALE 1:2	

CANRIG DRILLING TECHNOLOGY LTD.

KIT, HANDLER LOCK MOD 275 TON

PROJECT AY10986 REV 0