



## SAFETY ALERT

DATE: May 26, 2004

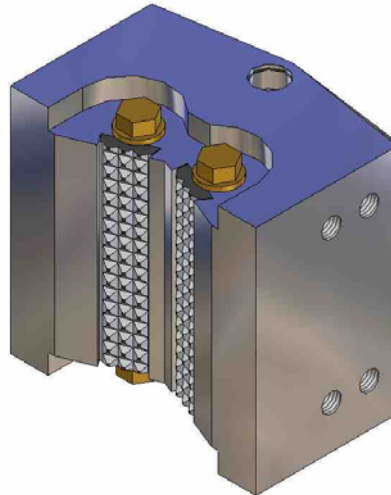
**SUBJECT:** Top Drive Backup Wrench Die Retention

**SERIAL NUMBERS:** All

**DISCUSSION:** An incident happened recently where a die fell out of a top drive backup wrench to the rig floor. Gripper dies are currently retained by cotter pins and/or spring (roll) pins. If force is applied to the dies by the relative movement of the pipe, up or down, these pins can shear and a die can come free and possibly fall.

**RECOMMENDATION:** To minimize the possibility of the dies coming loose, the operator should do the immediate actions:

1. Replace or modify the die block. The current standard die block uses a cotter pin and/or spring (roll) pin to hold the die in the die block. The new design has four bolts with washers to hold the dies in the die block. New die blocks or modification drawings and instructions are available (see chart).



2. Perform daily inspection of retainer bolts to ensure they are in place and not damaged. Inspect after suspected movement of assemblies without a fully opened or closed gripper.

**Proper operation of the top drive is the best way to prevent incidents of this nature.**

**Die Block for 7" Grippers (4017)**

	<b>Original die block</b>	<b>Modification DWG</b>	<b>Replacement Part</b>	<b>Size</b>
<b>Part</b>	DT12847	DT13733	DT13734	4.50 to 7.00"
<b>Assembly</b>	AY11813	AY12322	AY12323	
<b>Part</b>	DT13188	DT13812	DT13811	2.50 to 5.00"
<b>Assembly</b>	AY11949	AY12360	AY12359	

**Die Block for All 9" Grippers (6027, 8035, 1050, 1165 & 1275)**

	<b>Original die block</b>	<b>Modification DWG</b>	<b>Replacement Part</b>	<b>Size</b>
<b>Part</b>	DT10093	DT13712	DT13716	5.75 to 9.00"
<b>Assembly</b>	588-06-1	AY12304	AY12308	
<b>Part</b>	DT10094	DT13713	DT13717	3.75 to 7.00"
<b>Assembly</b>	588-06-2	AY12305	AY12309	
<b>Part</b>	DT10096	DT13715	DT13719	3.25 to 6.5"
<b>Assembly</b>	588-06-4	AY12307	AY12311	
<b>Part</b>	DT10095	DT13714	DT13718	2.50 to 5.75"
<b>Assembly</b>	588-06-3	DT12306	AY12310	

Should you have any questions or concerns, please do not hesitate to contact your CANRIG representative or the Field Operations Manager listed below.

**INFORMATION:**

For further information contact:

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