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| 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: TB107 | Rev: 0 | Date: April 28, 2015 | |
| Usage Instructions for Tesco's First Generation External Casing Drive Die Sets | | | |
| <input checked="" type="checkbox"/> Internal Use Only | | <input type="checkbox"/> External Use | <input type="checkbox"/> Mandatory |
| | | | <input checked="" type="checkbox"/> Recommended |

NOTE: Reference technical bulletin **TB074 - Mark 2 (MK2) Die Sets Available for Tesco's External Casing Drive Systems.**

BACKGROUND INFORMATION

Tesco released Mark 2 (MK2) die sets for use with Tesco's External Casing Drive Systems (ECDS) to increase the tool's torque transfer capability. A technical bulletin (TB074) was also released instructing Tesco business units and customers they must use MK2 dies with P110 grade casing or higher. Instruction was also given in TB074 on when die sets produced prior to the release of the MK2 die sets could still be used. Despite the publication of TB074, Tesco business units and customers were later instructed to scrap all stock of the earlier die sets. This instruction was incorrect.

The purpose of this bulletin is to revoke the instruction to scrap all stock of die sets produced prior to the release of the Mk2 die sets and reinstate the instructions given in TB074. Therefore, all stock of the earlier ECDS die sets can still be used provided the conditions in Table 1 are met, after which it is recommended they be replaced with MK2 die sets.

| Version | Date (D/M/Y) | ECN | Description of changes |
|---------|--------------|----------|-----------------------------|
| Rev 0 | 04/28/2015 | 253-0014 | Initial release of document |

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AFFECTED PRODUCTS

All die sets produced before the introduction of the Mark 2 (MK2) die sets that are used with the 3-1/2" to 7" Casing Drive (Part # 720632) and 7" to 8-5/8" Casing Drive (Part # 720635). See below for a complete breakdown of the applicable die sets.

Table 1: Affected ECDS die sets

| Part # | Description | * Maximum Torque ft-lb) |
|---------|--|-------------------------|
| | 3 1/2" to 7" Casing Drive (Part # 720632) | |
| 1410533 | Die Set,6-5/8"Casing,(3-1/2"to7"Drive),ECDS, Low Torque, Max 19400 ft-lb | 19400 |
| 1410505 | Die, 6-5/8"Casing,3-1/2"to7"Drive,ECDS, Low Torque, Max 19400 ft-lb | 19400 |
| 15696 | Die,7"Casing,4-1/2" to 7"Casing Drive, ECDS, Low Torque, Max 22600 ft-lb | 22600 |
| 15697 | Die,5-1/2"Casing,ECDS , Low Torque, Max 13300 ft-lb | 13300 |
| 15698 | Die,4-1/2"Casing,ECDS , Low Torque, Max 7500 ft-lb | 7500 |
| 16266 | Die,5"Casing,ECDS , Low Torque, Max 10600 ft-lb | 10600 |
| 720826 | Die Set,3-1/2"Casing,ECDS,(Set Of Three), Low Torque, Max 2500 ft-lb | 2500 |
| 720827 | Die Set,4-1/2"Casing,ECDS,(Set Of Three), Low Torque, Max 7500 ft-lb | 7500 |
| 720828 | Die Set,5"Casing,ECDS,(Set Of Three), Low Torque, Max 10600 ft-lb | 10600 |
| 720829 | Die Set,5-1/2"Casing,ECDS,(Set Of Three), Low Torque, Max 13300 ft-lb | 13300 |
| 720830 | Die Set,7"Casing,(4-1/2"to7"Drive),ECDS, Low Torque, Max 22600 ft-lb | 22600 |
| 820035 | Die,3-1/2"Casing,ECDS , Low Torque, Max 2500 ft-lb | 2500 |
| | 7" to 8-5/8" Casing Drive (Part # 720635) | |
| 17187 | Die,8-5/8"Casing,ECDS , Low Torque, Max 29500 ft-lb | 29500 |
| 17188 | Die,7-5/8"Casing,ECDS , Low Torque, Max 24800 ft-lb | 24800 |
| 720695 | Die,7-3/4"Casing,ECDS , Low Torque, Max 25400 ft-lb | 25400 |
| 720831 | Die Set,7"Casing(7-5/8"to8-3/4"Drv)ECDS, Low Torque, Max 22600 ft-lb | 22600 |
| 720832 | Die Set,7-5/8"Casing,ECDS,(Set Of Three), Low Torque, Max 24800 ft-lb | 24800 |
| 720833 | Die Set,7-3/4"Casing,ECDS,(Set Of Three), Low Torque, Max 25400 ft-lb | 25400 |
| 720834 | Die Set,8-5/8"Casing,ECDS,(Set Of Three) , Low Torque, Max 29500 ft-lb | 29500 |
| 810134 | Die,7"Casing,7-5/8" to 8-3/4"CD,ECDS, Low Torque, Max 22600 ft-lb | 22600 |

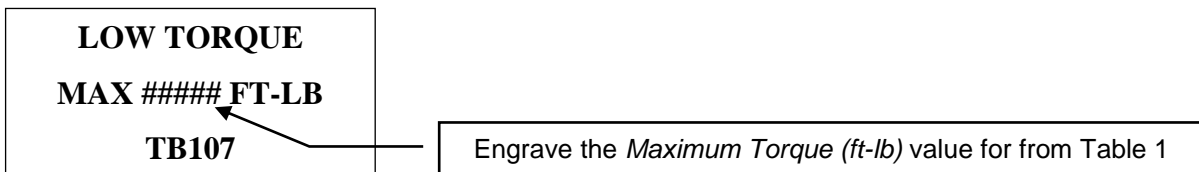
* Maximum torque values are taken from Engineering Memo EM000168 and based on L80 casing. The use of softer casing may reduce the maximum torque value.

ACTION REQUIRED

All Tesco business units and customers are recommended to use up their stock of any ECDS die set identified in Table 1 before using a similar MK2 die set, provided a job will allow for use of an earlier die set.

The following actions must be completed before using a die set identified in Table 1:

- Confirm each die is in *as new* condition, meaning it does not display any signs of corrosion. Quarantine any dies that are **not** in *as new* condition. Then transfer the quarantined die to the relevant Tesco business unit's quality control department.
- Engrave the following information into each die - use a ¼" Font size.



- Confirm the torque required by the job does not exceed the die set's maximum torque value, as listed in Table 1.
- Confirm the die set will not be used with P110 grade casing or higher.

All operators of Tesco equipment are encouraged to provide feedback so that Tesco can continue to provide the safest and most reliable equipment in the industry.