

Change 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: CB048	Rev: 0	Date: January 27, 2012		
Upgrade of the Side Entry Swivel Sub Load and Temperature Ratings				

BACKGROUND INFORMATION:

ECN-071-0079 introduced a number of changes on the Cement Plug Launching System (CPLS) to improve the products. Below is a list of these changes:

1. Load and Temperature Rating of Side Entry Swivel Sub (SESS):

A destructive pull test has been conducted on the SESS shaft to determine the load rating based on API 8C section 5.5., "Alternative design verification test procedure and rating". Based on the findings of the pull test, the tensile load rating can now be upgraded from 400 Ton to 600 Ton (544 metric ton). For further information on the test, refer to report # 710223.

As well, due to customer requirements, the specification for the material for load path components (TPI-0005) has been change to include a -40°C (-40°F) and a -50°C (-58°F) impact values. This affects the shaft material on the SESS. Therefore, the SESS shaft is now rated to either -40° or -50°C. The specific value is stamped on the nameplate of the SESS. *Note that this rating is the shaft material rating only, and should not be confused with the operating temperature rating which is determined by the high pressure seal temperature rating (see Appendix A).* The low temperature rating of the shaft is important during casing running jobs when the SESS is installed above the CDS. During casing running the SESS is not operational therefore the operating temperature is not applicable.

Due to the changes described above, the supplier has changed the OEM number of the swivel and spare part kits. This resulted in a TESCO part number change of the swivel and the spare parts kits. *Note that no change has been made to the form, fit and function of the seal kits.* See "Affected Products" below and Appendix C.

2. SESS, SESS Travel/Test Stand and SESS Test Accessory Added to the CPLS Matrix:

Since the SESS, SESS travel/test stand and SESS test accessory is part of the CPLS system, it has been added to the CPLS matrix. See attached Matrix in Appendix B.

3. Additions to Ball Launch Assembly Kit:

The following parts were added to TESCO part number 5005996-1 as these parts are used during the cementing process:

- Adapter, 4" Figure 1002 winged to 2" Figure 1502 threaded (part number 990366). Typically used to connect the 2" cement line to the SESS.
- Nut, 4" Figure 1002 (part number 720814). Typically used with a blank to cap the SESS during the casing running job.
- Blank, 4" Figure 1002 (part number 13553). Typically used with the nut to cap the SESS during the casing running job.

Version	Date (D/M/Y)	ECN	Description of changes
Rev 0	13 February 2012	071-0079	Initial release of document

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AFFECTED PRODUCTS:

1. Load and Temperature Rating of SESS:

<i>Part Description</i>	<i>Old Part Number</i>	<i>New Part Number</i>
Side Entry Swivel Sub (SESS)	7000017	7000017-1
Kit,Spares,High Pressure Packing Seals & O-Rings,Rotary Cement Swivel	5010533	5010533-1
Kit,Spares,High Pressure Seal Cartridge & O-Rings,Rotary Cement Swivel	5010534	5010534-1
Kit,Spares,Oil Seals,Rotary Cement Swivel	5010535	5010535-1
Kit,Spares,Bearings,Rotary Cement Swivel	5010536	5010536-1
Kit,Spares,Wear Sleeve & O-Rings,Rotary Cement Swivel	5004986-1	5004986-2
Kit,Spares,O-Rings,Wear Sleeve,Rotary Cement Swivel	5004991-1	5004991-2
Kit,Spares,Ball Catcher & Dowel,Rotary Cement Swivel	5004992-1	5004992-2

2. SESS, SESS Travel/Test Stand and SESS Test Accessory Added to the CPLS Matrix:

<i>Part Description</i>	<i>Old Part Number</i>	<i>New Part Number</i>
Matrix,Cementing Plug Launching System (CPLS)	1320089Rev7	1320089Rev8

3. Additions to Ball Launch Assembly Kit:

<i>Part Description</i>	<i>Old Part Number</i>	<i>New Part Number</i>
Kit,Ball Launching Assembly (BLA),CPLS	5005996-1	5005996-2

ACTION REQUIRED:

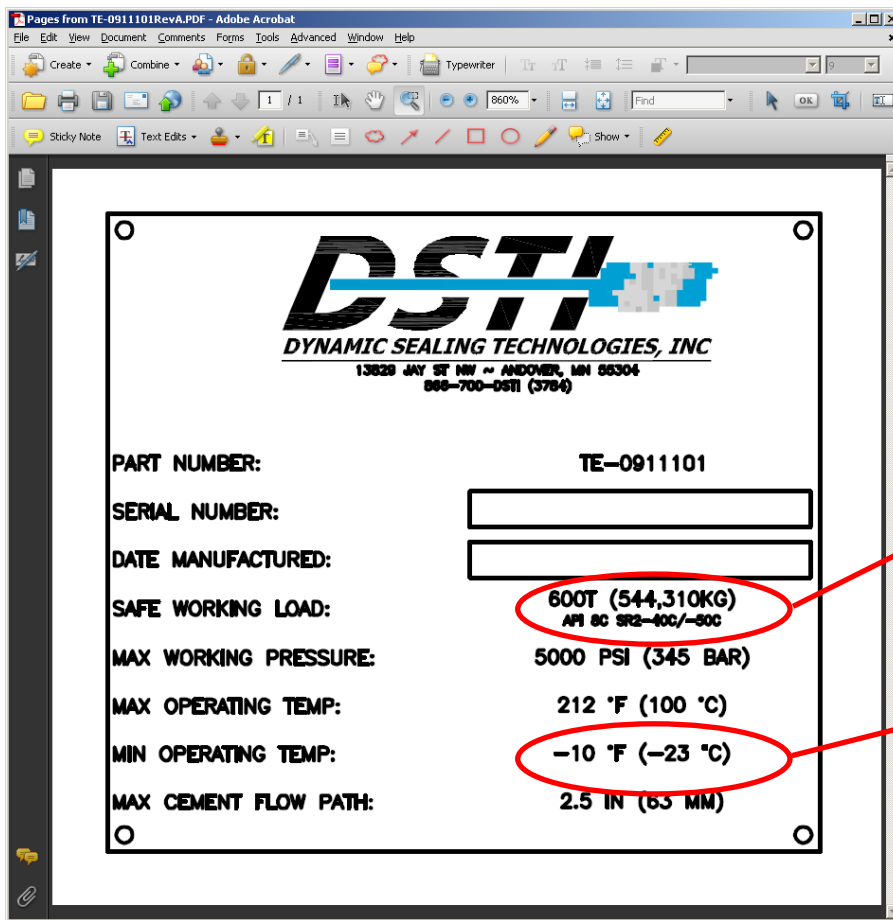
1. Purchasing Agents:

- Change all current purchase orders for part number 7000017 to order 7000017-1.
- Change all current purchase orders for spare part kits to order the new part numbers.
- Revise all current purchase orders for 5005996-1 to order 5005996-2. Contact the supplier to add additional parts into storage container.

2. All District Managers:

- Proceed to use part number 7000017. Refer to name plate for load and temperature ratings of the shaft.
- Use up all old seal kits in stock. The old seal kit will work with the new SESS (7000017-1). New seal kits will also work with old SESS (7000017).
- Purchase the following parts and add them in the storage container of Ball Launcher kits:
 - Qty 1 x 990366 (Adapter,Union,Hammer,10000-psi,4"Fig 1002 Winged x 2"Fig 1502).
 - Qty 1 x 720814 (Nut,Union,Hammer,4",FIG 1002).
 - Qty 1 x 13553 (Sub,Blind,Male,Union,Hammer,4",Fig 1002).

APPENDIX A: NAME PLATE ON SESS



SESS load and temperature rating

Minimum SESS operating temperature

APPENDIX B: MATRIX, CEMENT PLUG LAUNCHING SYSTEM (CPLS)

New parts added

BALL LAUNCHING ASSEMBLY	ACCESSORIES	CEMENTING PLUG	PLUG ADAPTERS	Cementing Plug Launching System	
<p data-bbox="397 241 690 1606">KIT BALL LAUNCHED ASSEMBLY P/N 5005696-2 P/N 5003553 P/N 5003480 P/N 1320094 P/N 1320096 P/N 1320087 P/N 5003550 P/N 5012002 P/N 720014 P/N 13553 P/N 900306 P/N 5003489</p>	<p data-bbox="698 241 836 1606">STAND, TRAVEL/TESTING, SESS P/N 5013533 ACCESSORY, TEST, SESS P/N 5013887 P/N 1320081 P/N 5013533</p>	<p data-bbox="844 241 982 1606">KIT, CEMENTING PLUG LAUNCHING P/N 5000850 KIT, CEMENTING PLUG P/N 5000843 KIT, CEMENTING PLUG P/N 5000810 KIT, CEMENTING PLUG P/N 5000806</p>	<p data-bbox="990 241 1177 1606">KIT, CEMENTING PLUG ADAPTER P/N 900301 KIT, CEMENTING PLUG ADAPTER P/N 900302 KIT, CEMENTING PLUG ADAPTER P/N 900303 KIT, CEMENTING PLUG ADAPTER P/N 900304</p>	<p data-bbox="1185 241 1307 955">23 Jan 2012</p> <p data-bbox="1185 241 1307 955">2012 JAN 2012 2012</p>	
<p data-bbox="397 955 690 1606">KIT BALL LAUNCHED ASSEMBLY P/N 5005696-2</p>	<p data-bbox="698 955 836 1606">STAND, TRAVEL/TESTING, SESS P/N 5013533</p>	<p data-bbox="844 955 982 1606">KIT, CEMENTING PLUG LAUNCHING P/N 5000850</p>	<p data-bbox="990 955 1177 1606">KIT, CEMENTING PLUG ADAPTER P/N 900301</p>	<p data-bbox="1185 955 1307 955">2012</p>	
<p data-bbox="397 241 690 955">KIT BALL LAUNCHED ASSEMBLY P/N 5005696-2</p>	<p data-bbox="698 241 836 955">ACCESSORY, TEST, SESS P/N 5013887</p>	<p data-bbox="844 241 982 955">KIT, CEMENTING PLUG P/N 5000843</p>	<p data-bbox="990 241 1177 955">KIT, CEMENTING PLUG ADAPTER P/N 900302</p>	<p data-bbox="1185 241 1307 955">2012</p>	



2012
JAN 2012
2012

2012

2012

2012

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2012

CEMENTING PLUG	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 9-5/8" CASING PIN 710183	KIT, CEMENTING PLUG, FOR 2" BALL PIN 890289	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 10-3/4" CASING PIN 5001889	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 11-3/4" CASING PIN 5001870	KIT, CEMENTING PLUG, FOR 2" BALL 11-3/4" CASING PIN 890347
KIT, CEMENTING PLUG, FOR 1-1/2" BALL 9-5/8" CASING PIN 710183	KIT, CEMENTING PLUG, FOR 2" BALL PIN 890289	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 10-3/4" CASING PIN 5001889	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 11-3/4" CASING PIN 5001870	KIT, CEMENTING PLUG, FOR 2" BALL PIN 890347	KIT, CEMENTING PLUG, FOR 2" BALL 11-3/4" CASING PIN 890307
PLUG ADAPTER	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 9-5/8" X 32-38 LBFT PIN 890198	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 9-5/8" X 40-43.5 LBFT PIN 890210	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 10-3/4" X 37-53 LBFT PIN 890357	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 10-3/4" X 60-77.3, 2 LBFT PIN 890388	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 11-3/4" X 54 LBFT PIN 890359
DOC KIT	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 9-5/8" X 32-38 LBFT PIN 890198	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 9-5/8" X 40-43.5 LBFT PIN 890210	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 10-3/4" X 37-53 LBFT PIN 890357	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 10-3/4" X 60-77.3, 2 LBFT PIN 890388	KIT, CEMENTING PLUG, FOR 1-1/2" BALL 11-3/4" X 54 LBFT PIN 890359



Method: M11037
 Manufacture to standard: P85005
 23 Jan 2012

8	071-0079	Add SESS, Travel stand & Test Accessory	12Jan2012	12Jan2012	12Jan2012
7	198-0001	Add Ball gauge and update part number 800596-	15EC2011	29MAR2011	29MAR2011
6	071-0095	Add 5" and 4-1/2" tooling kit. Transfer to 506W	15FEE2011	15FEE2011	15FEE2011
5	071-0056	Change ball launching assembly kit	EON	EON	EON
REV	EON	DESCRIPTION	DATE	DATE	DATE

TITLE:	CEMENTING PLUG LAUNCHING SYSTEM
DRAWN BY:	HLR
DATE:	29MAR2011
CHECKED:	APPROVED:
DWG NO:	1320089
PAGE:	3 OF 3
REV:	8

APPENDIX C: SPARE PARTS KIT DEFINITIONS:

Sheet 6 of 7

Item	P/N	Qty.	Description	Notes
1	TE-0911101-R1	1	Shaft	See Sheet #1
2	TE-0911101-H	1	Housing	See Sheet #3
3	TE-0911101-CN	2	Cap	Alloy Steel
4	TE-0911101-1	1	Seal	Alloy Steel/Coating
5	TE-0911101-482	1	Seal	Alloy Steel
6	TE-0911101-483	1	Seal	Alloy Steel
7	6208	2	Ball Bearing	Sealed Steel
8	9100-750	2	Seal	Open
9	8.50" Seal Cartridge	2	Primary Seal Assembly	Includes carriage, packing & backup ring
10	8.50" Lip Seal	2	Secondary Seal	Includes -lip, backup-ring & in cap 2
11	Oil Seal	2	Multiple Seal	Spring side face outward
12	2-277	2	Metric O-Ring	Static seal between seal retainer and cap
13	2-278	2	Metric O-Ring	Static seal between housing and cap
14	1-381	2	Metric O-Ring	Static seal on shaft (flange)
15	2-365	4	Metric O-Ring	Static seal between seal retainer and housing
16	9-365	4	Metric Back-up Ring	Static seal between seal retainer and housing
17	1/2"-13 1.75" SHCS	12	Socket Head Cap Screw	Steel with flared head
18	1/2"-13 1.90" SHCS	24	Socket Head Cap Screw	Steel
19	5/16"-18 7/8 SHCS	4	Socket Head Cap Screw	Steel
20	4.850 x .853 Shim	1	Distal Pin	Stainless steel
21	Wash	2	Primary Wash	Steel
22	Zerk	2	1/4"-20 Zerk Fitting	Steel

Sales Kits

Item	P/N	Qty.
4	TE-0911101-M1	4
15	2-365	4
18	9-365	4
19	5/16"-18 7/8	4

Tesco # 5004988-2

Item	P/N	Qty.
15	2-365	4
18	9-365	4

Tesco # 5004991-2

Item	P/N	Qty.
8	TE-0911101-H	2
9	8.50" x .853 Shim	1

Tesco # 5004992-2

Sales Kits

Item	P/N	Qty.
9	8.50" Lip Seal	2
10	8.50" Backing Seal	2
11	Oil Seal	2
12	2-277	2
13	2-278	2
14	1-381	2

Tesco # 5010533-1

Item	P/N	Qty.
9	8.50" Lip Seal	2
10	8.50" Backing Seal	2
11	Oil Seal	2
12	2-277	2
13	2-278	2
14	1-381	2

Tesco # 5010534-1

Item	P/N	Qty.
7	6208	2
8	9100-750	2

Tesco # 5010535-1

Item	P/N	Qty.
7	6208	2
8	9100-750	2

Tesco # 5010536-1

Notes:

- Sales kit and component identification drawing.
- Soak primary seals (item 9) in oil prior to assembly.

THIRD ANGLE PROJECTION:

CUSTOMER APPROVAL/DATE:

Drawn	RAW	8/20/10
Checked	PJE	8/20/10
Checked	TOB	8/25/11

TOLERANCE EXCEPT AS NOTED:
 X.X ±.125
 X.XX ±.005
 X.XXX ±.005
 ANGLES ± 0.5°
 SH-WT MTF/P/L/TMG:

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CUSTOMER: **TESCO**

P/N: **TE-0911101**

REV: **A**