

Change Bulletin

No: CB010

Rev: 0

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Description: Bonnet Access Window and Bonnet Bolt Length Change



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BACKGROUND INFORMATION:

An access window and removable panel has been added to the bonnet on the EMI 400. This change will allow better access to the fittings on top of the gearbox that make up part of the gearbox lubrication system. Figure 1 shows the location of the access window in the bonnet (Item 1) and the removable panel (Item 20).

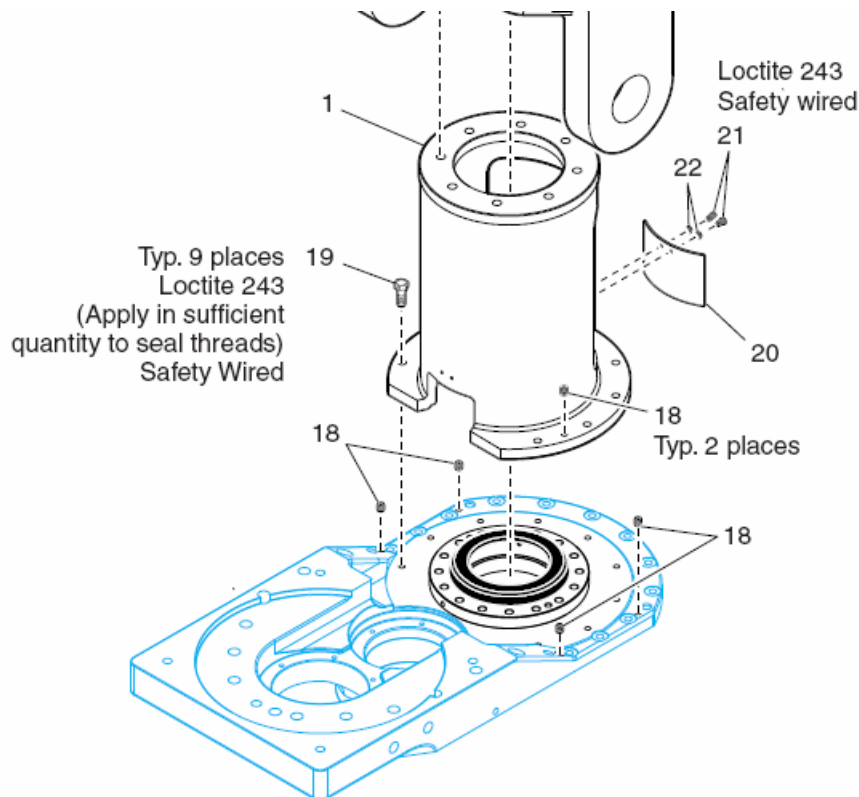


Figure 1 – Bonnet Access Window (Split Block version shown)

The bolts that were used to connect the bonnet to the gear box lid (Item 19) were originally specified as 1/2"-13UNC x 1-1/2". The combined thickness of the bonnet flange and flat washer resulted in a thread engagement of approximately 3/8" making this connection susceptible to failure from highly torqued fasteners or impacts to the attached components. This bolted connection has been modified to use 1/2"-13 UNC x 1-3/4" fasteners without a washer to provide an improved connection.

This change is documented fully by ECN 130-0008.

AFFECTED PRODUCT:

This change is applicable to all EMI 400 Top Drives manufactured prior to approximately March 15, 2007.

ACTION REQUIRED:

Bonnet Access Window:

The bonnet access window is a non-essential upgrade that may be added to the top drive when a unit is brought into a Tesco Service Centre for routine maintenance. The modification can be made to existing units by a number of machining/cutting operations including torch cutting and grinding. Please refer to the correct drawings for the specific top drive configuration as follows,

250T EMI 400, Yoke and Link Block – DWG 810138 rev. 4, DWG 810139 rev. 6
250T EMI 400, Split Block – DWG 830056 rev. 2, DWG 830057 rev. 2
150T EMI 400, Split Block - DWG 830056 rev. 2, DWG 820107 rev. 2

Bonnet Bolts:

To date only two top drives have experienced a failure of the bonnet connection. The first of these failures was directly associated with an impact event while the second was not conclusive as to cause. Given the very limited occurrence of this problem, it is recommended that the modification be performed during routine maintenance. The corrective action required is to replace the existing 1/2"-13 UNC x 1-1/2" fasteners (PN 3116) with longer 1/2"-13UNC x 1-3/4" fasteners (PN 5967) and to omit the flat washer. When applying Loctite to these bolts make sure to apply around the full circumference of the threads and in sufficient quantity to ensure a water tight seal.

Contact your local TESCO Parts and Service Center for further information regarding this bulletin and or supply of affected components noted above.