

Change Bulletin

No: **CB015**

Rev: 0

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Description: Torque Bushing Assembly Upgrade



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BACKGROUND INFORMATION:

Occasions have arisen where the space between the UHMW (ultra-high molecular weight nylon) pads in the torque bushing assembly is insufficient to accommodate the 12" wide torque track. A stack up of tolerances among the various assembly components has resulted in the spacing between the UHMW pads finishing at between 11- $\frac{3}{4}$ " and 12- $\frac{1}{4}$ ". Consequently, the holes securing the torque bushing side plates to the front plate do not always line up. This situation necessitated slotting the holes on the side plates and/or front plate of the torque bushing assembly by as much as $\frac{1}{4}$ " to accommodate this variance.

This change provides adjustment of the bushing during assembly in $\frac{1}{16}$ " increments from 11- $\frac{3}{4}$ " to 12- $\frac{1}{4}$ ". This change will also permit simple field adjustment of the side plates to tighten up clearance on the torque track due to normal wear of the UHMW liners.

This change is fully documented in ECN-097-0042 and ECN-134-0017.

AFFECTED PRODUCT:

This change affects torque bushing assemblies for all top drive models. Unless otherwise indicated, parts on order have been reworked; WIP, warehouse, BU inventory and field inventory will be used up.

Parts that have been REVISED due to this ECN:

Part No.	Description
14712	Front Plate, HMI Bushing
14728	Front Plate, ECI/HCI Bushing
14804	Front Plate, Std Bushing
3930	Side Plate, Std, Raw
8031	Side Plate Mach, Std, DS
8355	Side Plate Mach, Std, ODS
14803	Side Plate Weld, Std, DS
14802	Side Plate Weld, Std, ODS
14978	Side Plate Weld, EMI, DS
14979	Side Plate Weld, EMI, ODS
14726	Side Plate Weld, HCI, DS
14727	Side Plate Weld, HCI, ODS
42392033	Side Plate, HMI, Raw
42392003	Side Plate Mach, HMI, DS
42392021	Side Plate Mach, HMI, ODS
14723	Side Plate Weld, HMI, DS
14724	Side Plate Weld, HMI, ODS
3832	Shim, Std, $\frac{1}{8}$ " Thk
3833	Shim, Std, $\frac{1}{16}$ " Thk
14722	Torque Bush Assy, HMI
14976	Torque Bush Assy, EMI
7970	Torque Bush Assy, HCI/ECI
40000001	Torque Bush Assy, HCI/ECI
7969	Torque Bush Assy, Std

Parts that have been REVISED due to this ECN:

Part No.	Description
7922	24' Extend Frame Weldment
8649 ¹	Accum Mount Assy, DS
8650 ²	Accum Mount Assy, ODS
3934	Torque Track Pin
42393007	Front Plate, Mach, HMI
980011	Front Plate, Torque Bush
980009	Side Plate, EMI 400, DS
980010	Side Plate, EMI 400, ODS
731145	Torque Bush, EMI 400
840049	Kit, Torque system, 350-EXI-600
810390	Torque Bushing Assy, 350-EXI-600
810331	Front Plate, Torque Bushing, 350-EXI-600
810332	Side Plate, Torque Bushing, 350-EXI-600, DS
810333	Side Plate, Torque Bushing, 350-EXI-600, ODS
40000136	Side Plate, Torque Bushing, LTD Clear, Weld, HCI, ODS
40000140	Side Plate, Torque Bushing, LTD Clear, Weld, HCI, DS
40000141	Side Plate, Torque Bushing, LTD Clear, Mach, HCI

NEW Parts as a result of this ECN:

Part No.	Description
970146	Analysis, Side Plate Adjuster
970147	Torque Bush Side Plate Adjuster

Parts that have been DISCONTINUED due to this ECN:

Part No.	Description
14993/ 39602037	Accumulator Mount, Base
15012/ 39602035	Accumulator Mount, Weld
14409/ 39602036	Accumulator Mount, Lower
14991/ 39602031	Accumulator Front Panel
13160/ 39602032	Accumulator Mount, Base

ACTION REQUIRED:

As described in the "Affected Product" section, there are two new parts arising from this change bulletin; five parts have been discontinued; and 33 parts have been revised. Please note that upgrade of the torque bushings in the field is optional and not mandatory. As such, this bulletin is issued for information only.

The changes consist of the following:

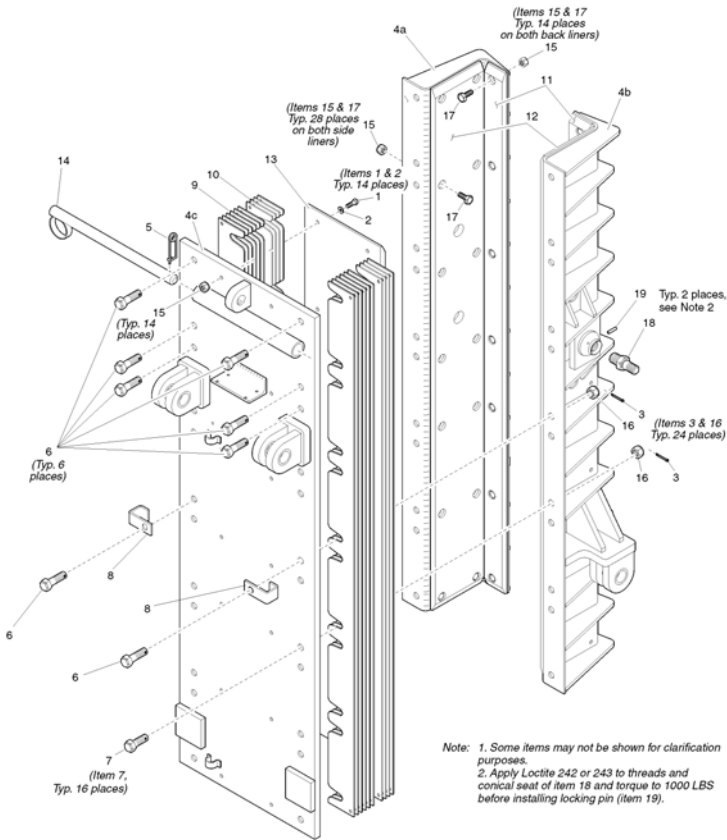
- The mounting holes for the side plates have been slotted
- Dimensioning and GD&T scheme for the front plates has been revised
- A 5-sided adjuster nut has been added to the torque bushing assemblies
- The accumulator mounts and standard pin have been modified, and the frame pads have been extended to accommodate the adjuster nuts.

An example of these changes is shown on the torque bushing assembly for HCI/ECI (part 7970) on the next page. Refer to each part's specific drawing (as listed in the previous section) to observe the changes for the part in question.

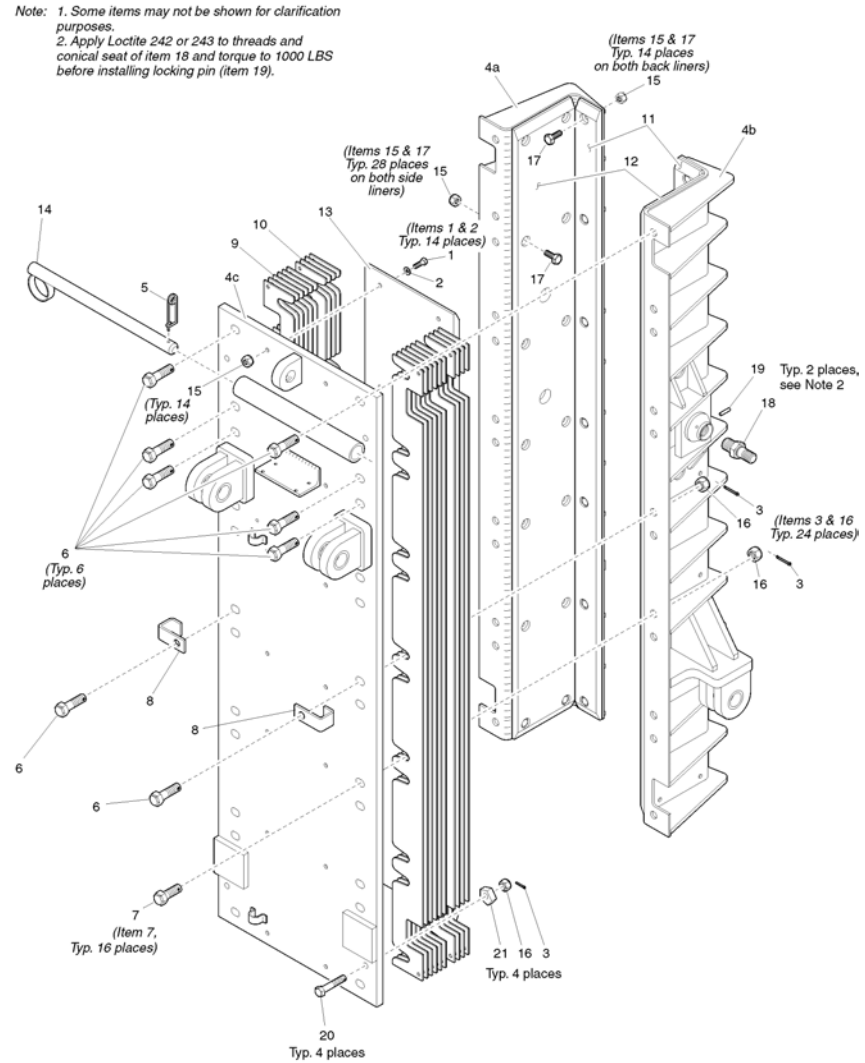
¹ Part 8649: Rework is N/A to "on order" parts but warehouse parts have been reworked

² Part 8650: Rework is N/A to "on order" parts but warehouse parts have been reworked

Earlier version:
 Note the bolting holes are round



Revised version showing the slotted side plate mounting holes, notched side plates, 5-sided adjuster nuts, notched extend frame shim plates. Accumulator mount modifications are not shown but are to clear the new 5-sided adjuster nuts.



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