

Safety Bulletin

No: SB012

Rev: 3

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Description: Crossover Sub Recall



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TESCO

BACKGROUND INFORMATION

Tesco Top Drives equipped with 6 ⁵/₈" Regular (Reg) Pin down drive quills or load subs installed in 500 and/or 650 Ton machines and equipped or configured with the NC 50 (4 ¹/₂" IF) Mud Saver Valves (MSV) will employ a cross over sub between the quill or load sub pin connection and the upper box connection of the MSV - NC 50 (4 ¹/₂" IF).

The cross over sub is a 6 ⁵/₈" Reg - Box by 4 ¹/₂" IF - Pin with Part Number (P/N) designation 13654 or 17829. The geometry of this cross over sub in combination with high flow rates may result in accelerated erosion with the potential of cross over sub failing.

MODELS AFFECTED

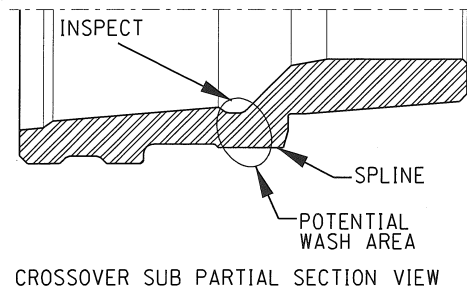
Any machine that uses this cross over sub in converting from the 6 ⁵/₈" Reg - Pin to a 4 ¹/₂" IF - Pin may be affected. The models included in this group are:

- HS, HCI, HCIS, ECI, and ECIS machines of either 500 or 650 ton capacity.

ACTION REQUIRED

The above referenced cross over sub **MUST** be taken out of service and replaced with P/N 500330, actuator bracket P/N 9365, a quantity of two hose extensions: P/N 3722, and a quantity of two #6 MJIC nipples, P/N 0330. Additional consideration must be given to the safety chain length to the lower leg and reducing the saver sub seal length to 8" when using 8' elevator links. The following suggested alternatives exist:

- Replace with the upsized 6 ⁵/₈" MSV (has 6 ⁵/₈" connection top and bottom), eliminating the need for the cross over sub.
- On receipt of this bulletin, complete both a wet MPI and visual inspection at least every fourteen operating days while paying *particular attention to the internal transition area for any evidence of washing (see image below)* and drill with elevators closed on the drill pipe. Replace on receipt of new crossover sub with P/N 500330.



Please contact Tesco Corporation at the following email address on issues specific to this bulletin.

Safety_Technical_Bulletins@TescoCorp.com

Contact your local Tesco Part Sales Center for supply of affected components as noted above.