



Safety Bulletin			 <p>Tesco Corporation 6204 – 6A Street SE Calgary, AB. T2H 2B7 Phone: (403) 692 5700 www.tescocorp.com</p>
No: SB038	Rev: 0	Date: 23 Jan 2009	
Description: 10 Station Manifold Enclosure on 150 EMI 400 and 250 EMI 400 Top Drive			

BACKGROUND INFORMATION:

An isolated incident happen in the field where the 10 station manifold enclosure’s door of an EMI 400 top drive broke free of the enclosure. The welds which attach the piano hinge to the enclosure failed, which allowed the door to break free of the enclosure. There is currently no secondary retention on the door. Failure of the welds can result in a dropped object hazard.

To avoid similar incidents, the following actions have been taken:

1. ECN-113-0064 changed the design of 10 station manifold enclosure. The improvements include:
 - The piano hinge was replaced with two bullet type hinges with stronger welds.
 - A safety lanyard was added between the enclosure and the door as a secondary method of retention.
 - The door can now open 180° instead of 160°
2. A repair kit has been developed for units in the field to attach a lanyard between the enclosure and the door as a secondary method of retention. (See “Action required” for details)

AFFECTED PRODUCT:

All 150 EMI 400 and 250 EMI 400 top drive products may be affected. Check inside of 10 station manifold enclosure, if there is no lanyard attached between the enclosure and the door, this unit is affected.

ACTION REQUIRED:

The above mentioned incident is an isolated case. However it is highly recommended that the piano hinge welds are inspected and a nylon-coated lanyard is attached to the enclosure and door as per the following instructions.

1. Order a repair kit TESCO Part no. 1410106. The kit includes the following:

Quantity	Tesco Part Number	Description
2	17431	Screw, Hex head, 3/8” UNC x 1-1/4”, 18-8 SS
4	14552	Washer, sealing, 3/8”
2	17421	Nut, Lock, Nylon, 3/8” UNC, 18-8 SS
2	1083	Washer, flat, type A, wide, 3/8”
2	1410105	Nut, Lock, Stover, 3/8” UNC
16”	16296	Safety Strap, 1/16”
2	14685	Sleeve, oval crimp, copper, 1/16”

2. Drill 13/32” holes at specified location as shown in Figure 1.
3. Install hardware and seal holes with silicone sealant as shown in Figure 1.

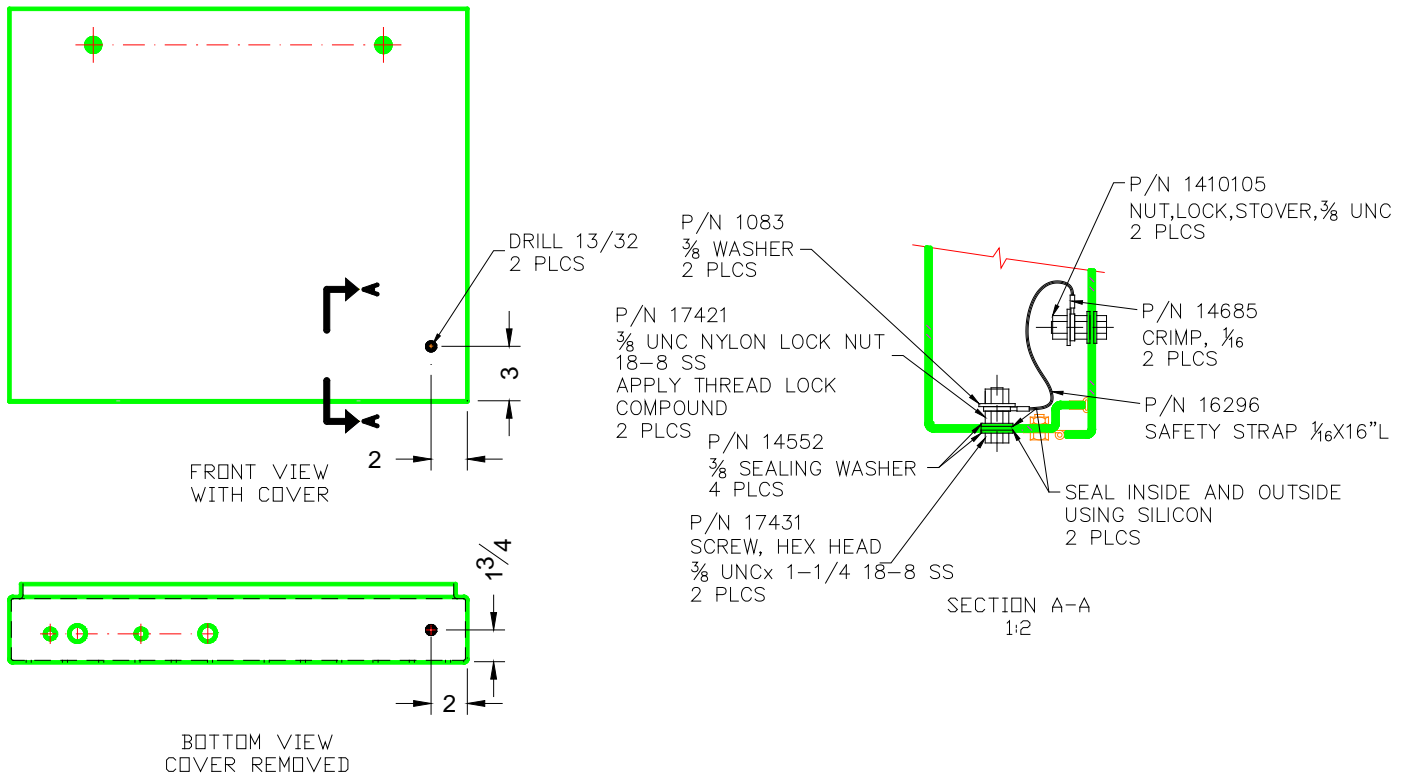


Figure 1



DRILL
HOLES
2 PLCS

Figure 2 shows location of drilled holes.



Figure 3 shows detail of assembled parts on bolt.



Figure 4 shows outside of enclosure after assembling.

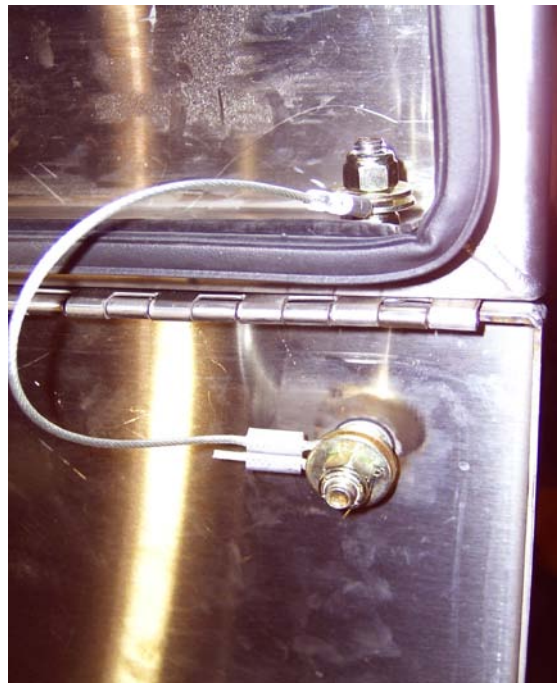


Figure 5 shows inside of enclosure after assembling.

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