

Technical Bulletin

No: TB069

Rev: 0

Date: 16 Sep, 2009

Description: Torque Bushing Clevis Weld Interference (ECN-168-0006)



Tesco Corporation
3993 W. Sam Houston Pkwy N.
Suite 100
Houston, Texas.77043
Phone: (713) 359-7000
www.tescocorp.com

BACKGROUND INFORMATION:

An interference problem has been identified during the manufacturing of Top Drive Torque Bushings. Weld interference is being caused due to the manufacturing tolerances of the following mating parts (See figs 1 & 2):

1. P/N 7750 – 'Clevis, Upper, Torque, Bush, HCI' – Dwg # 40000121
2. P/N 3941 - 'Clevis, Lower, Extend Frame – Dwg # 43030314

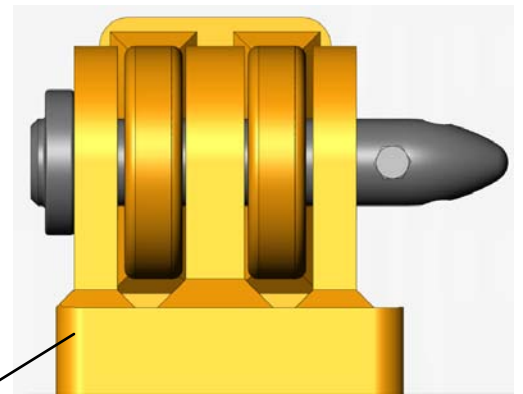
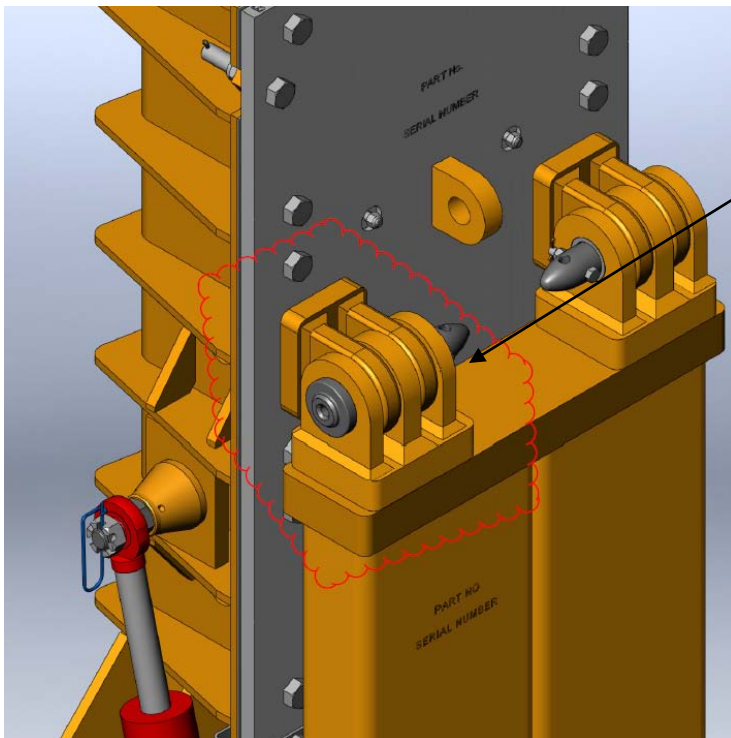


Figure 1

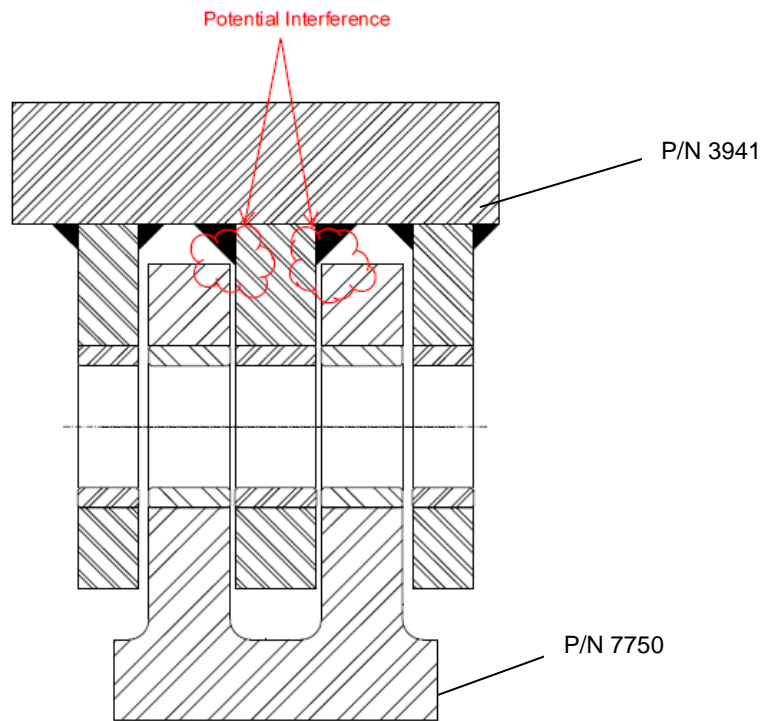


Figure 2

AFFECTED PRODUCT:

Torque Bush Clevis for all ECI, EXI and HCI Top Drives.

ACTION REQUIRED:

1. **Field Repair:** P/N 7750 – ‘Clevis, Upper, Torque, Bush, HCI’, requires an approximate 3/16” radius to be hand ground on the top of each lug (see fig 3). The radii on top of the lugs will eliminate the possibility of weld interference (see fig 4).
2. Surface finish is to be re-applied to prevent corrosion.

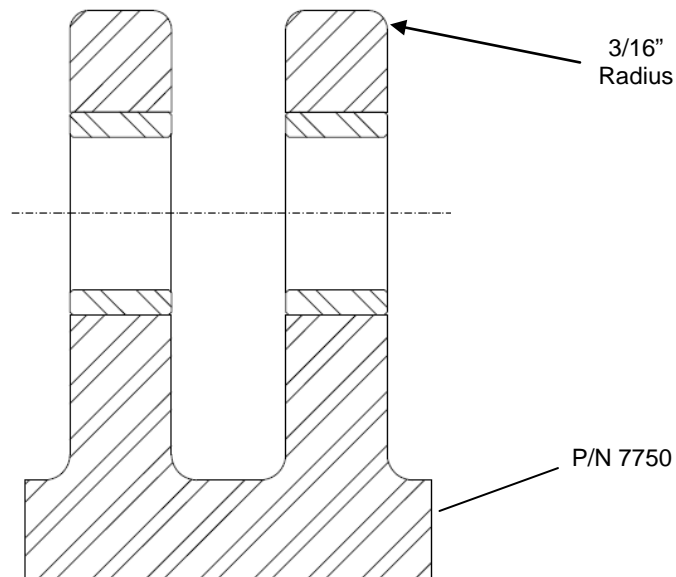


Figure 3

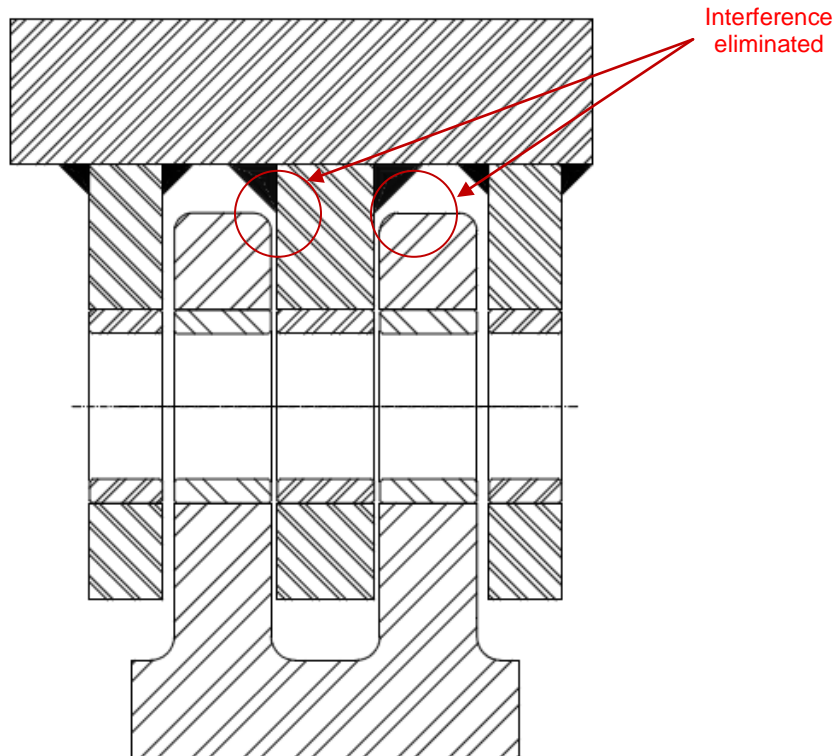


Figure 4

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