



DATE: October 26, 1993

**SUBJECT:** Top Drive Maintenance

**SERIAL NUMBERS:** All

**DISCUSSION:** When doing maintenance or repairs to the Top Drive System, it is important to re-assemble parts to *manufactures specifications*.

**RECOMMENDATION:** When assembling any Top Drive components it is important that:

1. All capscrews be coated with Loctite 242 Threadlocker. This is a medium strength threadlocker that prevents rusting of threads and helps prevent loosening due to vibration. This threadlock can be sheared by normal hand tools.
2. All capscrews and bolts used on the Canrig Top Drives meet or exceed ASTM Gr. 8 specifications. These must be torqued to the values shown in the Parts Books or to the following values:

|               |      |      |      |      |      |      |      |
|---------------|------|------|------|------|------|------|------|
| SIZE:         | 1/4" | 3/8" | 1/2" | 5/8" | 3/4" | 7/8" | 1"   |
| TORQUE(ft.lb) | 11   | 40   | 99   | 198  | 350  | 566  | 848  |
| TORQUE(N.m)   | 14.9 | 54.2 | 134  | 268  | 475  | 767  | 1150 |

It is recommended that tooth anti-vibration lock washers be used where possible.

3. When using capscrews with locknuts, use only Grade C Stover locknuts or equivalent. These can be identified visually by eight raised dots. These are reusable but after repeated removal and installation new nuts are recommended.

**INFORMATION :**

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