



Safety Alert

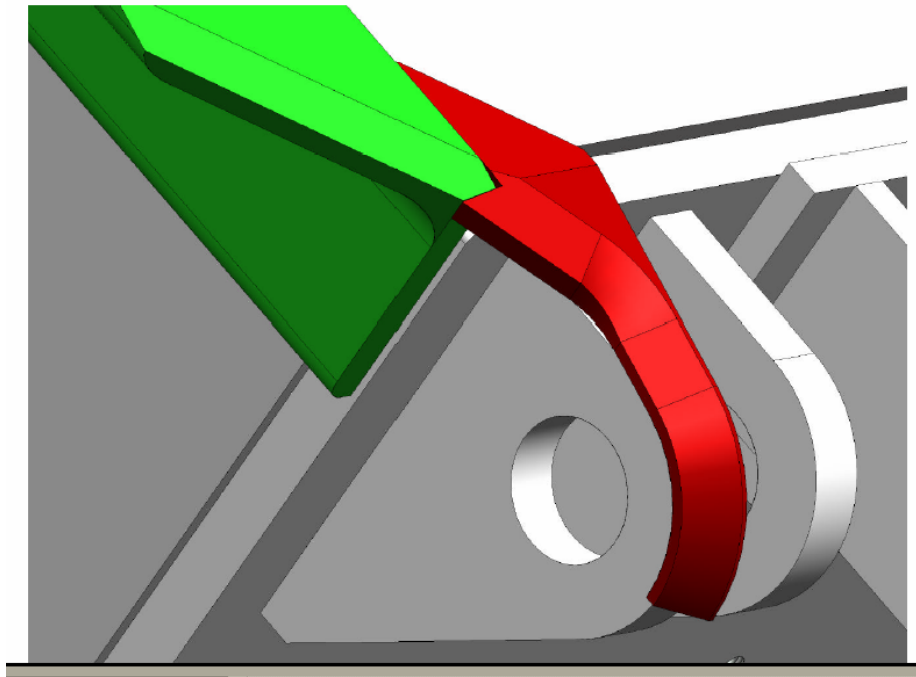
DATE: 25-Jan-05

SUBJECT: Torque Guide – Casing Entrapment

SERIAL NUMBERS: All Portable Torque Guides on TD serial numbers below 270

DISCUSSION: A near miss incident was reported, when a joint of casing got caught on an edge of the bottom of section 2 and subsequently fell to the floor due to breakage of the lifting sling. Although this was considered an unusual accident, CANRIG has developed an additional guard to the hinge point on the bottom of section 2.

RECOMMENDATION: *Perform the modification recommended in PB 52 (Shown Below)*
Further, CANRIG has developed an additional guard that can be installed at the joint of section 2 to decrease another possible pinch point as per the attached drawings. Please order DT14141 and weld as shown on the drawing.



When in doubt, do not hesitate to contact CANRIG and ask questions.

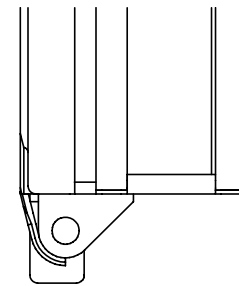
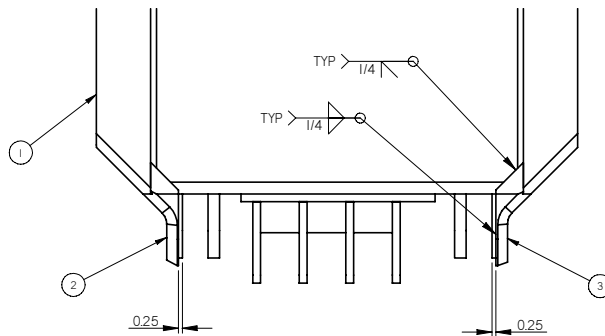
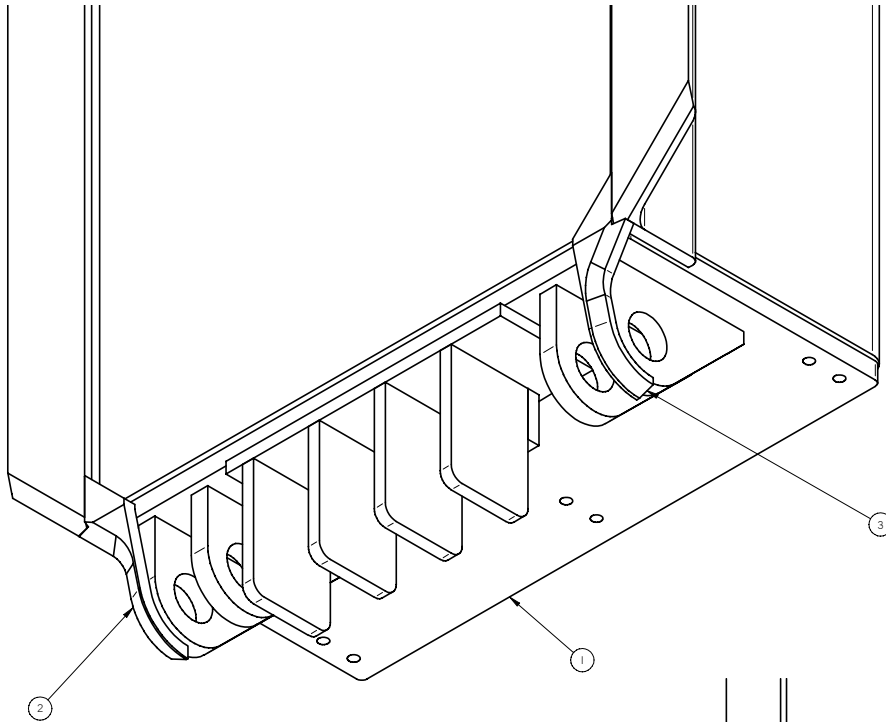
INFORMATION:


For further information contact:

Field Operations Manager
Canrig Drilling Technology Ltd.
14703 FM 1488
Magnolia, Texas 77354
Phone: 281.259.8887

IF IN DOUBT...PLEASE ASK!

ITEM No.	QTY	DESCRIPTION	MATERIAL	CANRIG PART No.
1	1	TORQUE GUIDE SECTION 2, FINAL WELDMENT		893200
2	1	PLATE, DEFLECTOR DS, SECTION 2		DT14140-DS
3	1	PLATE, DEFLECTOR ODS, SECTION 2		DT14140-ODS



No.	YMD	BY	REVISION	WELDING PROCEDURE UNLESS OTHERWISE SPECIFIED - ANSI/AWS D1.1-98 OR CSA W59-M1989	DRAWN DIA	04/04/12	 Canrig CANRIG DRILLING TECHNOLOGY LTD. MOD. SECTION 2, DEFLECTOR PLATE																																																					
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				TOLERANCE - UNLESS OTHERWISE SPECIFIED	<table border="1"> <thead> <tr> <th colspan="2">REMOVE SHARP CORNERS AND BURRS</th> <th colspan="2">FABRICATING (METRIC)</th> <th colspan="2">MACHINING IMPERIAL</th> </tr> <tr> <th>CASTING</th> <th>± 1/16</th> <th>0 TO 600 mm</th> <th>± 1 mm</th> <th>DECIMAL</th> <th>.x ± 0.030"</th> </tr> </thead> <tbody> <tr> <td>⊙ CONCENTRICITY</td> <td>.005 TIR</td> <td>> 600 mm</td> <td>± 3 mm</td> <td></td> <td>.xx ± 0.15"</td> </tr> <tr> <td>— STRAIGHTNESS</td> <td>± .005 IN 5 INCHES</td> <td></td> <td>± 3 mm</td> <td></td> <td>.xxx ± 0.005"</td> </tr> <tr> <td>⊥ SQUARENESS</td> <td>± .010 IN 5 INCHES</td> <td>FABRICATING IMPERIAL</td> <td></td> <td></td> <td></td> </tr> <tr> <td>∥ PARALLELISM</td> <td>± .010 IN 5 INCHES</td> <td>0 TO 24"</td> <td>± .06"</td> <td></td> <td></td> </tr> <tr> <td>⊕ TRUE POSITION</td> <td>.005</td> <td>> 24"</td> <td>± .12"</td> <td></td> <td></td> </tr> <tr> <td>⊖ MACHINED SURFACES</td> <td>125</td> <td>ANGULAR</td> <td>± 2°</td> <td>ANGULAR</td> <td>± 1°</td> </tr> </tbody> </table>			REMOVE SHARP CORNERS AND BURRS		FABRICATING (METRIC)		MACHINING IMPERIAL		CASTING	± 1/16	0 TO 600 mm	± 1 mm	DECIMAL	.x ± 0.030"	⊙ CONCENTRICITY	.005 TIR	> 600 mm	± 3 mm		.xx ± 0.15"	— STRAIGHTNESS	± .005 IN 5 INCHES		± 3 mm		.xxx ± 0.005"	⊥ SQUARENESS	± .010 IN 5 INCHES	FABRICATING IMPERIAL				∥ PARALLELISM	± .010 IN 5 INCHES	0 TO 24"	± .06"			⊕ TRUE POSITION	.005	> 24"	± .12"			⊖ MACHINED SURFACES	125	ANGULAR	± 2°	ANGULAR	± 1°	EST. WEIGHT	SCALE	PROJECT	DTI4141	REV 0
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CANRIG DRILLING TECHNOLOGY LTD

PRODUCT BULLETIN NUMBER: 52

DATE: July 12, 1999

SUBJECT: PORTABLE TORQUE GUIDES

SERIAL NUMBERS: 13, 14, 16, 19-24, 26-33, 36, 38, 40-46, 51-54, 56-65, 67-79, 81-95, 97-102, 104-116, 121, 125, 128, 132, 134, 140

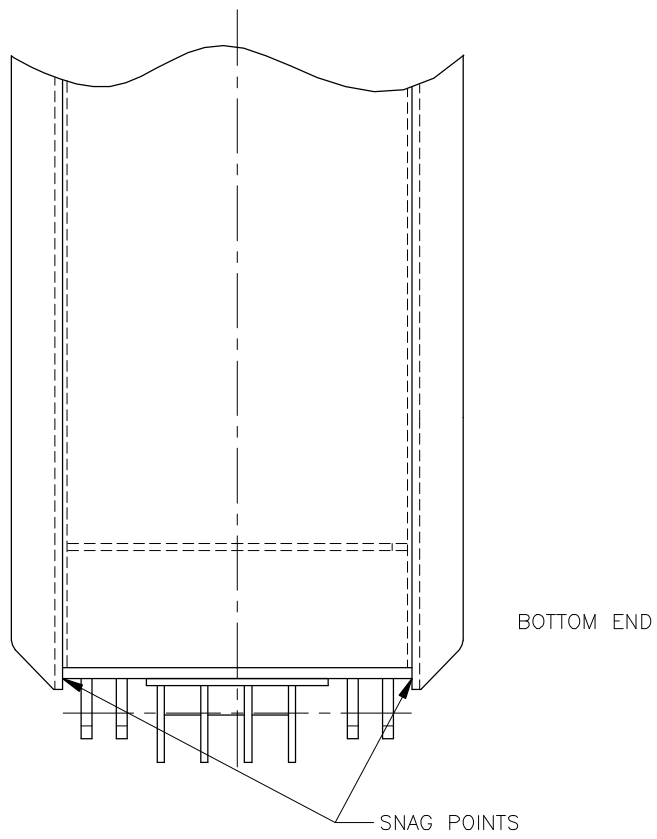
DISCUSSION: When running casing, angles on the Torque Guide Section 2 can be a snag hazard if using a pick-up/lay down machine to push the casing.

RECOMMENDATION: The angles can be trimmed back approximately 1/2 inch to be flush or recessed with the bottom of the Torque Guide tube. See attached drawing. The angle should be beveled and ground smooth. This will help prevent premature wear of the Top Drive guide rails.

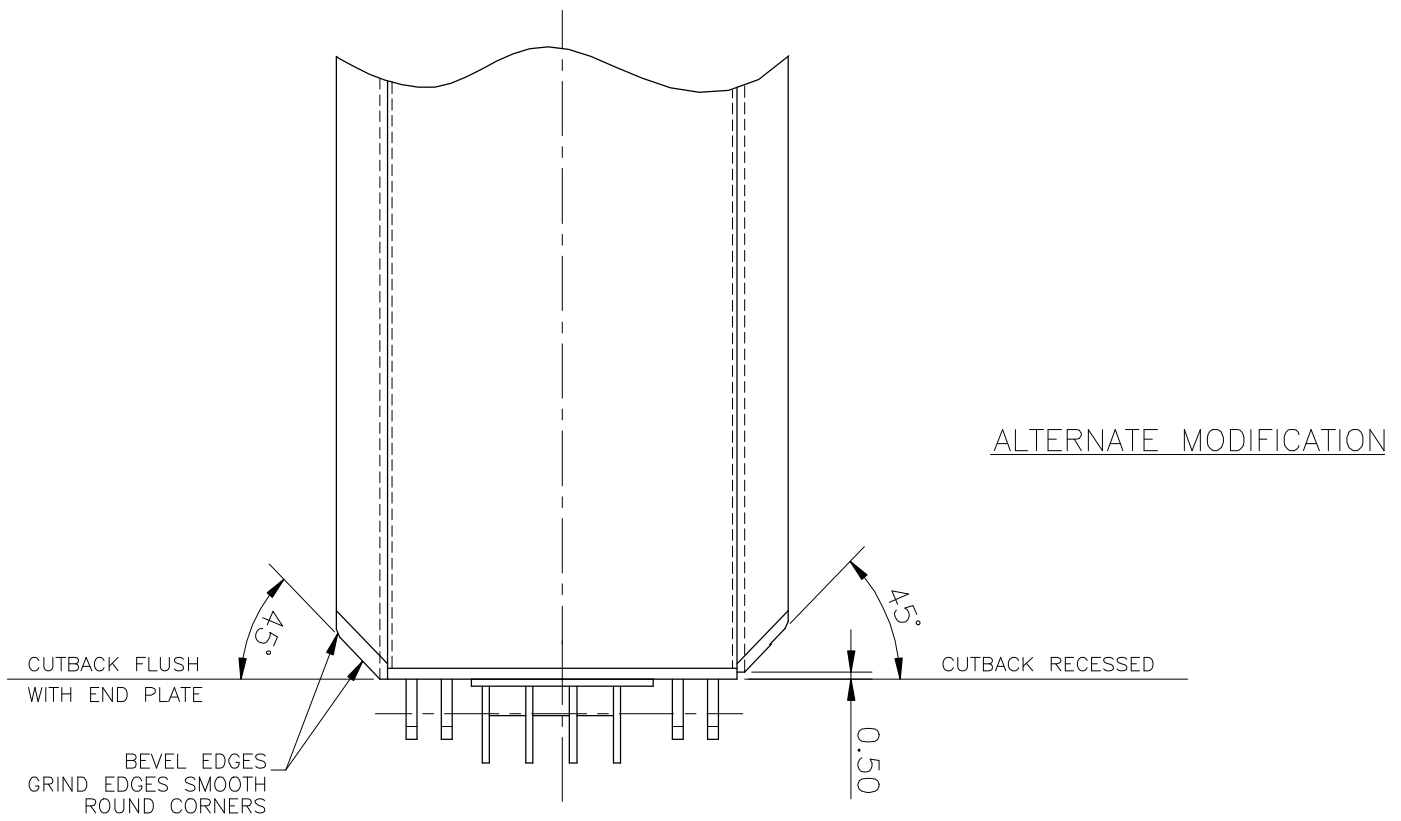
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EXISTING SECTION 2



MODIFIED SECTION 2