
PRODUCT: TOP DRIVE

DATE: 06.08.2010

**SUBJECT: ROTARY HOSE RETENTION, M-RIG, F-RIG, SUNDOWNER
(FOR NABORS TOP DRIVES ONLY)**

**SERIAL NUMBERS: M-RIG - 359,370,394,397,417,424,425,427,429,432,437,438,452,455,464,468,469,470,
475,476,479,480,482,483,488,491,493,494,496,497,508,514,532,533,538,553,557,565,
568,571,738,741,749,752,756
F-RIG - 335,338,346,352,355,356,363,365,372,384,385,387,396,398,400,405,406,407,
408,409,418,422,423,433,439,442,461,471,513,544,549,555,558,570,604
SUNDOWNER AC/DC – 195,362,368,410,414,520,584**

DISCUSSION: It was reported that Rotary Hose safety clamp was secured to the Top Drive Guard with a safety sling which caused a Top Drive Guard member to break off and fall to the rig's floor. This is not a recommended practice.

RECOMMENDATION: If a suitable "tie-off" point is currently not sufficient, kits have been created to provide a permanent "tie-off" location for Rotary Hose Clamp.

Refer to the following Rotary Hose Retention Kits for an itemized parts listing.

TD Models:

Rotary Hose Retention Kits:

**6027AC – M-RIG
1250AC – F-RIG
6027AC/DC - SUNDOWNER**

**AY16645
AY16682
AY16685**

INFORMATION:

For further information
contact:

For a complete list of all bulletins go to www.canrig.com

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M-rig Rotary Hose Retention (AY16645) Procedure:

Parts:

DT19013 - PLATE, RETENT.,ROTARY HOSE,275T,M-SERIES
SH-0750NC-0350-W - CAPSCR, HEX SOC HD, 3/4-10UNC x 3.50, W
LW-0750-NLS - LOCKWASHER, 3/4 NORD-LOCK SMALL
M21-2000-010 - WIRE ROPE, 1/16", 7 x 7, STAINLESS
M19-3006-010 - FERRULE, 1/16, OVAL, ALUMINUM
E03-2000-010 - CABLE TIE, 13.4 IN LG
(CUSTOMER SUPPLIED) 7/8" x 48" LG WIRE ROPE SLING W/ HEAVY DUTY
THIMBLE AND 7/8" SHACKLE

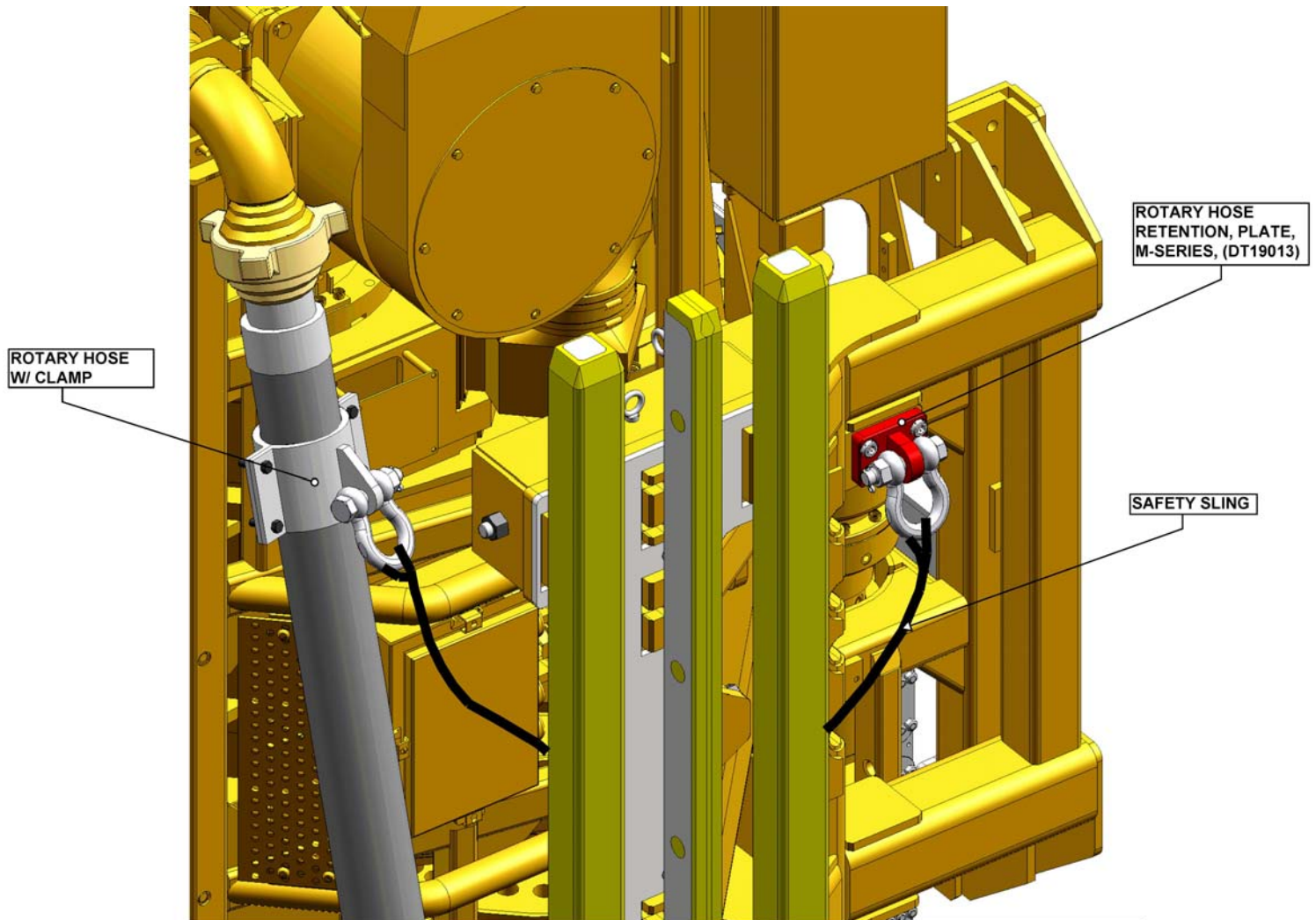


Fig. 1

1. Remove existing (4) $\frac{3}{4}$ "-10UNC capscrews from M-rig Guide Frame and replace with Rotary Hose Retention Kit for M-series (AY16645) which includes Rotary Hose Retention Plate (DT19013) with longer capscrews (4) $\frac{3}{4}$ "-10UNC x 3 $\frac{1}{2}$ " (SH-0750NC-0350-W-GR8) and (4) Nordloc washers (LW-0750-NLS). Rotary Hose Retention Plate (DT19013) is installed on top of the existing M-rig Guide Frame. See Fig. 1.
2. Torque (4) $\frac{3}{4}$ -10UNC x 3 $\frac{1}{2}$ " (SH-0750NC-0350-W-GR8) capscrews to 350 ft-lbs and safety wire with (M21-2000-010) and (M19-3006-010).
3. Install one end of sling to shackle and attach to lug in Rotary Hose Retention Plate (DT19013). (Sling and shackle supplied by customer.)
4. Install other end of sling to a shackle and attach on the Rotary Hose Clamp. Tie-wrap slings to eliminate excess slack with (E03-2000-010). Final assembly should be as shown in Fig. 1.

F-rig Rotary Hose Retention (AY16682) Procedure:

Parts:

DT19020 - LUG, RETENTION, ROTARY HOSE, F-RIG
DT19021 - MOD,LUG,RETENTION,ROTARY HOSE, F-RIG
(CUSTOMER SUPPLIED) 7/8" SHACKLE

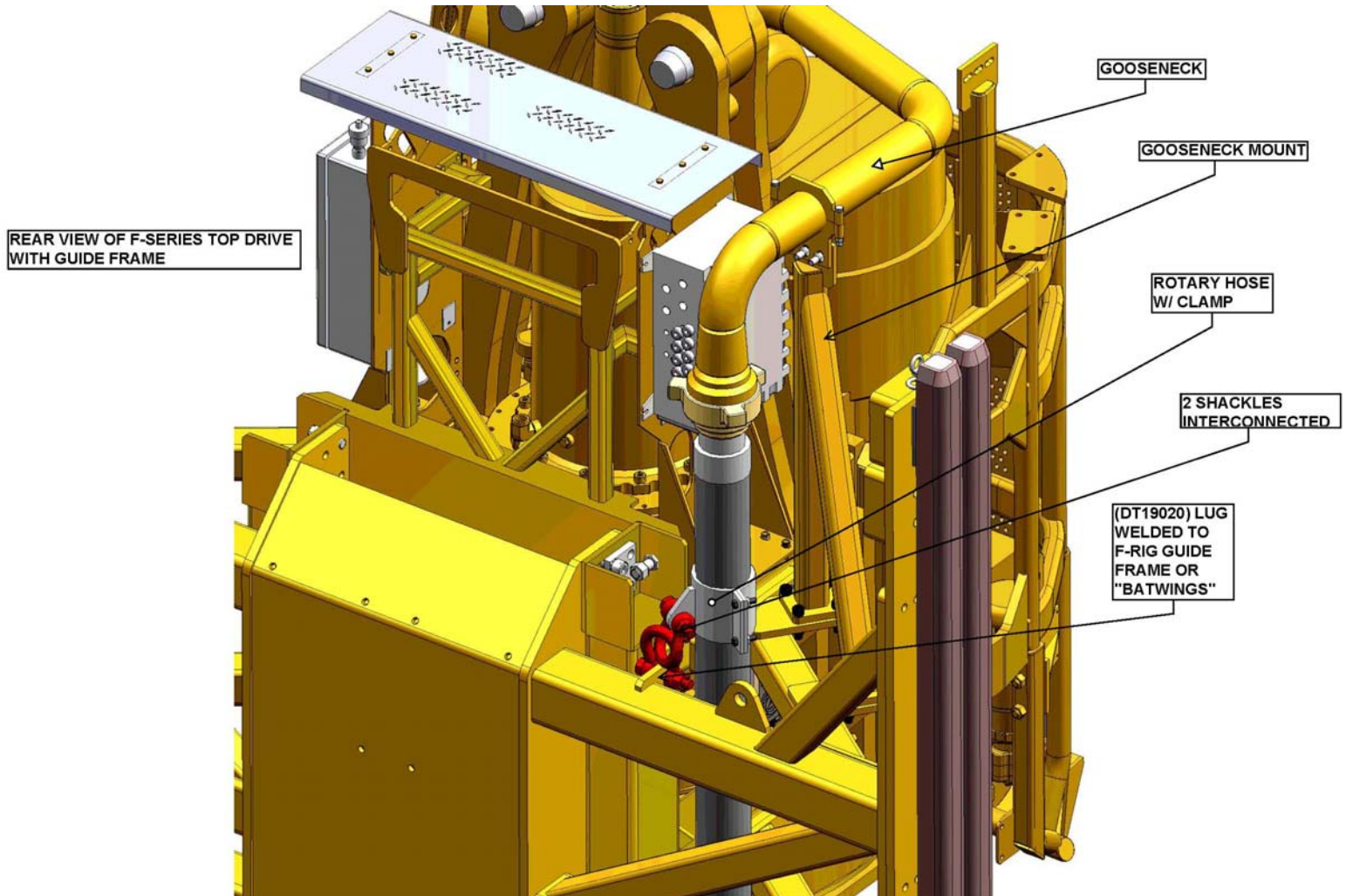


Fig. 2

1. Refer to included drawing (DT19021).
2. Weld lug (DT19020) to F-rig Guide Frame based on specifications shown in the modification drawing (DT19021).
3. Interconnect (2) shackles (supplied by customer) between Rotary Hose Clamp and the lug (DT19020) welded to the F-rig Guide Frame as shown in Fig. 2.

Sundowner Rotary Hose Retention (AY16685) Procedure:

Parts:

DT19013 - PLATE, RETENT.,ROTARY HOSE,275T,M-SERIES
SH-0750NC-0350-W - CAPSCR, HEX SOC HD, 3/4-10UNC x 3.50, W
LW-0750-NLS - LOCKWASHER, 3/4 NORD-LOCK SMALL
M21-2000-010 - WIRE ROPE, 1/16", 7 x 7, STAINLESS
M19-3006-010 - FERRULE, 1/16, OVAL, ALUMINUM
E03-2000-010 - CABLE TIE, 13.4 IN LG
(CUSTOMER SUPPLIED) 7/8" x 48" LG WIRE ROPE SLING W/ HEAVY DUTY THIMBLE
AND 7/8" SHACKLE

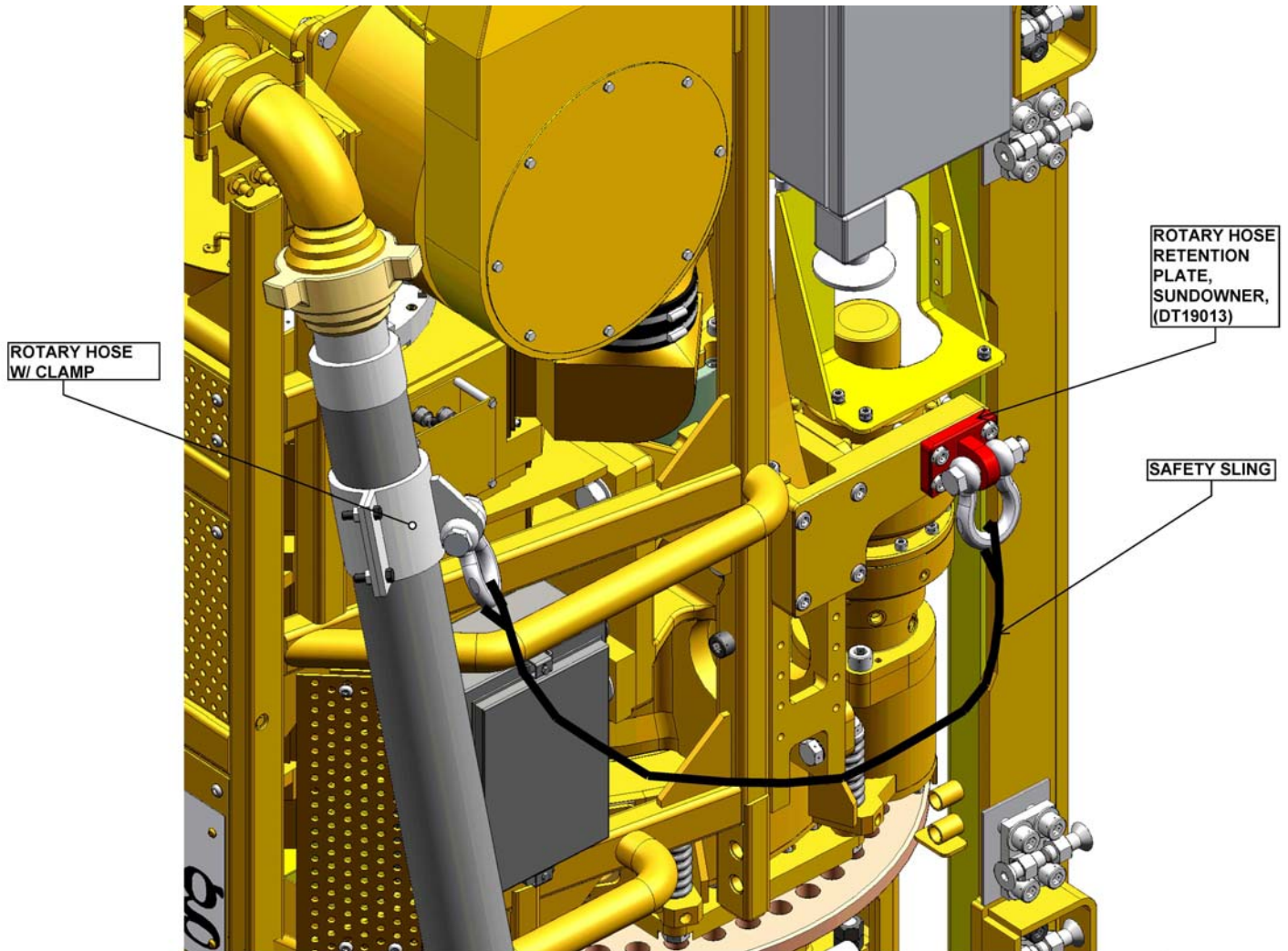


Fig. 3

1. Remove existing (4) $\frac{3}{4}$ "-10UNC capscrews from existing Connector Plate and replace with Rotary Hose Retention Kit (AY16685) for Sundowner which includes Rotary Hose Retention Plate (DT19013) with longer $\frac{3}{4}$ "-10UNC x $3\frac{1}{2}$ " (SH-0750NC-0350-W) capscrews and (4) Nordloc washers (LW-0750-NLS). Rotary Hose Retention Plate is installed on top of the existing Connector Plate. See Fig. 3.
2. Torque the (4) $\frac{3}{4}$ "-10UNC x $3\frac{1}{2}$ " (SH-0750NC-0350-W) capscrews to 350 ft-lbs and safety wire with (M21-2000-010) and (M19-3006-010).
3. Install one end of sling to shackle and attach to lug in Rotary Hose Retention Plate (DT19013). (Sling and shackle supplied by customer)
4. Install other end of sling to a shackle and install on the Rotary Hose Clamp. Tie wrap slings to eliminate excess slack with (E03-2000-010). Final assembly should be as shown in Fig. 3.