

PRODUCT: Portable Top Drive Systems

DATE: 9/26/11

SUBJECT: Torque Guide Section 1, Tensioning cylinders guard

SERIAL NUMBERS: N/A

DISCUSSION: A Guard around the Tensioning cylinders on the Torque Guide, Section 1, was only tack welded and this was missed on inspection. The tack welds subsequently failed, in the field, and the guard fell to the rig floor.

RECOMMENDATIONS: Immediately inspect the cylinder guards to verify they have sufficient welds.

PROCEDURES:

See Fig 1, Fig 2, & Fig 3  
For location of the  
Guard

Location of  
Cylinder Guards  
Under Tensioning  
Cylinders



FIG. 1

Top View  
Of Cylinder Guard



FIG.2

Cylinder Guard

Tensioning Cylinder

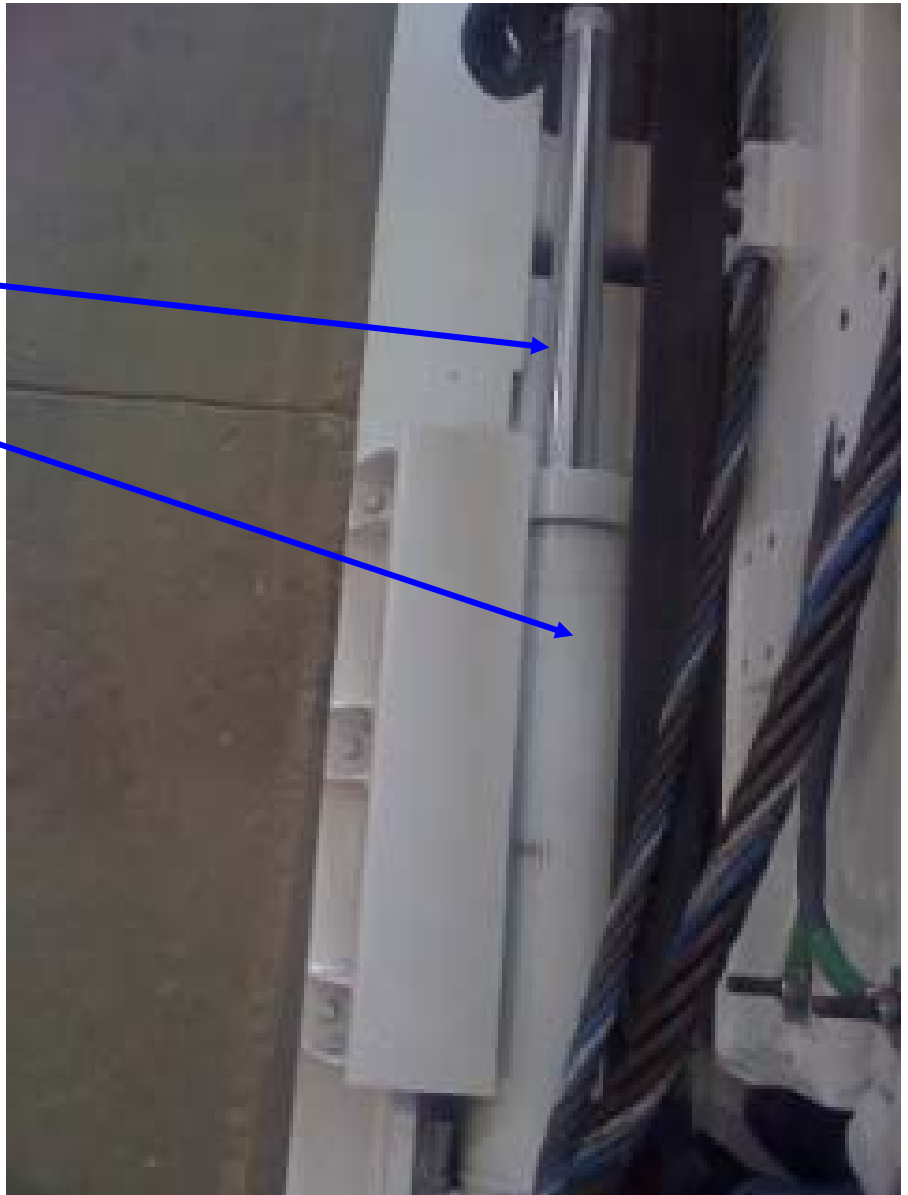


FIG. 3

See Fig 4, 5, & 6 for  
welding inspection areas

1. If there are insufficient welds, or only tack welds. Properly secure the plate to insure it does not fall to the rig floor until Repairs can be performed.
2. If welding is required, insure all equipment is turned off, and the ground for welding is located on the Torque Guide and as close to the welded area as possible.
3. Repairs can be performed using good welding practices for mild carbon steel.

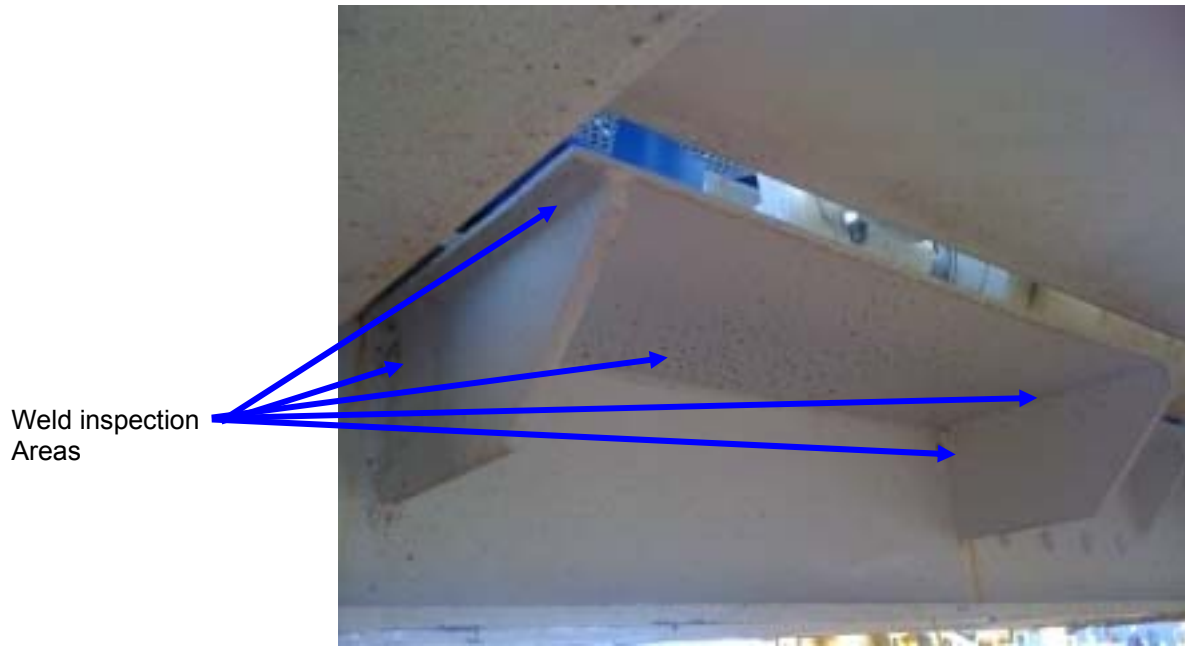
Weld inspection  
Areas



FIG. 4

Weld inspection  
Area





**INFORMATION:**

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