

Safety Bulletin

No: SB039

Rev: 0

Date: Jun. 19, 2008

Description: 350 EXI 600 Top Drive Guard Door Secondary Restraint and Hinge Upgrade



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BACKGROUND INFORMATION:

TESCO has received a report of a hinge failure on a guard door of the 350 EXI 600 top drive. The failure of the hinge resulted in the guard door falling to the rig floor. This bulletin outlines instructions for the installation of a more robust hinge design, and the addition of a secondary restraint for affected product until the upgraded hinge repair has been made.

The incident occurred in a customer's rig up yard, and did not result in any personal injuries.

Refer to the images below for details:

Original EXI guard showing bullet style welded hinges. Two per door on top and bottom doors.

Photo showing installation
Detail of upgraded hinge



Figure 2.
Upgraded Hinge detail

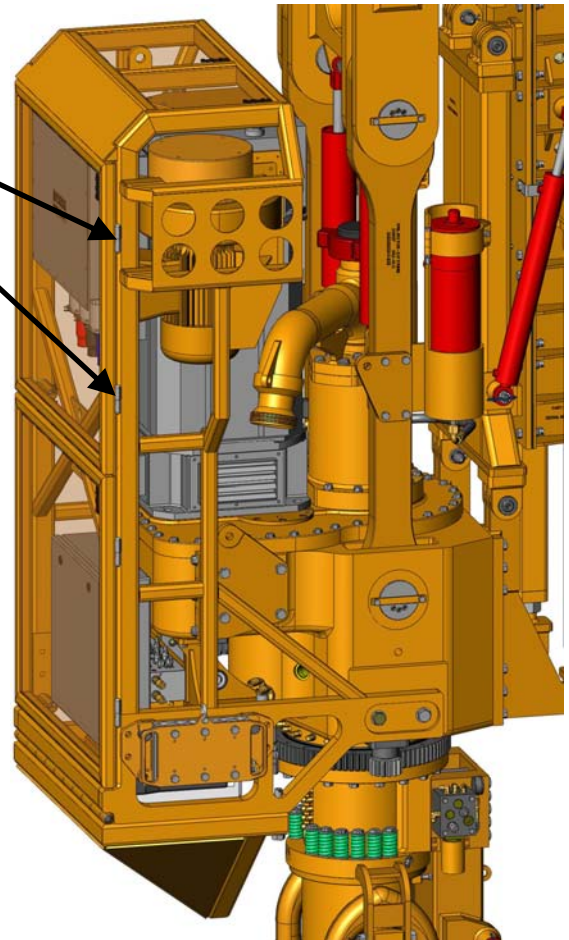


Figure 1.
Original EXI Guard Hinge Detail

AFFECTED PRODUCT:

All 350 EXI 600 top drive system guard doors as shown below:

Affected Part No.	Description
810502	Guard, Final Weldment Assembly, 350EXI600

ACTION REQUIRED:

Hinge upgrade is covered in detail by TESCO ECN #082-0064.

1. Prior to having hinge upgrades performed, TESCO strongly advises operators to add secondary restraint to both the upper and lower guard doors. A suitable restraint can be accomplished by welding a short length (approx. 1 foot) of 3/8" link chain between the guard door, and the guard frame. This chain should be welded to the hinge side of the door so as not to interfere with normal operation of the door.
2. Refer to Figures 3 and 4 below for specific information regarding fabrication of replacement hinges, and modification to guard and doors.
3. After the modifications are completed, the secondary restraint may be removed if desired, or left in place.

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

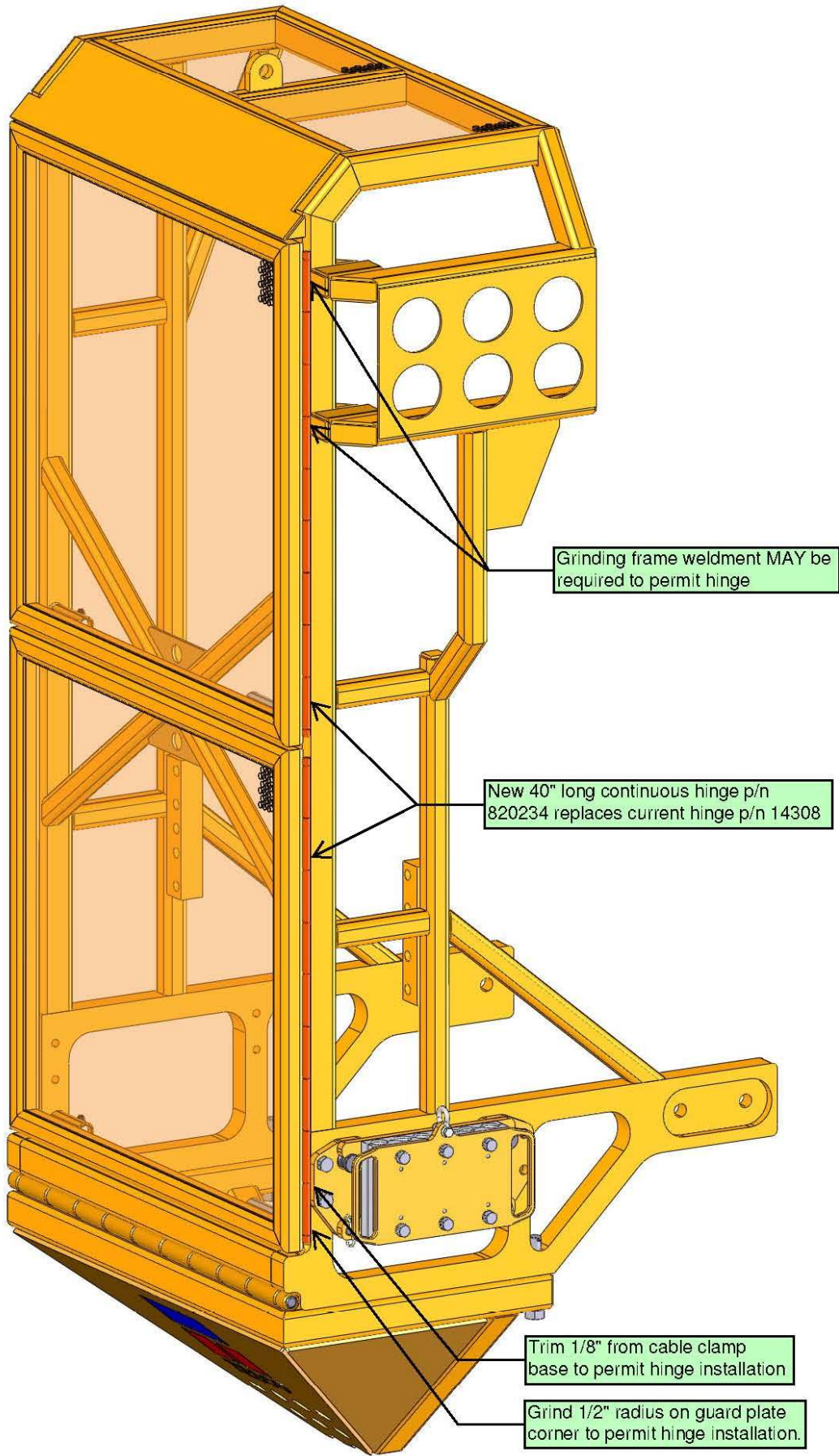
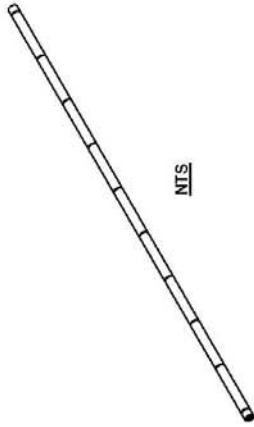
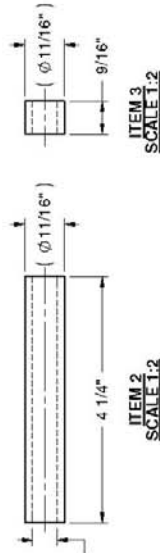
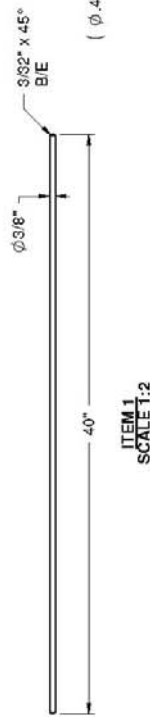
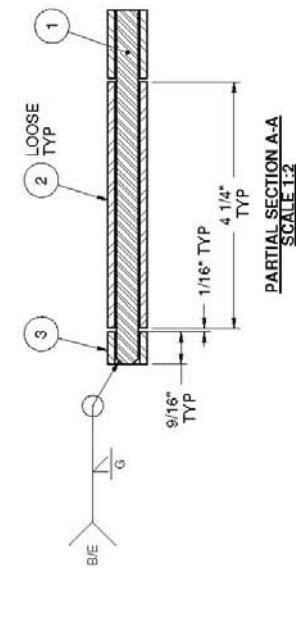
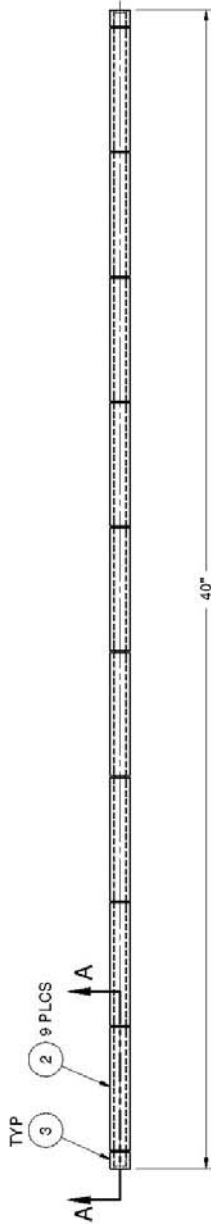


Figure 3. Hinge Upgrade Installation Details

ITEM	PART No.	QTY	DESCRIPTION	SIZE	MATL	WT
1	-	1	BAR, ROUND, 3/8" OD	40" LG	C1018	1
2	-	9	Pipe, 3/8" XS	4 1/4" LG	A106 Gr.B	0
3	-	2	Pipe, 3/8" XS	9/16" LG	A106 Gr.B	0



Member# M71377
 Tesco's permit to practice# P066505
 5 Jun 08

REV	ECN	DATE	DESCRIPTION
0	062-0064	29MAY2008	ISSUED FOR PRODUCTION

<p>NOTES</p> <p>1. UNLESS NOTED, ALL PARTS SHALL BE PERMANENTLY IDENTIFIED.</p> <p>MACHINED PARTS, STAMP, ETCH OR ENGRAVE DRAWING NUMBER, REVISION, AND PURCHASE ORDER NUMBER. WELDMENTS, APPLY DRAWING NUMBER AND REVISION USING FABRICATED PARTS AND SHARES, APPLY DRAWING NUMBER AND REVISION USING PAINT MARKER.</p> <p>2. ALL PRINTS AND COPIES SHALL BE RETURNED UPON JOB COMPLETION. OTHERWISE SPECIFIED IN WRITING BY TESCO CORPORATION.</p>		<p>MATERIAL SPECIFICATIONS:</p> <p>SEE BOM</p> <p>HEAT TREATMENT/SPECIAL PROCESS:</p> <p>N/A</p> <p>ALL DIMENSIONS IN INCHES UNLESS OTHERWISE NOTED</p> <p>TOLERANCES UNLESS OTHERWISE NOTED:</p> <p>MACHINING XX = ±0.00 XXX = ±0.05 BREAK EDGES: 015 X 45° MINIMUM RADIUS R010 FABRICATION: 8" TO 24" ±0.016 > 24" ±0.03</p>	<p>TESCO</p> <p>COPYRIGHT TESCO CORPORATION. ALL INFORMATION IN THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND SHALL REMAIN THE SOLE PROPERTY OF TESCO CORPORATION. THIS DOCUMENT AND ITS CONTENTS ARE NOT TO BE REPRODUCED IN ANY MANNER OR IN PART, NOR SHALL BE REVEALED IN ANY WRITTEN PERMISSION FROM TESCO CORPORATION.</p> <p>THIS IS A BLUE PRINT. DO NOT SCALE DRAWING.</p>	<p>TITLE: HINGE, DOOR, GUARD, 350EXI600</p> <p>PROJECT: KRIS Z</p> <p>DRAWN: KRIS Z</p> <p>DATE: 29MAY2008</p> <p>SCALE: 1:4</p> <p>ENG CHECK: [Signature]</p> <p>DATE: 29MAY2008</p> <p>SHEET SIZE: B</p> <p>WEIGHT: 4 bs</p> <p>PART/DWG NO.: 820234</p> <p>REV: 0</p> <p>PAGE: 1 OF 1</p>
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Figure 4. Fabricated Hinge Detail