



Model: See Affected Units Serial #: N/A	Jan. 20, 2021
Product Bulletin # TDS-222 v 2.0	

LWCV Anti-Rotation Bracket Securement Upgrade

Canrig has updated the securement and safety securement of the Lower Well Control Valve (LWCV) anti-rotation bracket. This update reduces the risk of a dropped object incident by eliminating the option for multiple bolt lengths and incorrect safety wiring of the anti-rotation bracket.

Affected Units

All top drives with a Canrig manufactured 3" LWCV actuator.

Recommendation

Contact RIGLINE 24/7™ to order kit Canrig P/N: AY24529. Install the updated bracket securement on the LWCV actuator following the procedure below.

Table 1: LWCV Anti-Rotation Bracket Securement Kit – P/N: AY24529

Item	P/N	Qty	Units	Description
1	DT25176	4	EA	Stud, Threaded, 3/8-16UNC x LG, Wired
2	HN-0375NC-GR8	4	EA	Hex, Nut, 3/8-16UNC, GR8
3	LW-0375-NL-SP	4	PAIR	Lockwasher, 3/8, Nord-Lock, SP
4	M19-3009-010	2	EA	Ferrule, 1/8, Oval, Aluminum
5	M10022	24	IN	Wire Rope, 1/8, 7 x 19, Stainless
6	M19-3006-010	4	EA	Ferrule, 1/16, Oval, Aluminum
7	M21-2000-010	36	IN	Wire Rope, 1/16" Dia
8	C10009	1	EA	Threadlocker, Loctite #271, Red
9	DT25178	6	EA	Shim, Anti-Rotation Bracket
10	DT25173	1	EA	Chain Link, 1/4", Securement Loop

Procedure

1. Perform lock-out/tag-out procedure according to local regulations to isolate all forms of energy to the top drive.
2. Remove LWCV actuator from the top drive.



Caution! Do not lift the actuator by the guard. Use a lifting cap for the valve to lift the actuator.

3. Weld Item 10 to the actuator guard on the same side the anti-rotation bracket is mounted to as shown in Figure 1 with a 1/8" fillet weld.

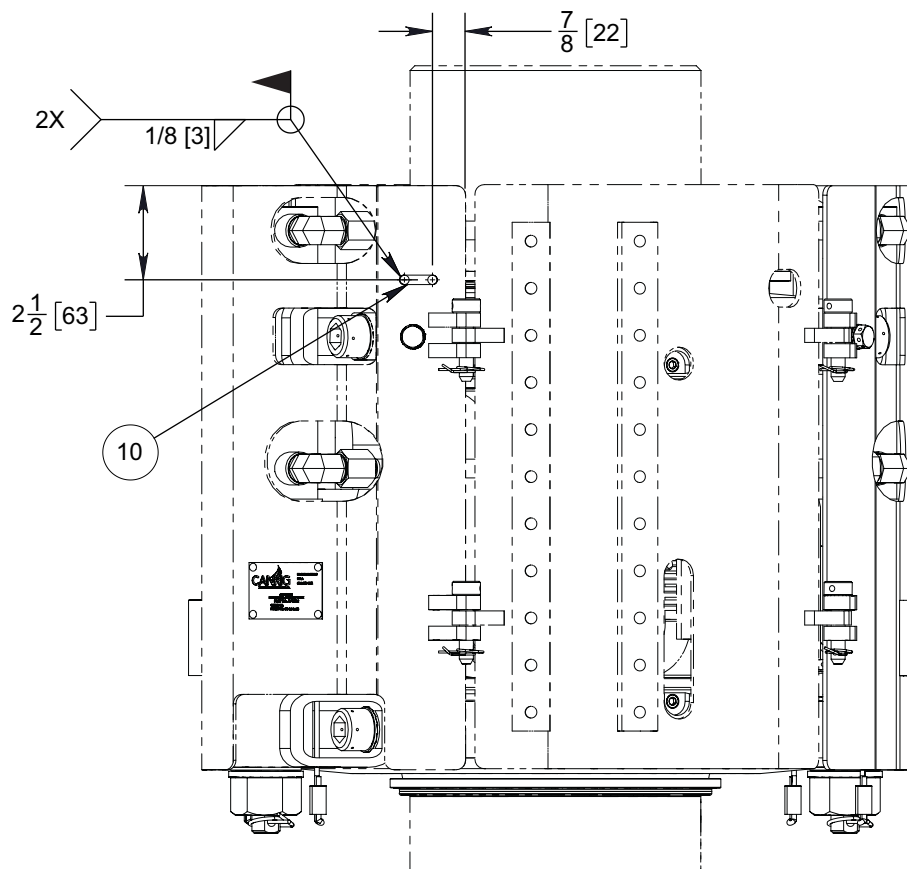


Figure 1: Welding Securement Point to Guard

4. Remove the anti-rotation bracket and shim plates from the LWCV actuator.
5. Clean the hole threads where the bracket was mounted.
6. Take the anti-rotation bracket and Item 9 (DT25178). Align over the threaded holes. Install same amount of shim plates as were taken off.



Note: It is possible to install the anti-rotation bracket, shims, and studs after LWCV actuator is threaded on to the quill.

7. Install Qty. 4 of Item 1 (DT25176) into threaded holes on the guard panel as shown in Figure 2. Run studs down until they bottom out on the guard. Do not over torque.

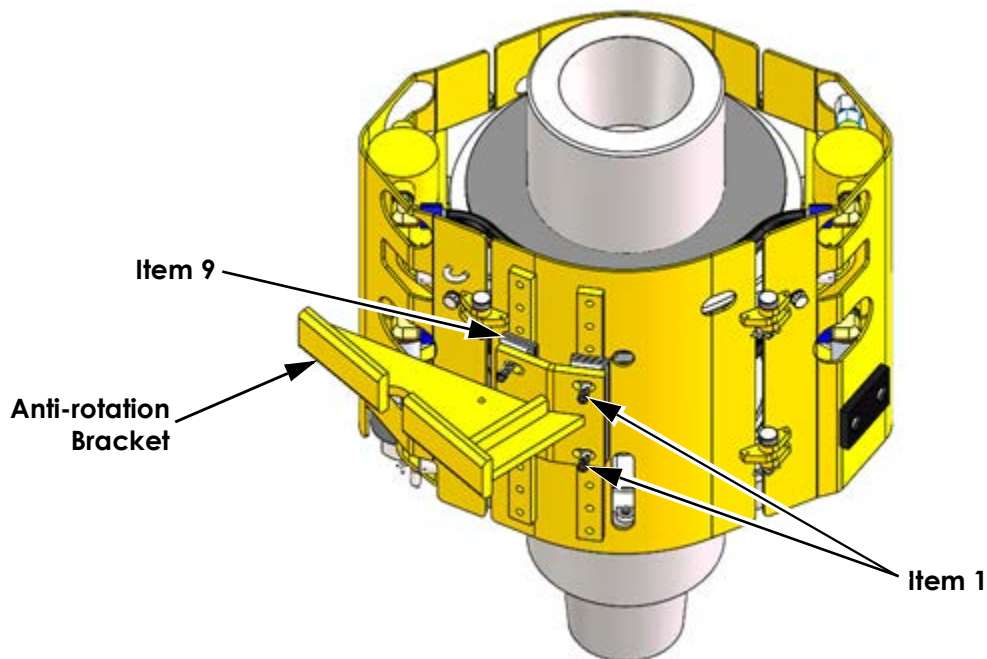


Figure 2: Installation of Threaded Studs

8. Apply Red Loctite® #271 to Qty. 4 of Item 2 (HN-0375NC-GR8). Install Item 2 and Item 3 (LW-0375-NL-SP) onto the threaded studs as shown in Figure 3. Torque to 40 ft-lb (54 N-m).
9. Allow 10 minutes for Loctite to dry.

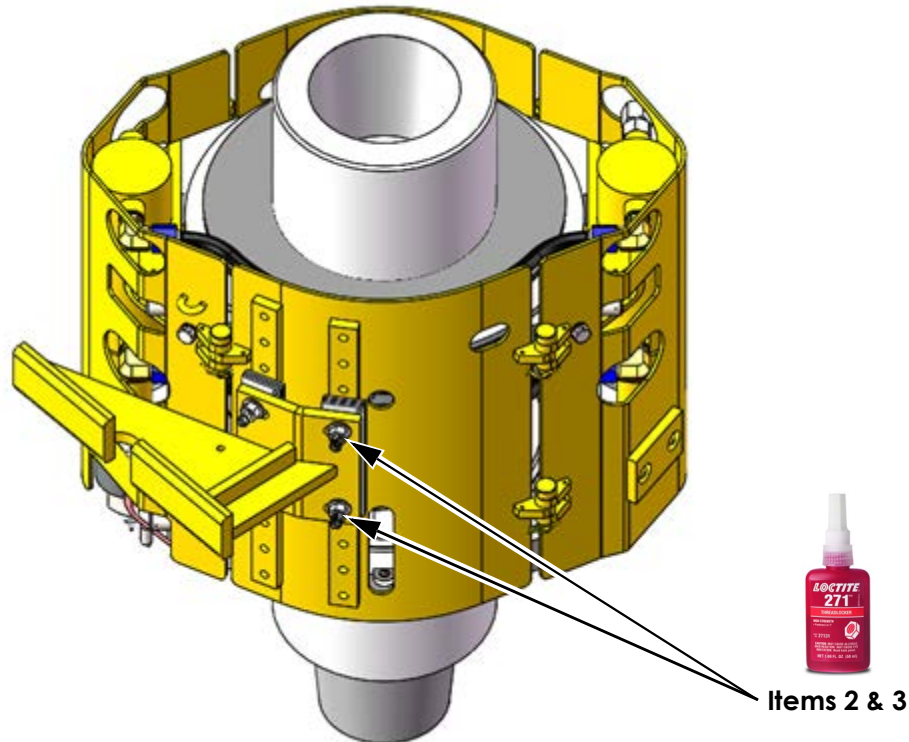


Figure 3: Anti-Rotation Bracket Installation

10. Install Items 4 & 5, 1/8" safety wire and ferrules around anti-rotation bracket, as shown in Figure 4 on page 5. Ensure excess slack is removed.
11. Install Items 4 & 5, 1/8" safety wire and ferrules through shims (DT25178), as shown in Figure 4 on page 5. Ensure excess slack is removed.
12. Install items 6 & 7, 1/16" safety wire and ferrules through threaded studs (DT25176), as shown in Figure 4. Ensure excess slack is removed.

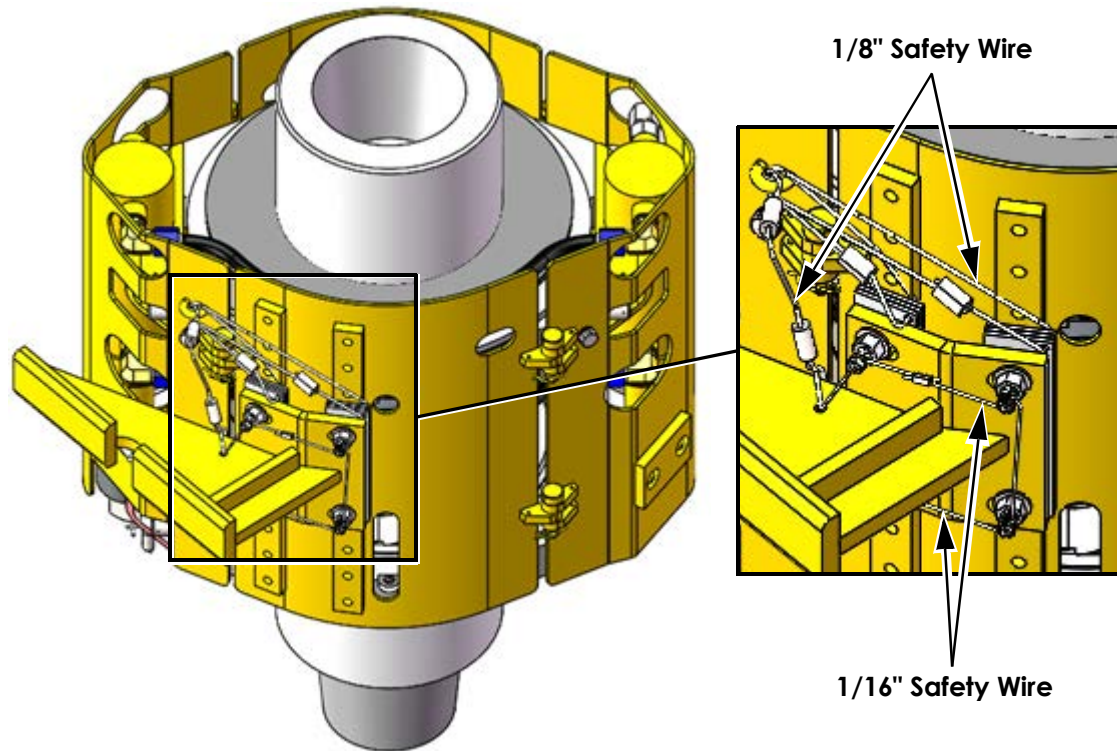


Figure 4: Safety Wire Installation

13. For more details about safety securement, see provided drawing AY24529.
14. Install LWCV actuator on the top drive. Ensure there is a 1/8" gap between the anti-rotation bracket and the Back-Up Wrench (BUW).
15. Remove lock-out/tag-out and continue operations.