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| Model: 1250AC/1275AC | Jun. 26, 2019 |
| Serial #: N/A | |
| Product Bulletin # TDS-169 Version: 2.0 | |

Blower Motor U-Bolt Support

Scope

This document supersedes the previous version. It has been revised to include support for the P10576-7 blower which is rated for 480V. Disregard this bulletin if upgrade procedures have already been implemented on blower models P10576 (600V) or P10576-7 (480V) following the previous version. Canrig recommends implementing this upgrade in all other instances.

Issue

During periods of rough drilling, the feet on the motors used on the P10576 (600V) and P10576-7 (480V) blowers could fatigue and crack. This could leave the motor unsecured to the blower motor mount and/or cause damage to the impeller.

Affected Blower

| Blower Part No. | Blower Motor Part No. | Blower Motor Voltage |
|-----------------|-----------------------|----------------------|
| P10576 | E01-1016-030 | 600V |
| P10576-7 | E13343 | 480V |

Note: Contact RIGLINE 24/7™ Support to order the U-bolt upgrade kit for blowers other than the one listed.

Recommendation

- Inspect the blower assembly. Check for signs of cracks or other damage to the motor, motor mount, or blower frame. Replace or repair any damaged components.
- Regularly inspect the blower assembly for signs of cracks or damage to the components. Check for loose or broken connections and fasteners. Inspect daily under normal conditions. Inspect more frequently when experiencing rough drilling and high vibrations. See section 4B of the Top Drive Product Manual for recommended inspection intervals.

If additional support to the blower motor is desired, Canrig offers a kit that allows the installation of U-bolts, see Table 1 below.

Table 1: (AY23152 Rev C) Blower Motor Support U-Bolt Assembly Components

| Item | Qty. | Part No. | Description |
|------|------|--------------|--|
| 1 | 1 | DT33137 | U-BOLT, 1/2-13UNC x 13.38 H x 10.25 ID Note: This item only required for older P10576 blower U-bolt replacement. |
| 2 | 2 | DT33138 | U-BOLT, 1/2-13UNC x 14.38 H x 12.75 ID |
| 3 | 4 | LN-0500NC-SS | LOCKNUT, 1/2-13UNC, GR8, STOVER |
| 4 | 10FT | M21-2000-010 | WIRE ROPE, 1/16 IN, DIA |
| 5 | 10 | M19-3006-010 | FERRULE, 1/16, OVAL, ALUMINUM |
| 6 | 2 | H16712 | CLAMP, HOSE, 3/16 IN ID, WORM TYPE, SS |

U-bolt Addition Procedure

Preliminary Fabrication

The blower motor mount will require four (4) drilled holes at locations indicated on Figure 1 for installation of the U-bolts on the P10576 blower and Figure 2 on page 3 for the installation of the U-bolts on the P10576-7 blower.

Drilled Holes for P10576 Blower

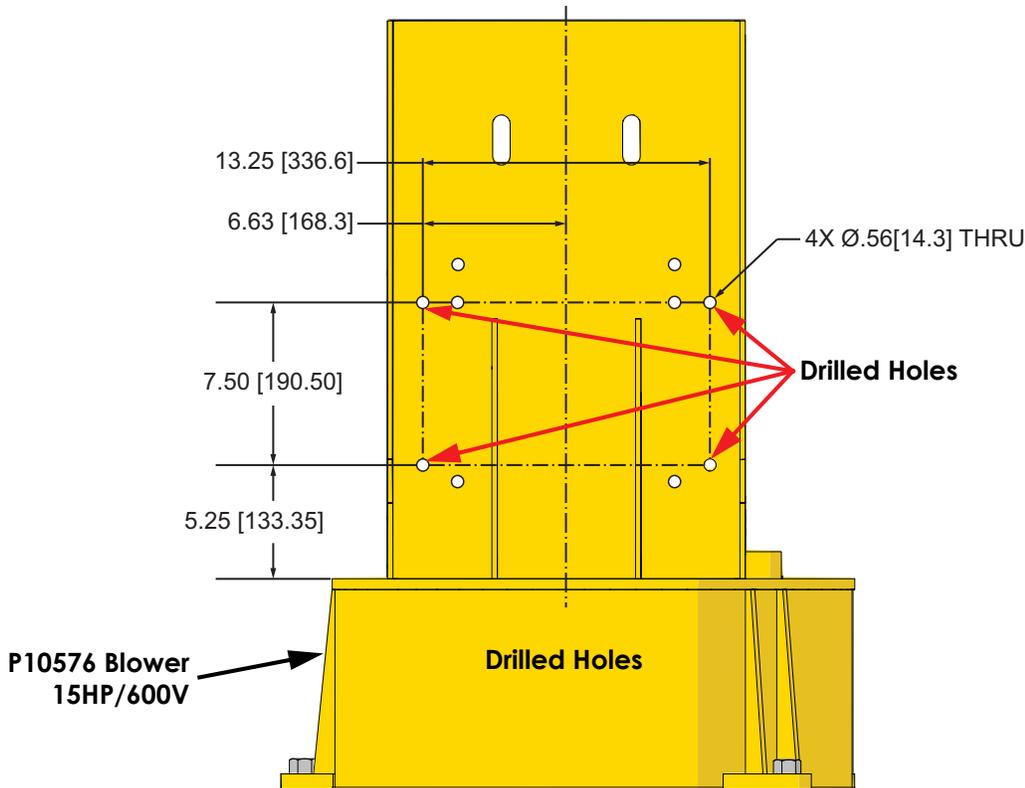


Figure 1: Four holes required to mount U-bolts on P10576 Blower

Drilled Holes for P10576-7 Blower

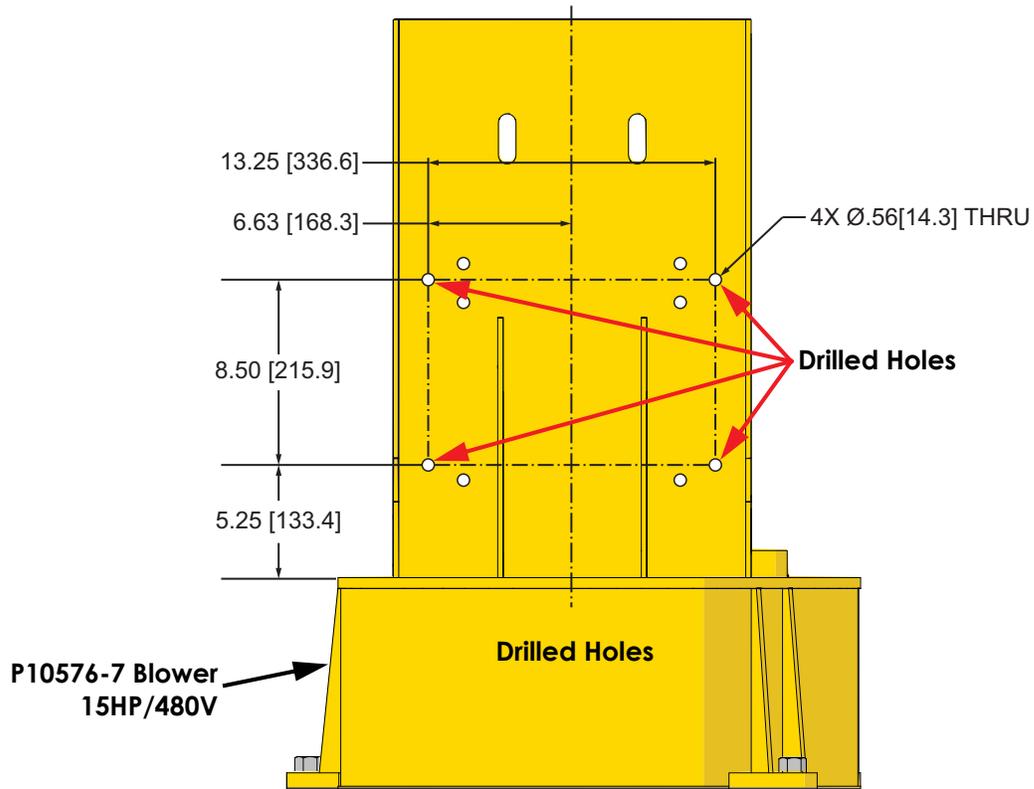


Figure 2: Four holes required to mount U-bolts on P10576-7 Blower

Installing U-bolts

1. Make a closed loop with wire rope around each hose clamp and crimp before securing hose clamp to the U-bolt as shown on Figure 3 and Figure 4. Locate hose clamp (H16712) around 6 1/2 inches from the end of the thread of the U-bolt and secure it as shown on Figure 3.

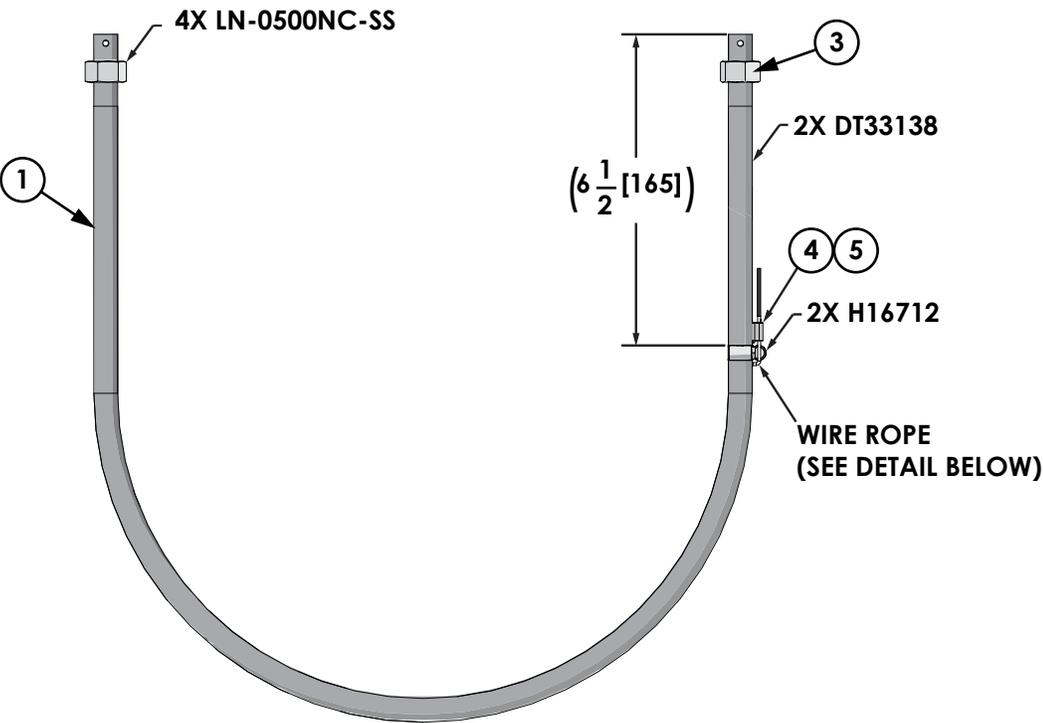


Figure 3: Detail of U-bolt

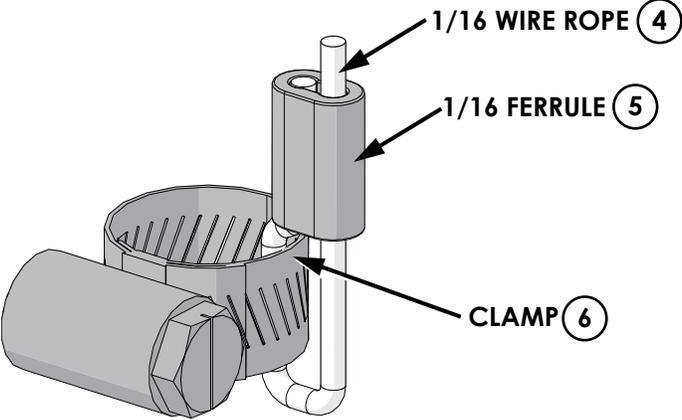


Figure 4: Crimp safety wire to Item 6 (hose clamp)

2. Loop existing wire ropes crimped to hose clamps through the blower motor mount cutouts as shown on Figure 5. Ensure minimal slack in safety wire.

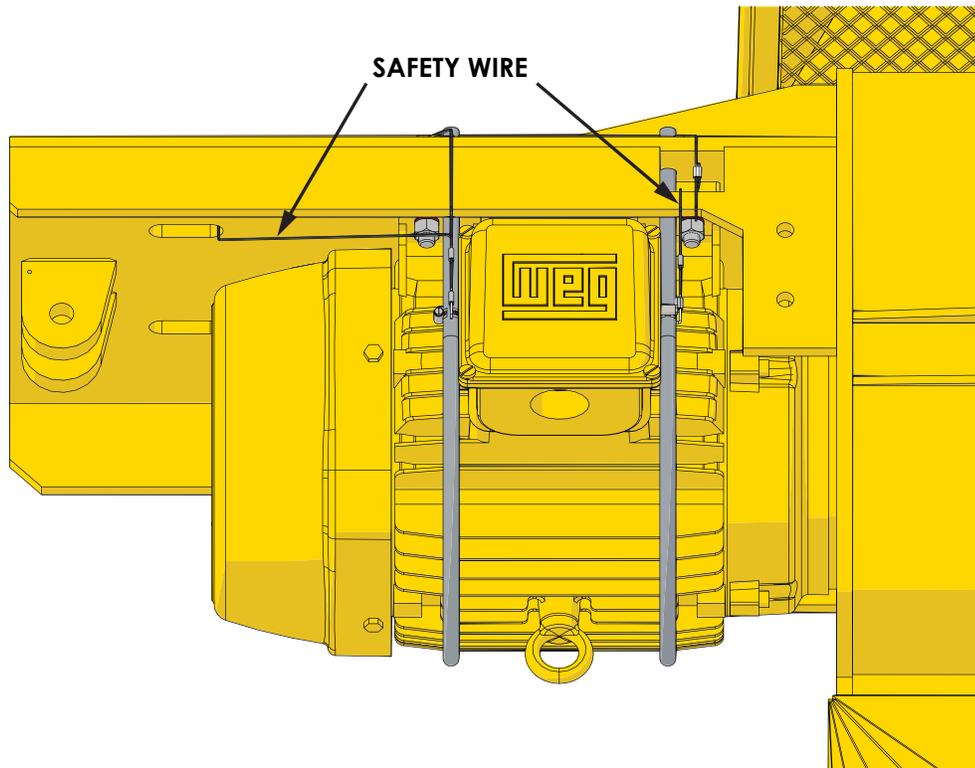


Figure 5: Safety Securement for U-Bolts

3. Clamp the blower motor by installing the two U-bolts (DT33138) firmly around the bottom of the blower motor and through holes drilled in blower support mount as shown on Figure 6.
4. Install LN-0500NC-SS locknuts on DT33138, torque to 43 ft-lbs.

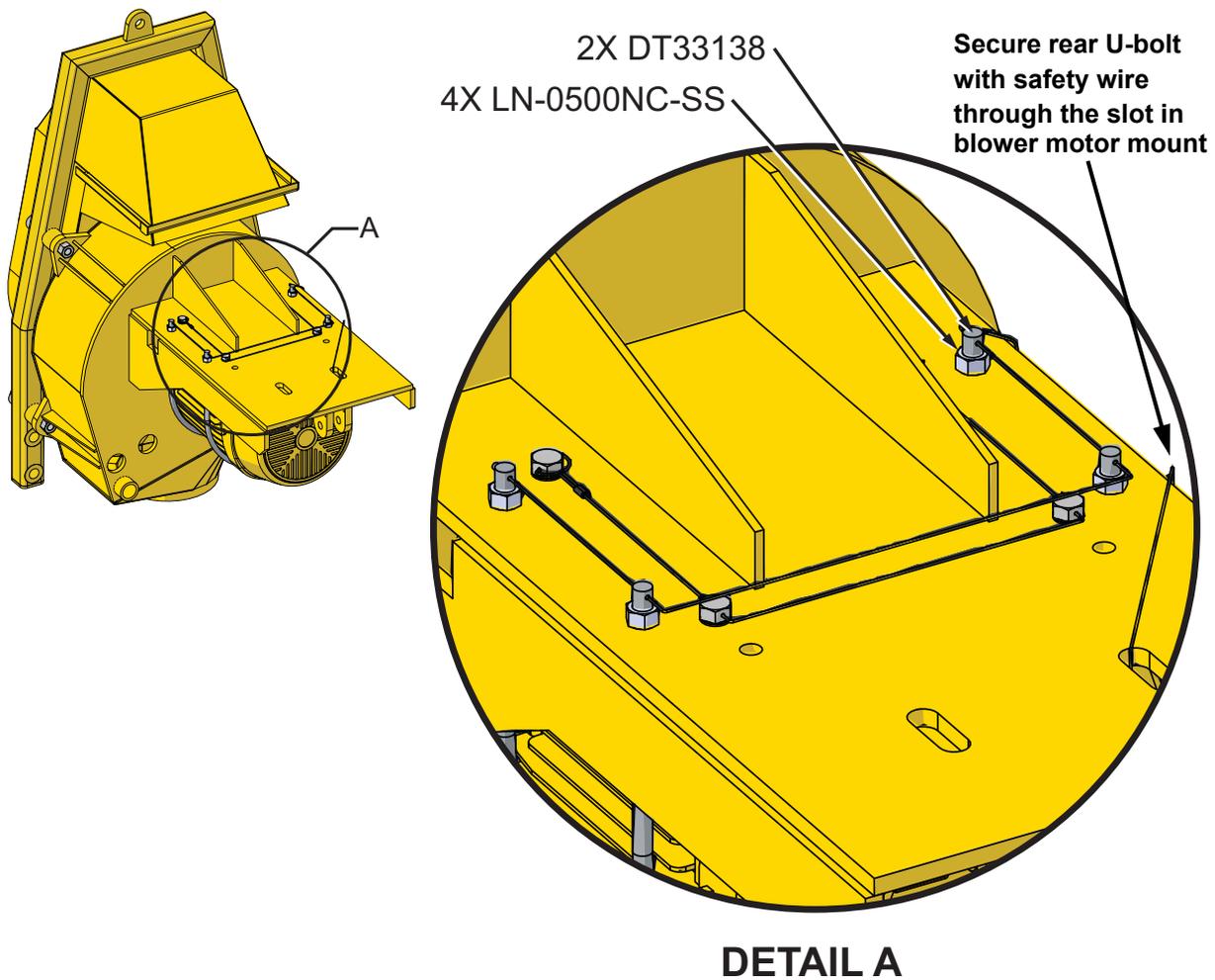


Figure 6: Install U-bolts

5. Add safety securement to the U-bolts by adding safety wire (M21-2000-010) through drilled holes in threaded end of the U-bolts (DT33138) as shown on Figure 7. Crimp with ferrules (M19-3006-010). Attach the other end of the safety wire through the blower motor mount cutout. Ensure minimal slack in safety wire.

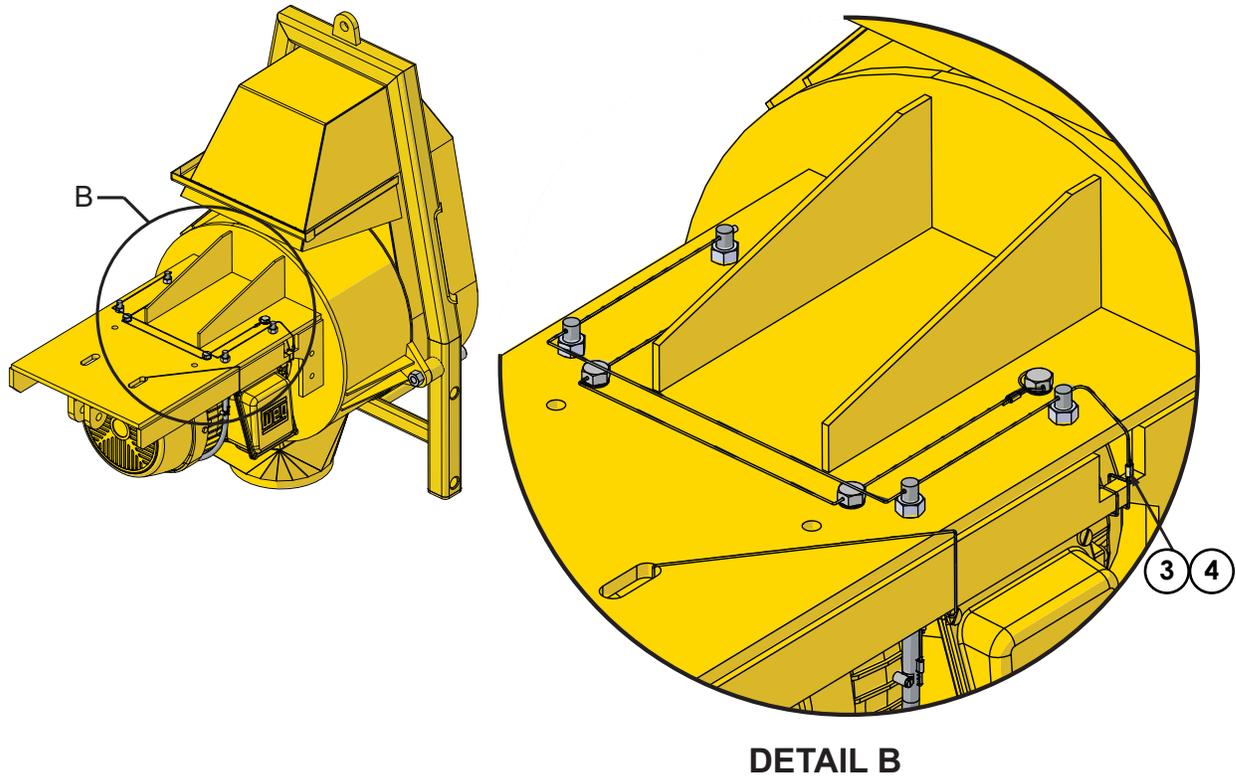


Figure 7: Safety securement on the U-bolts. See Table 1 on page 2 for items.