



Model: 275T – 750T	Sep. 11, 2018
Serial #: See Affected Assemblies List	
Product Bulletin # TDS-186	

Adding Safety Securement to Steel Stabbing Bell Adjuster Plate

In response to Product Alert TDS-179, Canrig recommends adding safety securement to the steel stabbing bell adjuster plate. The following procedures must be followed by qualified technicians only.

Option 1: Modify the existing steel stabbing bell adjuster plate (P/N DT14614) to add safety securement. See "Option 1: Modifying Existing Adjuster Plate" on page 2.

Option 2: Replace the existing adjuster plate (P/N: DT14614) with an updated version that has an improved adjuster plate and stabbing bell guides. Contact RIGLINE 24/7™ Support to order the Kit (P/N: AY23442). The Kit includes the new fasteners and wire rope. Canrig recommends replacing the existing adjuster plate if the existing adjuster plate is damaged or deformed. See "Option 2: Replacing the Adjuster Plate" on page 2.

Affected Assemblies

Consult affected top drive product manual to verify affected BUW frame assemblies.

Table 1: Affected Assemblies

Top Drive Models	BUW Frame Assemblies and Steel Stabbing Bell Kits
6027 AC 1250 AC 1275 AC	AY21507
	AY17930
	AY13519
	AY13519-1
	AY21317
	AY21323
	AY22712
	AY12915
	AY12916
	AY21918
	AY12924
	AY12925
	AY12926
	AY12929

Option 1: Modifying Existing Adjuster Plate

Use the steps below to modify the existing adjuster plate for safety securement. **Do not re-use a damaged or deformed adjuster plate!** Replace adjuster plates that are damaged or deformed. See Option 2 to replace the adjuster plate.

1. See “Removing the Steel Stabbing Bell and Guide” on page 3 to remove the stabbing bell and guides with adjuster plate.
2. Drill the two 3/16" holes on the stabbing bell adjuster plate (Canrig P/N: DT14614) as shown in Figure 1.

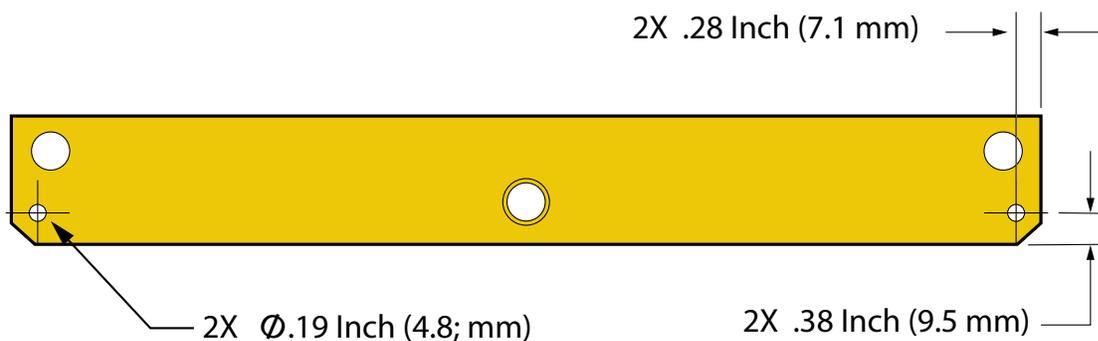


Figure 1: Modifying Existing Adjuster Plate (P/N: DT14614)

3. Re-install the adjuster plate and steel stabbing bell guide. See “Installing the Stabbing Bell Guide” on page 6.
4. Re-install the steel stabbing bell. See “Reinstalling the Steel Stabbing Bell” on page 8.

Option 2: Replacing the Adjuster Plate

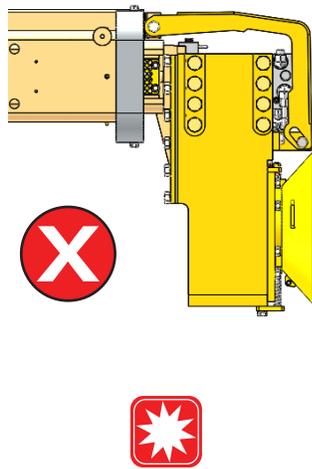
The existing adjuster plate (P/N: DT14614) can be replaced with an updated version. Canrig has created a Kit (P/N: AY23442) with an improved adjuster plate and Stabbing Bell guides. The Kit (P/N: AY23442) includes the new fasteners and wire rope.

Contact the RIGLINE 24/7™ Support to order Kit (P/N AY23442). Refer to the following procedure to replace the existing adjuster plate (P/N DT14614) and guides (P/N DT14612 and P/N DT14613).

P/N	Unit of Measure	Qty	Description
AY23442	Each	1	Kit, Guide, Steel Stabbing Bell

Removing the Steel Stabbing Bell and Guide

Before disassembly of steel stabbing bell components, orient the Back-up Wrench (BUW) as shown in Figure 3 or Figure 4 so the stabbing bell cannot accidentally drop out when the front retainer plate is removed. **Do NOT orient the BUW as shown in Figure 2!**



Danger! The Steel Stabbing Bell can fall out in this Position after the retaining plate has been removed!

Figure 2: Incorrect BUW Position. **(DO NOT USE)**

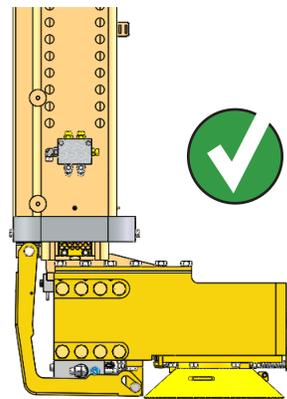


Figure 3: Correctly oriented BUW

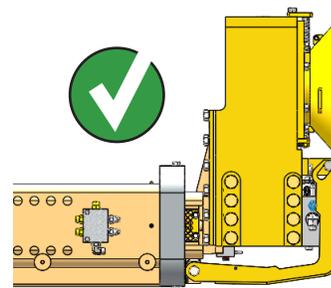


Figure 4: Correctly oriented BUW.

1. Loosen the four 5/8" fasteners uniformly to control the release of the spring energy. Remove the four 5/8" fasteners (UNF) to remove the front retainer plate. **Note:** These fasteners use UNF (Fine Thread) and **should be used only in this location.**



Caution!

The front retainer plate has stored energy due to the compressed springs. **Care should be taken when removing the front retainer plate!**

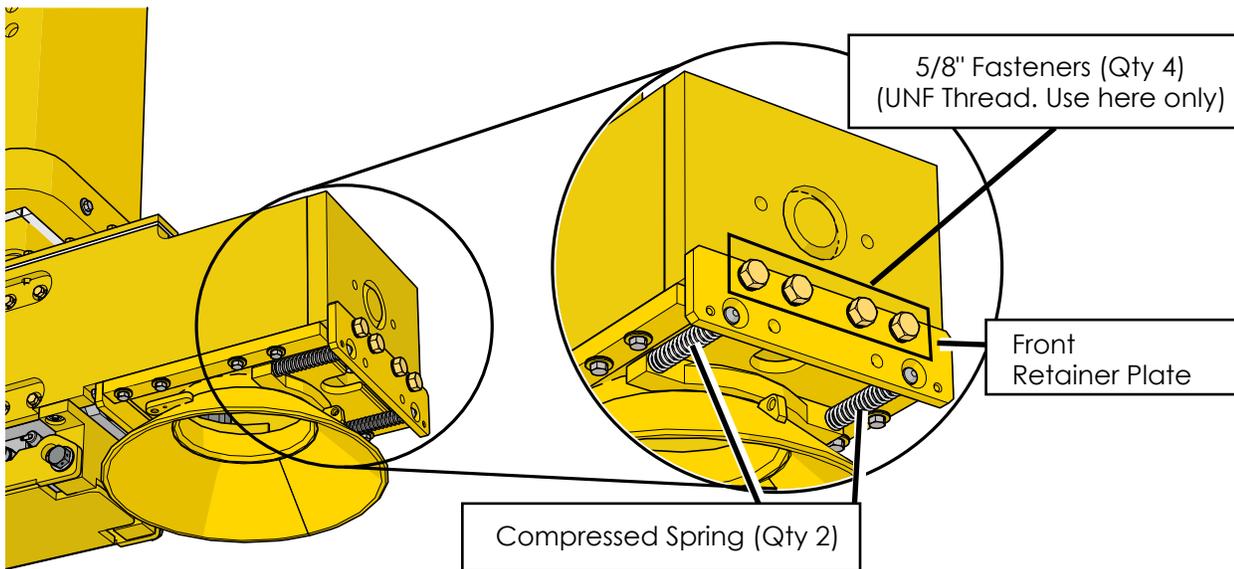


Figure 5: Loosen Fasteners uniformly to control the release of spring energy

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- Slide out the stabbing bell toward the front of the gripper to remove it from the guides.



Warning!

Some older BUW use tensioner springs to position the stabbing bell. **These tensioner springs will have stored mechanical energy**, so care should be taken when removing the stabbing bell! See Figure 7 on page 5.

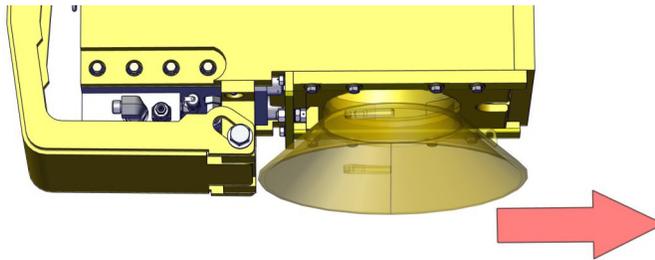
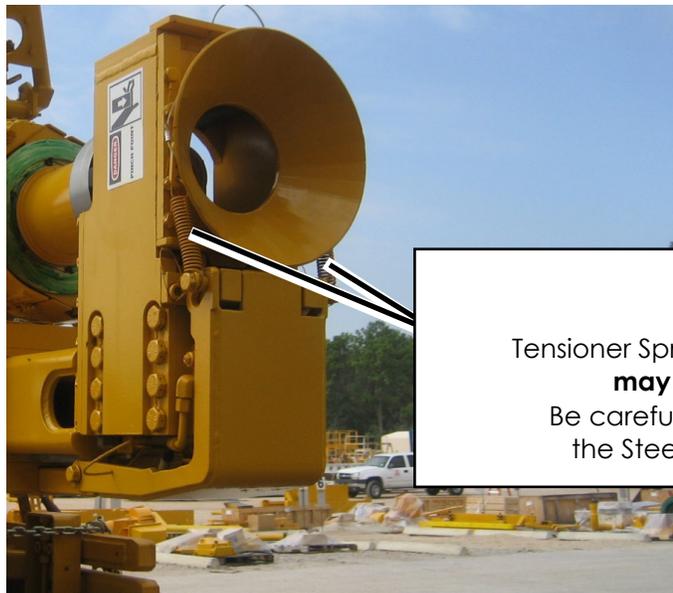


Figure 6: Slide the Steel Stabbing Bell toward the front of the gripper to remove

- Some older BUW Steel Stabbing Bells use tensioner springs to position the stabbing bell. These springs will have stored energy. **Caution must be taken when removing the steel stabbing bell!**



Tensioner Springs. **Spring Energy may be present!**
Be careful when removing the Steel Stabbing Bell!

Figure 7: Some BUW Designs use Tensioner Springs

- Remove the eight 5/8" fasteners to remove both guides (P/N: DT14612 and P/N: DT14613) and adjuster plate (P/N: DT14614).

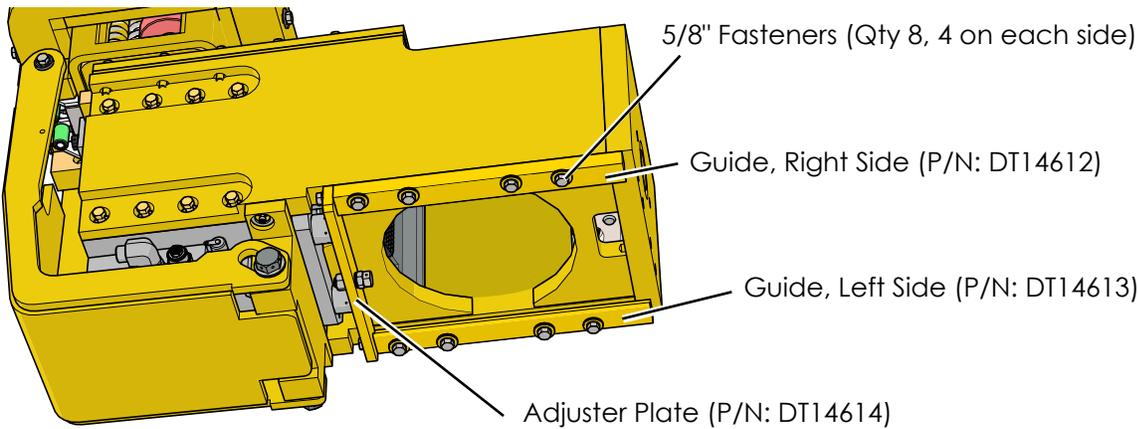


Figure 8: Back-Up Wrench with old design for Adjuster Plate and Guides

Installing the Stabbing Bell Guide

- Coat all fasteners with Loctite® 242 threadlock or equivalent.
- Use 1/2" fasteners (P/N: SH-0500NC-0125-W) to fasten adjuster plate to the stabbing bell guides. See Figure 9. Torque 1/2" fasteners to 99 ft-lb.

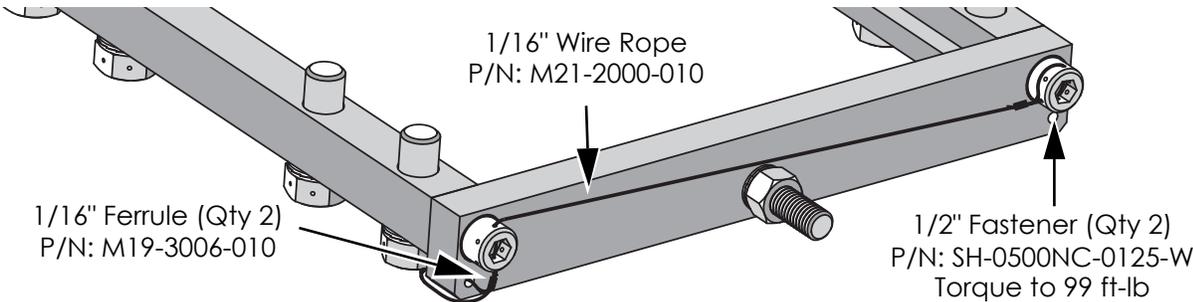


Figure 9: Safety Wire the bolts on the Adjuster Plate

- Secure with 1/16" wire rope (P/N: M21-20000-010) and 1/16" ferrule (P/N: M19-3006-010) as shown in Figure 9.

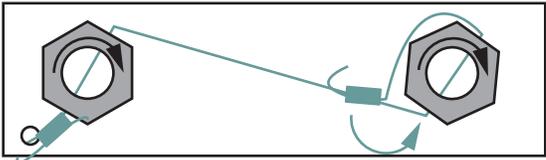


Figure 10: Backward rotation is prevented by the tension from properly routed secondary retention.

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- Install new stabbing bell guide kit (P/N AY23442) using supplied 5/8" bolts (HH-0625NC-0175-GR8-W, QTY 8) and 5/8" Nord-Lock Washers (LW-0625-NL, QTY 8). Torque the 5/8" bolts to 198 ft-lb.
- Safety wire these fasteners using 1/16" wire rope (P/N M21-2000-010) and 1/16" ferrules (P/N M19-3006-010). See Figure 12 and Figure 13.

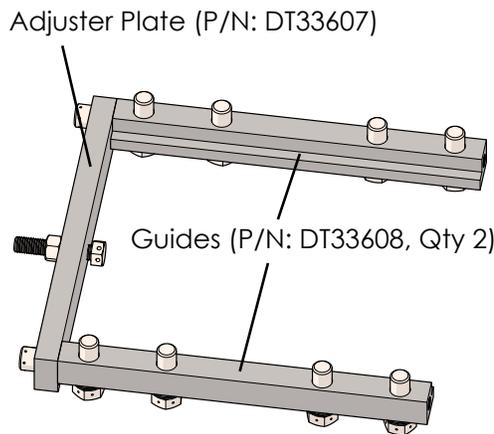


Figure 11: Stabbing Bell Guide Kit (P/N AY23442)

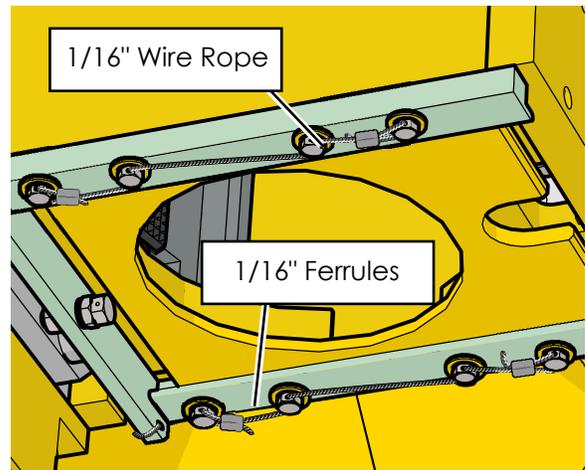


Figure 12: BUW with Kit and Safety Wire

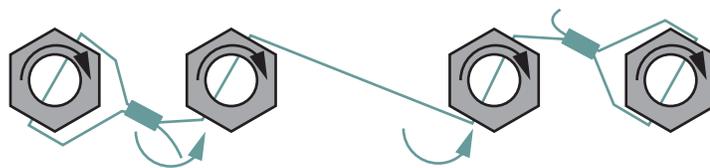


Figure 13: Backward rotation is prevented by the tension from properly routed secondary retention.

- Use 1/8" wire rope (P/N M10022) and 1/8" ferrules (P/N M19-3009-010) to secure the adjuster plate (P/N: DT33067) by looping around the Back-up Wrench lower guard mount as shown in Figure 14.

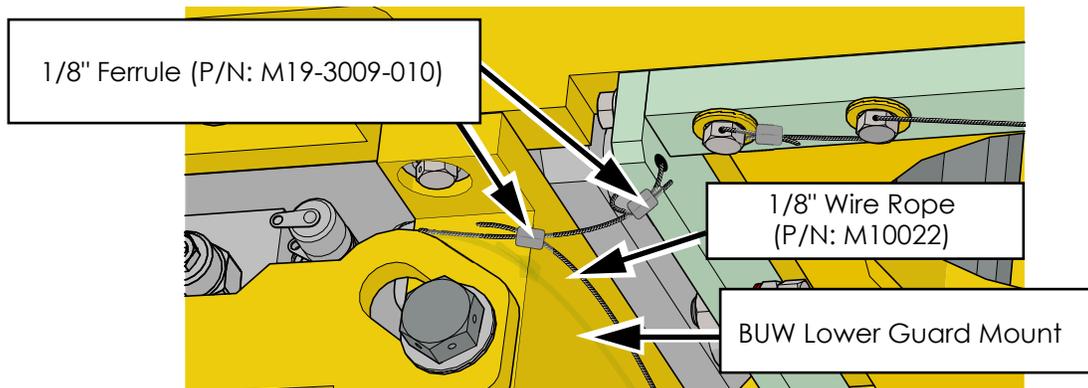


Figure 14: Safety Securement Added to Adjuster Plate

Reinstalling the Steel Stabbing Bell

1. Slide the stabbing bell back into the guides. If required, adjust the position of the stabbing bell by turning the bolt to move the stabbing bell into the desired location. Torque nut (P/N: HN-0500NC-GR8) to 99 ft-lb. Ensure the stabbing bell stop is in contact with adjuster bolt.

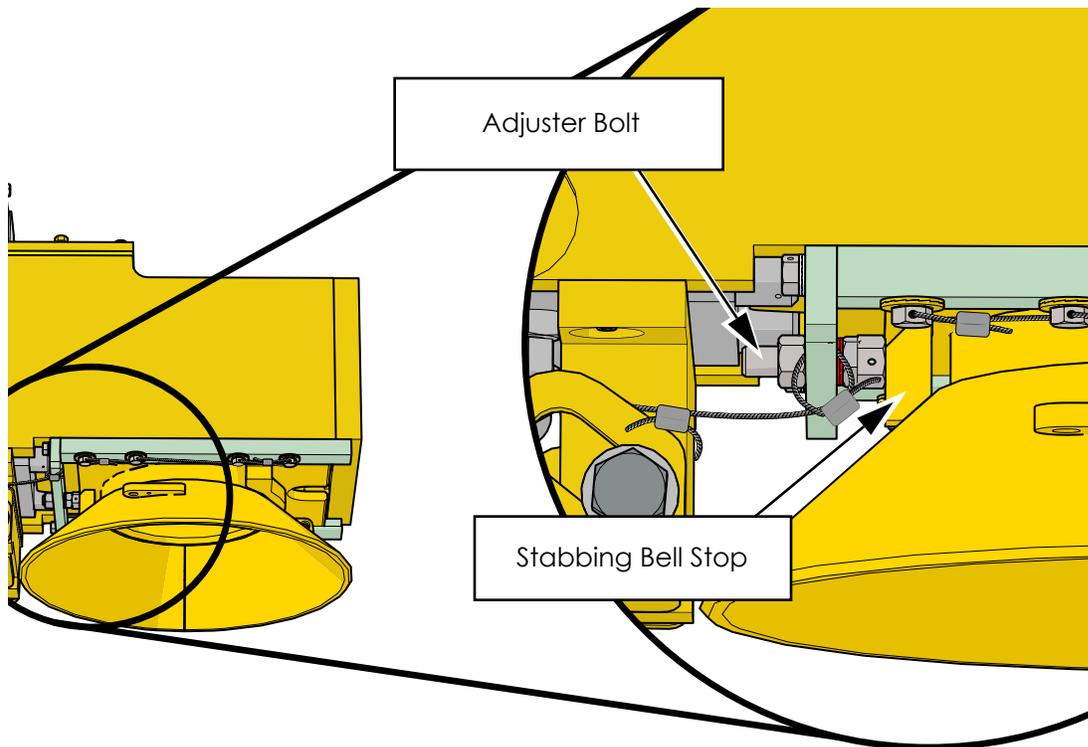


Figure 15: Stabbing Bell Adjuster Bolt

2. Install the springs onto both rods of front retainer plate.
3. Stab the rods into the two holes in the stabbing bell collar.
4. Torque the four 5/8" fasteners (UNF) evenly to mount the front retainer plate to Back-Up Wrench frame. Torque to 198 ft-lb.

5. Ensure there is no gap between the front retainer plate and Back-Up Wrench frame. See Figure 16.

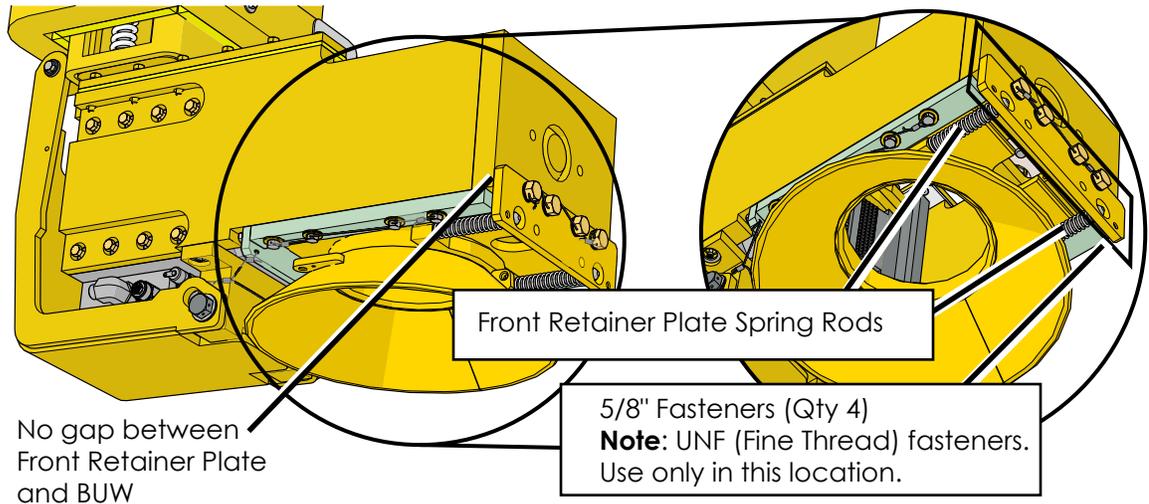


Figure 16: Re-attaching the Front Retainer Plate

6. Secure the steel stabbing bell by running a 1/8" wire rope (P/N: M10022) through the tab on the steel stabbing bell and tie to the front retaining plate using 1/8" ferrule (P/N: M19-3009-010, Qty 2) as shown in Figure 17.

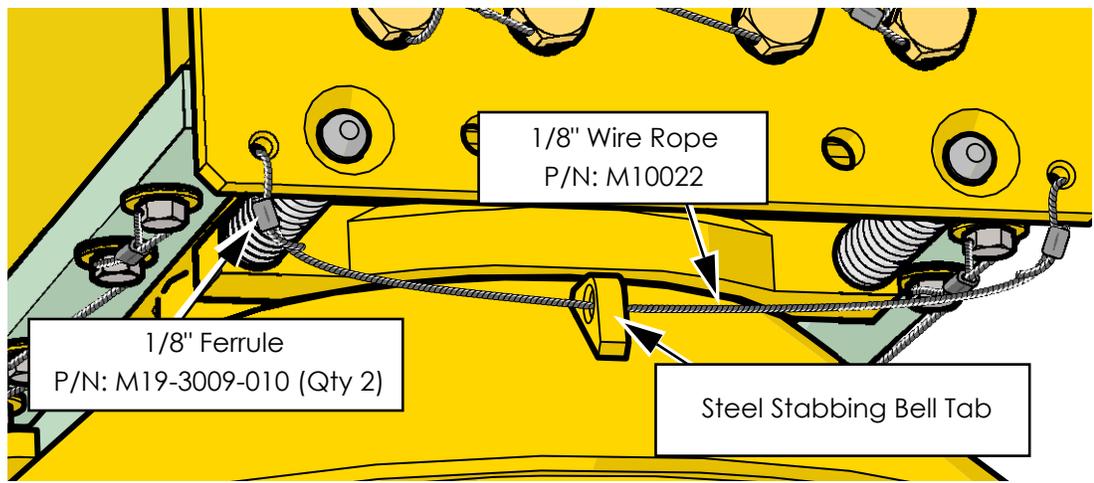


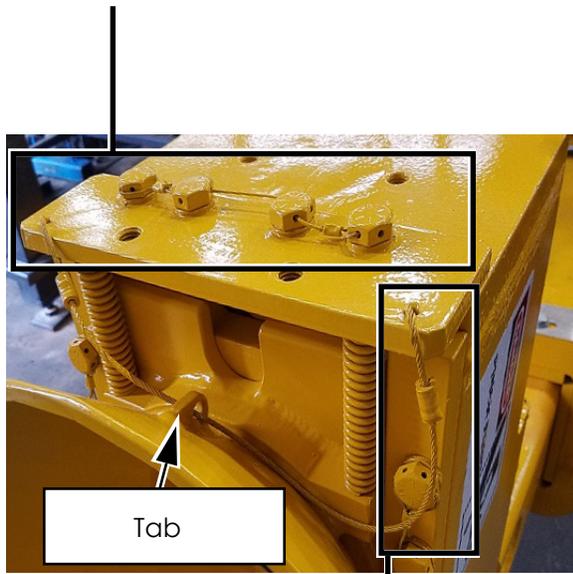
Figure 17: Secondary Retention for the Steel Stabbing Bell



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- 7. Ensure safety securement (wire rope) removed during disassembly is replaced in the same way as original design. See Figures 18–19.

Front Retainer Plate
Secondary Retention



Steel Stabbing Bell
Safety Securement

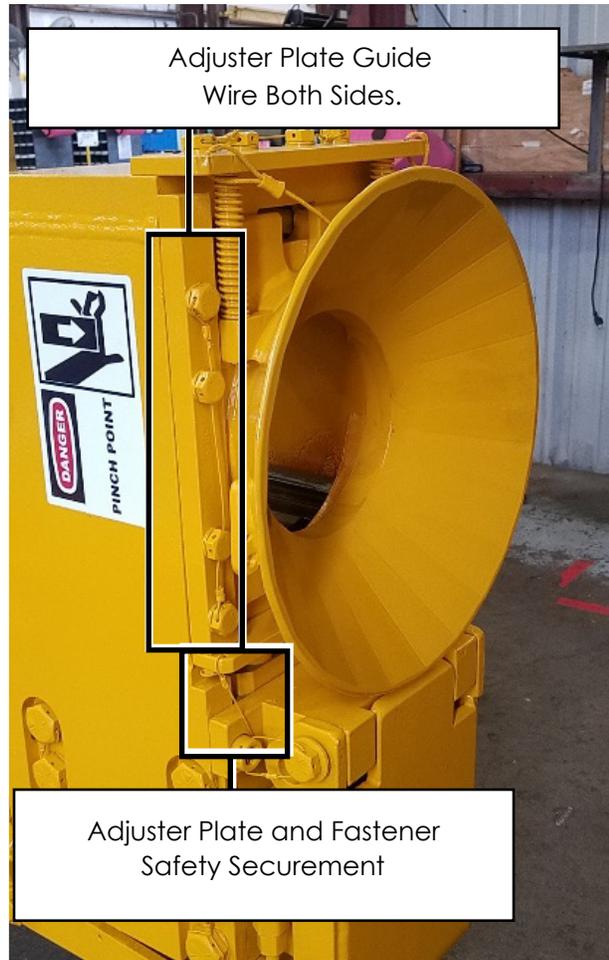


Figure 18: Front Retainer Plate and Stabbing Bell Lock Wiring

Figure 19: Adjuster Plate Guide and Fasteners Lock Wiring