



CANRIG DRILLING TECHNOLOGY LTD

PRODUCT BULLETIN NUMBER: 10

DATE: July 13, 1993

SUBJECT: Torque Guide Connection Flanges

SERIAL NUMBERS: 007, 008

DISCUSSION:

The lowermost Torque Guide Connection flange (immediately above the transport skid section) may be subject to forward acting forces when pulling tubular up the Vee-door ramp. These forces may overstress the flange connection bolts,

*S/N 007 Item 7, Drawing D-1-780-20-0

*S/N 008-117 Item 5, Drawing D-1-781-20-0

*S/N 008-125 Item 6, Drawing D-1-782-20-0

* See parts manual.

RECOMMENDATION:

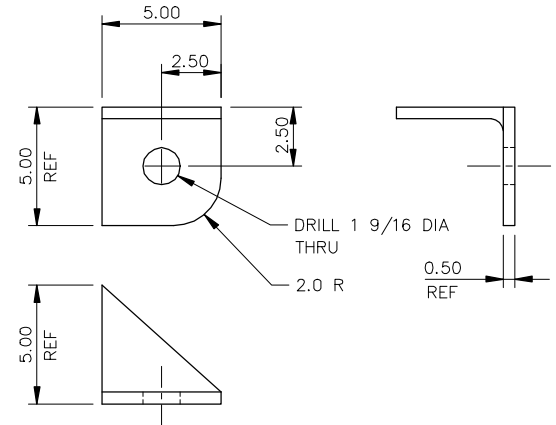
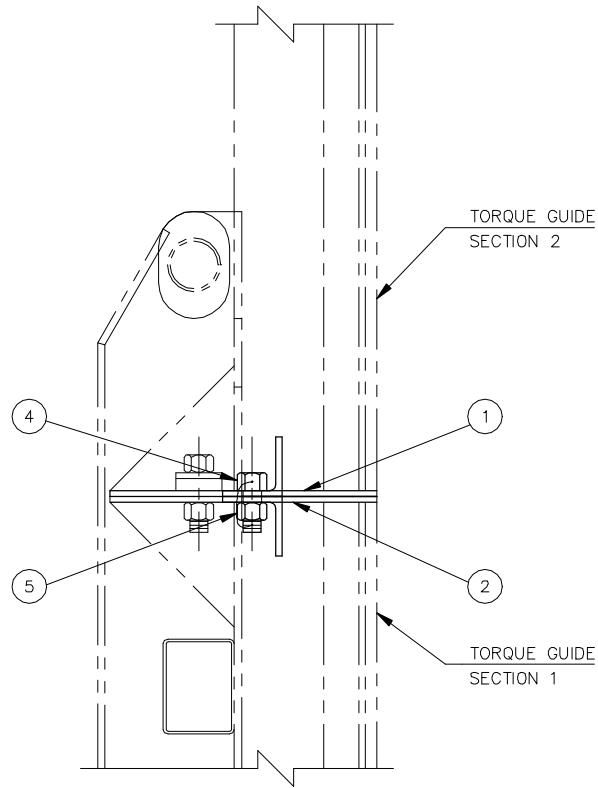
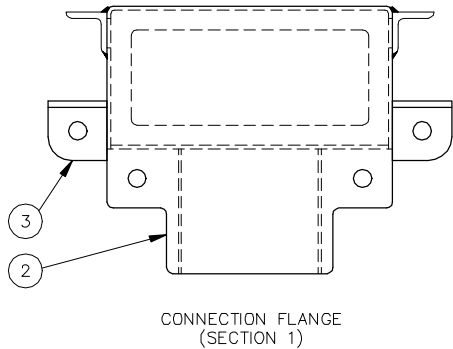
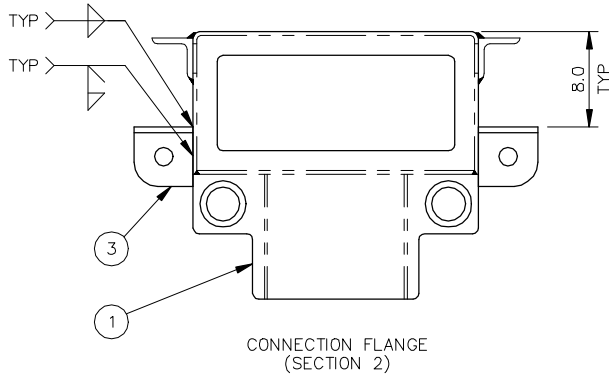
It is recommended that the bottom two connections be reinforced according to the attached modification, Drawing C-3-781-20-5.

INFORMATION :

For further information contact:

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ITEM	QTY	DESCRIPTION
1	REF	BOTTOM CONNECTION FLANGE C-3-780-30-6
2	REF	TOP CONNECTION FLANGE C-3-780-30-7
3	4	ANGLE, 5 x 5 x 1/2 x 5" LG.
4	2	CAPSCREW C-3-781-20-7
5	2	HEXNUT 1 1/2 NC Gr. 8



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					TOLERANCE - UNLESS OTHERWISE SPECIFIED				DRAWN	D.P.	93/06/25	CANRIG CANRIG DRILLING TECHNOLOGY LTD.
					REMOVE SHARP CORNERS AND BURRS		FABRICATING		MACHINING		CHECKED	
					CASTING ± 1/16		FRACTIONAL		FRACTIONAL ± 1/32		APPR'VD	
					⊙ CONCENTRICITY ±.005 TIR		0 TO 24 ± 1/16		DECIMAL .x ± .030		MATERIAL	
No.	Y/M/D	BY	REVISION	REFERENCE DWGS	±.010 IN 5 INCHES		> 24 ± 1/8		.xx ± .015		BY	PROJECT
					±.010 IN 5 INCHES		0 TO 24 ± .06		.xxx ± .005		Y/M/D	
					⊥ SQUARENESS ±.010 IN 5 INCHES		> 24 ± .12		ANGULAR ± 1'		EST. WEIGHT	SCALE
					∥ PARALLELISM ±.010 IN 5 INCHES		ANGULAR ± 2'				1:8	
					⊕ TRUE POSITION .005							
					MACHINED SURFACES 125							