



SAFETY ALERT

DATE: 23 April 2002

SUBJECT: SECOND NOTICE: SAFETY WIRING – LINK TILT CYLINDER GUARD

SERIAL NUMBERS: All

DISCUSSION: In March 2002, CANRIG released Safety Bulletin 73. Subsequent to this release, an accident occurred on a rig, where the Link Tilt guard fell off the Top Drive and struck an employee situated on the rig floor. It is absolutely imperative that the below instructions are being followed and the guard restraining system is being upgraded to include the specification as found on the attached drawing.

RECOMMENDATION: Check each link tilt guard for proper installation of two 1/8" safety restraint wires as per attached drawing. Please note that to ensure cables do not become frayed at the guard tie-off point, this tie-off point on the guard should be on the side, rather than on top. Further, check that the four retaining bolts holding the guard in position are in place and safety wired as per the attached drawing. If these bolts are not drilled for safety wiring, contact CANRIG and proper bolts will be provided to you. If any bolt or safety wire is missing or not applied as outlined on attached dwg, it should be rectified immediately, or the guard should be removed until it can be properly installed. Removing the guard will expose the stainless steel tubing and will increase the potential of a hydraulic leak. The following parts and material may be necessary to bring the guard restraining system into compliance:

- 8 feet of 1/8" safety wire (CANRIG part number M10022), cut into 4 equal length and eight ferrules (M19-3006-010), to make restraint cables.
- 6 feet of 1/16" safety wire (CANRIG part number M19-3009-010) and four ferrules (M21-2000-010), for wiring the 1/4" retaining bolts
- Crimping tool (LOCOLOC No.0 (available from CERTEX), or equiv.)
- Drill and 3/16 drill bit (in the event the hole has to be re-drilled on the side of the guard)

If you would like CANRIG to perform the above mentioned checks or modifications or if you have any questions regarding implementation of this bulletin, please contact the person listed below.

When in doubt, do not hesitate to contact CANRIG and ask questions.

INFORMATION:

For further information contact:

Field Operations Manager
Canrig Drilling Technology Ltd.
14703 FM 1488
Magnolia, Texas 77354
Phone: 281.259.8887
Fax: 281.259.8158



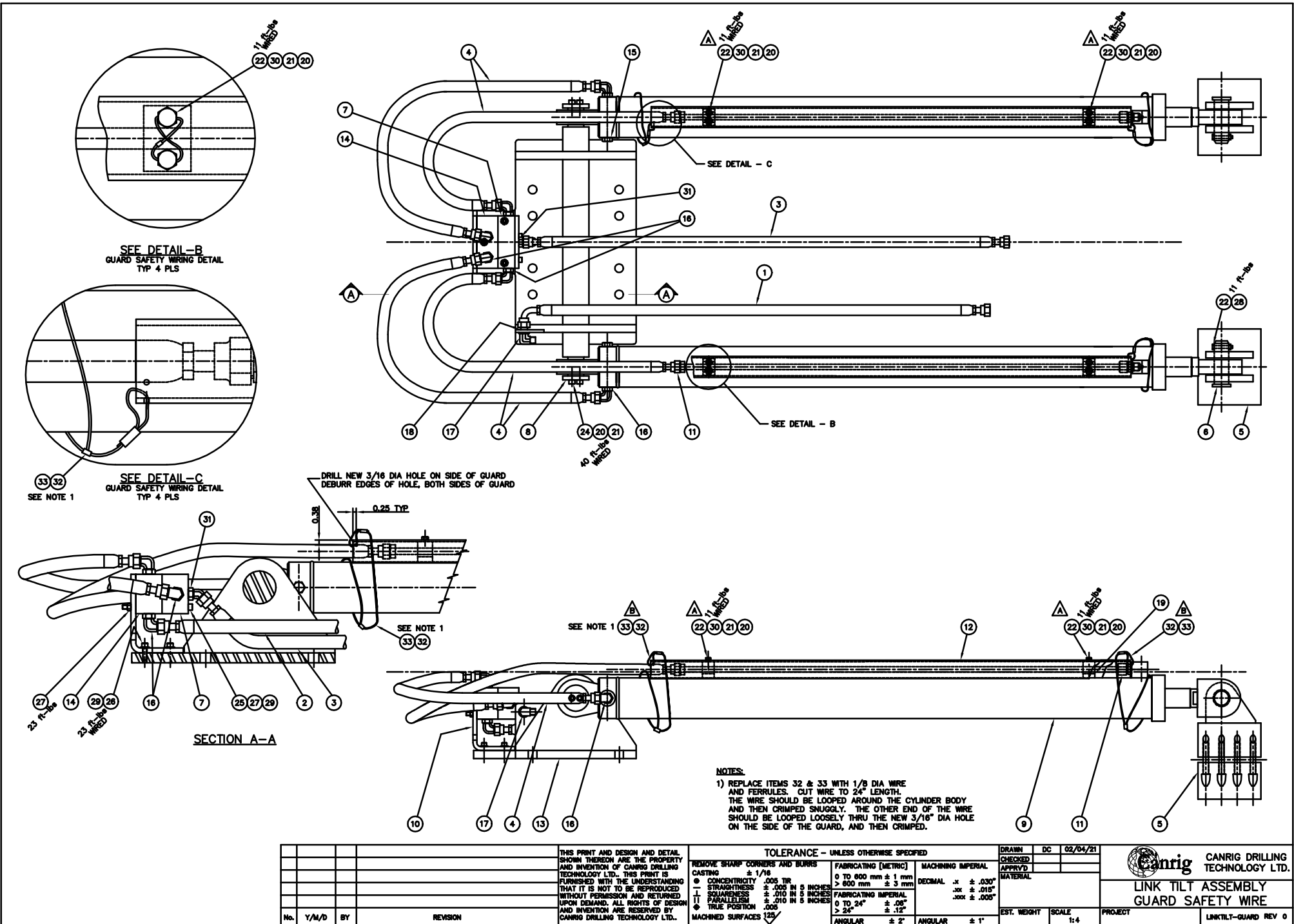
Engineering Bill of Material

Part: AY11262
Description: LINK TILT ASSY, 650 TON, 2 SPD

Eng ID: 0
Drawing ID: AY11262

Rev No: B

Item	Qty	Units	Part ID	Eng ID	Description
01	1.00	EA	F451JSJ9080808-44.79-X-42	0	HOSE ASSY, 1/2, SWV STR, 90° SHT, 44.79
02	1.00	EA	F451JSJS080808-30.8-X-28	0	HOSE ASSY, 1/2, SWV STR, SWV STR, 30.8
03	1.00	EA	F451JSJS080808-28.75-X-26	0	HOSE ASSY, 1/2, SWV STR, SWV STR, 28.75
04	4.00	EA	F451JSJS080808-24.8-X-22	0	HOSE ASSY, 1/2, SWV STR, SWV STR, 24.8
05	2.00	EA	594-02-6		LUG, ELEVATOR LINK, 750 TON
06	2.00	EA	594-05-0		PIN, 1.375 DIA, 3.62 LG, HEAD ONE END
07	1.00	EA	594-07-0		MANIFOLD, HYDRAULIC, LINK TILT
08	2.00	EA	689-12-0		RETAINER, LINK TILT
09	2.00	EA	689-14-0	0	CYL, HYD, BORE 3 1/4, ROD 2, STRK 47.94
09A	0.00	EA	H18-3220-01B		CYLINDER SEAL KIT
09B	0.00	EA	H19-1004-010		CYLINDER ROD EYE
09C	0.00	EA	M04-1000-020		BEARING, PLAIN RADIAL
09D	0.00	EA	M11-1022-010		RETAINING RING, INTERNAL
10	1.00	EA	689-16-0		MOUNT, FLOW DIVIDER, LINK TILT
11	2.00	EA	689-19-0-500	0	HYD TUBE, 1/2, LINK TILT, 500
12	2.00	EA	689-20-0		GUARD, HYDRAULIC TUBE, LINK TILT, 45.75
13	1.00	EA	919-11-0		UPPER SUPPORT LUG LINK TILT
14	1.00	EA	H04-1012-010		VLV, HYD, FLOW DIVIDER, INLINE, SAE-8
15	2.00	EA	H15-090109B-08		PLUG, SOC HEX, 1/2 ORB
16	7.00	EA	H15-520220-08-08		ELL 90°, MALE 1/2 ORFS, MALE 1/2 ORB
17	1.00	EA	H15-520701-08		ELL 90°, BULKHEAD, MALE 1/2 ORFS
18	1.00	EA	H15-520118-08		LOCKNUT, BULKHEAD 1/2, 13/16-16UNF
19	4.00	EA	H25-1002-010		CLAMP, SINGLE, 1/2 IN DIA
20	8.00	EA	M19-3006-010		FERRULE, 1/16, OVAL, ALUMINIUM
21	72.00	IN	M21-2000-010		WIRE ROPE, 1/16, 7 x 7, STAINLESS
22	10.00	EA	HH-0250NC-0175-GR8-W		CAPSCR, HEX HD, 1/4-20UNC x 1.75, GR8
24	4.00	EA	SH-0375NC-0125-W		CAPSCR, HEX SOC HD, 3/8-16UNC x 1.25
25	2.00	EA	SH-0312NC-0500		CAPSCR, HEX SOC HD, 5/16-18UNC x 5.00
26	3.00	EA	SH-0312NC-0100-W		CAPSCR, HEX SOC HD, 5/16-18UNC x 1.00
27	2.00	EA	LN-0312NC-GR8		LOCKNUT, 5/16-18UNC, GR8
28	2.00	EA	LN-0250NC-GR8		LOCKNUT, 1/4-20UNC, GR8
29	5.00	EA	FW-0312-A		WASHER, F, 5/16, PLAIN, TYPE A
30	8.00	EA	LW-0250-ET		LOCKWASHER, 1/4 EXTERNAL TOOTH
31	1.00	EA	H15-520320-08		ELL 45°, MALE 1/2 ORFS, MALE 1/2 ORB
32	8.00	EA	M19-3009-010		FERRULE, 1/8, OVAL, ALUMINIUM
33	96.00	IN	M10022		WIRE ROPE, 1/8, STAINLESS, 7 X 19



NOTES:
 1) REPLACE ITEMS 32 & 33 WITH 1/8 DIA WIRE AND FERRULES. CUT WIRE TO 24" LENGTH. THE WIRE SHOULD BE LOOPED AROUND THE CYLINDER BODY AND THEN CRIMPED SNUGLY. THE OTHER END OF THE WIRE SHOULD BE LOOPED LOOSELY THRU THE NEW 3/16" DIA HOLE ON THE SIDE OF THE GUARD, AND THEN CRIMPED.

			THIS PRINT AND DESIGN AND DETAIL SHOWN THEREON ARE THE PROPERTY AND INVENTION OF GANGS DRILLING TECHNOLOGY LTD. THIS PRINT IS FURNISHED WITH THE UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED WITHOUT PERMISSION AND RETURNED UPON DEMAND. ALL RIGHTS OF DESIGN AND INVENTION ARE RESERVED BY GANGS DRILLING TECHNOLOGY LTD.			TOLERANCE - UNLESS OTHERWISE SPECIFIED			DRAWN DC 02/04/21		CANRIG DRILLING TECHNOLOGY LTD.			
						REMOVE SHARP CORNERS AND BURRS CASTING ± 1/16 CONCENTRICITY ± .005 TR STRAIGHTNESS ± .005 IN 5 INCHES SQUARENESS ± .010 IN 5 INCHES PARALLELISM ± .010 IN 5 INCHES TILT POSITION ± .005 MACHINED SURFACES 125			FABRICATING [METRIC] 0 TO 600 mm ± 1 mm > 600 mm ± 3 mm FABRICATING IMPERIAL 0 TO 24" ± .06" > 24" ± .12" ANGULAR ± 2°		MACHINING IMPERIAL DECIMAL .x ± .030" .xxx ± .015" .xxxx ± .005" ANGULAR ± 1°		CHECKED APPROVD MATERIAL EST. WEIGHT SCALE 1:4 PROJECT LINKTILT-GUARD REV 0	
No.	Y/M/D	BY	REVISION											

This page intentionally left blank