



SAFETY ALERT

DATE: September 18, 2002

SUBJECT: Guide Runner Adjuster Bolts

SERIAL NUMBERS: 014-185

DISCUSSION: A near-miss incident was experienced when an adjuster bolt broke loose and fell from the Top Drive. The weld that held the nut of the adjuster bolt in place failed and caused the part to separate from the adjuster plate. Investigation showed that the nut was only welded on two sides

RECOMMENDATION: *Inspect each adjuster nut for penetration welds on all four sides of the nut.* If you find any nuts that do not have adequate welding, upgrade the welding to match the specification (see attached drawing) or order the appropriate number of adjuster plates to rectify the situation. The part number for the adjuster plates is as follows:

275 Ton
Rail Adjuster Plate – 841-37-0, TD Adjuster Plate – 841-39-0

350/500 Ton
Rail Adjuster Plate – 841-12-0, TD Adjuster Plate – 841-13-0

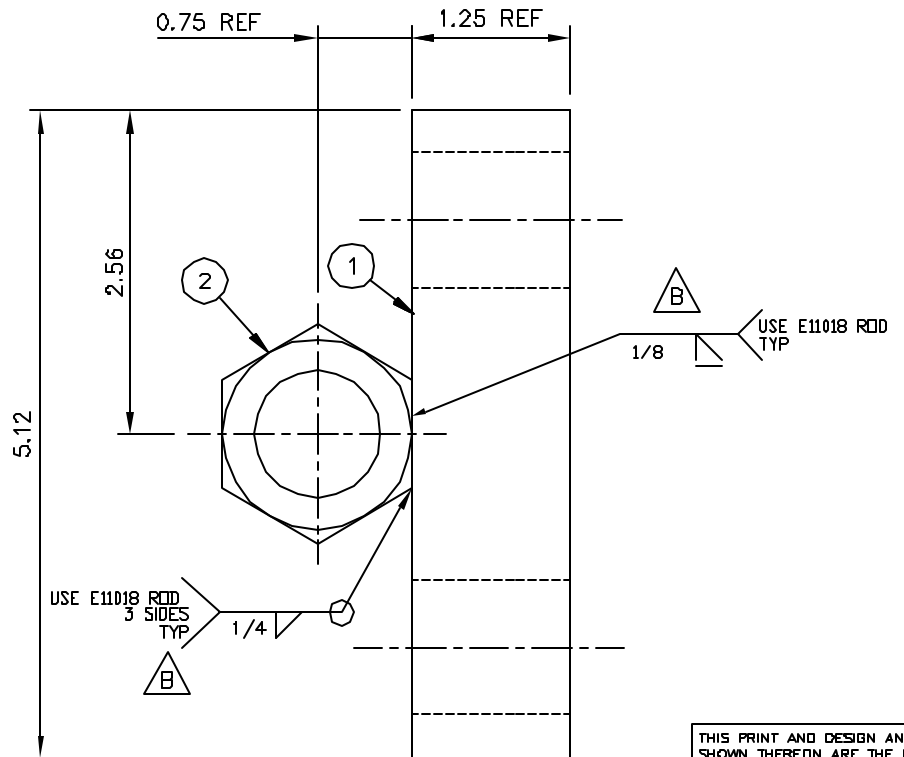
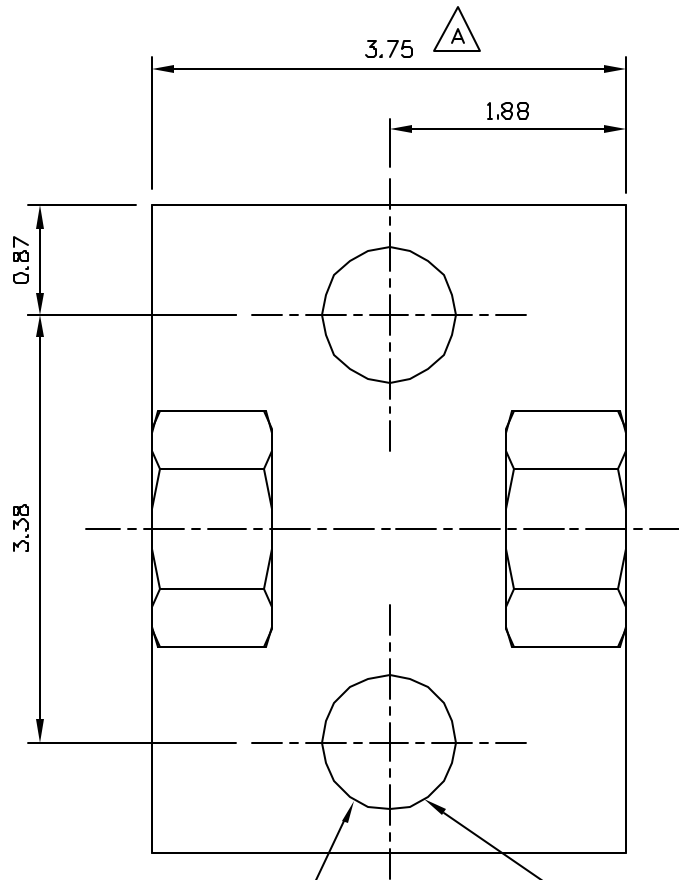
Should you have any questions or concerns, please do not hesitate to contact your CANRIG representative or the Field Operations Manager listed below. ***IF in doubt, ask!***

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

ITEM	QTY	DESCRIPTION
1	1	1 1/4 PLATE 3.75 X 5.12 A36
2	2	HEX NUT 1 NC



DRILL 1 1/16 DIA THRU
2 PLC'S TYP

STAMP - 1/4 LETTERS
IWG No.
P.D. No.

NOTES:
1) DO NOT NOT USE PLATED NUTS.

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No.	Y/M/D	BY	REVISION	REFERENCE DWGS
B	00/03/10	DC	ECN# 702, WELD SPEC	
A	98/10/07	GH	ECN# 315	

TOLERANCE - UNLESS OTHERWISE SPECIFIED		
REMOVE SHARP CORNERS AND BURRS	FABRICATING [METRIC]	MACHINING IMPERIAL
CASTING ± 1/16	0 TO 600 mm ± 1 mm	DECIMAL .x ± .030"
⊙ CONCENTRICITY ±.005 TIR	> 600 mm ± 3 mm	.xx ± .015"
— STRAIGHTNESS ±.005 IN 5 INCHES	FABRICATING IMPERIAL	.xxx ± .005"
⊥ SQUARENESS ±.010 IN 5 INCHES	0 TO 24" ± .06"	
∥ PARALLELISM ±.010 IN 5 INCHES	> 24" ± .12"	
⊕ TRUE POSITION .005	ANGULAR ± 2°	ANGULAR ± 1°
MACHINED SURFACES 129		

DRAWN	G.HILL	94/04/25
CHECKED		
APPRVD		
MATERIAL		
EST. WEIGHT	SCALE 1:1	PROJECT 8027E

Canrig CANRIG DRILLING TECHNOLOGY LTD.
GUIDE RAIL ADJUSTING CLAMP

841-13-0 REV B