

<h1>Safety Bulletin</h1>			 <p>Tesco Corporation 3993 W. Sam Houston Pkwy N., Suite 100 Houston, Texas 77043 Tel: 1-877-TESCO-77 (North America) Tel: 1 (713) 359-7195 (AMSS 24-hour support) Tel: 1 (713) 359-7295 (International) Email: <a href="mailto:bulletins@tescopcorp.com">bulletins@tescopcorp.com</a> <a href="http://www.tescocorp.com">www.tescocorp.com</a> <a href="http://www.tescoparts.com">www.tescoparts.com</a></p>
<b>No: SB056</b>	<b>Rev: 0</b>	<b>Date: 19 April 2011</b>	
<b>Description: Safety Wiring of Bolts for Elevator Link Clamp and Swivel Link Clamp</b>			

## BACKGROUND INFORMATION:

It has been found that the elevator link clamp and swivel bail clamp on some of the TESCO top drive systems have been installed without safety wiring on the bolts. The bolts used do not have drilled holes on the heads. The drilled holes are necessary for safety wiring purposes.

## AFFECTED PRODUCT:

All TESCO top drives including HC, HS, HMI, HCI, HXI, ECI, EMI and EXI may be affected. Figure 1 demonstrates the location of the potentially affected parts; Figure 2 shows the location of the clamp assembly in the HCI top drive system.

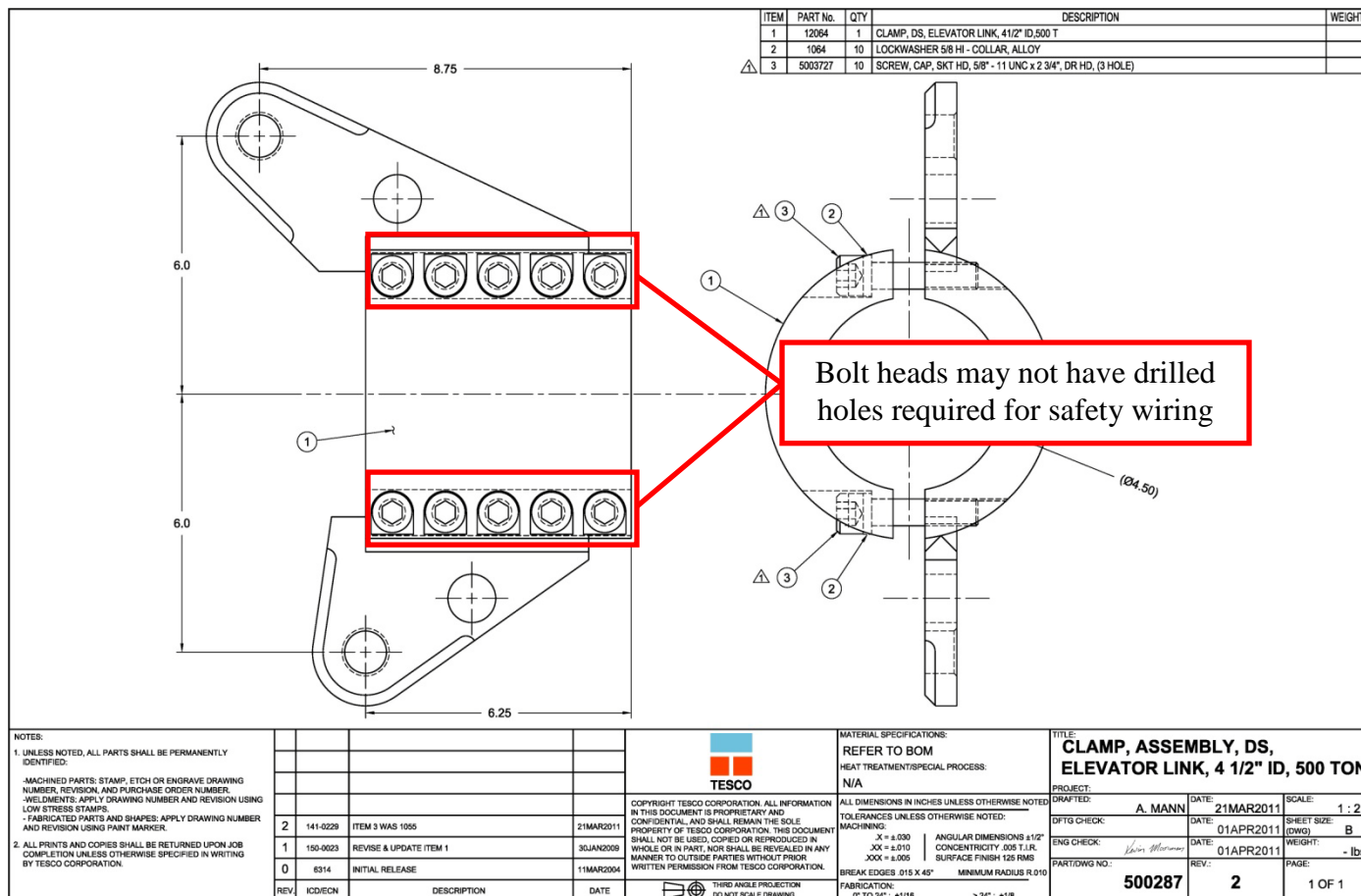


Figure 1: Elevator link clamp showing bolts

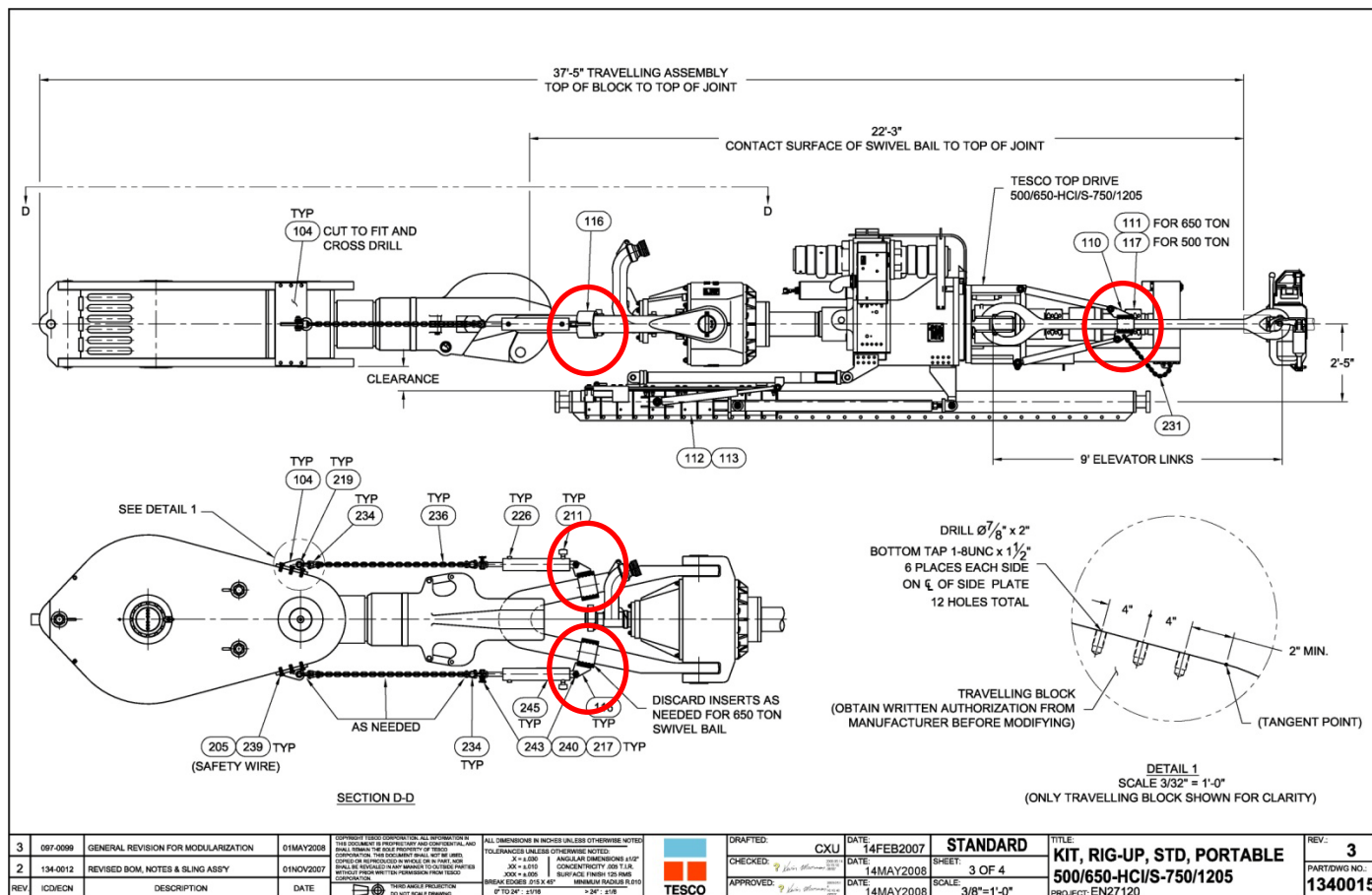


Figure 2. Location of the clamp in a top drive system

## ACTION REQUIRED:

Visually inspect the clamp in the locations noted in Figure 2. If the bolts that secure the two halves of the clamp together are safety-wired, then no action relating to this Bulletin is required.

Check the following parts on the top drive and in any spare parts inventory.

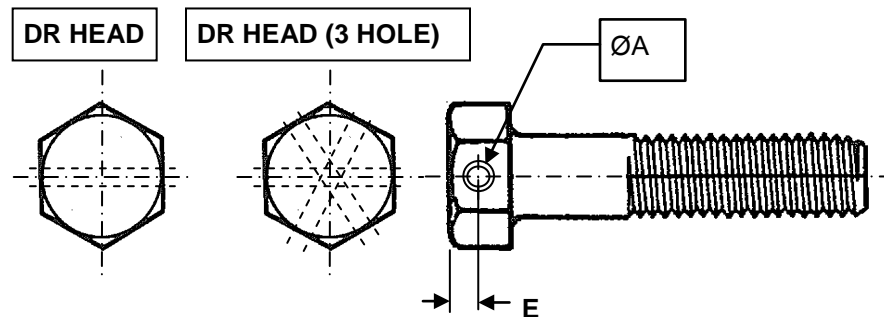
Description	Part Number	Serial Number	Date of Manufacture	Bolts Required
Clamp Set,Elevator Link,3.750"ID Insert,500T	7559	All	All	5003727
Clamp Set,Elevator Link,2.88"ID Insert,350T	8615	All	All	5003727
Clamp Set,Elevator Link,3.13"ID Insert,350T	730437	All	All	5003727
Clamp Set,Elevator Link,3.70"ID,350T	6998	All	All	6464
Clamp Set,Swvl Bail,6.06"ID,500T	7550	All	All	5003727
Clamp,Swvl Bail,7.06"ID	7551	All	All	5003727

The 20 bolts for the mounting clamp set (both the DS and ODS sides) must be safety-wired immediately. Ensure that the bolts being used have drilled heads to allow for safety wiring. Customers can cross-drill existing bolts, referencing document #55251107 (see Appendix A). Drilled bolts of the correct grade are also available through a local TESCO Parts and Service center.

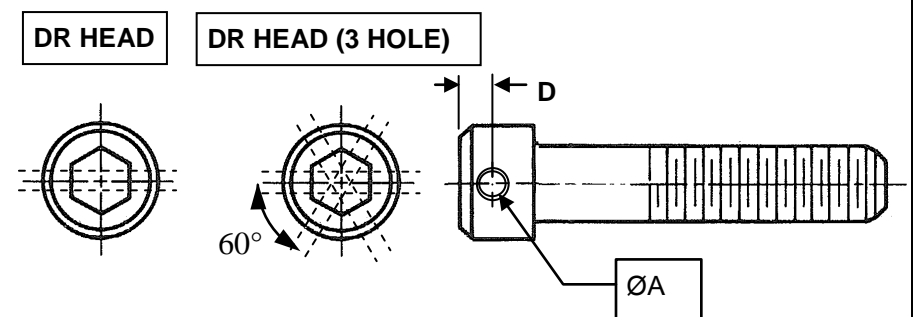
Version	Date (D/M/Y)	ECN	Description of Bulletin Changes
Rev 0	04/19/2011	141-0225, 141-0229	Initial release of document

**DRILLED HEAD**

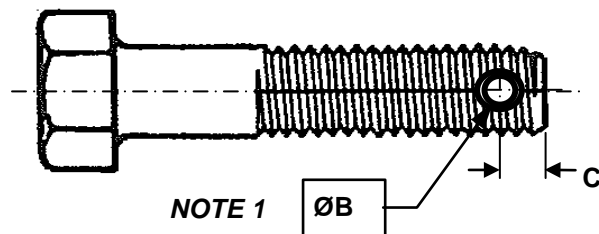
CAPSCREW (HEX HD)



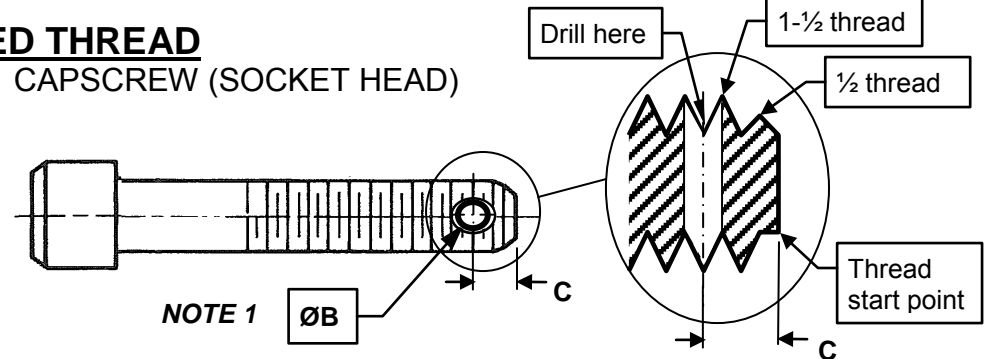
CAPSCREW (SOCKET HEAD)



CAPSCREW (HEX HD)

**DRILLED THREAD**

CAPSCREW (SOCKET HEAD)



**NOTE 1:** Break all corners with 82° counter sunk drill bit.

**NOTE 2:** Reference to Machinery's Handbook 26<sup>th</sup> Edition (Section: PINS AND STUDS).

**NOTE 3:** Count 1-1/2 threads as guideline and drill in V-groove of thread.

CAPSCREW SIZE	ØA	Drill Size ØB	C See NOTE 3	D	E	FOR COTTER PIN SIZE
1/4	1/16	3/32	0.10	0.06	0.09	1/16
5/16	1/16	1/8	0.12	0.08	0.12	3/32
3/8	7/64	1/8	0.12	0.09	0.13	3/32
7/16	7/64	1/8	0.12	0.11	0.16	3/32
1/2	1/8	5/32	0.18	0.12	0.18	1/8
5/8	1/8	5/32	0.20	0.15	0.22	1/8
3/4	1/8	3/16	0.20	0.19	0.26	5/32
7/8	5/32	3/16	0.20	0.22	0.30	5/32
1	5/32	3/16	0.20	0.25	0.35	5/32
1- 1/4 <	5/32	7/32	0.28	0.31	0.44	3/16

REV	DATE	BY	ICD	DESCRIPTION
0	2002/04/17	PE		ISSUED
1	2002/05/22	PE	4442	Practicality changes
2	2003/04/04	PE	5900	Changed drill sizes and positions

	Title DRILLING TABLES, DRILLED HEAD & DRILLED THREAD			
	File No. 55251107.doc	Sheet 1 of 1	Drawn P.E.	Model N/A
	Dwg No. 55251107	Date 2002/04/17	Rev 2	Checked Appd.