



Model: C500/C750

Serial #: N/A

May 28, 2025

Product Bulletin # TDS-267 Rev 2

C500/C750 Guard Reinforcement

Issue

There have been reports of cracks developing in areas of Top Drive Guard weldments.

Affected Units

Canrig Top Drives models C500 and C750 (formerly 1250AC and 1275AC).

Recommended Actions

A visual inspection is recommended to ensure no cracks are present on the TD Guard. Refer to areas shown in Figure 1. If no cracks are located, continue to monitor these areas during routine inspections as a precaution.

If cracks are discovered, refer to the instructions in the "Procedure" section on page 2.

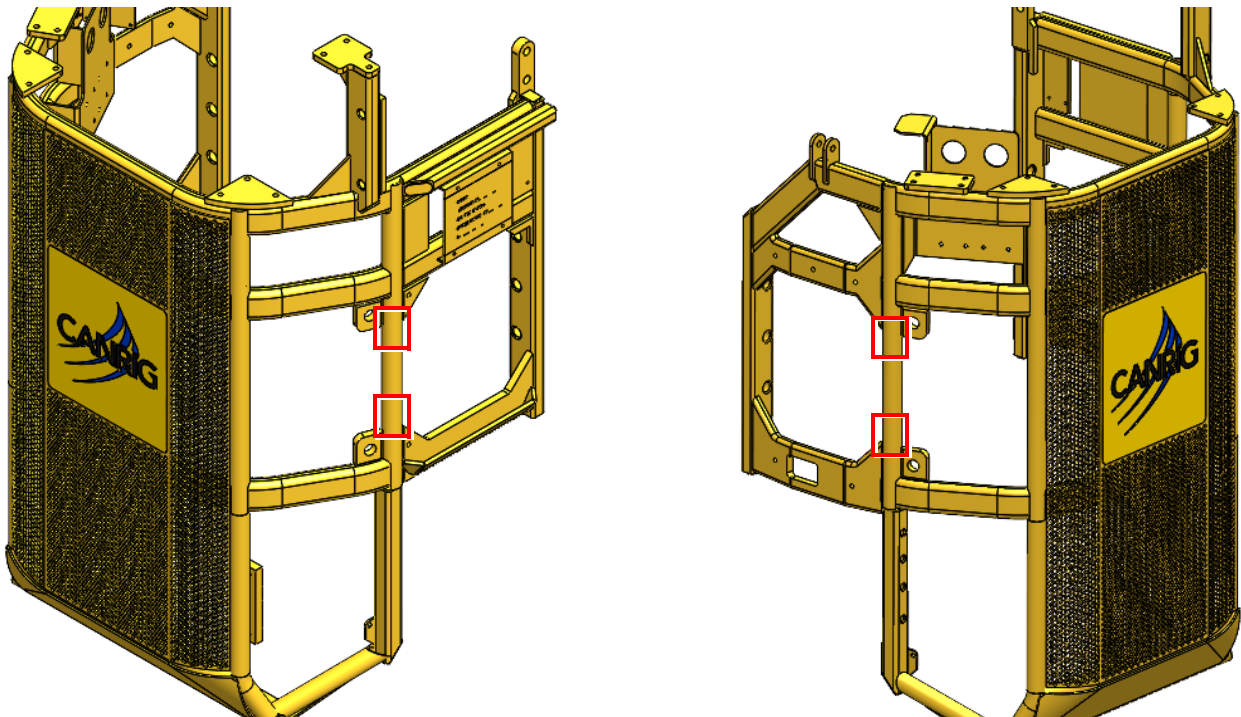


Figure 1: Areas where cracks could possibly develop



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Procedure

If cracks are discovered in these areas of the Guard, follow the steps below to perform the repair.

1. Determine the revision of the guard by checking the stamped revision mark—see Figure 2 for its exact location. After determining both the part number and revision of your guard, refer to Table 2 on page 3 to find the appropriate reinforcement plates required for the repair.

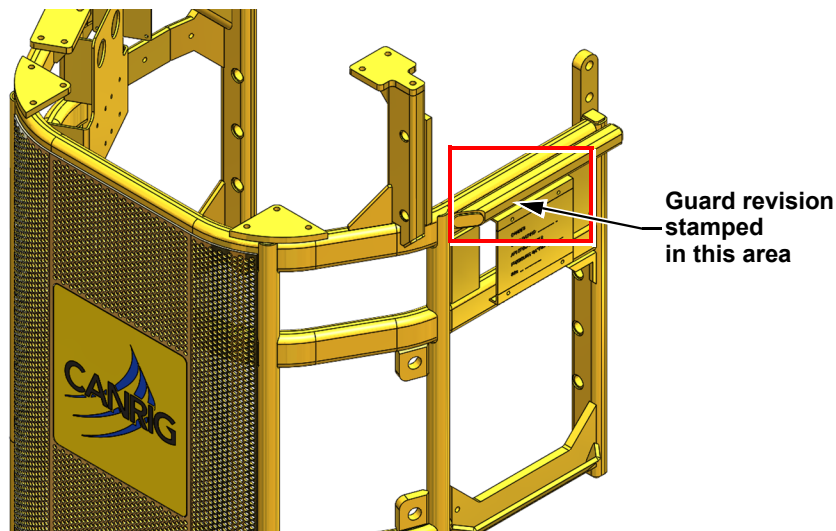


Figure 2: Location of Revision stamped on the guard

2. There are two options for completing the repair:
 - a. Using Canrig Guard Modification Kit (P/N: DT27200).
 - b. Fabricate your own plates to perform the repair.

Using Canrig Guard Modification Kit (P/N: DT27200)

1. Contact parts.sales@canrig.com or your Canrig representative to order Guard Modification Kit DT27200. See Table 1 for kit components.

Table 1: Guard Modification Kit (P/N: DT27200)

Item	Qty	Description	Canrig P/N
1	2	PLATE, DETAIL, 2.25 X 15, C500/750 GUARD	DT27200-1
2	1	PLATE, DETAIL, 2 X 17.50, C500/750 GUARD	DT27200-3
3A	1	PLATE, DETAIL, 4 X 20.63, C500/750 GUARD	DT27200-2
3B	1	PLATE, DETAIL, 4 X 23, C500/750 GUARD	DT27200-4



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Table 2: Guard Reinforcement Plates

		Reinforcement Plates	
Guard P/N	Revision	ODS	DS
DT33192	C or older	DT27200-1 (Item 1) DT27200-4 (Item 3B)	DT27200-1 (Item 1) DT27200-3 (Item 2)
	D	DT27200-1 (Item 1) DT27200-2 (Item 3A)	
DT11507-0	All	DT27200-1 (Item 1) DT27200-4 (Item 3B)	
DT33250	F or older	DT27200-1 (Item 1) DT27200-4 (Item 3B)	
DT33238	All	DT27200-1 (Item 1) DT27200-4 (Item 3B)	

2. Continue to "Plates Installation" on page 7.

Fabricating your own Plates

Item 1: DT27200-1 (Qty 2)

1. Using ASTM A36 material, fabricate two (2) plates (item 1 on Table 1 on page 2) as indicated in Figure 3.

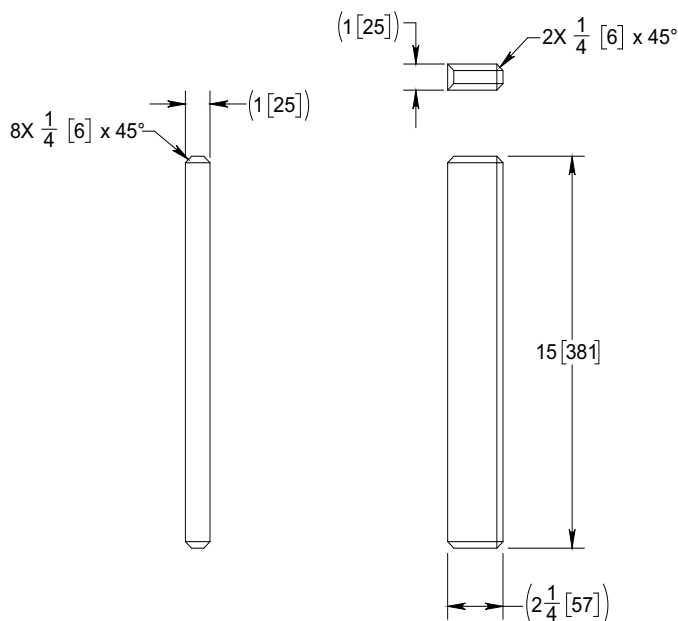


Figure 3: Plate P/N: DT27200-1



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Item 2: DT27200-3 (Qty 1)

- Using ASTM A36 material, fabricate one (1) plate (item 2 on Table 1 on page 2) as indicated in Figure 4.

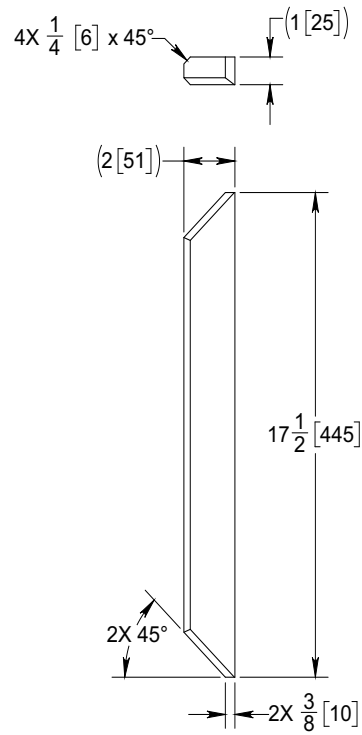


Figure 4: Plate P/N: DT27200-3



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Item 3A: DT27200-2 (Qty 1)

- Using ASTM A36 material, fabricate one (1) plate (item 3 on Table 1 on page 2) as indicated in Figure 5.

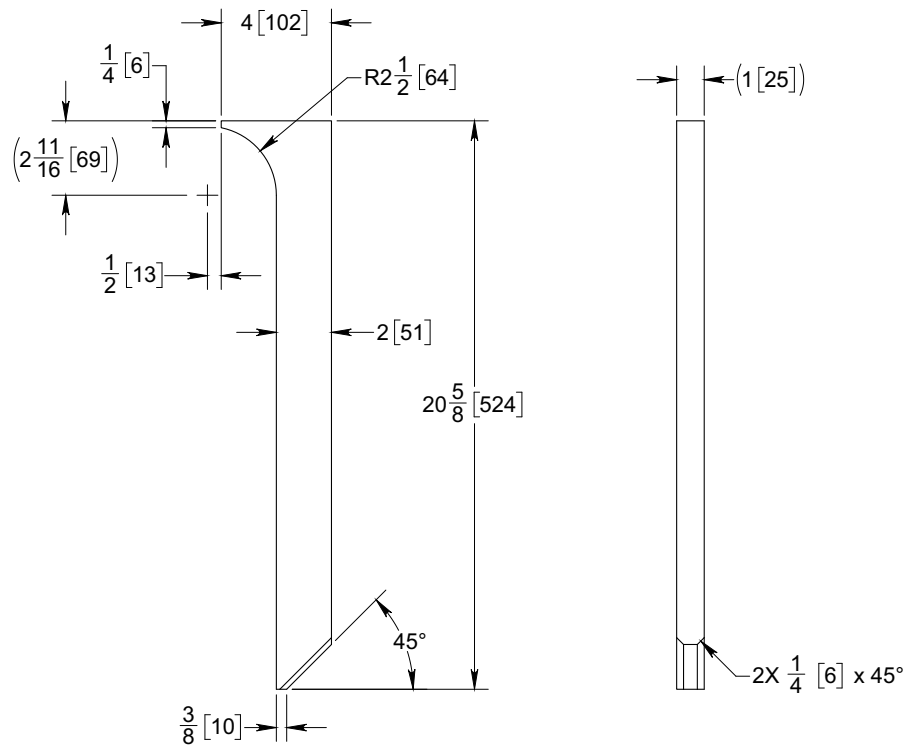


Figure 5: Plate P/N: DT27200-2



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Item 3B: DT27200-4 (Qty 1)

- Using ASTM A36 material, fabricate one (1) plate (item 4 on Table 1 on page 2) as indicated in Figure 6.

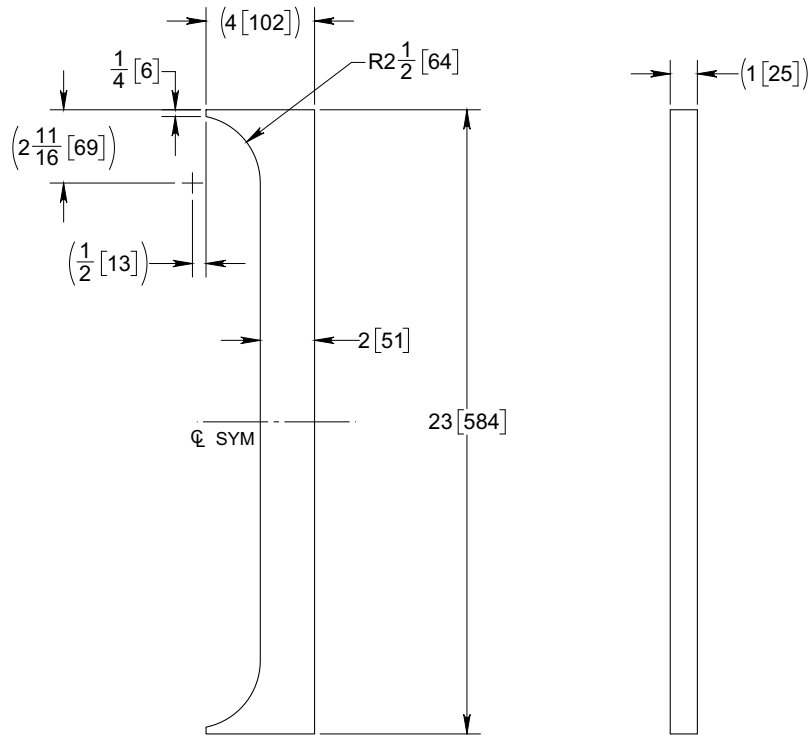


Figure 6: Plate P/N: DT27200-4



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Plates Installation

NOTICE

This procedure is the same regardless if the plates were acquired from Canrig or fabricated on site.

Guard Driller's Side (DS)

NOTICE

Installation of the DS plates is the same for all guard P/N and revisions.

1. Weld item DT27200-1 (item 1) and DT27200-3 (item 2) to the DS of the guard as shown in Figure 7. **Note:** Outside of items 1 and 2 are flush with outside of plate/HSS above and below them.

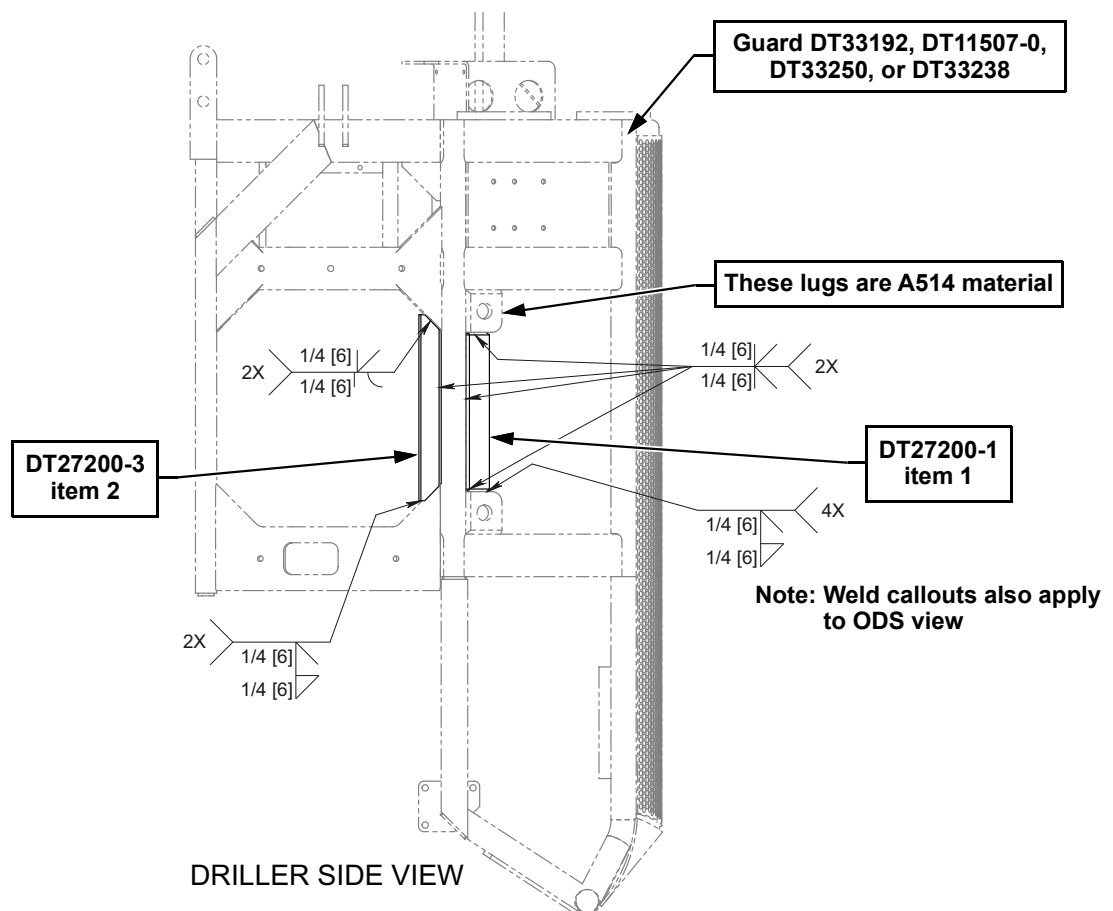


Figure 7: Plates installed on guard (DS)

NOTICE

Welding Procedure Specification (WPS) required for all welds. Note that lifting lugs above and below item 1 are ASTM A514 material.



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Guard Off-Driller's Side (ODS)

- If the guard is DT33192 Rev D, then the bottom ODS beam will be 1" plate. In this case, one (1) of plate P/N: DT27200-2 (Item 3A) is required.
1. Remove existing 4" x 4" x 1/2" triangular gusset (See Figure 8) on the top ODS.

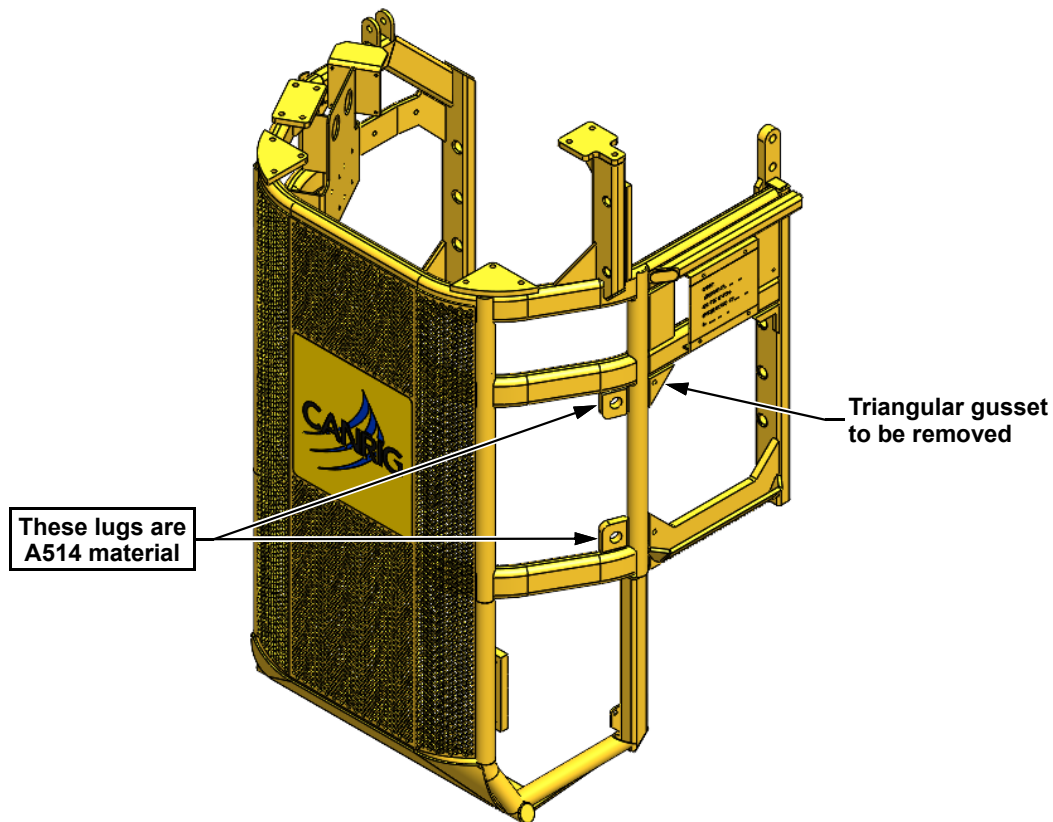


Figure 8: Triangular gusset to be removed.



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2. Replace with plate P/N: DT27200-2 (item 3A) as shown in Figure 9. **Note:** Outside of items 1 and 3A are flush with outside of plate/HSS above and below them.
3. Drill 5/8" hole as shown in Detail A in Figure 9.

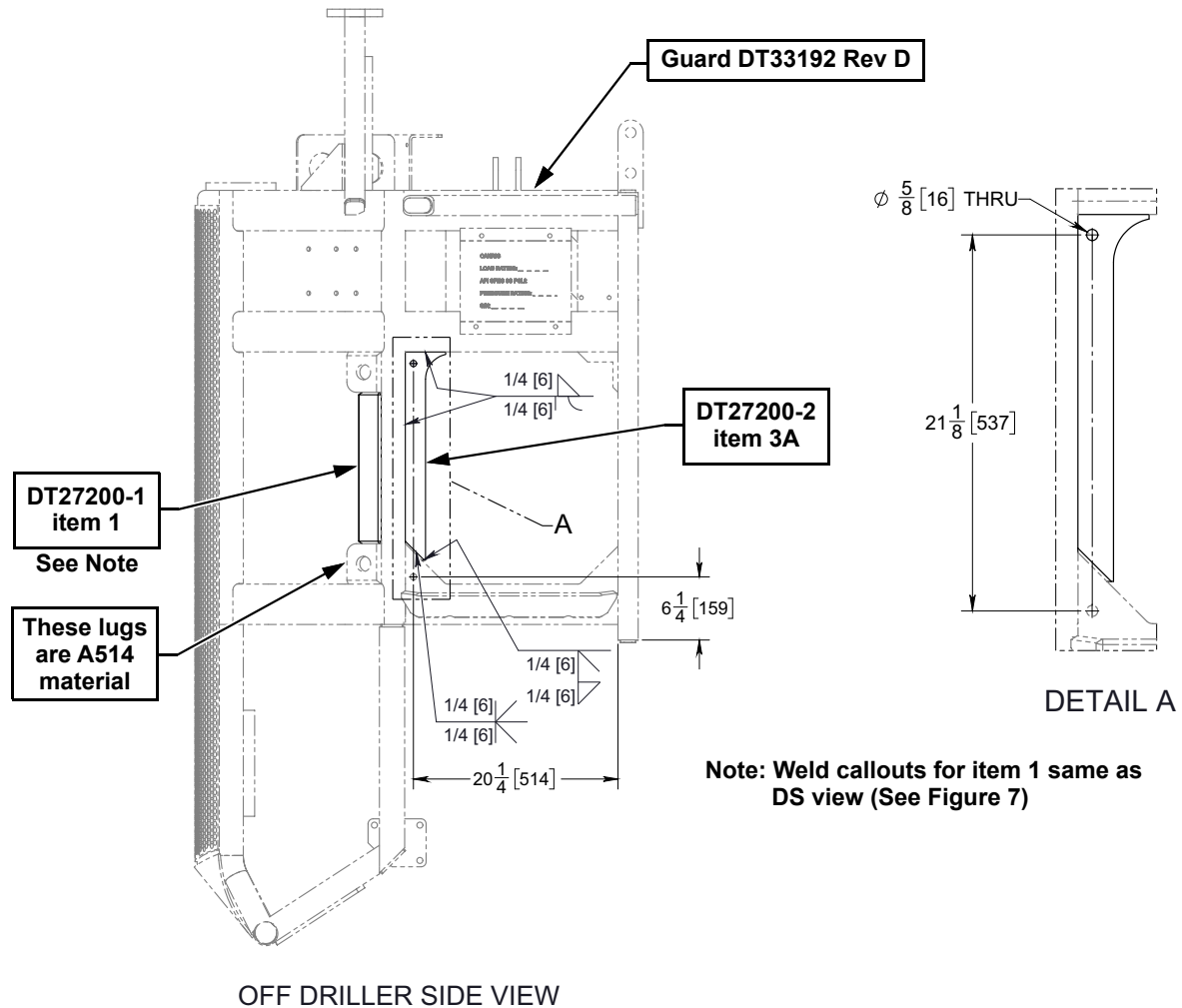


Figure 9: Plates installed on guard (ODS)

NOTICE

Welding Procedure Specification (WPS) required for all welds. Note that lifting lugs above and below item 1 are ASTM A514 material.

Go to "Post Weld NDE and Paint" on page 11.



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- If the guard is DT33192 **Rev A, B, or C**, or DT11507-0, DT33250, or DT33238, then the bottom ODS beam will be 4" X 2" HSS with a 4" x 4" x 1/2" triangular gusset (See Figure 10) at its junction with the vertical pipe. In this case, one (1) of plate P/N: DT27200-4 (item 3B) is required.
1. Remove the existing 4" x 4" x 1/2" triangular gussets on the top and bottom ODS as shown in Figure 10.

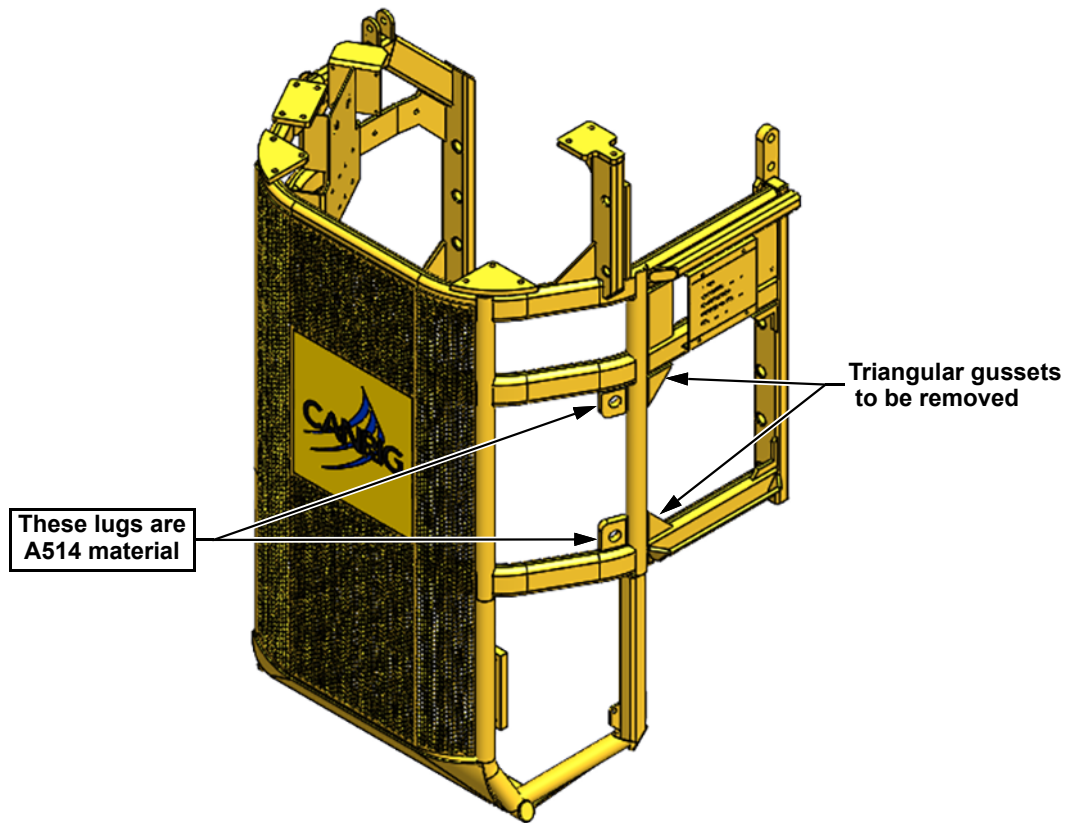


Figure 10: Triangular gussets to be removed.

2. Replace with plate P/N: DT27200-4 (item 3B) as shown in Figure 11 on page 11. **Note:** Outside of item 3B is flush with outside of plate/HSS above and below them.
3. Drill 5/8" holes as shown in Detail B in Figure 11 on page 11.



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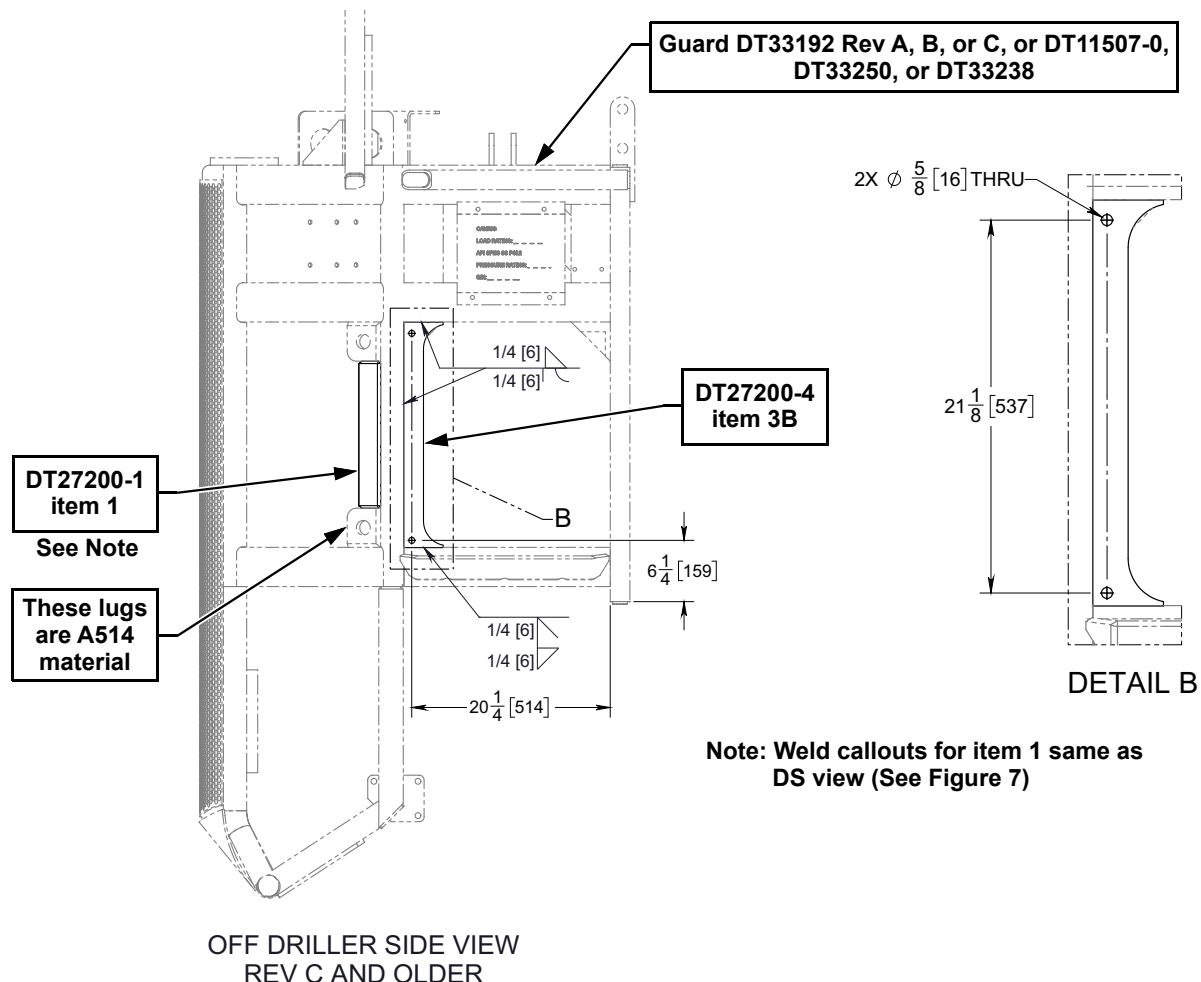


Figure 11: Plates installed on guard (ODS)

Post Weld NDE and Paint

NOTICE

The following apply to both DS and ODS procedures.

- MPI all new welds as per Canrig Specification ENG 707.
- MPI of welds to ASTM A514 material should be done not less than 48 hours after completion of welding.
- Protect all machined holes and surfaces prior to blasting and painting as per Canrig Specification ENG 713.
- Touch up paint Canrig Yellow (RAL No. 1006 / Maize Yellow).
- After painting plates, apply anti-corrosion protector to the machined holes and surfaces.