



Model: C500/C750	May 14, 2025
Serial #: N/A	
Product Bulletin # TDS-267 Rev 1	

C500/C750 Cage Reinforcement

Issue

There have been reports of possible cracking in areas of Top Drive Cage 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 Cage. Refer to areas shown in Figure 1 on page 2. If no cracks are found, continue to monitor these areas during routine inspections as a precaution.

If cracks are found, refer to the instructions under "Procedure" on page 2.



Model: C500/C750

Serial #: N/A

May 14, 2025

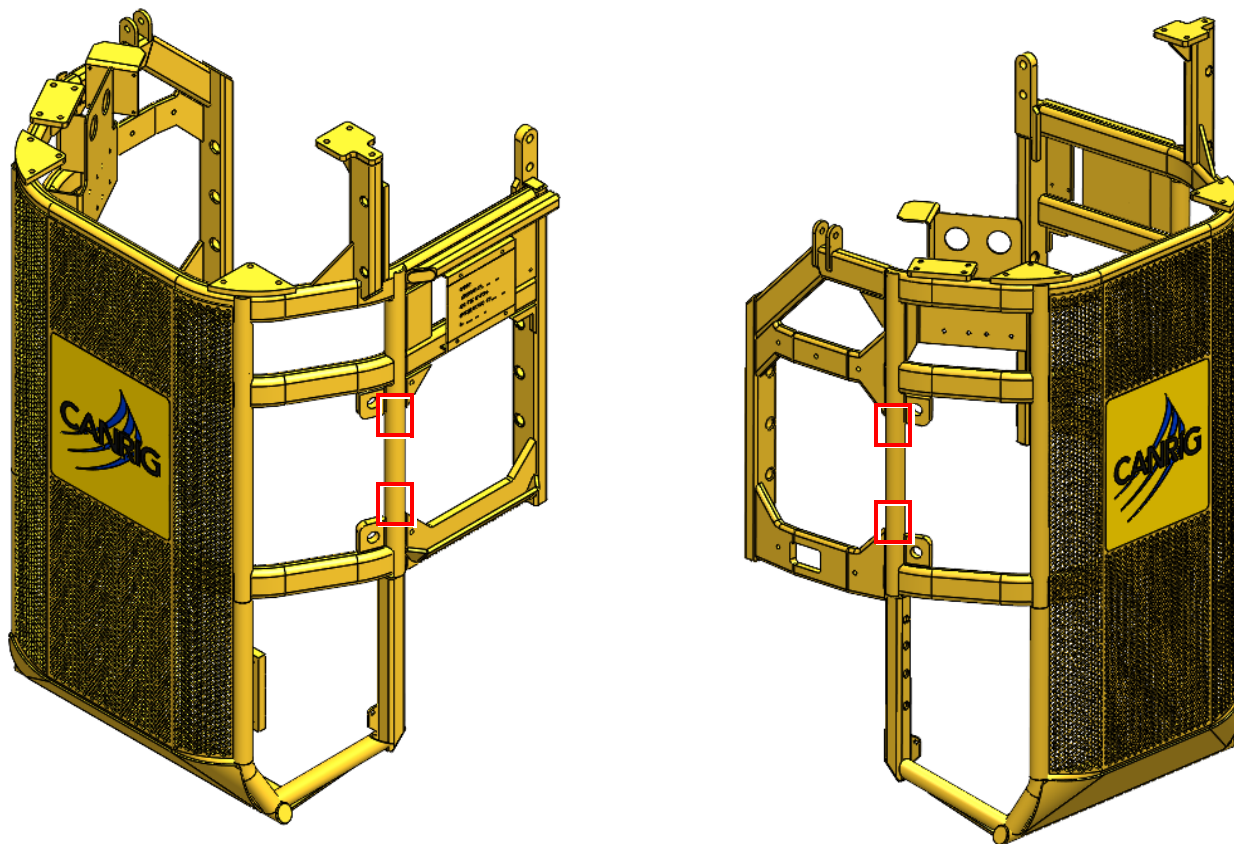


Figure 1: Areas where cracks could possibly develop

Procedure

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

1. Determine the revision of your Cage. To do this, check the stamped revision number on the cage, see Figure 2 on page 3 for location.



Model: C500/C750

Serial #: N/A

May 14, 2025

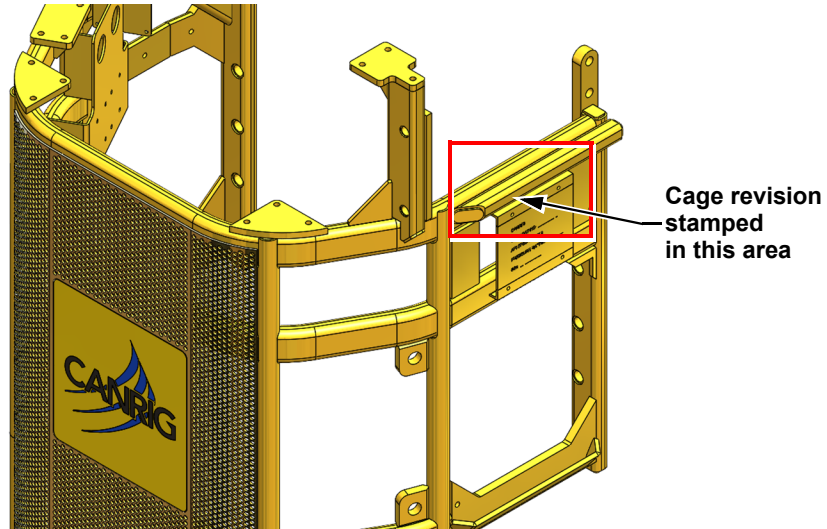


Figure 2: Location of Revision stamped on the cage

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

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

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

Table 1: Cage 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

2. Continue to "Plates Installation" on page 8.



Model: C500/C750

Serial #: N/A

May 14, 2025

Fabricating your own Plates

Item 1: DT27200-1 (Qty 2)

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

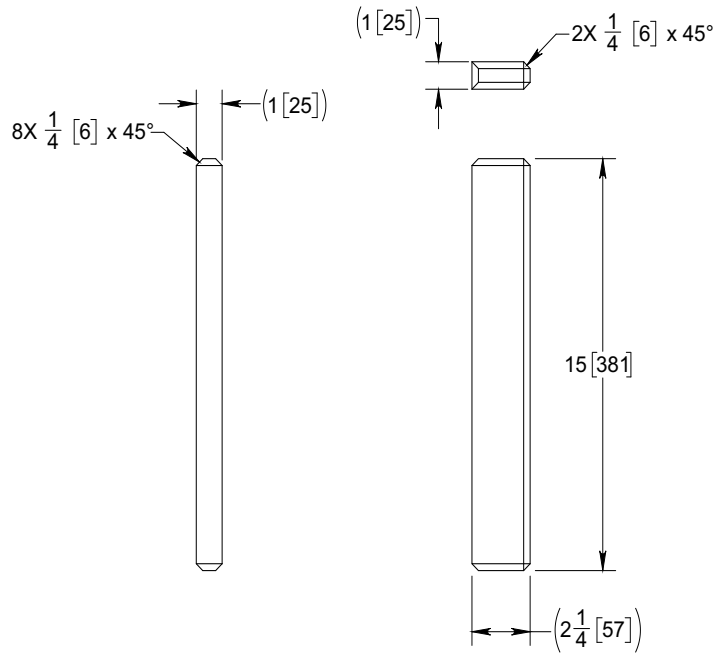


Figure 3: Plate P/N: DT27200-1



Model: C500/C750

Serial #: N/A

May 14, 2025

Item 2: DT27200-3 (Qty 1)

- Using ASTM A36 material, fabricate one (1) plate (item 2 on Table 1 on page 3) as indicated in Figure 4 on page 5.

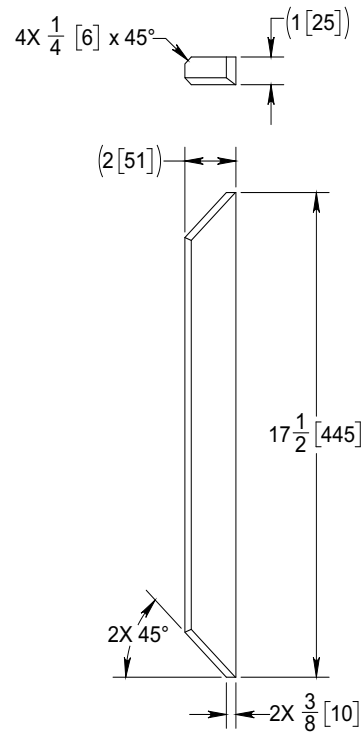


Figure 4: Plate P/N: DT27200-3



Model: C500/C750

Serial #: N/A

May 14, 2025

- If you have a Cage Revision A, B, or C continue with section "Item 3A: DT27200-2 (Qty 1) – For Cage DT33192 Rev A, B, or C or DT11507-0" below.

Item 3A: DT27200-2 (Qty 1) – For Cage DT33192 Rev A, B, or C or DT11507-0

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

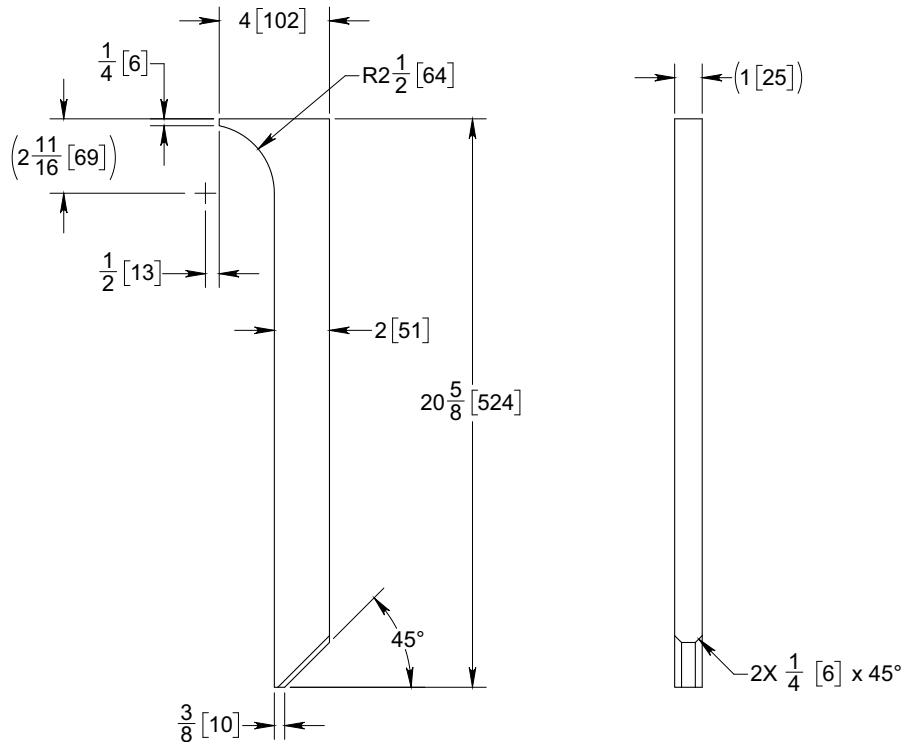


Figure 5: Plate P/N: DT27200-2



Model: C500/C750

Serial #: N/A

May 14, 2025

- If you have a Cage Revision D continue with section "Item 3B: DT27200-4 (Qty 1) – For Cage DT33192 Rev D" below.

Item 3B: DT27200-4 (Qty 1) – For Cage DT33192 Rev D

1. Using ASTM A36 material, fabricate one (1) plate (item 4 on Table 1 on page 3) as indicated in Figure 6.

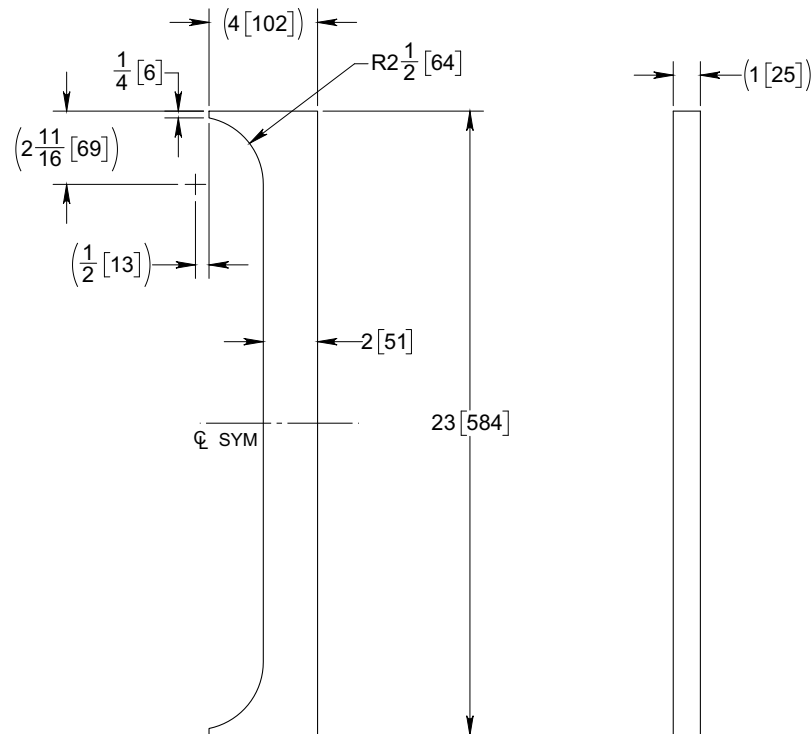


Figure 6: Plate P/N: DT27200-4



Model: C500/C750

Serial #: N/A

May 14, 2025

Plates Installation

NOTICE

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

Cage Driller's Side (DS)

NOTICE

Installation of the DS plates is the same for all cage revisions.

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

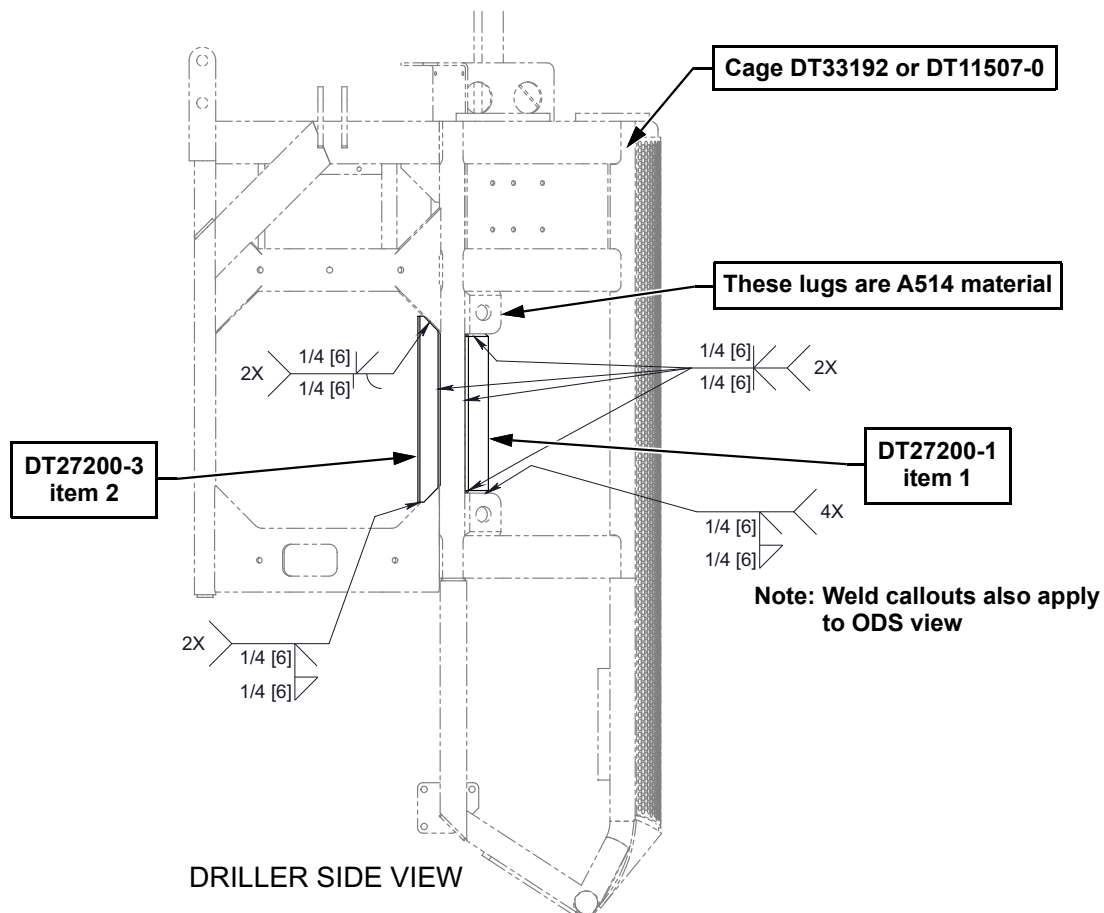


Figure 7: Plates installed on cage (DS)

NOTICE

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



Model: C500/C750

Serial #: N/A

May 14, 2025

Cage Off-Driller's Side (ODS)

- If the cage is **Rev D** (Ref. Drawing DT33192), then the bottom ODS beam will be 1" plate.
1. Remove existing 4" x 4" x 1/2" triangular gusset (See Figure 8) on the top ODS.

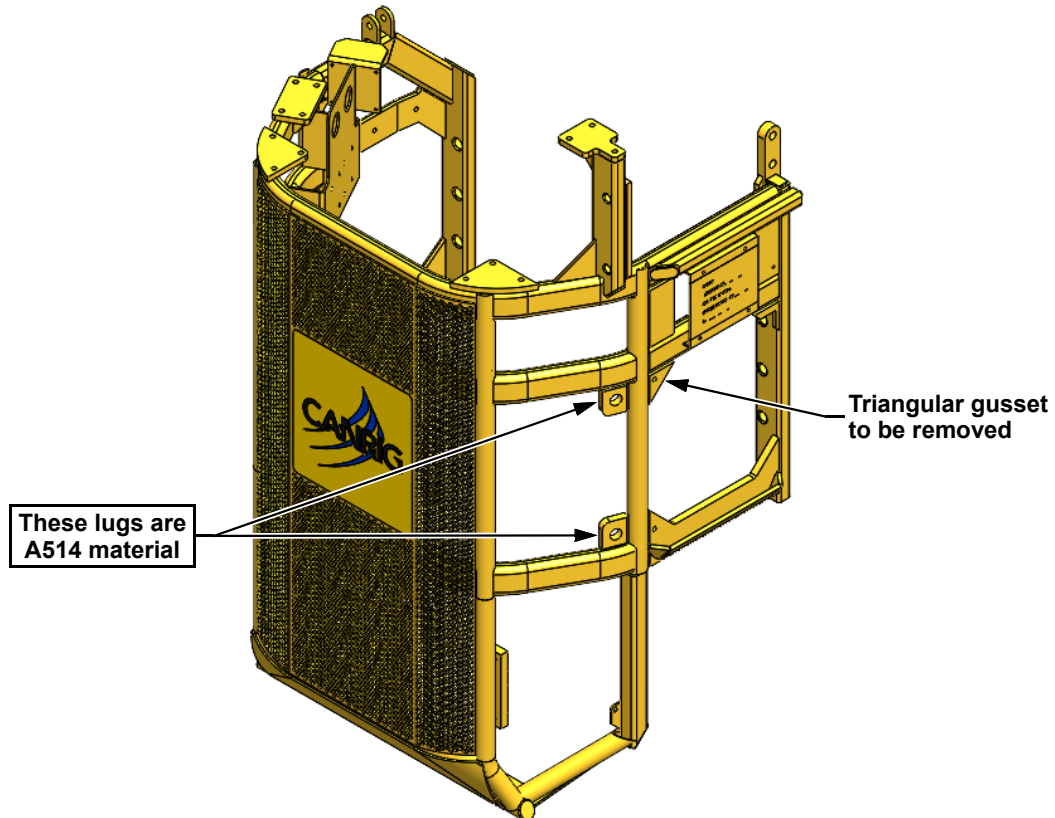


Figure 8: Triangular gusset to be removed.

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 $\frac{5}{8}$ " hole as shown in Detail A in Figure 9.

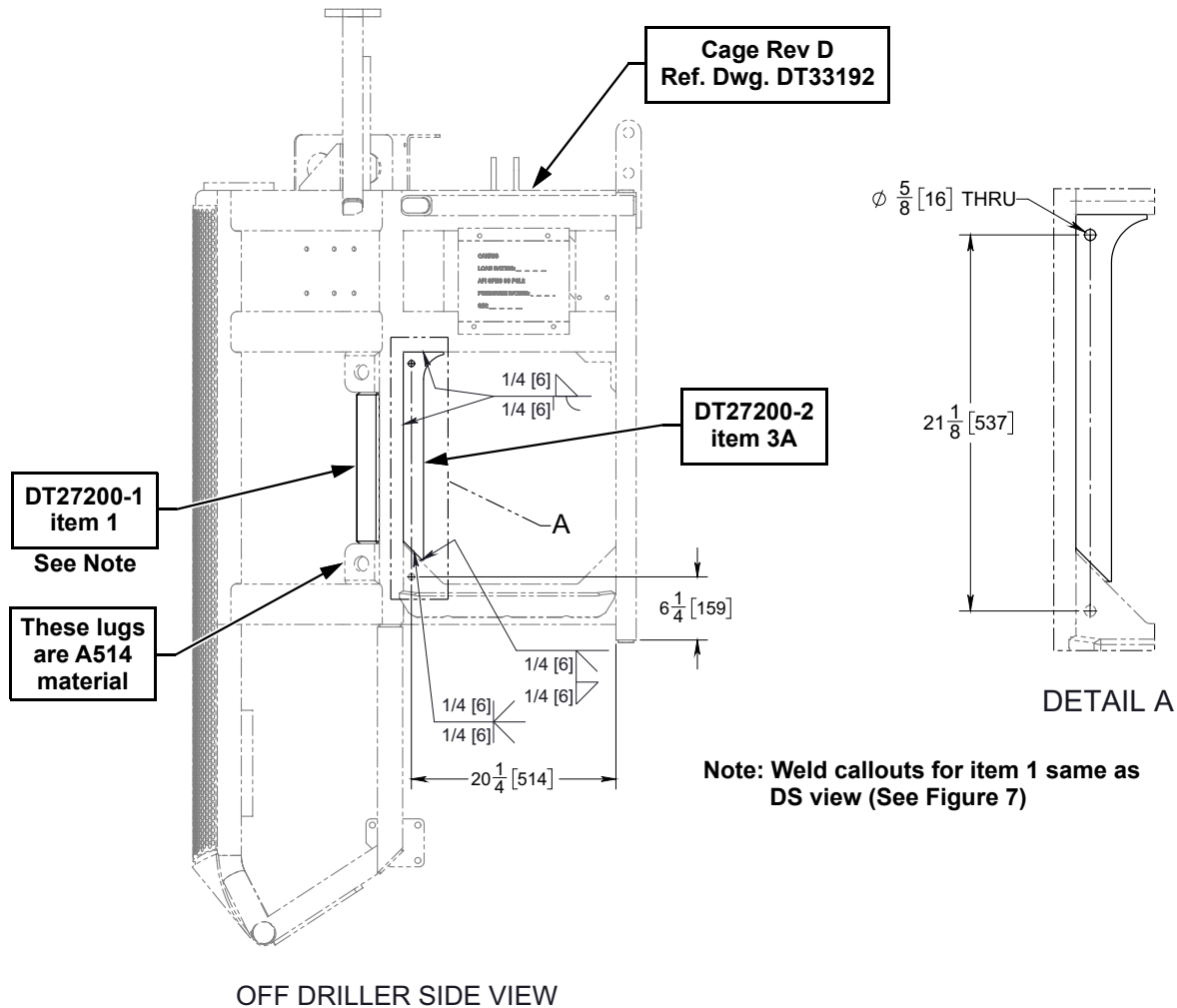


Figure 9: Plates installed on cage (ODS)

NOTICE

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

Go to Step 4 on page 12.



Model: C500/C750

Serial #: N/A

May 14, 2025

- If the cage is DT33192 **Rev A, B, or C** or DT11507, 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.

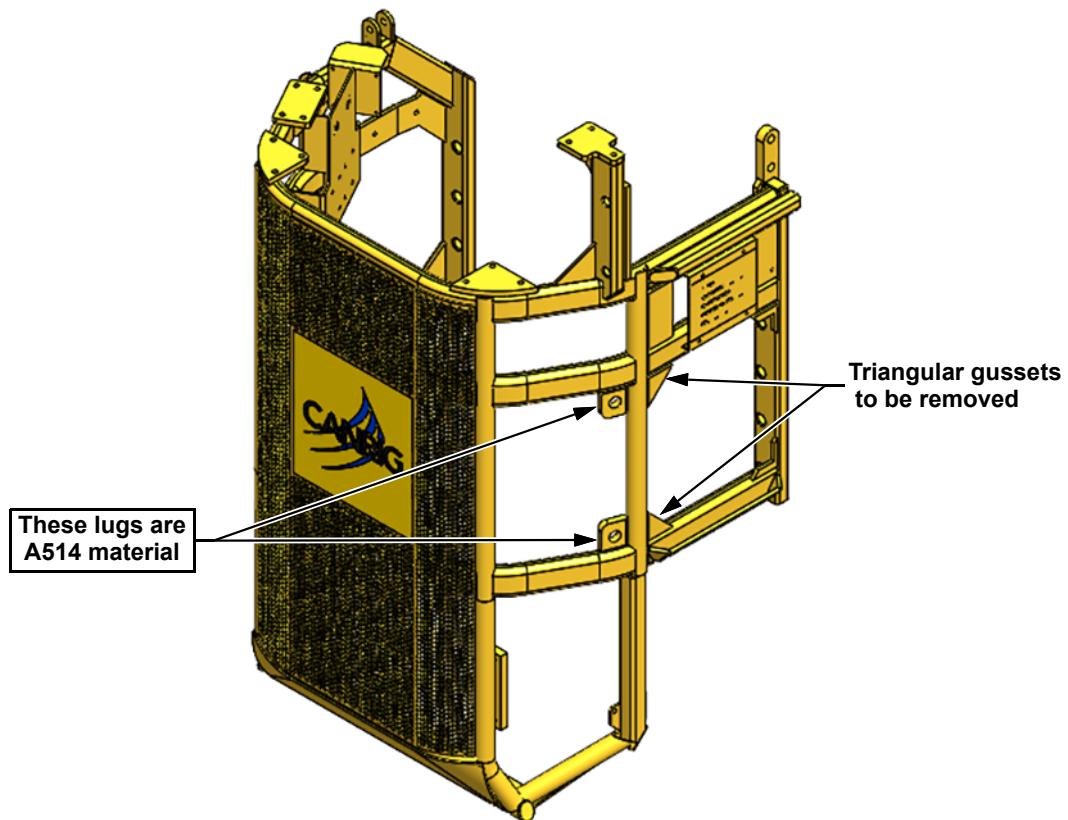


Figure 10: Triangular gussets to be removed.



Model: C500/C750

Serial #: N/A

May 14, 2025

2. Replace with plate P/N: DT27200-4 (item 3B) as shown in Figure 11 on page 12. **Note:** Outside of item 3B is flush with outside of plate/HSS above and below them.
3. Drill 5/8" hole as shown in Detail B in Figure 11.

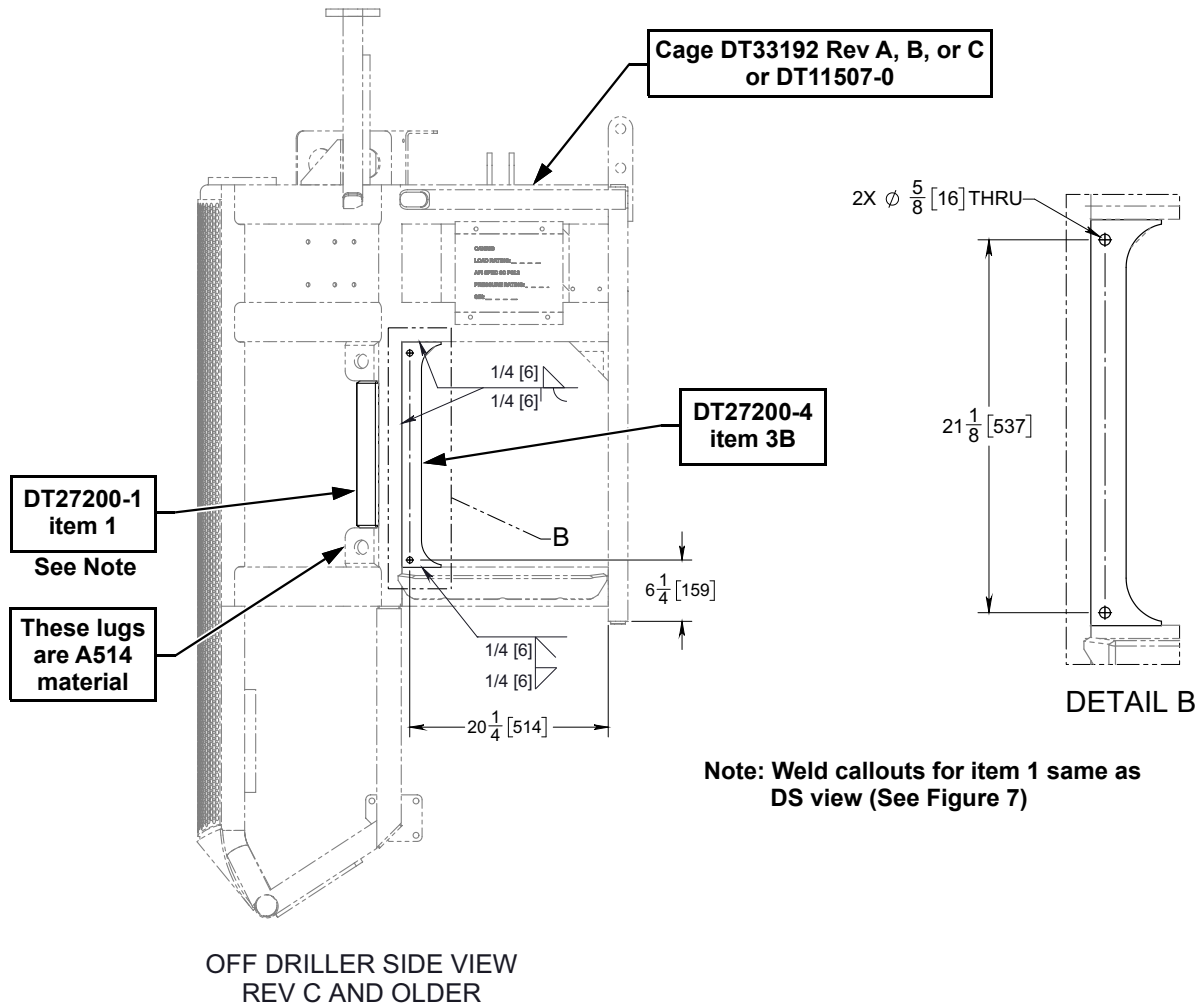


Figure 11: Plates installed on cage (ODS)

4. MPI all welds of ASTM A514 material within 48 hours after completion of welding.
5. Protect all machined holes and surfaces prior to blasting and painting.
6. Touch up paint Canrig Yellow (RAL No. 1006 / Maize Yellow).
7. After painting, apply anti-rust protection.