



Model: 275T, 500T, and 750T
Serial #: See Affected Units List

Jan. 12, 2016

Product Bulletin # TDS-155

Alert



Mudline Clamp Alert

Issue

Mud line clamps are intended to secure the mud line to the top drive guard for additional support. When mud lines are replaced, attention must be given to the proper installation of the mud line clamps. Improper installation can lead to failure of the fasteners.

Additionally, standard operating conditions can potentially loosen fasteners on the top drive mud line support and mud line clamp. Loose fasteners can lead to excessive loads on the mud line clamp and support. Canrig recommends that the top drive is inspected daily for loose fasteners and components. If fasteners are loose, they must be re-torqued according to Canrig specification ENG 725.

Table 1: Affected Part Numbers

| Model Number | Part Number | Description |
|---------------------------------------|----------------------------|-----------------------------|
| Standard 500T-AC 750T-AC (3" Bore) | DT11233 | Clamp, Mud Line, 3" Bore |
| 275T | 815-37-0 | Clamp, Mud Line |
| | DT14084-DS, DT14084-ODS | Mud Line Support |

Reference Documentation

Refer to the top drive manual, section 4B for inspection and maintenance procedure regarding daily inspection for loose components.

Also, refer to the following recently released documents on Nabors Sharepoint for more information on the mud line:

- TDS-147 Split Ring Upgrade

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Part Reference

The mud line, mud line support, and mud line clamp can be found at the top of the top drive, either on the ODS or DS side. Inspect entire assembly daily to ensure that all fasteners are properly torqued according to Canrig ENG 725.

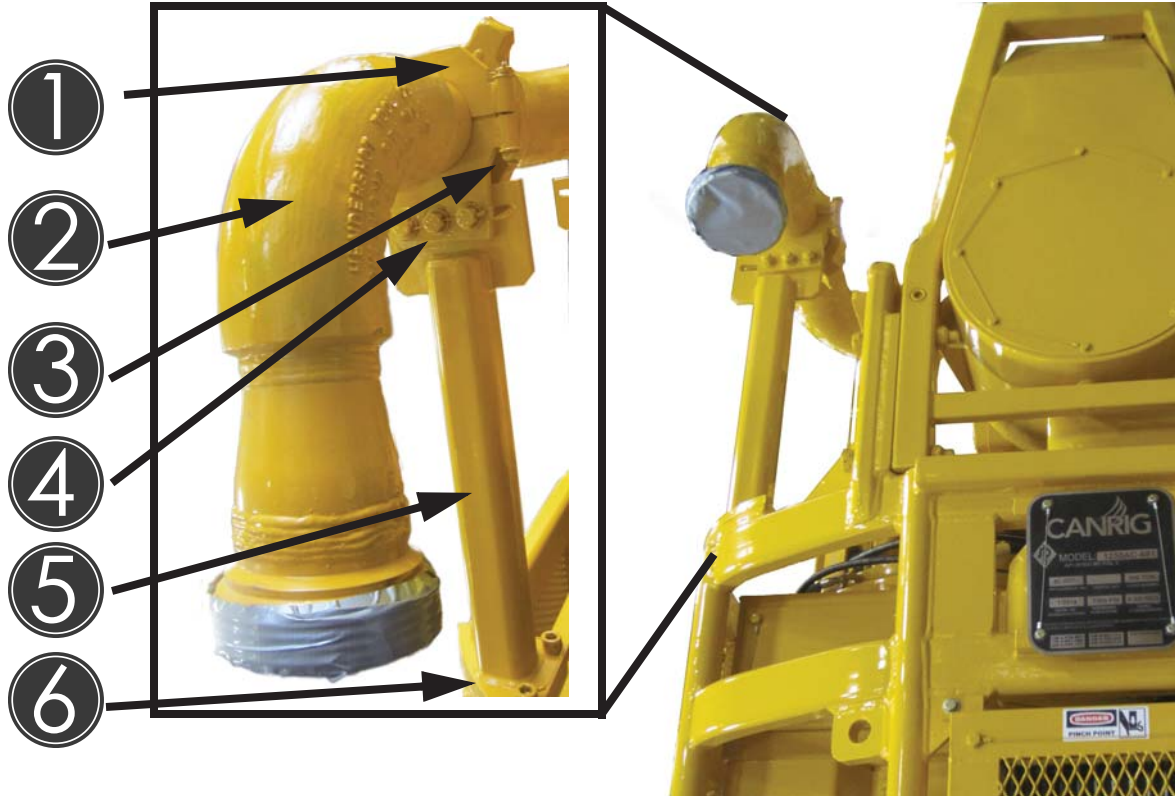


Figure 1: The mud line, mud line support, and the mud line clamp

| Item | Description |
|------|---|
| 1 | Mud line Clamp |
| 2 | Mud Line |
| 3 | (2) 1/2"-13 UNC x 4" LG Fasteners |
| 4 | (3) 5/8"-11 UNC x 2" LG Fasteners |
| 5 | Mud Line Support |
| 6 | (3) Socket-head Capscrews, 3/4"-10 UNC x 1 1/2" LG Fasteners |

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Inspection Procedure

For retention of these parts, Canrig recommends the following course of action:

1. Visually inspect the mud line clamp installation and confirm that mud line clamp is parallel with the mud line support, and not installed at an angle, as shown in Figure 2.
2. To check if the mud line clamp is parallel to the mud line support, measure the distance from the bottom corners of the clamp to the bottom edge of the support mount as shown in Figure 3.
3. If mud line clamps appear to be installed improperly, check the gap between the two clamps as shown in Figure 2. Gaps on either side of the clamp should be equal to each other.

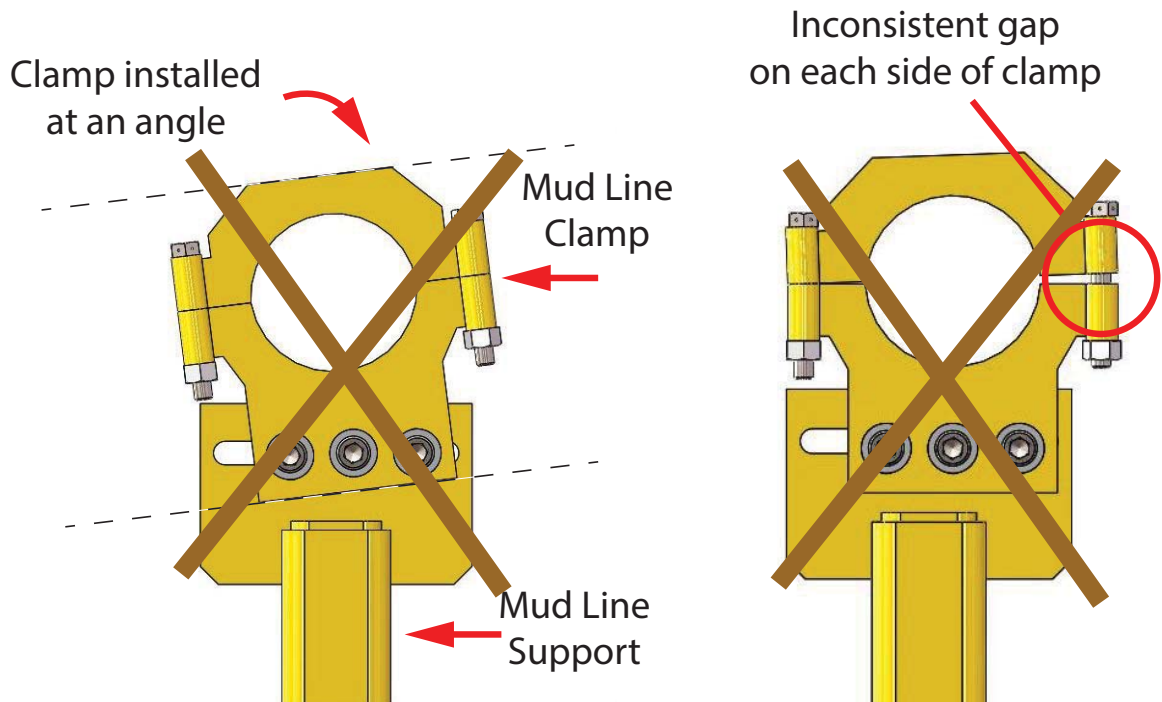


Figure 2: Common problems when installing mudline clamps

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Installation Procedure

For retention of these parts, Canrig recommends the following course of action:

1. Loosen the clamp fasteners (1/2" -13 UNC x 4" long, 2 each).
2. Loosen the mud line support fasteners (5/8" -11 UNC x 2" long, 3 each).
3. Loosely fit the clamp so that it is parallel with the mud line support mount as shown in Figure 3.
4. Ensure the gaps between the clamps are equal on either side with as shown in Figure 3.
5. Ensure the mud line clamp and mud line support are parallel by measuring the distance from the bottom corners of the clamp to the bottom edge of the support mount as shown in Figure 3.
6. If Step 4 and Step 5 are valid, torque the (2) 1/2"-13UNC x 4" fasteners to 99 ft-lbs.
7. Confirm the mud line clamp is still parallel with the mud line support mount.
8. Torque the (3) 5/8"-11UNC x 2" fasteners to 198 ft-lbs.
9. Ensure the mud line clamp is still parallel with the mud line support mount as shown in Figure 3.
10. If the mud line clamp and the mud line support are not still parallel, loosen the fasteners and repeat Step 3 through Step 8.

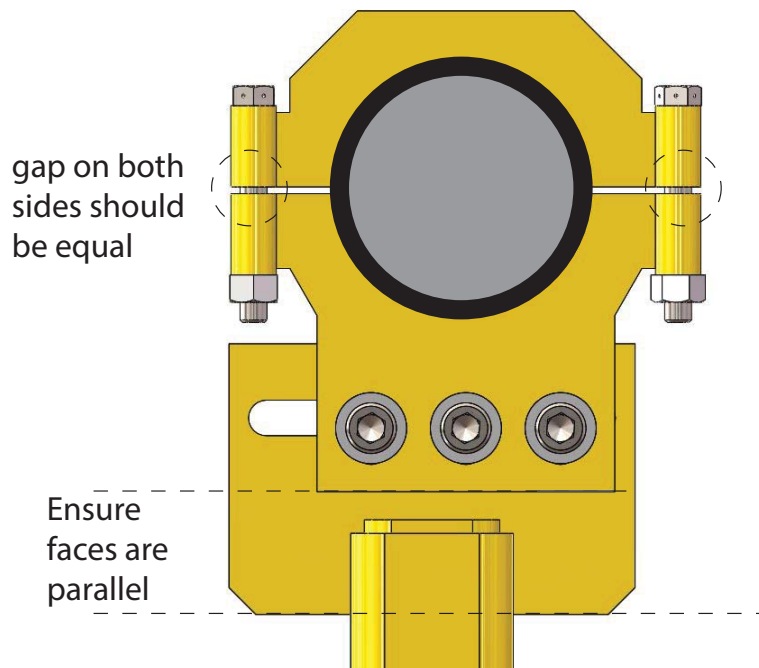


Figure 3: Ensure proper installation