



Model: See Affected Units	Oct. 25, 2021
Serial #: N/A	
Product Bulletin # TDS-234 Rev 1	

Portable Torque Guide Updates

Canrig Drilling Technology has updated the Portable Torque Guide for top drive models C500 and C750 to meet the recommendations of the DROPS online program. This update primarily adds safety securement to the bolts and pins that previously didn't have it and will also be added to all newly built portable torque guides.

The benefit of this update is to add another layer of drop protection to the components on the portable torque guide. These updates are not required for the operation of the torque guide and adding them is solely up to the discretion of the owner of the torque guide.

This change does not include any components that are only used during rig-up and rig-down.

Affected Units

Canrig Top Drive models C500 and C750 with portable torque guide.

Torque Guide Updates

Updates include adding safety securement to the following:

- Torque guide pin
- Tensioning cable guides
- Tensioning cable cylinder guard
- Cylinder clevis pin and anti-rotation slider
- Tensioning cylinder mount and retainer plate
- J-Boxes mounting bolts

Contact RIGLINE 24/7™ to order replacement parts and/or to request assistance with this improvement.

Torque Guide Pin

1. Wire the pins connecting each section of the track (Figure 1).
 - a. Drill the pins (AY18964) for 1/8" wire or replace with part DT25435. (12X).
 - b. Drill the bolts shank for 1/16" wire or replace with pre-drilled bolts. (12X).
 - c. Weld a half link on the torque guide sections to route the wire through. (12X).

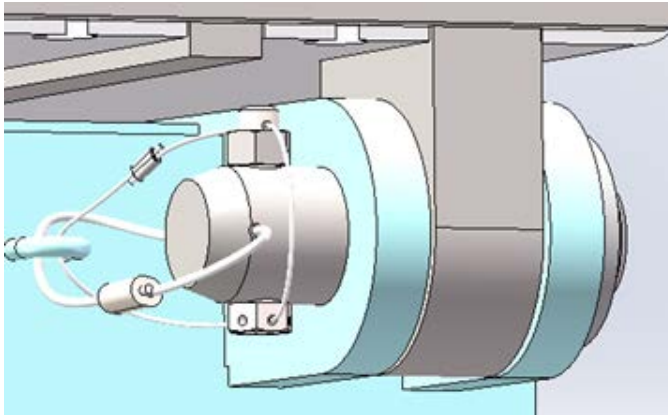


Figure 1: Torque guide pins

Components required if existing ones cannot be modified:

Table 1: Parts for Torque Guide Pin

Part Number	Qty.	Description
DT25435	12	Pin, TG, w/Threaded hole plug
HH-0500NC-0250-GR8-DW	12	Capscr, Hex HD, 1/2-13UNC x 2.50, Gr 8, DW
LN-0500NC-GR8	12	Locknut, 1/2-13UNC, Gr 8, Stover
M21-2000-010	12ft	Wire Rope, 1/16 Dia
M10022	11ft	Wire Rope, 1/8 Dia
M19-3006-010	12	Ferrule, 1/16 Oval, Aluminum
M19-3009-010	12	Ferrule, 1/8 Oval, Aluminum
M10130	12	Chain, 1/4, Grade 70, Half of a link

Tensioning Cable Guides

1. Wire the tensioning cable guides (Figure 2).
 - a. Weld a half link to the bolted half of the cable guide (850-92-0) or replace with part DT25432.
 - b. Weld a half link to the torque guide tube. (20X) The link on the tube will need to be kept as close to the cable guide as possible and the 1/8" wire kept as short as possible to avoid the wire or the link from being snagged by the top drive runner.

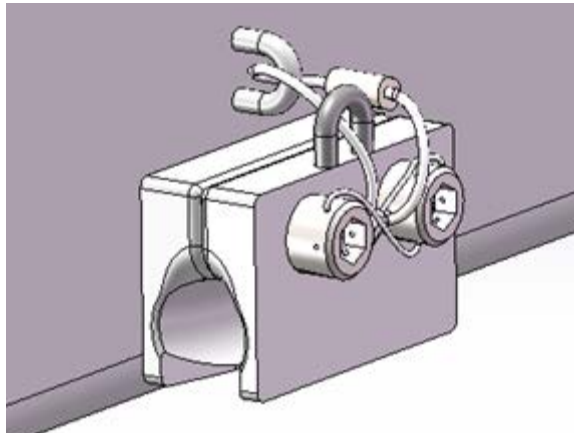


Figure 2: Tensioning cable guides

Components required if existing ones cannot be modified:

Table 2: Parts for Tensioning Cable Guides

Part Number	Qty.	Description
DT25432	20	Guide, Tensioning cable, Bolted half
M21-2000-010	13ft	Wire Rope, 1/16 Dia
M10022	17ft	Wire Rope, 1/8 Dia
M19-3006-010	12	Ferrule, 1/16 Oval, Aluminum
M19-3009-010	12	Ferrule, 1/8 Oval, Aluminum
M10130	20	Chain, 1/4, Grade 70, Half of a link

Tensioning Cable Cylinder Guard

1. Wire the cover for the tensioning cable cylinder (Figure 3).
 - a. Drill a hole close to the right edge of the cover (895-81-0) or replace with part DT25431 for 1/8" wire.
 - b. Drill holes in the gussets for 1/16" wire.
 - c. Drill holes on the bolts shank for 1/16" wire or replace with pre-drilled bolts. (12X).

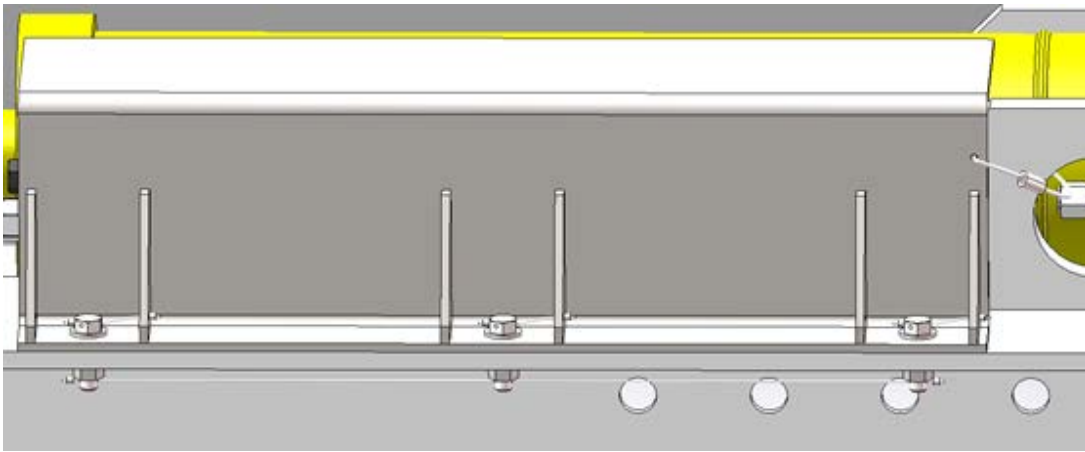


Figure 3: Tensioning cable cylinder guard

Components required if existing ones cannot be modified:

Table 3: Parts for Tensioning Cable Cylinder Guard

Part Number	Qty.	Description
DT25431	1	Guard, Tensioning cylinder
HH-0500NC-0175-GR8-DW	3	Capscr, Hex HD, 1/2-13UNC x 1.75, Gr 8, DW
LN-0500NC-GR8	3	Locknut, 1/2-13UNC, Gr 8, Stover
M21-2000-010	34in	Wire Rope, 1/16 Dia
M10022	28in	Wire Rope, 1/8 Dia
M10197	8	Ferrule, 1/16 Stop, Aluminum
M19-3009-010	1	Ferrule, 1/8 Oval, Aluminum

Cylinder Clevis Pin and Anti-rotation Slider

1. Wire the clevis pin (837-21-0) and anti-rotation slider on the tensioning cylinders (Figure 4).
 - a. Drill hole in the head of the pin (837-21-0) or replace with part DT25433 for 1/8" wire. (2X).
 - b. Replace bolt and nut with a bolt with a hole in the shank and a slotted hex nut. (2X).
 - c. Add cotter pin and quick link. (2X).

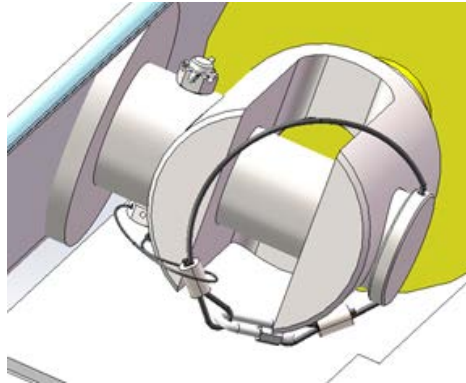


Figure 4: Cylinder clevis pin and anti-rotation slider

Components required if existing ones cannot be modified:

Table 4: Parts for Cylinder Clevis Pin and Anti-rotation Slider

Part Number	Qty.	Description
DT25433	2	Pin, Tensioning Cylinder
HH-0500NC-0350-GR8-DW	2	Capscr, Hex HD, 1/2-13UNC x 3.50, Gr 8, DW
HSN-0500NC-GR8	2	Hex Nut, Slotted, 1/2-13UNC, Gr 8
M12123	2	Cotter pin, 1/8 x 1 1/2
M13859	2	Quick Link, 3/16, 600 LB WLL
M21-2000-010	22in	Wire Rope, 1/16 Dia
M10022	39in	Wire Rope, 1/8 Dia
M19-3006-010	2	Ferrule, 1/16 Oval, Aluminum
M19-3009-010	4	Ferrule, 1/8 Oval, Aluminum

Tensioning Cylinder Mounting Pin and Retainer Plate

1. Wire the keeper plate (850-89-0) for the tensioning cylinder mounting pin (Figure 5).
 - a. Add cotter pin and quick link. (2X).
 - b. Drill a hole through the outer cylinder mount and the keeper plate or replace with part DT25434 for 1/8" wire. (2X).
 - c. If not already done, wire the heads of the 2 bolts together. May require the bolts to be replaced if they are not already drilled for wire. (4X).

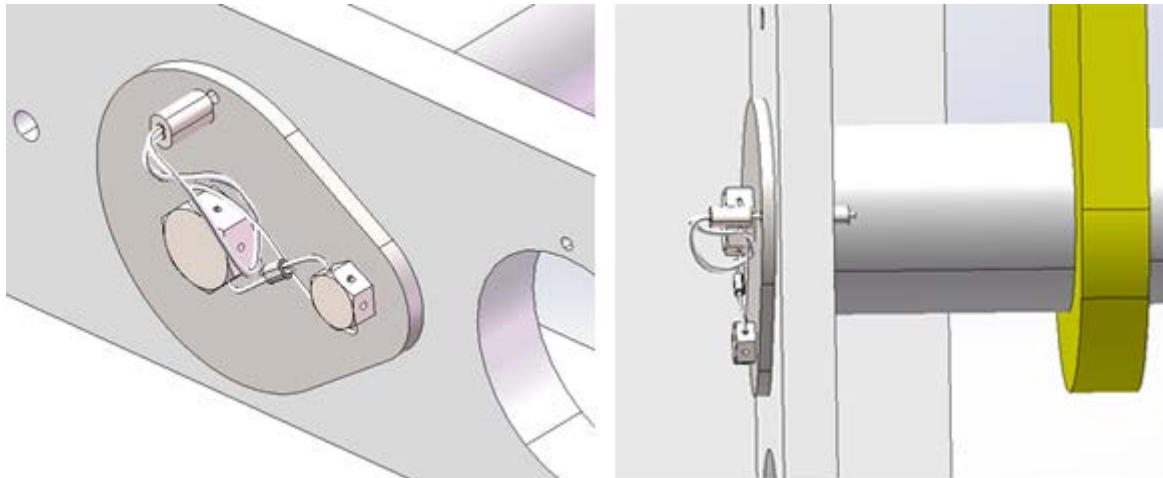


Figure 5: Tension cylinder mounting and retainer plate

Components required if existing ones cannot be modified:

Table 5: Parts for Tensioning Cylinder Mounting Pin and Retainer Plate

Part Number	Qty.	Description
DT25434	2	Tensioning pin retainer
HH-0750NC-0100-GR8-W	2	Capscre, Hex HD, 3/4-10UNC x 1.00, Gr 8, W
HH-0500NC-0100-GR8-W	2	Capscre, Hex HD, 1/2-13UNC x 1.00, Gr 8, W
M21-2000-010	18in	Wire Rope, 1/16 Dia
M10022	6	Wire Rope, 1/8 Dia
M19-3006-010	2	Ferrule, 1/16 Oval, Aluminum
M19-3009-010	2	Ferrule, 1/8 Oval, Aluminum
M10241	2	Ferrule, 1/8 Stop, Aluminum



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J-Boxes Mounting Bolts

1. Wire the bolts, on both sides, for mounting the junction boxes (Figure 6).
 - a. Drill the bolts on the shank for 1/16" wire or replace with pre-drilled bolts. (12X). On the back of the torque guide, make sure the wire rope runs vertically not horizontally, to reduce the chance of it being snagged.

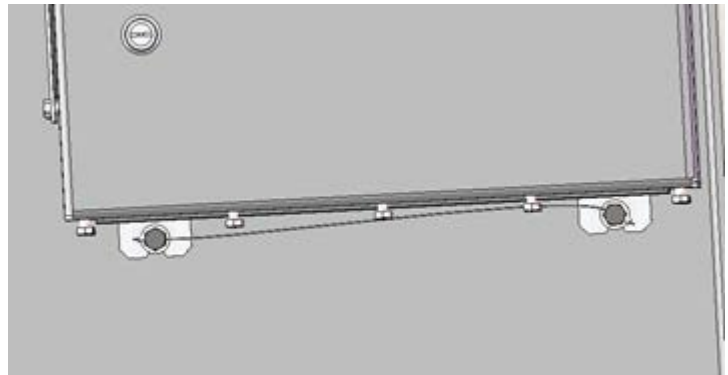
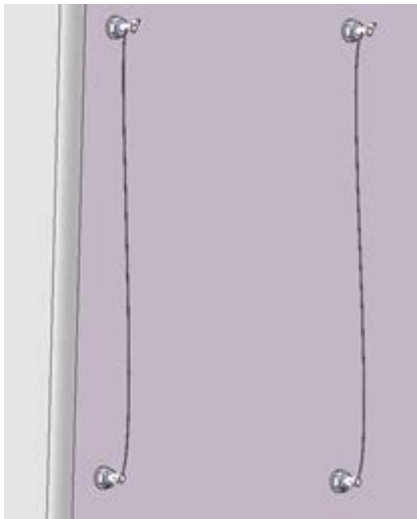


Figure 6: J-Boxes mounting bolts

Components required if existing ones cannot be modified:

Table 6: Parts for J-Boxes Mounting Bolts

Part Number	Qty.	Description
HH-0375NC-0125-GR8-DW	8	Capscrew, Hex HD, 3/8-16UNC x 1.25, Gr 8, DW
HH-0250NC-0125-GR8-DW	4	Capscrew, Hex HD, 1/4-20UNC x 1.25, Gr 8, DW
LN-0375NC-GR8	8	Locknut, 3/8-16NC, Stover, Gr 8
LN-0250NC-GR8	4	Locknut, 1/4-20NC, Stover, Gr 8
M21-2000-010	18ft	Wire Rope, 1/16 Dia
M10197	24	Ferrule, 1/16 Stop, Aluminum

Contact RIGLINE 24/7™ to order any of these replacement parts and/or to request assistance with this improvement.