



|   |               |
|---|---------------|
| Model: See Affected Assemblies<br>Serial #: N/A | Jan. 22, 2021 |
| Product Bulletin # TDS-230 v 1.0                |               |

# BUW Gripper Die Retainer Plate

## Issue

An upward force on the BUW gripper dies can cause the die retention to fail. If the die block is not completely retracted in the back-up wrench (BUW) or if the wrong stabbing bell (also known as the stabbing guide) is used, there is a risk the drill pipe could make contact with the dies and push them out of the die blocks as the top drive is lowered on the drill string.

Canrig has created an improvement to the die retention in the BUW gripper die block assembly. The dies are now retained with a retainer plate rather than washers or lock washers. The retainer plate is a more robust design and offers more protection to the dies.

## Recommendations

1. If the die blocks are using washers or lockwashers to retain the die (see Figure 1), Canrig recommends upgrading to the new retainer plate design (see Figure 2.)

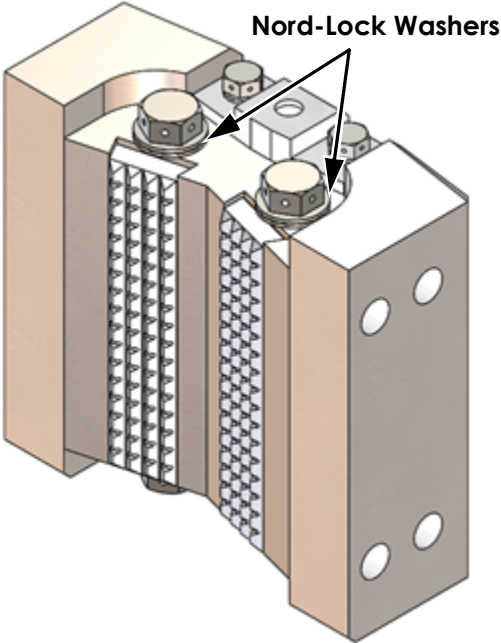


Figure 1: Old Die Block with Nord-Lock Washer Retention

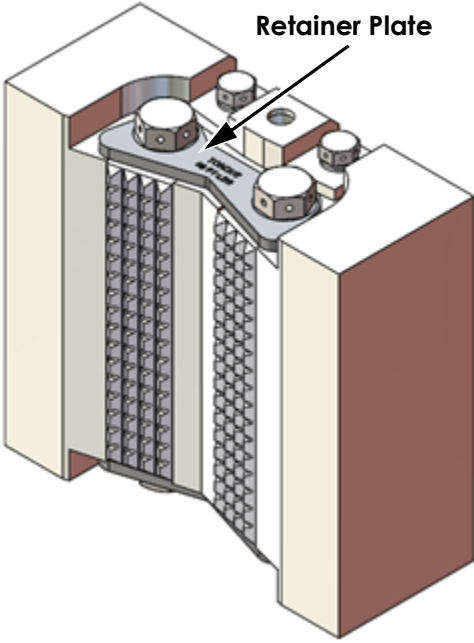


Figure 2: New Die Block with Die Retainer Plate



|   |               |
|---|---------------|
| Model: See Affected Assemblies<br>Serial #: N/A | Jan. 22, 2021 |
|---|---------------|

2. Ensure the stabbing bell is the correct size for the gripper die blocks used. See SD10134 (Stabbing Bell/Die Block Compatibility Chart). Generally, the bore of the stabbing bell should be no more than 1/2" larger than the drill pipe outside diameter.
3. When lowering the top drive on the drill pipe, ensure the BUW gripper is fully retracted.
4. Visually inspect the die retention of the BUW gripper daily. Verify the gripper die retention is properly installed and not damaged.

## Affected Assemblies

Die block assemblies affected by this upgrade are shown below:

**Table 1: Die Block Parts/Assemblies**

| Die Block Assembly Part No. | Die Block Part No. | Description   | Die Retainer Plate Kit Part No. |
|-----------------------------|--------------------|---|---------------------------------|
| AY12689                     | DT14330            | DIE BLOCK ASSY, 5.75 - 9.00<br>(Discontinued Product)       | AY25173<br>(See Table 2)        |
| AY12689-1                   | DT14330            | DIE BLOCK ASSY, W/SP, 5.75 - 9.00<br>(Discontinued Product) |                                 |
| AY12689-2                   | DT14330            | DIE BLOCK ASSY, 5.75 - 9.00<br>(Discontinued Product)       |                                 |
| AY12692                     | DT14333            | DIE BLOCK ASSY, 3.25 - 6.50<br>(Discontinued Product)       |                                 |
| AY12692-1                   | DT14333            | DIE BLOCK ASSY, W/SP, 3.25 - 6.50<br>(Discontinued Product) |                                 |



|   |               |
|---|---------------|
| Model: See Affected Assemblies<br>Serial #: N/A | Jan. 22, 2021 |
|---|---------------|

**Table 1: Die Block Parts/Assemblies (Continued)**

| Die Block Assembly Part No. | Die Block Part No. | Description  | Die Retainer Plate Kit Part No. |
|-----------------------------|--------------------|--|---------------------------------|
| AY12692-2                   | DT14333            | DIE BLOCK ASSY, 3.25 - 6.50, CRE (Discontinued Product)  | AY25173<br>(See Table 2)        |
| AY12691                     | DT14332            | DIE BLOCK ASSY, 2.50 - 5.75 (Discontinued Product)       |                                 |
| AY12691-1                   | DT14332            | DIE BLOCK ASSY, W/SP, 2.50 - 5.75 (Discontinued Product) |                                 |
| AY12691-2                   | DT14332            | DIE BLOCK ASSY, 2.50 - 5.75, CRE (Discontinued Product)  |                                 |
| AY12690                     | DT14331            | DIE BLOCK ASSY, 3.75 - 7.00 (Discontinued Product)       |                                 |
| AY12690-1                   | DT14331            | DIE BLOCK ASSY, W/SP, 3.75 - 7.00 (Discontinued Product) |                                 |
| AY12690-2                   | DT14331            | DIE BLOCK ASSY, 3.75 - 7.00, CRE (Discontinued Product)  |                                 |
| AY19799                     | DT32132            | DIE BLOCK ASSY, INTEG., 3.25 - 6.50                      |                                 |
| AY19799-1                   | DT32132            | DIE BLOCK ASSY, INTEG., 3.25 - 6.50, CRE                 |                                 |
| AY23478                     | DT33179            | DIE BLOCK ASSY, 5.75 - 9.00, FIXED END                   |                                 |
| AY23492                     | DT33179            | DIE BLOCK ASSY, 5.75 - 9.00, CYL. END, CRE               |                                 |
| AY19681                     | DT31839            | DIE BLOCK ASSY, INTEG., 5.75 - 9.00                      |                                 |
| AY19681-1                   | DT31839            | DIE BLOCK ASSY, 5.75-9.00, CYL. END, CRE                 |                                 |
| AY23483                     | DT33182            | DIE BLOCK ASSY, 3.25 - 6.50, FIXED END                   |                                 |
| AY23484                     | DT33182            | DIE BLOCK ASSY, 3.25 - 6.50, FIXED END, CRE              |                                 |
| AY23479                     | DT33180            | DIE BLOCK ASSY, 3.75 - 7.00, FIXED END                   |                                 |
| AY23480                     | DT33180            | DIE BLOCK ASSY, 3.75 - 7.00, FIXED END, CRE              |                                 |
| AY23488                     | DT33187            | DIE BLOCK ASSY, 3.75-7.00, CYL END                       |                                 |
| AY23489                     | DT33187            | DIE BLOCK ASSY, 3.75- 7.00, CYL. END, CRE                |                                 |
| AY23481                     | DT33181            | DIE BLOCK ASSY, 2.50 - 5.75, FIXED END                   |                                 |
| AY23482                     | DT33181            | DIE BLOCK ASSY, 2.50 - 5.75, FIXED END, CRE              |                                 |
| AY23490                     | DT33188            | DIE BLOCK ASSY, 2.50 - 5.75, CYL. END                    |                                 |
| AY23491                     | DT33188            | DIE BLOCK ASSY, 2.50 - 5.75, CYL. END, CRE               |                                 |



|  |               |
|--|---------------|
| Model: See Affected<br>Assemblies<br>Serial #: N/A | Jan. 22, 2021 |
|--|---------------|

# Replacement Kit

**Table 2: P/N: AY25173 – Die Retainer Plate Kit**

| Qty  | Canrig Part No.      | Description                              |
|------|----------------------|--|
| 2    | DT25969              | RETAINER, DIE, DIE BLOCK                 |
| 4    | HH-0500NC-0100-GR8-W | CAPSCR, HEX HD, 1/2-13UNC x 1.00, GR8, W |
| 1 FT | M21-2000-010         | WIRE ROPE, 1/16 IN, 7 x 7, STAINLESS     |
| 4    | M19-3006-010         | FERRULE, 1/16, OVAL, ALUMINUM            |

Contact RIGLINE 24/7™ for additional information.