



Model: See affected models

Serial #: N/A

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Product Bulletin # TDS-204 v 1.0

## Improved Gearcase Drain Available

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**Note:** Disregard this product bulletin if you have implemented procedure described in Product Alert *TDS-196 Gearcase Drain Issue*.

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The lube oil may not properly drain from the gearcase into the sump tank when rotating at high RPM. Canrig has created an improved gearcase drain with a baffle to direct the flow of oil into the sump tank.

## Affected Models

- Top drive models: 1250AC-681, 1250AC-865, 1275AC-681, and 1275AC-865.

## Recommendation

Contact RIGLINE 24/7™ Support to order the new gearcase drain. Install the new drain on the gearcase assembly using the field installation kit Canrig P/N: AY24934.

## Procedure

Follow the steps below to install the new gearcase drain.

1. Perform lock-out/tag-out procedures according to local regulations to isolate all forms of energy to the top drive.
2. Drain all oil from the gearcase.
3. Remove current elbow drain assembly, hardware, and O-ring seal.
4. Install new O-ring, drain elbow, and eight (8) SH-0375NC-0125-W bolts by hand as shown in Figure 1 on page 2.
5. Ensure the flat reference face on the drain elbow is aligned parallel to the edge of the gearcase as shown in Figure 2 on page 2.

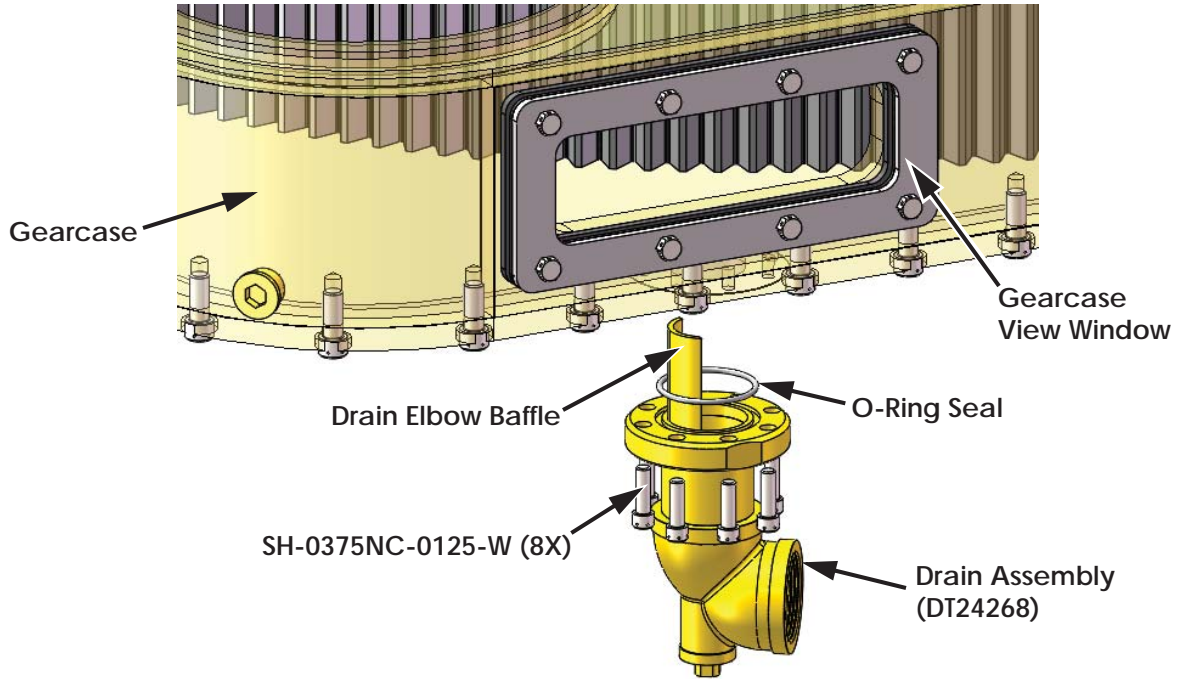


Figure 1: Drain Elbow Installation

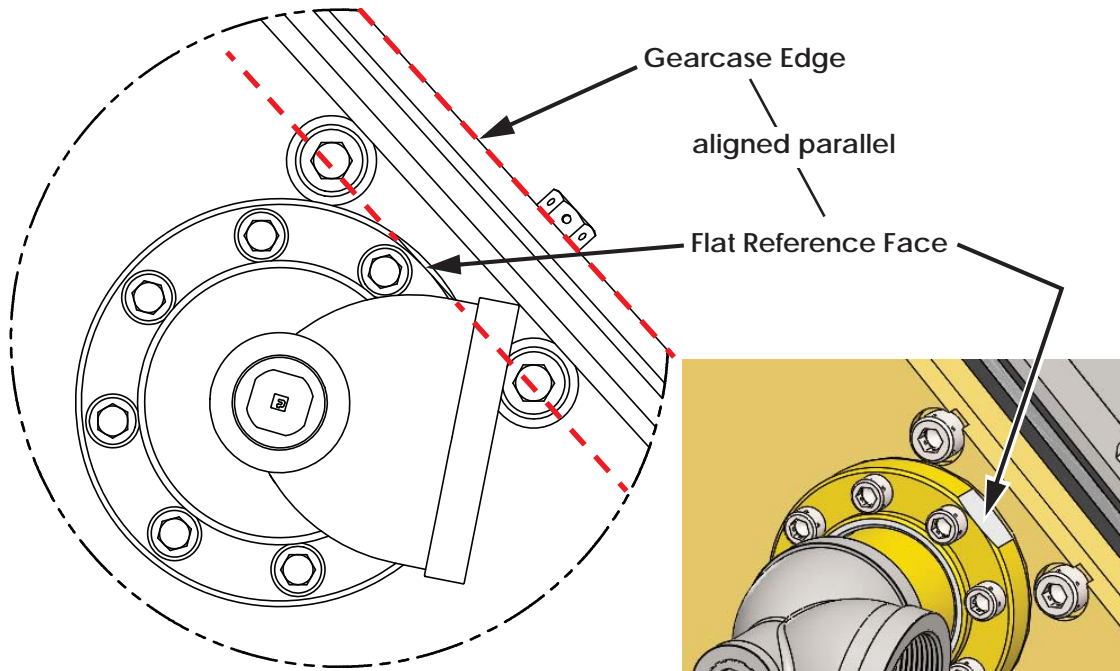


Figure 2: Drain Elbow Alignment

6. Tighten bolts in star pattern to ensure even pressure on the O-ring.
7. Torque the SH-0375NC-0125-W bolts to 40 ft-lb per Canrig Engineering specification ENG 725.
8. Apply safety securement to SH-0375NC-0125-W bolts together using 1/16" wire rope and ferrules.
9. Ensure the baffle is oriented correctly. Inspect the baffle position through the view window. The convex side of the baffle should be pointing towards the motor pinion as shown in Figure 3.

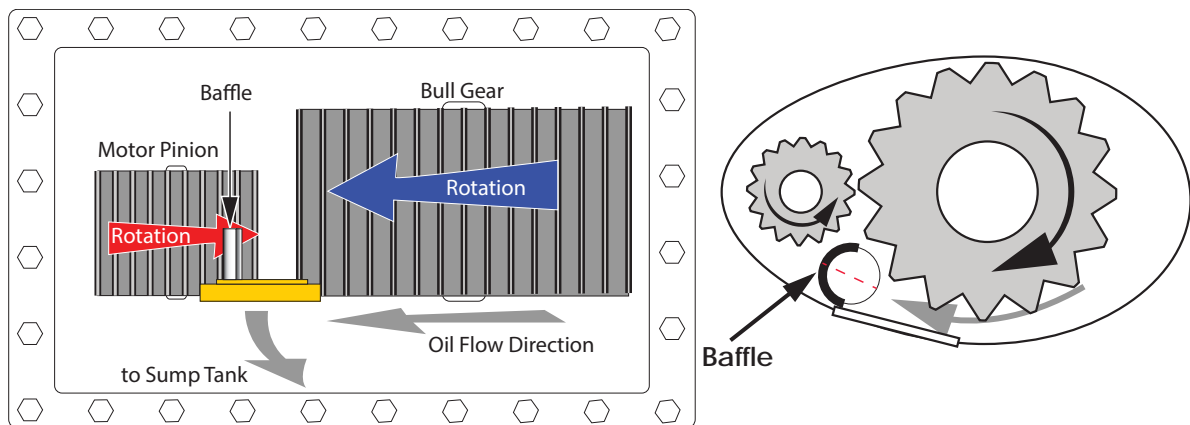


Figure 3: Arrangement Illustration

10. Refill the gearcase with recommended oil.
11. Remove lock-out/tag-out and test the equipment for correct operation.