



Model: See Affected Units

Serial #: N/A

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Product Bulletin # CDS-013 Rev 1

Alert



Do Not Weld on ICDS and CCDS Mandrels

Issue At Hand

One of the features of the Internal Casing Drive Systems (Internal CDS and Internal Compact CDS) is a Casing Stop Collar that prevents the ICDS/CCDS tool from being stabbed too deep into the casing and damaging either the ICDS/CCDS tool or the casing. The Casing Stop Collar sits against the Mandrel's shoulder that stops it from moving vertically up when it unintentionally hits the casing. Several bolts hold the Casing Stop Collar in place.

It came to Canrig's attention that some customers have welded the Casing Stop Collar to the Mandrel on some of their CDS tools.

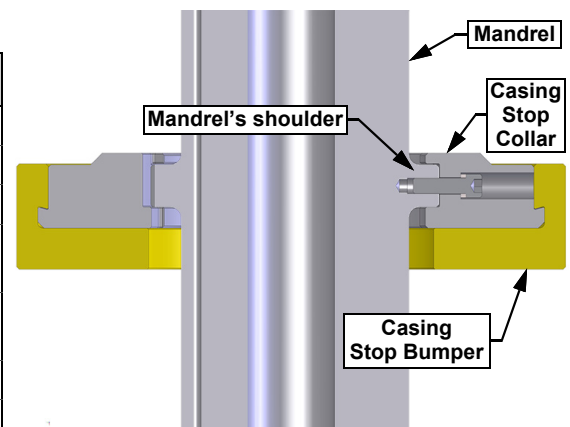
Welding on the load path components including ICDS & CCDS mandrels is not permitted. The unauthorized welding may affect material properties and cause defects or cracks which may cause component catastrophic failure.

Affected Units

All Internal CDS and CCDS tools featuring Load Path Mandrels regardless the date of manufacture:

Table 1: ICDS and CCDS Load Path Mandrels

ICDS	CCDS
4-1/2" ICDS Mandrel	4-1/2" CCDS Mandrel
5-1/2" ICDS Mandrel	5-1/2" CCDS Mandrel
7" to 9-5/8" ICDS Mandrel	7" to 9-5/8" CCDS Mandrel
9-5/8" to 13-3/8" ICDS Mandrel	9-5/8" to 13-5/8" CCDS Mandrel
12-3/4" to 16-3/4" ICDS Mandrel	13-3/8" to 16-3/4" CCDS Mandrel
17-7/8" to 20" ICDS Mandrel	17-7/8" to 20" CCDS Mandrel
24" ICDS Mandrel	



Recommended Actions

Remove from service, scrap and replace any ICDS & CCDS Mandrels found to have been welded.