

# PEMAC PTE LTD



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5CT, 6A, 7 & 16A

## SERVICE BULLETIN

To: **All Users of Pemac Push Arm Models SPA7-- & SPA9--**

Bulletin No: **PPL-SB061**

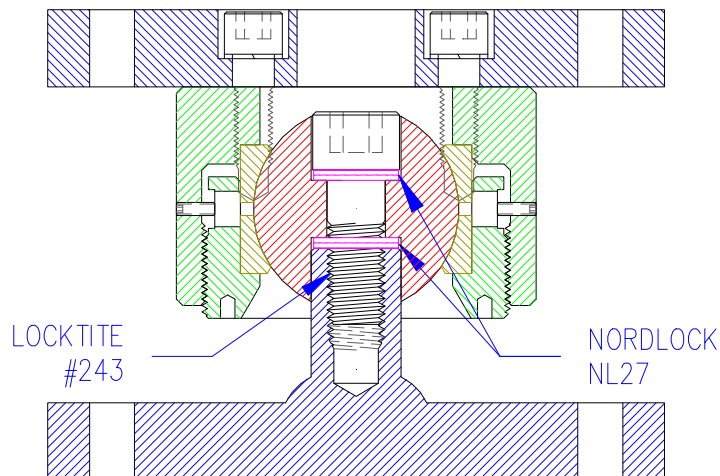
**27 May 2006**

Subject: **Additional Security for Ball Joint on HawkJaw Push Arms**

A 1-1/8" capscrew was recently reported to have backed out of ball joint, allowing the support-end of the arm to drop. Service Bulletin PPL-SB051 required a safety lock washer to be installed between ball and pin, to transfer residual torque from the push arm, via bearings, grease and ball, to the ball pin bracket.

Review of field conditions found that safety washers can easily be installed in the 'natural' position, between capscrew and ball, where they are unable to lock the ball to the pin. To avoid mis-assembly, an extra safety lock washer; Nord-Lock p/n NL27 is placed between capscrew and ball as shown. The 1-1/8" capscrew should be installed with Loctite 243 removable threadlocker and torqued to 200 ft lb.

Existing Push Arm Models SPA7-- & SPA9-- should be checked for tightness of the capscrew and for correct position of safety lock washers, when rig operations allow. An additional Nord-Lock washer set is available for free issue to all applicable rigs as listed below.



<b>Rig</b>	<b>Model No.</b>	<b>Serial No.</b>	<b>Delivered</b>
Ensco 97	SPA9S57	3705	May-2003
Trident IX	SPA9SD	3894	June-2003
West Pelaut	SPA7SM	4413	Dec-2003
Smedvig T-9	SPA7SM	4412	Jan-2004
Teknik Berkat	SPA7SM	4523	Feb-2004
West Menang	SPA7SM	4489	Sept-2004
Smedvig T-8	SPA7JT8	5017	Oct-2004
Ensco 53	SPA7SD	5063	Nov-2004
West Setia	SPA7SM	5023	Jan-2005
Smedvig T-6	SPA7SM	5228	Jan-2005
Ensco 54	SPA7SD	5190	Feb-2005
Ensco 96	SPA7SD	5302	Mar-2005
Trident XVII	SPA7SD	6531	May-2006

**N.B.** All Push Arms for HawkJaw power tongs should be checked for the presence of a **safety sling** around the arm and its support beam.