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# SAFETY ALERT

## Product Safety Bulletin No. 6

### **Subject:**

It has been reported that the bolts that retain the Rotary Seal Assembly to the Link Assembly Rotary Seal Spacer have broken, causing the Rotary Seal Assembly to not swivel with Link Collar Assembly.

### **Products:**

All GDM 500/650 and 750/850 Ton Top Drives

### **Assemblies Affected:**

Rotary Seal Assembly and Link Assembly Rotary Seal Spacer / Rotary Manifold Stand (reference drawings A500015, A500135, A800025)

### **Issue:**

GDS received reports of an incident involving the 12 bolts (P/N 008121.0424DH) breaking. If repairs are not implemented in time, the hoses connecting the Rotary Seal Assembly to the hydraulic manifold may become stretched and fail.

No injuries occurred as a result of the incident.

### **Recommendation:**

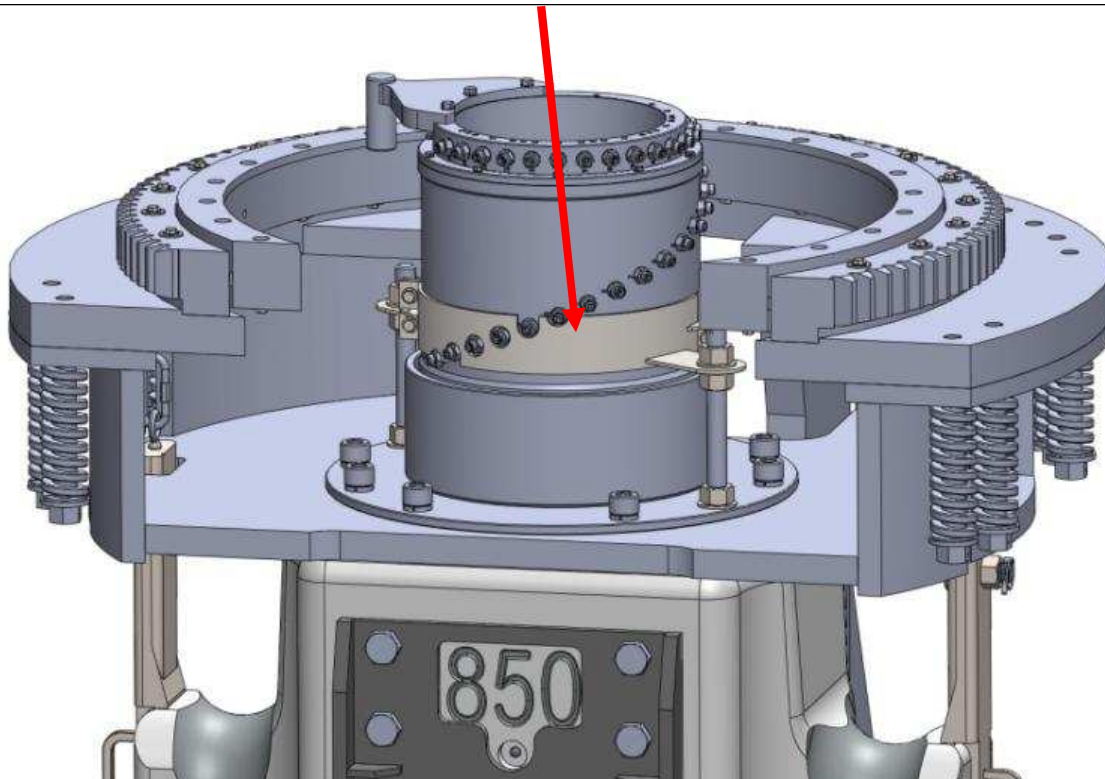
GDS recommends installing either kit A500441 or A800044 (depending on top drive model) to insure that the rotary seal is able to swivel as required. If it is determined that more immediate repairs are required, please contact the GDS Service Department.

### **Solution:**

Inspect the Rotary Seal Assembly and the Link Assembly Rotary Seal Spacer / Rotary Manifold Stand to insure there are no issues that require attention.

## Install the Rotary Manifold Anti-rotation Clamp A500441 / A800044

Depicted below is the 850 Ton configuration. The 500/650 ton model are very similar. The arrow shows the location of the Rotary Manifold Anti-rotation clamp.



### **Caution:**

This Safety Alert is issued for all GDM Top Drives. Not following the recommendations and/or guidance in GDS Product Safety Bulletins may result in death, bodily injury or property damage.