

**Product:**

15K "ES" BOP

**Incident:**

An incident occurred in the field with a piston rod and the piston rod head. The piston rod head sheared off while opening the rams. A restriction prevented the ram from retracting normally and the load induced on the rod head sheared it off.

**Action:**

TOT will replace all of the rod heads with a new redesigned rod head and the addition of a ram guide on certain actuators. This change effects every "ES" actuator. The blind, slip, and pipe actuators on the quad require a new piston rod head and the ram guide. The shear actuator requires a new Rod Head. Actuators on the shear seal require a ram guide and new piston rod, and the pipe slip requires a new piston rod head.

This recall takes effect immediately please contact TOT immediately to have these parts replaced. If the actuator parts can not be changed immediately please limit the hydraulic pressure to 1500psi maximum to prevent any future problems until you can have the parts replaced.

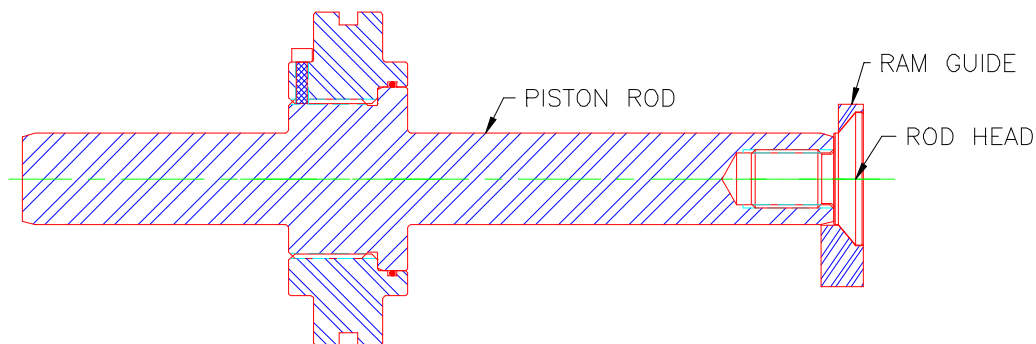
Assembly of the Rod Head to the piston rod includes the use of Loctite 242 (Blue) for proper performance. Two drops of this Loctite on the piston rod threads will ensure adequate adhesion.

**Details:**

Pipe, Slip, and Blind Rams on the Quad: See drawing ES46-T011-1

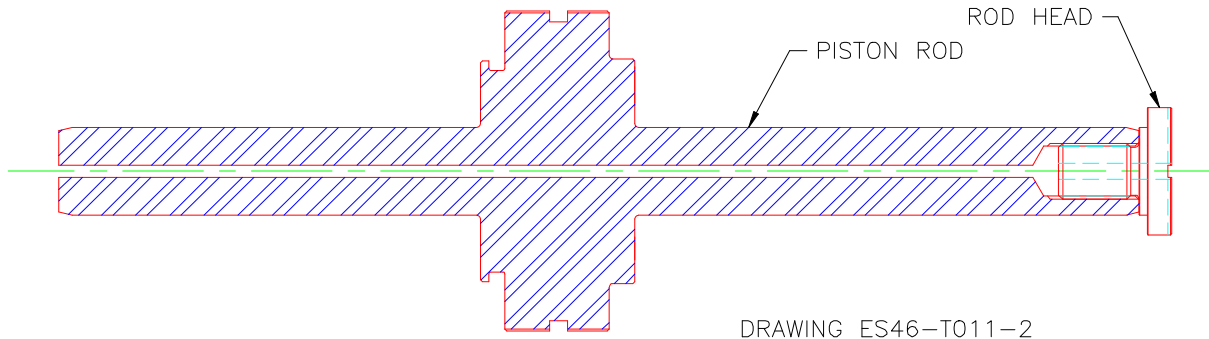
New Rod Head part number 9905-2833 rev. C

New Ram Guide part number 2001-0024 rev. -



Prepared by:	TOT 15,000psi Working Pressure "ES" BOP	<b>PSB-050</b> February 2001 Page 1 of 3
Approved by:		

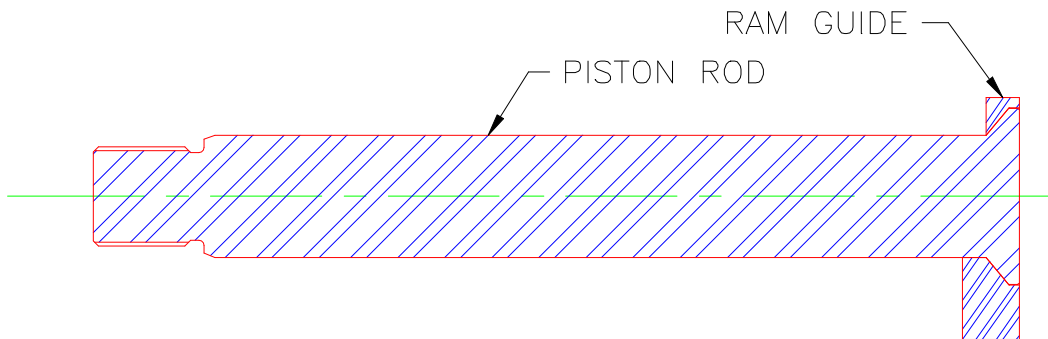
Shear Actuator on the Quad BOP: See Drawing ES46-T011-2  
New Rod Head part number 9905-2854 rev. C  
No Ram Guide required for this actuator.



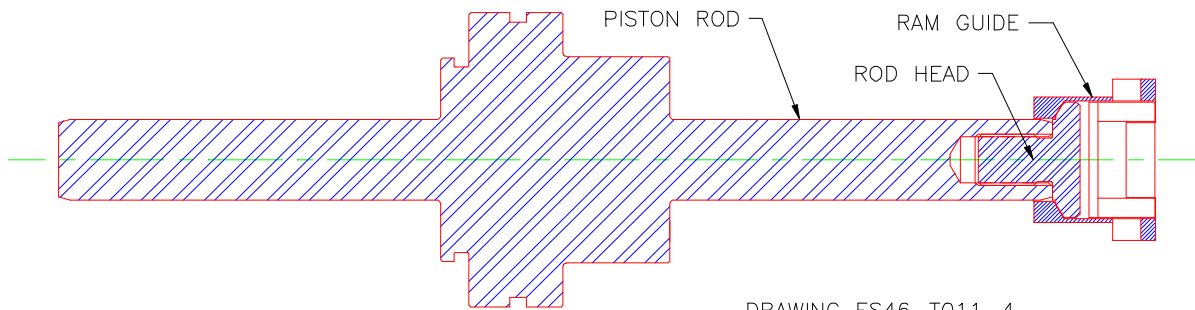
Combi Actuators also require a modification the following outlines the changes required for the pipe slip and shear seal actuators.

Shear Seal Actuator: See Drawing ES46-T011-3  
New Piston Rod part number 9905-2926 rev A  
New Ram Guide part number 2001-0025 rev. -

The piston rod must be replaced for this unit along with the addition of the ram guide.  
The shear seal does not have a rod head like the other actuators the design on the piston rod is such that it is not required.



Pipe Slip Actuator: See Drawing ES46-T011-4  
New Rod Head 9905-2425 Rev. B  
No other parts need to be changed.



All of these changes must be done. Please send your equipment in to Texas Oil Tools for this change to be performed by our assembly technicians and tested to our specifications.