

Information Bulletin No. IB11-005

May 26, 2011

ALERT

**R&M Energy Systems announces product recall of
Hercules® Model 150H BOP (Cap Assemblies Only)**

We have been made aware of a voluntary recall by R & M Energy Systems of “Cap” assemblies used on their Hercules® Model 150H BOP fittings. This type of fitting is typically used for Well Head equipment, however it may also be used in other pressure equipment applications.

The recalled equipment have the Manufacturing Date Code “**0810T**” shown on one of the 3 hammer lugs. These “Caps” were supplied to their customers between September 2010 and February 2011.

It has been found that the material for the “Cap” in question did not meet all of the requirements for ASTM A-395 – Ductile Iron. It is required to follow the fabricator’s instructions with respect to the inspection and removal of the Cap, as presented in the attached document below. Improper inspection and/or replacement of the Cap may pose the risk of injury to the operator and bystanders. Owners of the recalled Caps are advised to discontinue use immediately.

For more information concerning this recall and required follow up action, please review the attached document careful and where necessary, call R & M Energy System Canada’s Customer Service Department at (800) 661 5659.

The number of affected fittings (Caps) in Alberta is unknown. At this time, we have not known of any incident.

For more information on pressure equipment safety in general, visit our web site at www.absa.ca.

<original signed by>

K. T. Lau, Ph.D., P.Eng.
Administrator and Chief Inspector
Pressure Equipment Safety
Province of Alberta

PRODUCT RECALL NOTICE

PRODUCT BULLETIN G0111

Issued March 1, 2011

Products: Hercules® Model 150H BOP (Cap Assemblies Only)



Scope of Recall: Caps with a Manufacturing Date Code “0810T” cast on one of the 3 hammer lugs & supplied to our customers between September 2010 and February 2011. The “0810” designates that these Caps were cast during the month of August 2010.

Reason for Recall: Our supplier's Material Test Reports certified that parts with this date code met ASTM A395 requirements. However a detailed analysis of a cap with the “0810T” date code indicated that the cap material did not meet all of the requirements for ASTM A395 Ductile Iron.

Required Action: We believe in the best interest of our customers safety that they should immediately inspect all 150H BOPs **received or installed after Aug. 31, 2010 & before March 1, 2011** to see if any of the Caps have manufacturing Date Code “0810T” on one of the 3 hammer lugs as shown in the photo on the next page:



CAUTION: prior to inspecting a 150H BOP on an existing well installation, the pumping unit must be shut off using appropriate Lock-Out/Tag-Out procedures and the internal pressure must be bled off. Any Cap discovered with this date code can be easily removed as follows:

- A. Back ram screws out until they stop turning & then run them in approx. 6 turns.
- B. Using a 2 lb. "Dead Blow" Hammer or 1 - 2 lb. brass hammer strike a hammer lug in CCW direction until Cap is free to rotate by hand, and then unscrew Cap Assembly.
- C. Lower the Cap Assembly enough to allow ram screw to fully disengage from slot in the back end of ram.

If a 150H BOP is discovered with Caps having date code 0810T, only the Cap Assembly needs to be returned to R&MES for free replacement. There is no need to remove the BOP from an existing installation or to return a BOP assembly that is still on the shelf.

R&MES recognizes that a prolonged shut-down of existing wells with 150H BOPs with Caps having this date code is not feasible. Until replacement Caps can be sent for field replacement, R&MES strongly advises that well attendants exercise **EXTREME CAUTION** in not standing directly in front of the Caps anytime the pumping unit is in operation and/or BOP is under pressure. Once the quantity of Cap Assemblies is provided to R&MES Customer Service, we will arrange for the appropriate number of replacement Cap assemblies to be sent to the customer at no charge.

As a customer courtesy the ram screw, packing, gland nuts and optional handles (if equipped) do not have to be removed from the Caps. New Cap Assemblies w/all necessary hardware will be furnished at no charge.

For the convenience of our Distributors in contacting the End Users, please refer to the attached invoices which we have determined are the **only shipments that may have had 150H BOPs equipped with Cap Assemblies with date code "0810T"**.

Users of this BOP should be assured that we have performed additional analysis on 150H Caps manufactured both prior to, and after August 2010. We feel confident that 150H BOP Caps found with date codes other than 0810T are manufactured from fully compliant ductile iron material.

Effective Date: March 1, 2011

Contact Info: Please contact our Customer Service Dept regarding replacement caps at the toll free number below:

R&M Energy Systems Canada

Customer Service Department

1-800-661-5659

3703 – 98th Street

Edmonton, Alberta T6E 5N2