



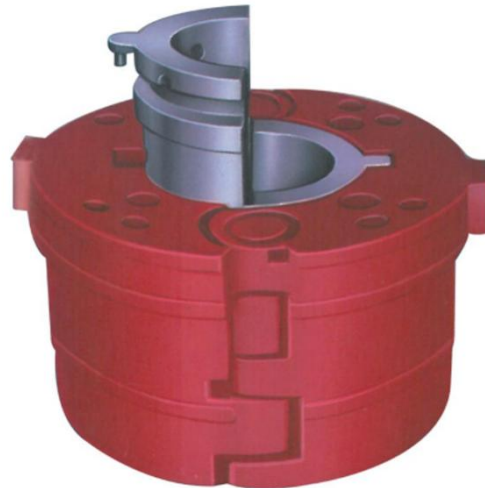
## INSERT BUSHING CAT IV FULL INSPECTION CERTIFICATE

<b>Customer:</b>	Daqing Drilling Company	<b>Date Of Service:</b>	09. April .2025
<b>Type Of Inspection:</b>	<b>CAT IV INSPECTION</b>	<b>Report No:</b>	QC-B-04-25-0166-10
<b>Rig &amp; Location:</b>	DQ Rig 037	<b>Specification:</b>	API RP 7L



### PROCEDURE

**The Rig was equipped Insert Bushing with the Following specifications:**

<b>S/No:</b>	<b>XD8172</b>
<b>Inspection Frequency:</b>	<b>6 Months</b>
<b>Equipment Name</b>	<b>Insert Bushing 9 5/8" - 10 3/4"</b>
<b>Specification:</b>	<b>API RP 7L CAT IV</b>



**-The products have been examined and found to conform to the relevant Quality standards and delivery are thus permitted**

<b>LEE &amp; ASNT Level II Inspector Name:</b>	<b>SIGNATURE:</b>	<b>Authenticating This Report:</b>	<b>SIGNATURE:</b>
<b>Abdullah Mofeed</b>		<b>Mohammed Abdullah</b>	



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### PROCEDURE

**Casing Insert Bushing found stripped down / disassembled condition for inspection. CAT IV Full inspection.**

**Casing Insert Bushing Inspection Was Conducted As Per API Standard.**

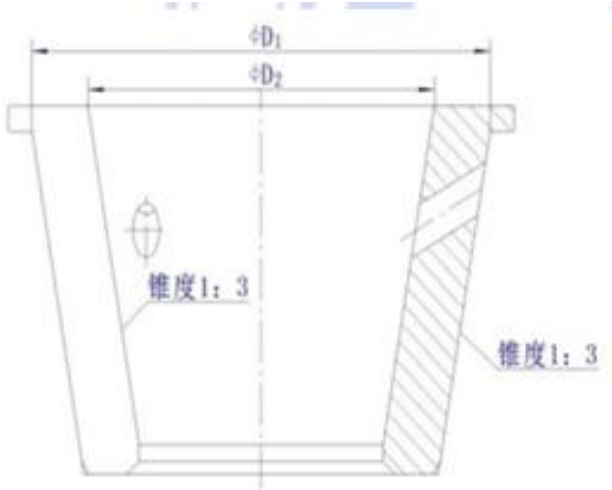
- Removed both halves of the drilling bowls outside of the insert bushing using the proper lifting chain sling
- Visually inspected the inner and outer surface areas of the bowl for any burrs and panned-over edges
- Cleaned the inside taper of the insert bowls from any abrasive materials
- Hold a straight edge against the tapered area to measure the taper length as per OEM recommendations
- Measured the taper angle and throat diameter and compared with OEM recommendations
- Performed MPI on the recess and load-bearing areas of the drilling bowls
- After completing the inspection, lubricate the back of the drilling bowls before assembling the master bushing
- Inserted the drilling bowls inside the insert bushing using the proper lifting chain sling
- Observed the height of the set slips in the insert bushing and ensured it was not riding low in it.
- Prepare and submit the inspection report

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序号	代号	描述	理论值 mm	允许磨损极限值 mm	
1	D1	套管补芯	CB6127	φ 660.4	φ 656.5
		上部外径	CB6126	φ 660.4	φ 656.5
			CB6114	φ 482.6	φ 480
			CB6115	φ 482.6	φ 480
2	D2	套管补芯	CB6127	φ 552.45	φ 556.6
		上部内径	CB6126	φ 482.6	φ 486.3
			CB6114	φ 412.75	φ 415.2
			CB6115	φ 365.13	φ 368.6
3		锥度 1: 3	3	2.82 ≤ 锥度 ≤ 3.18	

Measures	OEM Specification	Actual Value	Result
Casing core repair upper outer diameter D1	φ 480	520 mm	<b>Passed</b>
Casing core filling upper inner diameter D2	φ 415.2	410 mm	<b>Passed</b>
Taper 1:3	2.82 ≤ taper ≤ 3.18	3 mm	<b>Passed</b>

### PROCEDURE

**\*\* Visual and MPI were carried out on the Available Critical Areas of the CASING INSERT BUSHING and were Found Satisfactory for Further Use.**

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**\*\* CAT IV Inspection Was Carried out on the Insert Bowl and found Acceptable at The Time of Inspection.**



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