



INSERT BUSHING BOWL CAT IV INSPECTION REPORT

Customer:	Daqing Drilling Company	Date of inspection:	07-05-2024
Rig Name:	Rig (DQ 1202)	Report No:	QC-DQ-04-24-0138-29-15
Type of Inspection:	CAT IV Inspection.	Specification:	API RP 7L

PROCEDURE

The Rig Was Equipped with GAOYOU HUAXING Machinery Co., LTD (INSERT BUSHING BOWL)

QTY:	2 (set)
Equipment:	MASTER BUSHING
SN:	2246
Manufacture:	GAOYOU HUAXING Machinery Co.,Ltd
Ref Standard:	API RP 7L / OEM Recommendation
NEXT EXAMINATION:	After 06 Month

Remarks:

CAT IV Inspection Was Carried Out on INSERT BUSHING BOWL and Found Accepted at The Time of Inspection.

Inspector:

MOHAMED ABDALRA

Supervisor:

NAVEED HUSSEIN

Customer Representative





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PROCEDURE

- The Products Have Been Inspected and Found Them Conformable to Relevant

The Rig was equipped with GAOYOU HUAXING Machinery Co., Ltd MASTER BUSHING with following specification

- MASTER BUSHING was found partly stripped down /assembled condition for CAT IV Inspection.

1- Visually Check for Any Damage Wear DistortionEtch.	Performed
2- Check Marking of Serial Number.	Performed
3- Clean the Weld Area from Any Rust Painting Using Grinder Brush.	Performed
4- Visual Examination for Weld Area.	Performed
5- Visual Examination for Critical Area	Performed
6- Apply White Contrast for Weld Area.	Performed
7- Apply White Contrast for Critical Area.	Performed
8- Perform MPI Using Permanent Magnet and Black Ink.	Performed
9- MPI Interpretation API RP 7L Acceptance Criteria.	Performed

PROCEDURE

** Visual And MPI Was Carried Out on The Available Welding and Critical Areas of The INSERT BUSHING BOWL and Found Satisfactory for Further Use.

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Supervisor:

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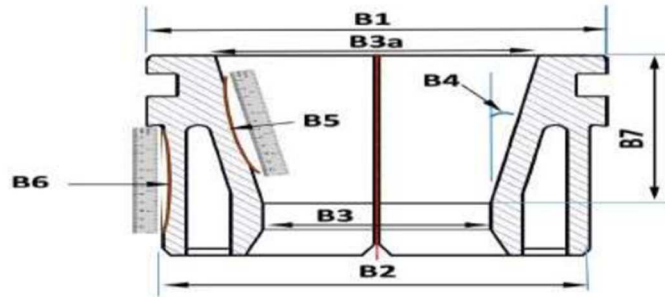
Customer Reprehensive





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Master Bushing Parameters	ACTUAL	OEM Nominal Specification	The maximum allowable tolerance
Bushing Upper Section OD B1:	520 mm	510	510 mm or less than 510 mm, Reject
Bushing Upper Section ID B2:	479 mm	475	475 mm or less than 475 mm, Reject
Bushing Lower Section OD B3a/B3b:	260 mm	265	945 mm or less than 265 mm, Reject
The Wear on the outer wall of Bushing B6:	3 mm	0	More than 5 mm, Reject
The Wear on the outer wall of Bushing B5:	3 mm	0	More than 5 mm, Reject

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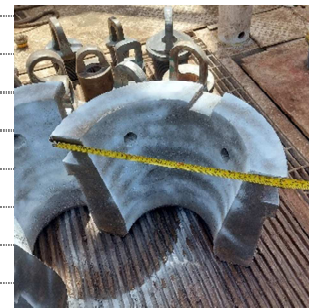




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PICTORIAL



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