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QUALITY CONTROL

CERTIFICATE OF INSPECTION AFTER REPAIR FOR 6 ¼" DRILL COLLAR

Client Name:	**Hilong Oil Services & Engineering**	Report No.:	HL22-QC-24-07-NA.001
Acceptance Createra.	☑API SPEC 7-2	Date of Inspection:	11.JULY.2024
Work Location:	**ABERDEEN WORKSHOP**	Rig No.:	HL-22
Test Equipment & Consumeable Details			
WHITE CONTRAST WCP-2	Batch #: 220602 Manufacture: Magnaflux Exp Date: JUN,2025	TECHNICAL DETAILS	Wet Visible Continuous
BLACK INK 7HF	Batch#.220605 Manufacture: Magnaflux Exp Date: JULY.2025	COIL(1200 AMP-TURNS/IN	22713 Cal.15.FEB.2024 Cal Due14.OCT.2024
FLUORESCENT 14HF	Batch #: 220306 Manufacture: Magnaflux Exp Date: March.2025	A.C HAND YOKE	PY-10 Cal.15.FEB.2024 Cal Due14.OCT.2024
INTENSITY METER	SR#1608000134 CAL.Date .15.FEB.2024 Cal Due14.OCT.2024	UV BLACK LIGHT	SR#1946875 Cal.15.FEB.2024 Cal Due14.OCT.2024
LEAD GAGE	SR#AH07KF0027 GAEMAKER LG-5003 Cal.15.FEB.2024 Cal Due14.OCT.2024	THREAD PROFILE GAGE	SR#21336 Cal.15.FEB.2024 Cal Due14.OCT.2024 SR#21335 Cal.15.FEB.2024 Cal Due14.OCT.2024
Magnetic Partical Concentration 7 HF	1.2 TO 2.4 ML/100 ML	WMPT Light Intensity	3500 Lux
Magnetic particle concentration flourcent 14 HF	0.1 TO 0.4 ML/100 ML	UV LIGHT INTENSITY:	3050 µw/cm²
Magnetism Direction (Longitudinal)			
METHODOLOGY:	• Through Visual inspection • Dimensional	•MPI inspection with Ultraviolet light *Lead Gaiging, Taper Gauging & Thread Profile Gauging.	
Connection:	**4 IF**	**Size:**	**6 ¼"**

Serial No.	Visual Inspection			MPI			Dimensional 3 Inspection																
							Pin						Box						Body				
	Pin	Box	Body	Pin	Box	Body	OD (in)	ID (in)	SRG ▯ (in)	SRG W ▯ (in)	Pin ▯ (in)	Bevel ▯(in)	OD (in)	CBD ▯ (in)	CBW ▯ (in)	BB ▯ (in)	BBL ▯ (in)	Bevel ▯ (in)	Pin Tong ▯ (in)	Box Tong ▯ (in)	EGR ▯ (in)	SGR ▯ (in)	Overall ▯▯(In)
2S624	Acc.	Acc.	--	Acc.	Acc.	--	6 ¼"	2 ¾"	4 5/16"	¾"	4 7/16"	5 7/8"	6 ¼"	4 29/32	5/8"	4 7/32"'	7 7/8"	5 7/8"	17 7/8"	21 ¼"	-	-	-

Conclusion: ■ **(01)The above Mentioned 6 ¼" Drill Collar were found "Acceptable" from Pin x Box Connection After Repair at time of Inspection ready to use.**

Abbreviations :

OD	*Outside Diameter*	**ID**	*Inside Diameter*	**SRG**	*Stress Relief Groove*	**CB**	*Counter Bore*	**BB**	*Bore Back*	**FB**	*Float Bore*
▯	*Diameter*	▯	*Length*	▯	*Width*	▯	*Depth*	**NP.**	*Not Present*	**NA.**	*Not Applicable*
EGR	*Elevator Groove Recess*	**SGR**	*Slip Groove Recess*	**CR**	*Crack*	**B**	*Bent*	**PC**	*Premium Class*	**RF**	*Reface*
GT	*Galled Thread*	**PT**	*Pitting Thread*	**SP**	*Seal Pitting*	**TD**	*Thread Damage*	**SD**	*Seal Damage*	**M**	*Mashed*
1	*100 % Coating*	**2**	*99-71 % Coating*	**3**	*70-40 % Coating*	**4**	*Up to 40 %*	**5**	*Nil*	**WT**	*Wall Thickness*
	Colors Code:	***White***	**No Defects**	*Red*	**Crack or Extreme Damage.**	**Blue**	**Damage**	**Green**	**Seal Damage**	**Yellow**	**ACFM**

Inspector Name:	[illegible]	**Review By**					
Qualification:	ASNT Level II	**Senior Inspector:**	M. SARWAR	**Supervisor:**	RAO SOHAIL	**Customer Name:**	
Signature:						**Customer Signature:**	

Original - Client F[illegible] - Area Office QC/FN/AF,REP/026 Rev.00 Dated 01 AUG 2021