



CERTIFICATE OF INSPECTION AFTER REPAIR FOR 8" DRILL COLLAR

Client Name:	Hilong Oil Services & Engineering	Report No.:	HL22-QC-24-07-NA.004
Acceptance Creater:	<input checked="" type="checkbox"/> API SPEC 7-2	Date of Inspection:	11.JULY.2024
Work Location:	ABERDEEN WORKSHOP	Rig No.:	HL-22
Test Equipment & Consumable 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/cm ²
Magnetism Direction (Longitudinal)			
METHODOLOGY:	• Through Visual inspection • Dimensional • MPI inspection with Ultraviolet light *Lead Gaiging, Taper Gauging & Thread Profile Gauging.		
Connection:	6 5/8 REG	Size:	8"

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)			
8S624	--	Acc.	--	--	Acc.	--	---	---	---	---	---	---	---	---	---	8"	6 2/32"	5/8"	5 9/32"	8 3/8"	7 16/32"	---	20 7/8"	-	---	---
14S624	--	Acc.	--	--	Acc.	--	---	---	---	---	---	---	---	---	---	8"	6 2/32"	5/8"	5 9/32"	8"	7 16/32"	---	21 3/8"	-	---	---
13S624	--	Acc.	--	--	Acc.	--	---	---	---	---	---	---	---	---	---	8"	6 2/32"	5/8"	5 9/32"	8 1/2"	7 16/32"	---	20 1/2"	-	---	---
12S624	--	Acc.	--	--	Acc.	--	---	---	---	---	---	---	---	---	---	8"	6 2/32"	5/8"	5 9/32"	8 1/4"	7 16/32"	---	20 3/4"	-	---	---

Conclusion: ■ (04)The above Mentioned 8" Drill Collar were found "Acceptable" from 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:	Review By		
Qualification:	Senior Inspector: M. SARWAR	Supervisor: RAO SOHAIL	Customer Name:
Signature:			Customer Signature:
Original - Client File: QC/FN/AF,REP/026 Rev.00 Dated 01 AUG 2021			

