



MASTER BUSHING CAT IV INSPECTION REPORT

Customer:	Daqing Drilling Company	Date Of Service:	18.07.2024
Type Of Inspection:	CAT III INSPECTION	Report No:	QC-DQ-07-24-0206-03-01
Rig & Location:	DQ-022	Specification:	API RP 7L
S/No:	BS01		
Inspection Frequency:	6 Months		
Equipment Name	Master Bushing		
Specification:	API RP 7L CAT IV		

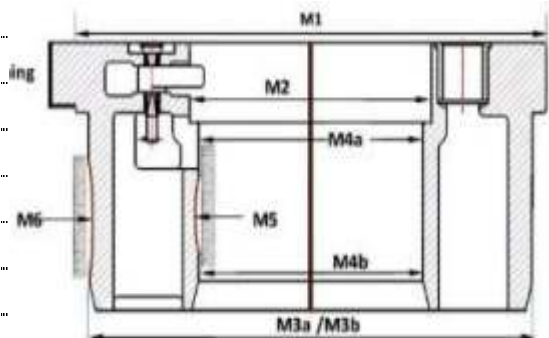
PROCEDURE

**** Visual and MPI Was Carried Out on the Available Critical of the Master Bushing and Found Satisfactory for Further Use.**

**** CAT IV Inspection Was Carried Out on Master Bushing and Found Accepted at The Time of Inspection.**

Master bushing found stripped down / disassemble condition for inspection. CAT IV Full inspection.
Master bushing Inspection Was Conducted as Per API Standard.

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



主补芯检测项目 Master bushing parameters	制造规范 OEM Specification	测量工具 Measuring tool	磨损量推荐 The maximum allowable tolerance
主补芯上沿外径 M1 Master bushing upper section OD M1	Φ1014.24-1015mm	卷尺 tape	小于 1005mm 报废 Less than 1005mm, Reject
主补芯上沿内径 M2 Master bushing upper section ID M2	Φ520.7-520.95mm	卷尺 tape	大于 527mm 报废 More than 527mm, Reject
主补芯下本体外径 M3a / M3b Master Bushing lower section OD M3a / M3b	Φ954.62-955.0mm	卷尺 tape	小于 945mm 报废 Less than 945mm, Reject
主补芯下本体内径 M4a / M4b Master Bushing lower section OD M4a / M4b	Φ482.6-482.85mm	卷尺 tape	大于 489mm 报废 More than 489mm, Reject
主补芯本体外壁磨损量(补芯高度范围内环带凹陷) M5 The wear on the outer wall of master bushing M5	-----	钢板尺 steel rulers	大于 3mm 报废 More than 3mm, Reject
主补芯本体外壁磨损量 M6 The wear on the outer wall of master bushing M6	-----	钢板尺 steel rulers	大于 3mm 报废 More than 3mm, Reject

ASNT Level II Inspector Name:	Authenticating This Report:	Signature & Stamp:	Date of Next Through Examination:
Abdullah Mofeed	Mohamed Abdalla		17.01.2025

REV: 01 Dated: 20 June 2022

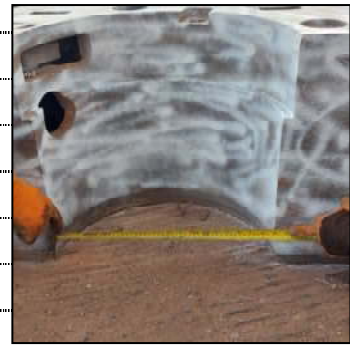




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Measures	Actual Dim.	OEM Specification
Bushing upper section OD M1 minimum value	1013 mm	(Min) 1005 mm
Bushing upper section ID M2 Maximum value	520 mm	(MAX) 527 mm
Master bushing lower section OD M3a/M3b minimum value	955 mm	(Min) 945 mm
Master bushing lower section OD M4a/M4b Maximum	480 mm	(Max) 489 mm
The maximum wear on outer wall of bushing M5	1.3 mm	(Max) 3 mm
The maximum wear on outer wall of bushing M6	1.7 mm	(Max) 3 mm



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