



INSERT BUSHING CAT IV INSPECTION REPORT

Customer:	HONG HUA OIL & GAS ENGINEERING SERVICES.	Date of inspection:	14-July-2024
Rig Name:	HH-29 / AS-67	Report No:	QC-HH-May-24-0203-016
Type of Inspection:	CAT IV Inspection.	Specification:	API RP 7L

PROCEDURE

The Rig Was Equipped With 10 1/8" Insert Bushing the Following Specification:

QTY:	1 (set)
Equipment:	Insert Bushing 10 1/8"
SN:	FK017 & FK018
SIZE:	10 1/8"
Ref Standard:	API RP 7L
NEXT EXAMINATION:	After 06 Month

INSPECTION RESULT

**** Visual & MPI was carried out on the available critical areas of the Insert Bushing and found Accept at the time of inspection**

**** CAT IV Inspection was carried out on An Insert Bushing & found satisfactory for further use**

PROCEDURE

Remarks:

CAT IV Inspection Was Carried Out on Insert Bushing 10 1/8" and Found Accepted at The Time of Inspection

**ASNT Level II
Inspector Name:**

Syed Aamir Ali



Supervisor:

NAVEED HUSSEIN

Customer Reprehensive





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**Insert Bushing was found stripped down / disassemble condition for inspection.
CAT IV Full inspection.**

- Removed both halves of the drilling bowls outside of the Insert bushing using the proper liftingchain sling
- Visually inspected the inner and outer surface areas of the bowl for any burrs and panned-overedges
- 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 OEMrecommendations
- Measured the taper angle 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 assemblingthe Bushing
- Prepare and submit the inspection report

PROCEDURE

** Visual And MPI Was Carried Out on The Available Welding and Critical Areas of the (INSERT BUSHING 10 1/8") and Found Satisfactory for Further Use.

** CAT IV Inspection Was Carried Out on (Insert Bushing 10 1/8") and Found Accepted at The Time of Inspection.

Remarks:

CAT IV Inspection Was Carried Out on Insert Bushing 10 1/8" and Found Accepted at The Time of Inspection

ASNT Level II Inspector Name:	Syed Aamir Ali	Supervisor:	NAVEED HUSSIEN
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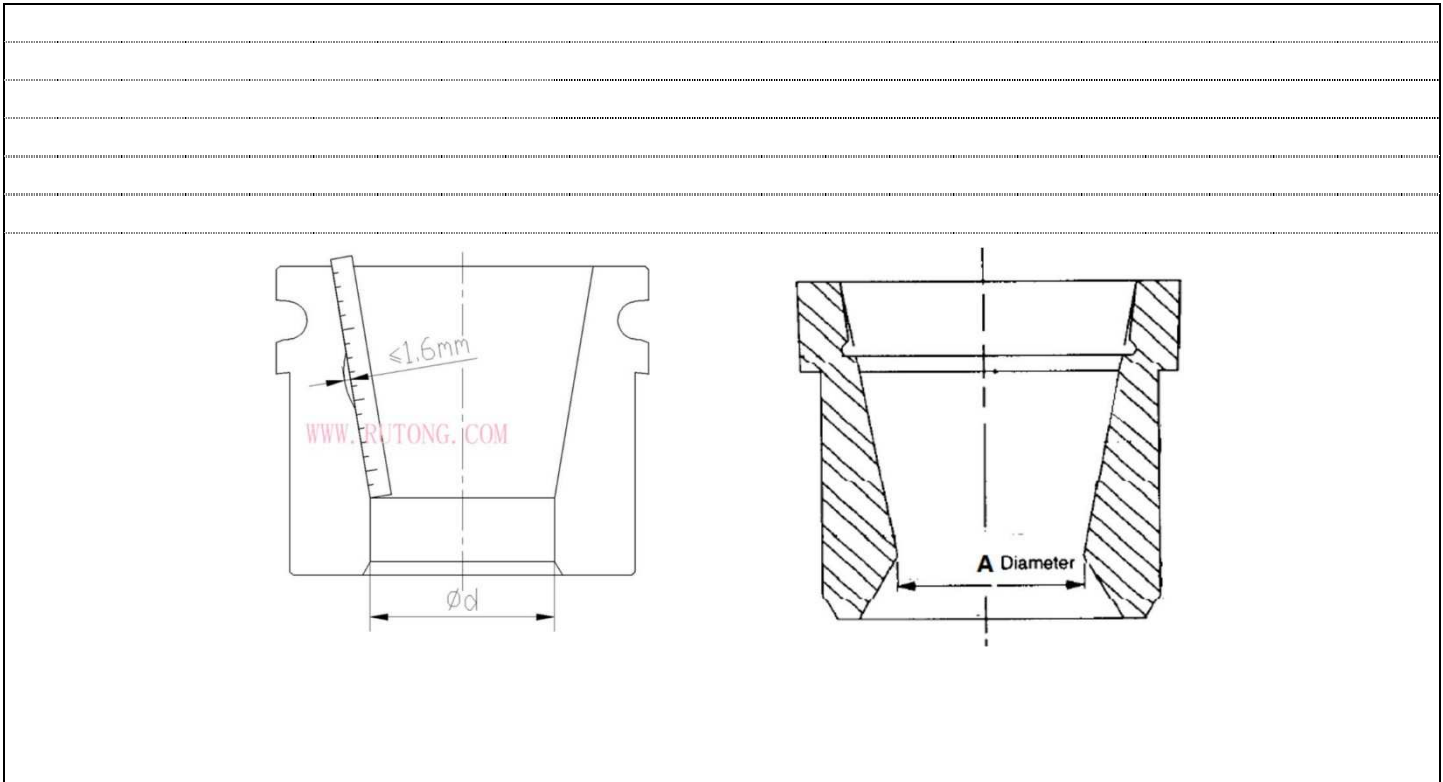
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Insert Bushing Parameters	Actual	The maximum allowable tolerance	Result
diameter A	260 mm	266	Qualified
Max. worn of drive bushing	0.5 mm	1.6mm	Qualified

Remarks:
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ASNT Level II Inspector Name:	Syed Aamir Ali		Supervisor:	NAVEED HUSSIEN
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PICTORIAL



Remarks:

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Inspector Name:**

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