



MASTER 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-24-0203-017
Type of Inspection:	CAT IV Inspection.	Specification:	API RP 7L

PROCEDURE

QTY:	1 (set)
Equipment:	Master Bushing
SN:	ZP375
Ref Standard:	API RP 7L
NEXT EXAMINATION:	After 06 Month

PROCEDURE

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

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

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Remarks:

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

ASNT Level II Inspector Name:	Syed Aamir Ali	Supervisor:	NAVEED HUSSIEN
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Customer Reprehensive





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PROCEDURE

-The products have been inspected and found them conformable to relevant Quality standards and delivery is thus permitted

Master Bushing was found in fully installed condition for CAT III inspection.

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

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ASNT Level II Inspector Name:	Syed Aamir Ali	Supervisor:	NAVEED HUSSIEN
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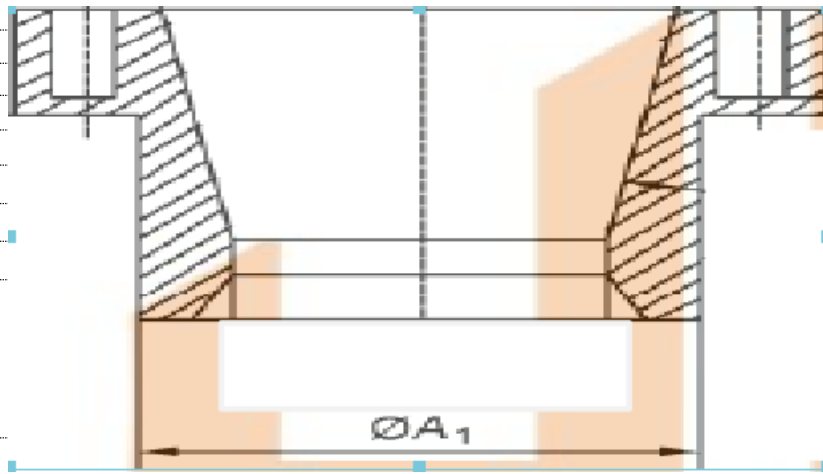
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Insert Bushing Parameters	Actual	The maximum allowable tolerance	Result
diameter A	950.91 mm	950.91	Qualified

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