



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 were carried Out on the Available Critical & Welding Areas 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.**

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Remarks:

CAT IV Inspection Was Carried Out on the 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 conformable to the relevant Quality standards and delivery are thus permitted

The Master Bushing was found to be fully installed for CAT IV inspection.

	Action
1- Removed both halves of the drilling bowls outside of the master bushing using the proper lifting chain sling	Performed
2- Visually inspect 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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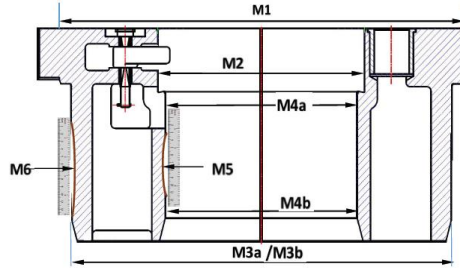
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Master Bushing Parameters	ACTUAL	OEM Nominal Specification	The maximum allowable tolerance
Master Bushing Upper Section OD M1:	1062mm	1014.25 mm - 1015 mm	1005 mm or less than 1005 mm, Reject
Master Bushing Upper Section ID M2:	660mm	520.7 mm - 520.95	530 mm or Less than 530 mm, Reject
Master Bushing Lower Section OD M3a/ M3b:	947mm	954.62 mm - 955 mm	945 mm or less than 945 mm, Reject
Master Bushing Lower Section OD M4a/ M4b:	360 mm	482.6 mm - 488 mm	490 mm or more than 490 mm, Reject
The Wear on the outer wall of Master Bushing M5:	--	-	More than 5 mm, Reject
The Wear on the outer wall of Master Bushing M6:	---	-	More than 5 mm, Reject

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ACTUAL
OEM Nominal Specification
The maximum allowable tolerance



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**ASNT Level II
Inspector Name:**

Syed Aamir Ali



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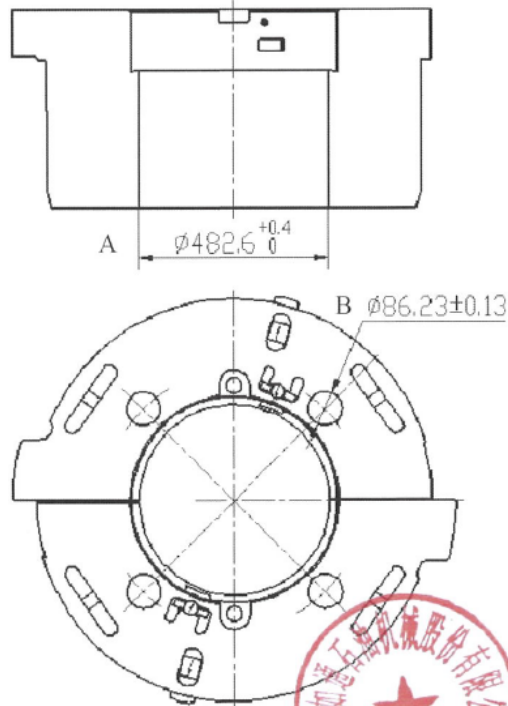




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Bushing wear inspection (ZP375-H)



Size	ZP375-H	Max
Maximum wear of the hole of the bushing (mm) A	5	482.6~488
Maximum wear of drive pin hole (mm) B	1.6	87.96
Maximum wear of body (mm) C	1.6	

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