



INSERT BUSHING CAT IV INSPECTION REPORT

Customer:	Zhongman Petroleum Engineering Technology Service (Hong Kong) Co. Limited Iraq Branch	Date Of Service:	21.05.2024
Type Of Inspection:	CAT III INSPECTION	Report No:	QC-ZPEC-05-24-0161-04/03
Rig & Location:	ZPEC Rig 25	Specification:	API RP 7L

S/No:	6608
Inspection Frequency:	6 Months
Equipment Name	2 3/8" – 8 5/8" INSERT BUSHING
Specification:	API RP 7L CAT IV

PROCEDURE

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

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

Insert bushing found stripped down / disassemble condition for inspection. CAT IV Full inspection.

Insert bushing Inspection Was Conducted as Per API Standard.

Removed both half of the drilling bowls outside of Insert 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 insert 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

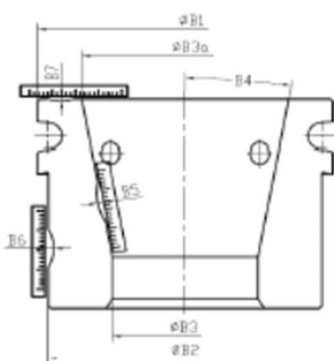
Performed MPI on the recess and load bearing areas of the drilling bowls


After completing the inspection, Lubricated the back of the drilling bowls before assembling the Insert bushing

Inserted the drilling bowls inside the Insert bushing using the proper lifting chain sling

Observed the height of the set slips in the Insert bushing and ensure that it is not riding low in it.

Prepare and submit the inspection report

补芯内衬 Insert Bushing	6608 (2 3/8"-8 5/8")		上部外径最小值B1(min)	510mm
			下部外径最小值B2(min)	475mm
			锥孔上部直径最大值B3a(max)	374mm
			锥孔下部直径最大值B3(max)	285mm
			锥孔角度B4(degree)	9°27'45"±2'30"
			锥面最大磨损B5(max)	3mm
			下部外壁最大磨损B6(max)	3mm
			上平面最大磨损B7(max)	3mm

ASNT Level II Inspector Name:	Authenticating This Report:	Signature & Stamp:	Date of Next Through Examination:
Khaled Mahmoud	Mohamed Abdalla		20.11.2024

REV: 01 Dated: 20 June 2022





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Measures	Actual Dim.	OEM Specification
Minimum upper outer diameter B1:	525 mm	(Min)510 mm
Minimum lower outer diameterB2:	480 mm	(Min)475 mm
Minimum diameter of the upper part of the taper hole B3a:	365 mm	(Max)374 mm
Maximum diameter of the lower part of the taper hole B3:	2605 mm	(Max)265 mm
Maximum wear of cone surface B5:	1mm	(Max) 3 mm
Maximum wear of the lower outer wall B6:	1mm	(Max) 3 mm
Maximum wear on upper plane B7:	2 mm	(Max) 3 mm



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