



CASING INSERT 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-07-24-0206-03-04
Rig & Location:	DQ-022	Specification:	API RP 7L

S/No:	333
Inspection Frequency:	6 Months
Equipment Name	13 3/8" Casing Insert Bushing Bowl
Specification:	API RP 7L CAT IV

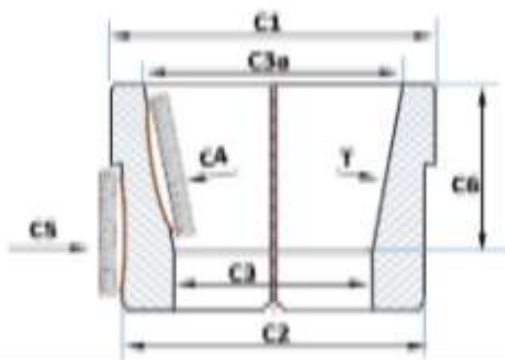
PROCEDURE

**** 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



补芯检测项目 Bushing parameters	制造规范 OEM Specification
补芯上沿外径 C1 Bushing upper section OD C1	Φ519.7-520.0mm
补芯下本体外径 C2 Master Bushing lower section OD C2	Φ481.5-481.8mm
补芯通孔内径 C3 The ID of bushing ID C3	Φ311.2mm
补芯内锥度 T Bushing inner taper T	9° 27' 45" ± 2' 30" T = (C3a - C3) / C6 = 0.333
补芯锥面磨损量 C4 The wear on bushing cone C4	-----
补芯下本体外壁磨损量 C5 The wear on outer wall of bushing lower section	-----

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 C1	522 mm	(Min) 514 mm
Bushing Lower Section OD C2	481 mm	(Min) 475 mm
The ID Of Bushing ID C3	380 mm	(Max) 387 mm
Bushing Inner Taper T	0.32 mm	$T = (C3a - C3) / C6 = 0.333$
The Wear On Bushing Cone C4	0.20 mm	More Than 1.6 Reject
The Wear On Outer Wall Of Bushing Lower Section	0.28 mm	More Than 1.6 Reject



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