



Customer:	Hilong Oil Services & Engineering	Date Of Service:	08-08-2024
Type Of Inspection:	CAT IV INSPECTION	Report No:	ATS-08-24-4132-EL-029
Rig & Rig Number:	RIG-100	Specification:	API RP 8B



**ABERDEEN Technical Services Would Like to Thank You for Giving Us the Opportunity to Work With Your Honorable Company**

Inspection Date:	08-08-2024	Due Date:	07-08-2025
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Inspector:	Aram Dlawar 	Supervisor:	Hasan Omran
OEM:			



International Well Control Forum



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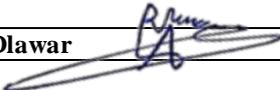
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The Rig Was Equipped with SJ PETROUM MACHINERY CO. Square Shoulder Elevator, with The Following Specification:

Equipment:	Square Shoulder Elevator, DD 2 7/8 EU -150 TB
Model/SN:	50901
Date of Manufacture:	-
Manufacturer:	JIANGSU RUTONG PETRO-MACHINERY CO.
Reference Standard:	API RP 8B
Next Examination Date:	After 1 Year

Remarks:

Detailed reports are attached detailing all readings and results in - 03 of 07 pages.

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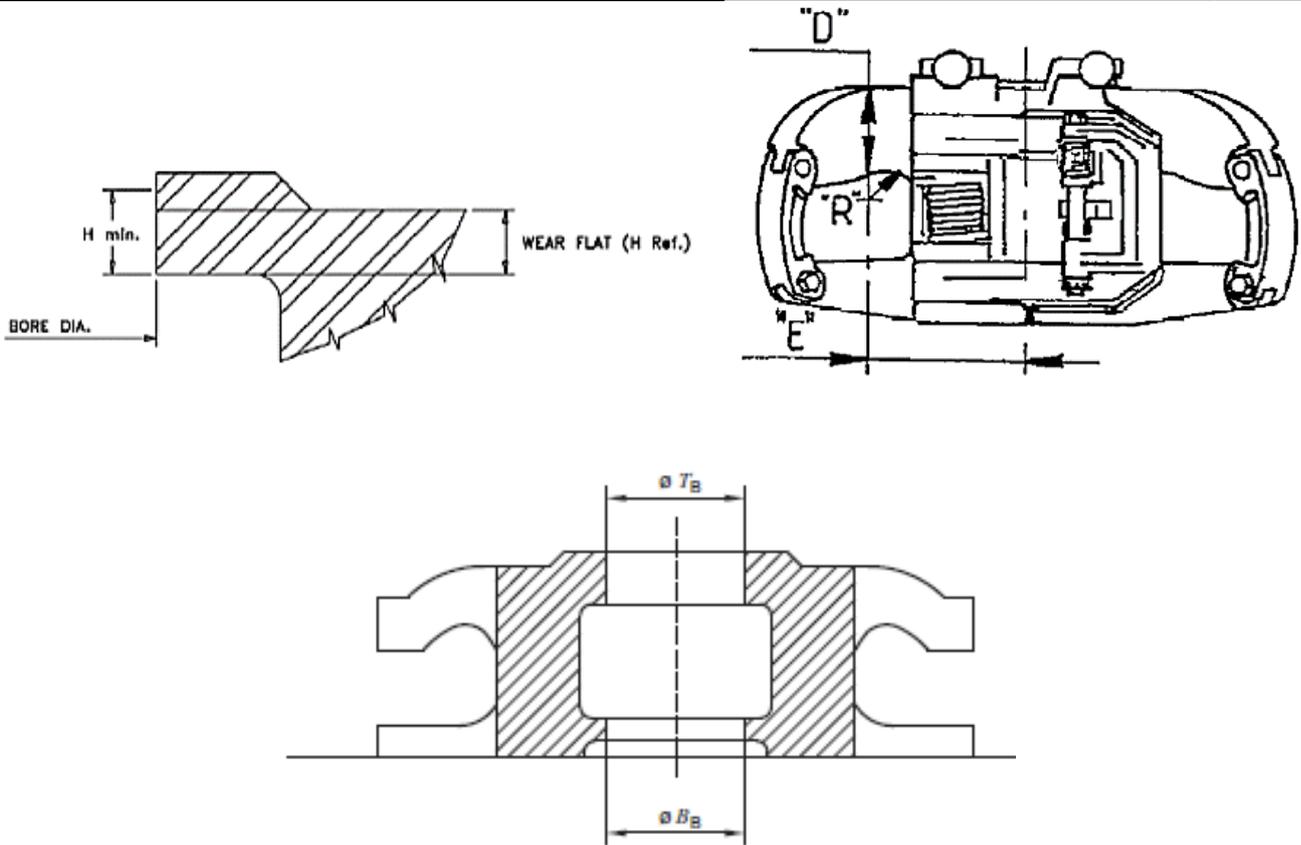


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**PROCEDURE**

- The Square Shoulder Elevator Has Been Inspected and Found Conformable to the Relevant Standard(s)
- The Rig was equipped with **JIANGSU RUTONG PETRO-MACHINERY CO. LTD.** Square Shoulder Elevator.
- Square Shoulder Elevator Found Stripped Down /Dismantling Condition for CAT IV Inspection.

Action	Result
• Visually check for the serial number and Identification	Pass
• Dismantle the elevator as far as possible into single components	Pass
• Prepare and clean the elevator body and accessories to the extent necessary for inspection.	Pass
• Visually check for any damage, missing parts, or cracks	Pass
• Visually check & MPI as per manufacture’s recommendations	Pass
• Visually check for damage, deformation or cracks on the hinge’s Ears, handles, Critical areas & hinges	Pass
• Measure the wear of bores, and ear thickness as per manufacture’s recommendations.	Pass
• Visually check after Reassemble the Elevator with new spring and spare parts.	Pass
• Repaint the Elevator	Pass
• Prepare and submit the inspection report.	Pass

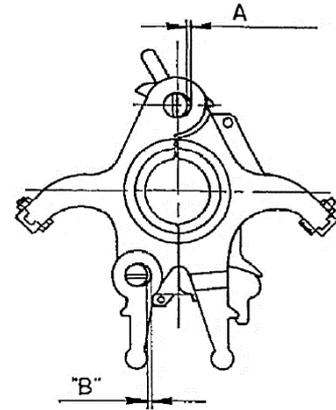
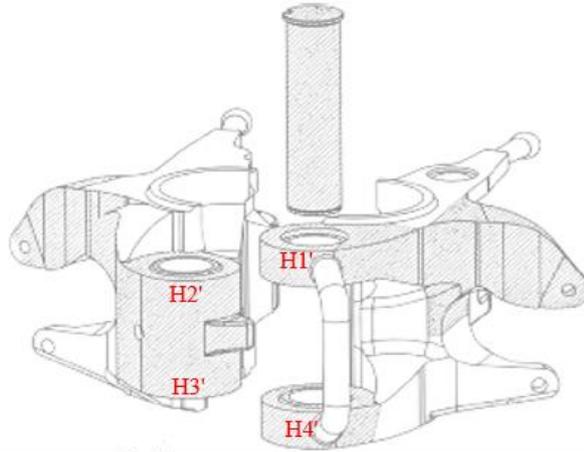
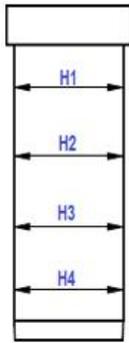


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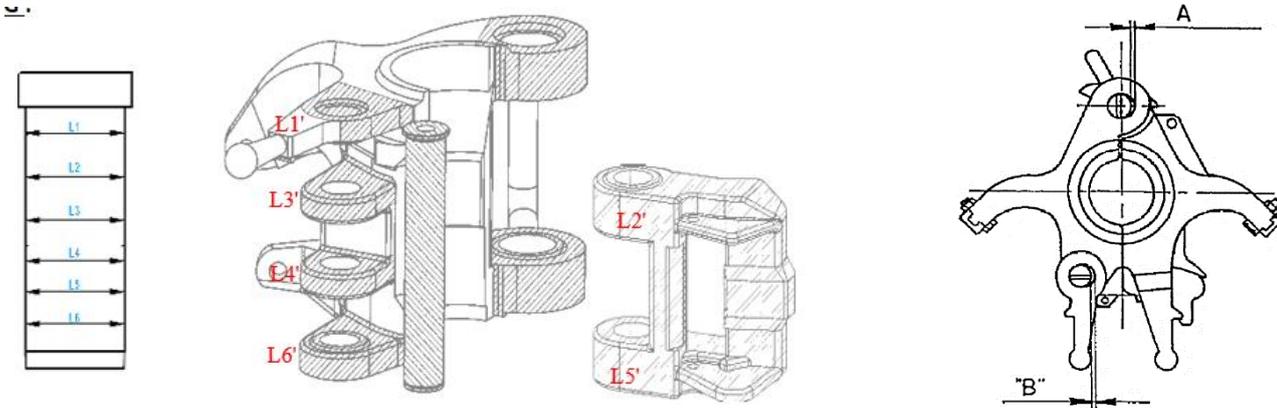
OREINTATION	DESCRIPTION	VALUES	OEM VALUES	RESULT
RIGHT	The maximum allowable wear tolerance of <b>(D)</b>	90 mm	85 mm	Accepted
	The distance “ <b>E</b> ” from the center line to the center of Arc	155 mm	155 mm	Accepted
	The designed value for radius “ <b>R</b> ” at the force point	45 mm	45 mm	Accepted
LEFT	The maximum allowable wear tolerance of <b>(D)</b>	90 mm	85 mm	Accepted
	The distance “ <b>E</b> ” from the center line to the center of Arc	155 mm	155 mm	Accepted
	The designed value for radius “ <b>R</b> ” at the force point	45 mm	45 mm	Accepted
TOP	Maximum Allowable (Worn) Load Shoulder Bore <b>TB</b>	81.50 mm	82.95 mm Max	Accepted
BOTTOM	Maximum Allowable (Worn) Load Shoulder Bore <b>BB</b>	81.40 mm	82.95 mm Max	Accepted
-	The minimum allowable thickness of the elevator load bearing point contact surface <b>(H)</b>	90 mm	60.00 mm	Accepted



Measurement	OEM Tolerance (A)	Actual Reading (mm)	Result
Hinge Pin OD (H1)	0.762 mm	44.84	Accepted
Hinge Pin OD (H2)		44.84	Accepted
Hinge Pin OD (H3)		44.84	Accepted
Hinge Pin OD (H4)		44.84	Accepted
Hinge Hole ID (H1')		45.09	Accepted
Hinge Hole ID (H2')		45.09	Accepted
Hinge Hole ID (H3')		45.09	Accepted
Hinge Hole ID (H4')		45.09	Accepted



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Measurement	OEM Tolerance (B)	Actual Reading (mm)	Result
Latch Pin OD (L1)	0.889 mm	31.93	Accepted
Latch Pin OD (L2)		31.95	Accepted
Latch Pin OD (L3)		31.93	Accepted
Latch Pin OD (L4)		31.96	Accepted
Latch Hole ID (L1')		32.00	Accepted
Latch Hole ID (L2')		32.02	Accepted
Latch Hole ID (L3')		32.03	Accepted
Latch Hole ID (L4')		32.03	Accepted

\*\* Visual And MPI Was Carried out on the critical areas and load bearing components of the elevator and Found **Satisfactory for Further Use**.

\*\* CAT IV Inspection Was Carried Out on the Elevator and Found **Accepted** At The Time of Inspection

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## Visual & Magnetic Particles Examination Report

Client Name:	Hilong Oil Services & Engineering	Location:	HL-100/ R026	Job Number:	ATS-08-24-4132
Date of Examination:	08-08-2024	Date of Report:	08-08-2024	Certificate No:	ATS-08-24-4132-EL-029

Serial Number	Description of the examined equipment	Result
50901	Square Shoulder elevator, DD 2 7/8 EU – 150 TB	Pass
S/N:	-	



### NDT Equipment Details

Standard	API RP 8B – CAT IV & ASTM E 709	Viewing Condition:	Colored Media	Method	WET
Yoke	Ac yoke	Serial No:	201504044	Due Date	27-12-2024
White Contrast	FLUXO: WCP-4	Batch No:	L230523/1	Due Date	23-05-2028
Black Ink	FLUXO: Black magnetic ink-3	Batch No:	L230125/3	Due Date	25-1-2025

### NDT procedure

Visual and MPI carried out for the above description and found free of surface defects at the time of inspection

Identification of any part found to have a defect and a description of the defect: **None**

Particulars of any repair, renewal or alteration required to remedy the defect identified above: **None**

ASNT Level II Inspector Name:	Signature & Stamp:	Date of Next Through Examination:
Aram Dlawar		07-08-2025



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Aram Dlawar		07-08-2025

