



INSIDE BLOWOUT PREVENTERS VALVES OPERATION AND MAINTENANCE PROCEDURE REV 1 –

06/05

ASSEMBLY PROCEDURE FOR THE REVERSE FLOW CHECK VALVES

1.0 SCOPE

- 1.1. This procedure will provide general instructions regarding assembling the Inside Blowout Preventer valves.

2.0 REFERENCES

- 2.1. The latest revision of the following specifications may be used to obtain additional information regarding this procedure.
 - Packard Quality Procedures Manual.
 - API Specification 7 latest edition.
 - Bill of materials.

3.0 ASSEMBLY PROCEDURE

- 3.1. Clean Upper and Lower Subs and all internal parts.
- 3.2. Visually Inspect for sign of damage or wear.
- 3.3. Fit Dart with new "O" ring. "O" ring elastomer must be compatible with environment.
- 3.4. Insert Spring onto Dart
- 3.5. Install Guide into Body.
- 3.6. Insert Dart and spring in the Body.
- 3.7. Apply thread dope to connections on Body and Lower Sub and Stab Body. Recommended: Dope base to include 40% to 60% (by weight) finely powdered zinc or lead.
- 3.8. Screw the Body into the Sub and make up shoulders with chain tongs or equivalent. Torque the Body and Sub to the make up torque value specified per API Specification RP7G. (Foot/Lb). Individual make up torque values will be in the accompanying data book.

4.0 HYDROSTATIC TEST REVERSE FLOW CHECK VALVE

- 4.1. Testing shall be performed in accordance with the test pressure and procedure stipulated in API SPEC 7.

HYDROSTATIC TESTING PRESSURES			
MINIMUM PRESSURE WORKING RATING		MAXIMUM HYDROSTATIC SHELL TEST PRESSURE	
psi	MPa	psi	MPa
5000	34.5	10,000	68.9
10,000	68.9	15,000	103.4
15,000	103.4	22,500	155.1

Note: test pressure shall be stabilized prior to the timing start for holding pressure.

- 4.2. Dope pin and box connections of valve.
- 4.3. Install test plugs on both box and pin connections of valve assembly to be tested.
- 4.4. With valve hanging Pin up and Box down, install pressure line to bottom of valve (box connection).
- 4.5. With bleed valve on top of test plug in the open position, fill valve with water until water bleeds through the open valve. Actuate bleed valve several times to eliminate any trapped air in the valve body.
- 4.6. Close bleed valve.
- 4.7. Pressure up Valve body to the recommended pressure per API SPEC 7
 - 4.7.1. Engage pump and pressure to required test pressure from section 4.1 and stabilize. After stabilization of pressure, the valve will be held at pressure for three (3) minutes minimum with no detectable pressure drop or leakage.
 - 4.7.2. At the elapse of the three minutes, the pressure will be reduced to zero.
 - 4.7.3. Engage pump a second time to required test pressure per section 4.1 and hold for a minimum of 10 minutes.
- 4.8. If pressure held, release pressure. After pressure is released open bleed valve on top of test plug and release pressure trapped on top side
- 4.9. Turn valve over and remove test plug from



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upper sub. Install pressure line to bottom (pin) connection of valve.

- 4.10. Using release rod, push against dart valve and fill with water. Water level is to be above parts. Release dart valve.
- 4.11. Pressure up valve to working pressure. Hold pressure for five minutes.
- 4.12. Release pressure on accepted assembly.
- 4.13. If the valve does not test, disassemble, clean, reassemble, and retest the valve to the requirements as outlined in this procedure.

5.0 INSTALLING STAB BODY ASSEMBLY

- 5.1. Insert release rod through I.D. of the lifting handle from the pin end of the Stab Body.
- 5.2. Screw the releasing handle into the threaded hole of the Stab Body.
- 5.3. Apply thread dope to connections on upper sub and release cap. **Recommended: Dope base to include 40% to 60% (by weight) finely powdered zinc.**
- 5.4. Install thread protector on pin of the Stab Body.

6.0 INSTALLING STAB BODY IN THE IBOP ASSEMBLY

- 6.1. Screw the Stab Body into the box end of the IBOP Sub.
- 6.2. Insure the Releasing Handle is loose.
- 6.3. Depress the Releasing Rod to open the Valve.
- 6.4. Tighten the Releasing Handle.

DISASSEMBLY PROCEDURE FOR THE INSIDE BLOWOUT PREVENTER VALVE

1.0 SCOPE

This procedure will provide general instructions regarding disassembly of the Inside Blowout Preventer valves.

2.0 REFERENCES

- 2.1. The latest revision of the following specifications may be used to obtain additional information regarding this procedure.
 - Packard Quality Procedures Manual.
 - API Specification 7 latest edition.
 - Bill of materials.

3.0 DISASSEMBLY PROCEDURE

- 3.1. Remove Stab Body
- 3.2. Take Handle out.
- 3.3. remove Releasing Rod
- 3.4. Inspect components for wear or damage.
- 3.5. Clean parts, replace wore or damaged one and assemble refer to 5.0 to reassemble the Stab Body.
- 3.6. "Break" connection between Body from Sub.
- 3.7. Remove all internal parts.
- 3.8. Remove rubber seal from the Dart.
- 3.9. Thoroughly clean all parts and valve body. Wore or Damaged parts should be replaced prior to re-assembly.

**PREPARING THE INSIDE BLOWOUT PREVENTER
VALVE FOR INSTALLATION**

1.0 SCOPE

1.1. This procedure will provide general instructions regarding installation of the Inside Blowout Preventer valves.

2.0 REFERENCES

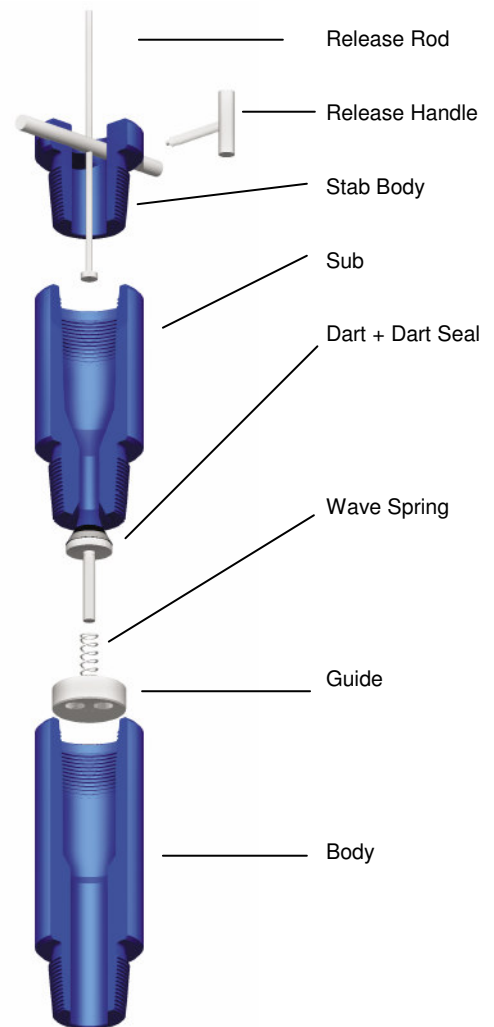
2.1. The latest revision of the following specifications may be used to obtain additional information regarding this procedure.

- Packard Quality Procedures Manual.
- API Specification 7 latest edition.
- Bill of materials.

3.0 INSTALLATION PROCEDURE

- 3.1. Clean shipping thread dope from threaded connections and
- 3.2. Apply thread dope suitable for drill string use.
- 3.3. Recommended: Dope base to include 40% to 60% (by weight)
- 3.4. Finely powdered zinc or lead.

NOTE: Failure to follow the above procedure explicitly may result in damage and subsequent premature valve failure.



ISO9001:2000 # 0163 API # 7-0207