



DPAL Soconord

Re tooling services

Re tooling



- DPAL offers re tooling services on customer own pipes
- Re tooling consists of tool joints replacement.
- The estimated cost is approximately a third of new drill pipes excluding internal plastic coating.

Cutting tool joints off



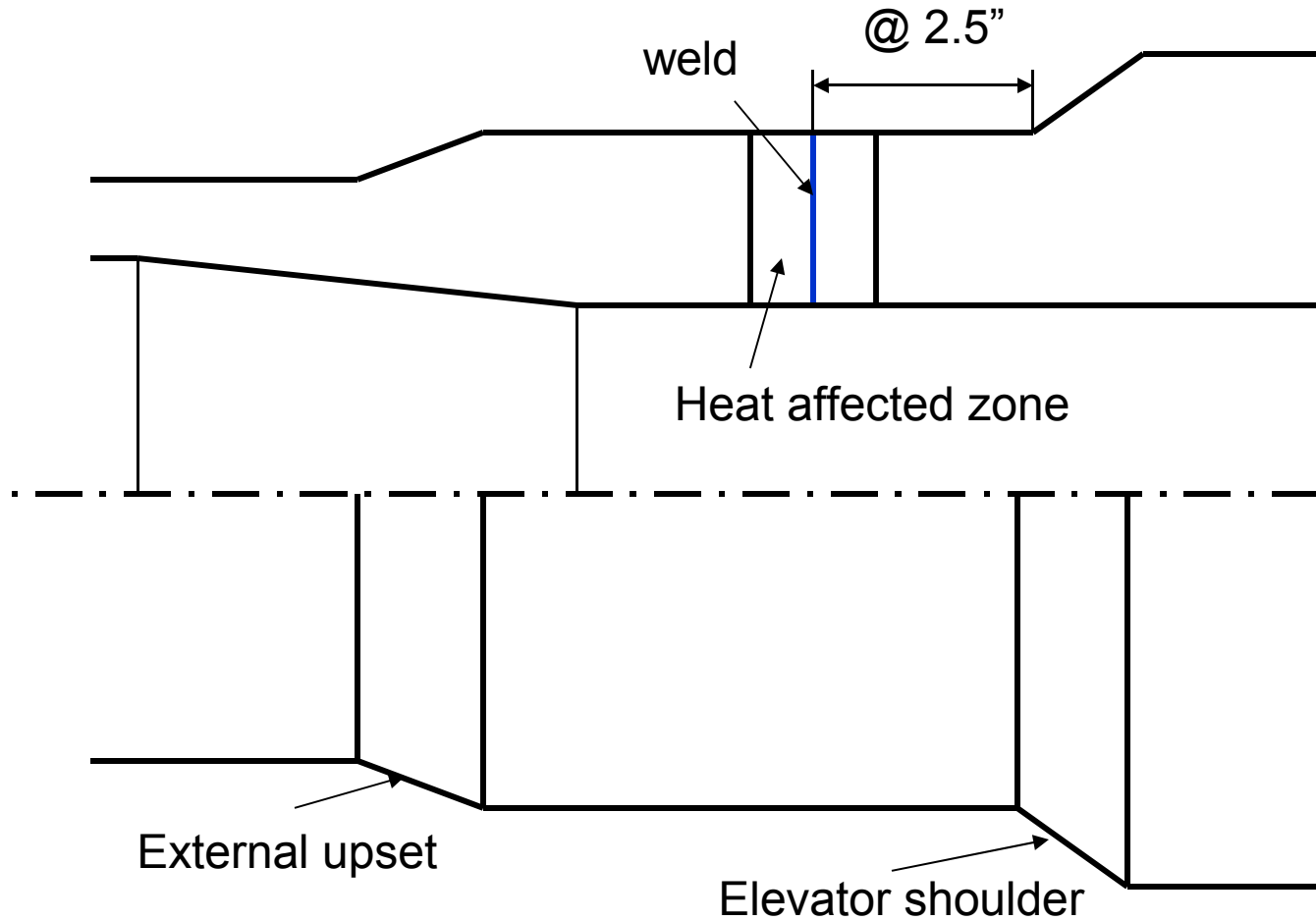
- Can be done in customer's yard to save on machining and transportation cost.
- Must be mechanical cutting (no torch)
- Must be done behind the weld on tube side (approximately 2.5" from the bottom of elevator shoulder)

Inspection and marking of tubes

- Inspection and straightening of the tubes is done by customer approved inspection company.
- Tubes must be marked with:
 - Grade, serial number, company name.
- Welding of new tool joint is performed on marked tubes only.
- Identification of new serial number of the drill pipe assembly is to be specified.



Cutting tool joints off



New tool joint specifications

- Tong Space (our standard is API + 2")
- Elevator shoulder (std: 18° box and 35° pin)
- Hard facing (type, flush or raised)
- Make and break (optional)
- Connection:
 - NC, Double shoulder (DP2S), Low Stress.
 - Size (OD – ID)
 - Protectors (pressed steel / plastic)



Internal plastic coating

- DPAL sub contract internal plastic coating to Vetco Tuboscope or licensees.



Re tooling

- DPAL will charge per set of tool joints welded (not per foot)
- Transportation, inspection, coating handled by DPAL are charged at cost plus 10%.

