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\_\_\_ " x 9 5/8" STACK SPECIFIC CIRCULATOR SUB-SEA TEST JOINT  
SERIAL # \_\_\_\_\_

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**Inspection Procedure**

Verify that the Serial Number on this Procedure matches the Serial Number of the Test Joint that you are using. The Serial Number is located on the Top Sub of the Test Joint. If these Numbers are not the same, STOP and call Nu-Tec.

The \_\_\_ " x 9 5/8" STACK SPECIFIC CIRCULATOR Sub Sea BOP Test Joint is designed to be shop maintained and repaired. No maintenance is required in the field except cleaning the outside tube, the dart seal area, and the dart itself. The seals located on the dart are designed to be field replaceable after each use. Seal kits, Dart Retrieving Tools, and Dart Fishing Tools are sent in a tool box with the Circulator Test Joint.

The Test Joint is completely assembled and tested before shipment to the field and is ready to be run upon arrival to the rig. Prior to running, an inspection of the Test Joint should take place to insure no damage has occurred in shipment. The inspection should include:

1. **OUTSIDE TUBE** – The rams and annulars seal on this surface. Inspect it, as you would drill pipe prior to running.
2. **WEEP HOLES** – The two weep holes in the lower sub should be open. If plugs are installed in these weep holes, remove the plugs prior to running the test joint. These plugs are installed to test the test joint on the pipe rack.
3. **DART** – Two rubber seals and one teflon seal should be on the dart. Replace damaged or missing seals. The Dart can be run installed in the test joint if there is to be no circulation prior to testing. The Dart can be removed from the Test Joint prior to running if circulation is anticipated. A Dart pulling tool is included to remove the Dart from the Dart Seat. After the test plug is seated in the well head, the Dart is dropped down the drill pipe.
4. **DART SEAT** – Check to be sure the seat is clean and no foreign material is located in this area. Foreign material would not allow the Dart to seat. The Test Joint is ready to be run in the hole.

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**STACK SPECIFIC CIRCULATOR TEST JOINT OPERATING PROCEDURE**

1. Pick up the CIRCULATOR Sub Sea BOP Test Joint with the rig crane and place in the "V" door.
2. Latch onto the Test Joint with the elevators and pick up in the Derrick.
3. Make up and RIH with **25,000 LBS** of tail pipe. Make up the Test Plug on the tail pipe, and the "Circulator" Test Joint on the Test Plug. Lower the Test Joint through the rotary and set the slips.
4. Inspect the Dart Seat in the top of the Test Joint to insure it is clean and free of debris. Apply dope to the Dart Seat.
5. Make up the drill pipe and RIH with the Tail Pipe, Test Plug, and Circulator Test Joint.
6. Prior to seating the Test Plug, circulate the capacity of the drill string at 3-4 **BPM** and max 300/350 **PSI**. The Well Head can be washed out at this time prior to seating the Test Plug.
7. **Drop the Test Joint Dart and allow to fall into place. The flow in the Test Joint will be diverted through the testing ports of the Test Joint after the Dart has seated.**
8. Test the BOP Stack as per the BOP Test Procedure. **DOWN THE DRILL PIPE.**
9. After all tests are complete, POOH with the testing assembly.
10. If required the Dart can be retrieved with the Nu-Tec overshot that is sent with the Test Joint.

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***DO NOT ROTATE WHILE TEST JOINT IS DOWN HOLE***

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