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TECHNICAL MANUAL FOR NON-RELEASEABLE GRAPPLE f/ 3.60" ROLLER BOGIE CUTTER

Tool Assy. Number:	11753600-0002
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Non Releasable Grapple f/ 3.60" Roller Bogie Cutter c/w 2.312" Fish Neck

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1.0 INTRODUCTION

- 1.1 The Non Releasable Grapple is designed to be used to retrieve the Roller Bogie Cutters that have a non-standard Fish Neck.

2.0 HEALTH and SAFETY

2.1 Recommended PPE for the disassembly and assembly process:

- 2.1.1 We recommend safety glasses and gloves as PPE for the disassembly and assembly process.

3.0 COSHH

- 3.1 COSHH related materials are not supplied with this product.

4.0 LUBRICATION

- 4.1 A Health and Safety Data sheet for the recommended grease is attached to the end of this document.

5.0 OPERATION

- 5.1. Attach Grapple to tool string and R.I.H.
- 5.2. On reaching fish jar downwards to insure that Grapple latches onto the Cutters fishneck.
- 5.3. P.O.O.H.

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- 6.0 **DISASSEMBLY PROCESS**
- 6.1 Grip Main Body (2) in vice.
- 6.2 Remove Grub Screws (6) from Main Body (2).
- 6.3 Unscrew Top Sub (1) from Main Body (2).
- 6.4 Remove Grub Screw (7) from Top Sub (1).
- 6.5 Unscrew Core (5) from Top Sub (1).
- 6.6 Remove Spring (8) from Main Body (2).
- 6.7 Remove Spring Spacer (4) from Main Body (2).
- 6.8 To disassemble from Roller Bogie Cutter Body insert a punch into hole in Latch (3) through slot in Main Body (2).
- 6.9 Pull Latch (3) back and rotate so that the punch is in the locked position of the slot.
- 6.10 Make up Disassembly prong (11753600-1103) to Main Body (2).
- 6.11 Once Disassembly Prong is made up to Main Body (2) the fingers of the Latch (3) will be pushed out far enough to allow removal of the Latch (3) and Main Body (2) from the Cutter body.
- 6.12 Unscrew Disassembly Prong from Main Body (2).
- 6.13 To continue to disassemble Grapple slide Latch (3) out of Main Body (2).

The Grapple is now totally disassembled.

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7.0 ASSEMBLY PROCESS

Note: During the assembly process ensure that all moving parts are lubricated using a Multip 2 type grease or similar.

- 7.1 Grip Top Sub (1) in vice.
- 7.2 Make-up Core (5) to Top Sub and insert Grub Screw (7).
- 7.3 Grip Main Body (2) in vice.
- 7.4 Slide in Latch (3).
- 7.5 Slide in Spring Spacer (4).
- 7.6 Slide in Spring (8).
- 7.7 Make up Top Sub (1) to Main Body (2).
- 7.8 Insert Grub Screw (6).

The Grapple is now totally assembled.

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MAINTENANCE

8.1 There is no on site maintenance.

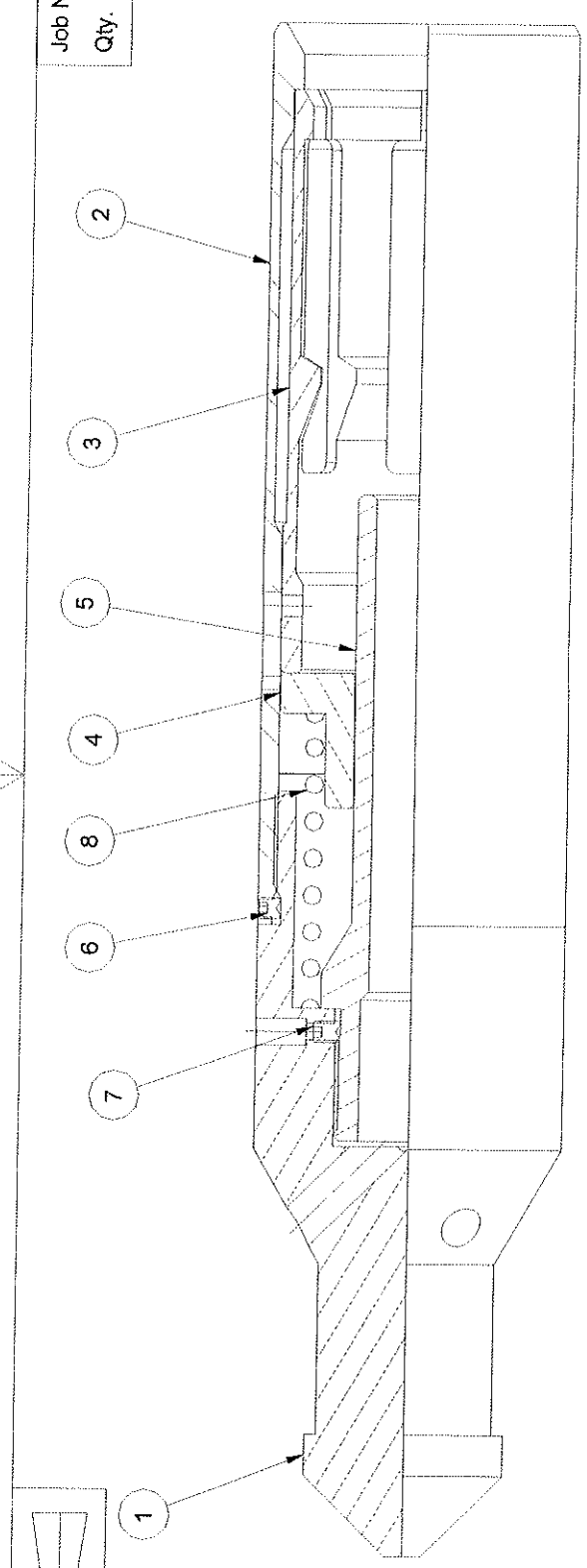
9.0 DRAWINGS and COSHH SHEETS

9.1 Drawing N^o 11753600-0002.

9.2 Drawing N^o 11753600-1103.

9.3 A Duron Multip 2 Grease COSHH Sheet.

Job No.
Qty.



Parts List

ITEM	DESCRIPTION	QTY	PART NUMBER
1	Top Sub	1	11753600-0603
2	Main Body	1	11753600-0703
3	Latch	1	11753600-0903
4	Spring Spacer	1	11753600-0803
5	Core	1	11753600-1002
6	Soc Head Set Screw	1	84000250-0105
7	Soc Head Set Screw	1	84000250-0205
8	Spring	1	85000654-0109
	Dis-Assembly Prong	1	11753600-1103

DESIGN SPECIFICATION	
SERVICE	STANDARD
TOP CONNECTION	2.312" FISHNECK
BOTTOM CONNECTION	N/A
MAX O/D	3.600"
OVERALL LENGTH	18.03"
WEIGHT	10.43 Kg (22.95 Lbs)

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Description: **Non-Releaseable 3.600" Grapple to suit**

Part No: 11753600-0002 Sheet 1 of 1

Drawn By: **S. Crossan**
Checked By: **A. McCombie**
Date Drawn: **20.2.03**
Date Checked: **6.3.03**

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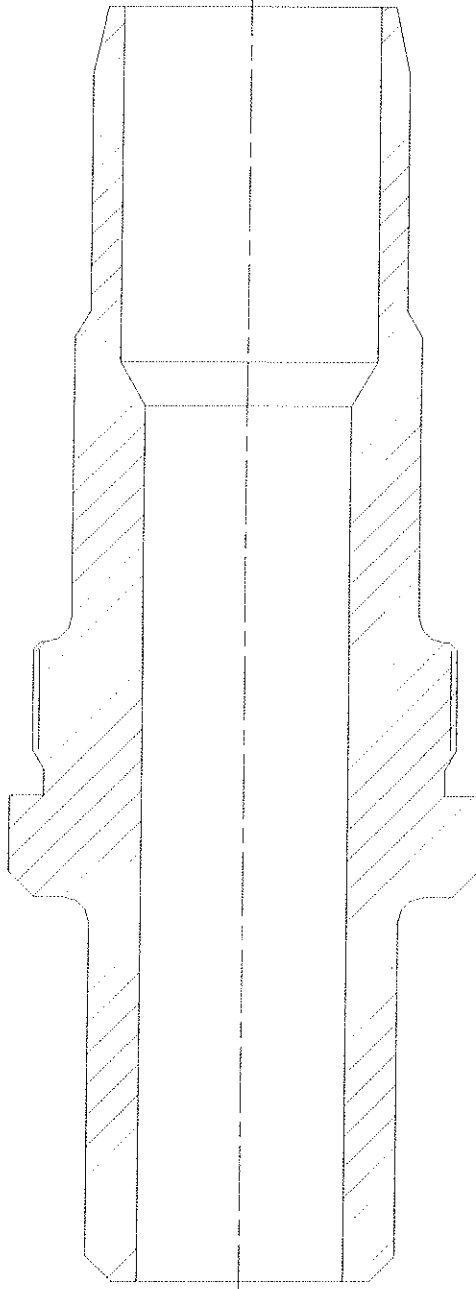
UNLESS OTHERWISE STATED

1. Remove all burrs and sharp edges.
2. Corner Radii R3.
3. Chamfer 1:2.
4. All dimensions are in millimeters.
5. Machine finish.
6. Concentricity within 0.15 TIR.
7. Chamfers 0.25 x 45°.
8. Machine X.X = 0.25
X.XX = 0.15
Angle is 12°
Chamfer radius = 0.75
11.52°
9. Thread lead angle 45°.
10. Thread break each 30°.

Revision	Date	Issued	Chg No.
A	23.4.03	140	
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Job No.
Qty.



DESIGN SPECIFICATION	
BASE MATERIAL	4140 (30-36 Rc.)
TOP CONN	3.250" - 8 TPI Stub Acme Pin
MAX. O/D	3.600"
O'ALL LENGTH	9.84"

Wireline Engineering Ltd.

Description: Dis-assembly Prong
to suit

3.600" Roller Bogie Cutter Grapple

Part No: 11753600-1103 Sheet 1 of 1

Drawn By: S. Crossan
Checked By: A. McCombie
Date Drawn: 20.2.03
Date Checked: 6.3.03

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UNLESS OTHERWISE STATED

- Remove all burrs and sharp edges.
- Finish all surfaces.
- Do not scale drawing.
- All dimensions are in millimeters.
- Machine finish.
- Concentricity within 0.15 TIR.
- Chamfers 0.25 x 45°.
- Machine X.A. = 0.25
- X.ZA = 0.15
- Angles = 12°
- Drilled holes = 0.75 (1/32")
- Thread lead angle 45°
- Thread lead angle 30°

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