



Redback Roller Reamer
Assembly Job Card

BODY SERIAL No.		TOOL SIZE RANGE	
CUTTER SERIAL No.		CONNECTION SIZE UP	
CUTTER TYPE		CONNECTION SIZE DOWN	
DATE of ASSEMBLY		STRING / NEARBIT	
DATE OF CHECK		3 POINT / 6 POINT	
DATE of DEPARTURE			

ITEM	DESCRIPTION	Pass/fail	DOC. REF												
1.0	<p>Clean pockets with degreaser or solvent cleaner</p> <p>Visually inspect the body and pocket for any mechanical damage</p> <p>Visually inspect the condition of the Helicoil inserts. REPLACE any helicoil that is damaged or protruding above the base of the pocket surface</p> <p>Helicoil Replaced: YES/NO Number Replaced:</p> <p>Place a New wedge in the cutter pocket to check if any wear is present. Record wear (mm):</p>		<p>MM-SSR-1R Page 4</p> <p>MM-SRR-1R Page 5</p> <p>MM-SRR-1R Page 13-14</p> <p>MM-SRR-1R Page 4</p>												
2.0	Apply thread compound to complete pocket area		MM-SRR-1R Page 10												
3.0	Lower cutter into pocket and fit wedges		MM-SRR-1R Page 11												
4.0	Wedge Bolts		MM-SRR-1R Page 11												
4.1	<p>Tighten up wedge bolts evenly and torque</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 50%;">Tool Range Size</th> <th style="width: 50%;">Torque Setting</th> </tr> </thead> <tbody> <tr> <td>561 Redress Kit</td> <td>280 ft lbs</td> </tr> <tr> <td>514 Redress Kit</td> <td>280 ft lbs</td> </tr> <tr> <td>445 Redress Kit</td> <td>200 ft lbs</td> </tr> <tr> <td>375 Redress Kit</td> <td>100 ft lbs</td> </tr> <tr> <td>350 Redress Kit</td> <td>80 ft lbs</td> </tr> </tbody> </table>	Tool Range Size	Torque Setting	561 Redress Kit	280 ft lbs	514 Redress Kit	280 ft lbs	445 Redress Kit	200 ft lbs	375 Redress Kit	100 ft lbs	350 Redress Kit	80 ft lbs	Actual Torque	MM-SRR-1R Page 12
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	299 Redress Kit TORQUE WRENCH S/N CALIBRATION DUE DATE	55 ft lbs		
5.0	Gauging of the Cutters (Gauging to be done over top row of buttons – ensure Correct alignment as per Ref: 2089) <ul style="list-style-type: none"> • Use of appropriate size gauge ring • Tolerance to be nominal +1/64 / -0" 			MM-SRR-1R Page 6
6.0	Finishing Operations			
6.1	<ul style="list-style-type: none"> • Clean and degrease the tool • Apply thread compound to connections • Install thread protectors • Paint the completed assembly (If required) 			
6.2	Mark Tool with the following details: Tool Serial Number (i.e. Body Serial Number GU****)			

SIGNED (Tool Dresser)	
PRINT (Tool Dresser)	
DATE	

SIGNED (Inspector)	
PRINT (Inspector)	
DATE	

