



Assembling and Disassembling the Slimline Full Bore Tubing Anchor Catcher

Assembly

NOTE: All threads, including screws and body threads, need to be properly lubricated prior to installation.

1. Stand the body on a work bench with the upper threads (the longer of the two on the body) on top. Grease the upper threads of body heavily with appropriate grease.
2. Make up the upper cone onto the body.
3. Make up the body nut onto the body so that the top of the body nut is flush or slightly below the top thread.
4. Check the engagement of the pin on the body nut with the pin on the upper cone. Ensure both pins make solid contact with each other with no binding.
5. Screw in the body nut screw to the body nut, securing it to the body.
6. Place the top flow deflector (sub) in a vice. Grease the top threads of the body with appropriate grease for 10-rd threads, and make up the body into the top flow deflector hand tight.
7. Grease heavily the middle portion of body (above and below the body ring) where the slips will ride.
8. Check the slip springs to ensure they are attached properly to the slips. Slightly crimp the end of the springs.
9. Slide the slip assembly over the body, making sure that you twist and push slips over the lower threads of the body instead of jamming the slips over the threads, in order to avoid spring breakage. Work the top half of the slips over the body ring, so that the ring rests within the notch on the bottom of the slips.

NOTE: After sliding the slips onto the body, check the slip springs again to ensure they are all still properly connected.

10. Slide the lower cone sleeve into the lower cone, line up the holes, and install the desired number of shear screws as equally as possible into the lower cone sleeve. It's helpful to install the screws in an alternating pattern, loosely at first, and then tightening them in a similar pattern, to prevent the screws from binding one side of the lower cone sleeve.

NOTE: Each shear screw takes 5,000 lbs (+/- 10%) of tension to shear; e.g., a 60k shear would be 12 pins.

11. Grease the lower body threads and make up the lower cone with those threads.
12. Check that the upper cone is bottomed out (i.e., the upper cone pin is in contact with body nut pin).

NOTE: The upper cone pin MUST be in contact with the body nut pin when installing the lower cone onto the body.

13. Tighten the lower cone until the lower cone sleeve is flush with the bottom thread. Test timing by sliding the slips up and down. They should come close to (~1/16"), but not contact, the cones when the tool is full released. If they contact the cones, adjust the cone position accordingly.
14. Fit the slip retainers over the corresponding grooves in the upper and lower cones, and test that the slip retainers can move smoothly over the lower cone.
15. Fasten the slip retainers to the upper cone using the slip retainer screws.
16. Install drag springs using the appropriate screws/washers.
17. Actuate tool to make sure the slips will come out and that everything turns smoothly. Make sure that there is no obstruction in the setting process.
18. Grease the bottom 10-rd threads, make up the bottom sub onto the body and tighten it through the tool.

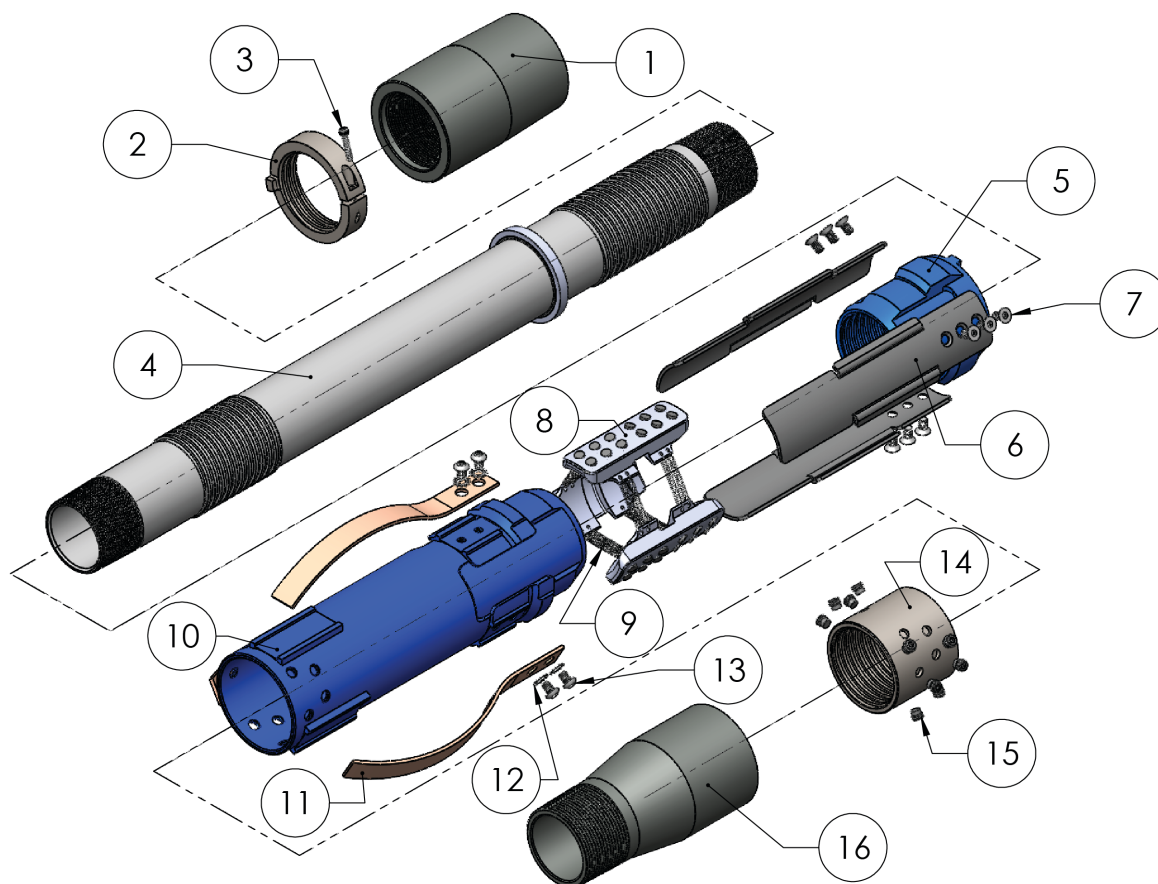
Disassembly

1. Place the top sub of the tool in a vice and remove the bottom sub.
2. Remove the drag springs.
3. Remove the slip retainers.
4. Unscrew the lower cone and the lower cone sleeve from the body.
5. Carefully lift the slips over the body ring and slide the slip assembly off the bottom end of the body. To prevent breaking the slip springs, spin the slip assembly in a clockwise motion once they come in contact with the lower threads on the body.
6. Unscrew the body from the top sub.
7. Remove the body nut screw and unscrew the body nut from the body.
8. Unscrew the upper cone from the body.



Diagram and Parts List

(for the 5.5" Slimline® Full Bore TAC model)



Item No.	Part number/description	Qty.
01	55SFBTS, Top Sub	1
02	55SFBBN, Body Nut	1
03	55SFBBNS, Body Nut Screw	1
04	55SFBBBD, Body	1
05	55SFBUC, Upper Cone	1
06	55SFBSR, Slip Retainer	3
07	55SFBSRS, Slip Retainer Screw	9
08	55SFBSL-C, Carbide Slip	3
09	55SFBSP, Slip Spring	12

Item No.	Part number/description	Qty.
10	55SFBLC, Lower Cone	1
11	55SDS1, Drag Spring	3
12	55SDSW, Drag Spring Washer	6
13	55SDSS, Drag Spring Screw	6
14	55FBLCS, Lower Cone Sleeve	1
15	55SFBPIN, Shear Screw (5K lbs.)	12
16	55SFBBS, Bottom Sub	1