

NIPPLE UP BOP

STEP	SUB	PROCEDURE	REMARKS
		<i>Discuss Operator BOP requirements with rig manager.</i>	BE AWARE OF CONTRACT AND PERMIT REQUIREMENTS.
0	1	PPE Requirements - Hard Hat, Safety Glasses, Work Gloves, Steel Toe Shoes, Back Support, and Anti-Fall Protection. Fit for Duty check on all hands.	All Full Body Harnesses are to be inspected prior to any use.
	2	Review JSA for Nipling up BOP.	Include all third party personnel.
	3	Discuss procedures with Rig Manager to include: <ul style="list-style-type: none"> - Stack design (Class II, IV, etc.) - Spacing out of stack. - Position, size and pressure rating of choke manifold. - Number and size of trucks required. - Know the weight of the BOP. - Pick-up lines are of sufficient size and rating to hoist BOP, (Including all third party equipment). - Cellar access, V-Door removal if required. - Presence of gas in cellar area. - The use of any third party services, ie. Nipple up crews, testing service, stack winches, cranes, trucks, etc. - Any hot work permit or confined space permit 	<p>Refer to Romfor Drilling Policy for Ram configurations and equipment requirements. Know the position and height of wellhead needed for class of stack.</p> <p>BPS recommends the use of winch trucks to assist handling BOP.</p> <p>Check wire rope rating tables for proper load limits and general condition of the pick-up lines.</p> <p>Be especially aware of the hazards of gas buildup in the cellar in areas of known hydrogen-sulfide gas.</p> <p>IT IS NOT A RECOMMENDED PROCEDURE to use chains.</p>
1		Verify the following items are ready or available, as required: <ul style="list-style-type: none"> - Adequate tie off points are in place to assure 100% tie off. - Flourescent vest. - Designate qualified man to be flagger. - Two way communication. - Proper API ring gasket. - Proper size hammer wrenches and hammers, if required. - Cellar covers. - Proper size rams. - BOP Bolts are the proper size and ready. - Extra set of door seals are on location. - Proper DSA or spools if required. - Tag lines. - Scaffolding, if used is inspected and installed properly. 	<p>Use antiffall protection devices.</p> <p>Do Not reuse old API ring gaskets. All bolts, wrenches, hammers and API rings are cleaned and in good condition.</p>

NIPPLE UP BOP

STEP	SUB	PROCEDURE	REMARKS
	2	Complete any hot work and confined space permit requirements before entering cellar, if required.	Refer to Rig Manager for requirements and approval.
	3	Remove mousehole and cover hole in floor.	
		READY TO NIPPLE UP	
		This procedure is based on the assumption that the starting wellhead is in place and tested.	
1		Install cellar covers and hole cover.	Working around cellars that are 6' deep or deeper, anti-fall protection must be worn at all times.
2		Clear floor area of all unnecessary equipment.	Keep all tools away from rotary area.
3		Attach pickup lines to blocks. Unlock blocks. Raise blocks up out of the way.	
4		Clear cellar area. Position flagger.	Flagger should wear a fluorescent vest and use two-way communications.
5		Pull rotary bushings (inner and master separately, if required) and install caution tape around rotary.	Use proper bushing puller. Pull with air hoist and use tag line to position. Be aware of position of feet.
		INSTALL BOPE	
		BPS highly recommends the use of a winch truck to snub in all equipment.	
		BPS Recommends the use of pick-up lines attached to the blocks to pick up and install all BOP equipment, including all Spools, DSA's and Preventers.	During all equipment pickup and BOPE stackings, BPS recommends that the Rig Manager be present at all times.
6		Position equipment as close to the cellar as possible. VERIFY THAT THE BOPS ARE NOT UPSIDE-DOWN.	MAKE SURE all equipment is clean and ring grooves are in good condition. Set equipment on boards or mats as applicable. DO NOT set the stack in the mud or dirt. DO NOT UNDER ANY CONDITIONS PLACE ANY BODY PARTS UNDER THE BOPE. BE ESPECIALLY ALERT WHEN EQUIPMENT IS IN MOTION.
7		Lower lifting lines down through rotary table slowly into position to tie onto first piece of equipment using the directions from flagger.	Driller or Rig Manager should be the only persons allowed to operate the Draw-works during nipple up operations. Use directions from flagger.

NIPPLE UP BOP

STEP	SUB	PROCEDURE	REMARKS
8		Attach pick-up line to BOP using proper lifting slings.	DO NOT go around sharp edges with slings. Be aware of pinch points. Refer to rig specific JSA.
9		Attach snub line from winch truck to BOP .	
10		STAND CLEAR , while Driller directed by flagger, raises BOP at the same time as the winch truck operator slacks off BOP to proper position for installation.	If needed, use an additional flagger to signal the winch truck operator. Flagger should not look through rotary table when cables are in tension.
11		Remove snub line and attach tag lines.	
12		While BOP is held securely, clean and ready bolts for installation.	Driller will chain down the brake handle and lock out the drawworks. Ensure the bolts are clean and of proper size for the flange.
13		Prepare ring grooves and install new API Ring gasket.	MAKE SURE the ring gasket is the proper one for flange and application.
14		Position BOP in proper position, ("two hole" for proper alignment if applicable).	Keep fingers, hands, feet and other body parts away from bolts and flange.
15		Under direction of the Flagger, using tag lines, lower BOP into position for bolt installation.	Use minimum amount of bolts while spotting in place. USE TAG LINES ONLY for positioning each section of the BOP. Refer to rig specific JSA.
		STACK BOP	
16		Driller will chain down the brake handle and lock out the draw-works.	
17		Install nuts on BOP bolts and hand-tighten.	VERIFY THAT BOP IS NOT INSTALLED 'UPSIDE-DOWN'
18		Remove pickup lines.	
19		Repeat Steps 2 through 18 for each section of the BOP stack.	

NIPPLE UP BOP

STEP	SUB	PROCEDURE	REMARKS
20		Tighten all BOP bolts using Nipple Up crew.	BPS recommends the use of Nipple-up crews utilizing torque wrenches. If not using a Nipple Up crew, use a rope on all hammer wrenches. Be aware of body position when tightening or breaking bolts. If conditions dictate the use of the rig crew to nipple up the BOP, see the rig specific JSA.
21		Install choke line valves.	Beware of pinch points. BPS recommends the use of teflon tape to position the ring gasket.
22		Install choke line from choke line valve to choke manifold.	BPS DOES NOT RECOMMEND the use of "Flex line" for the choke line. The choke line should be a straight length of pipe. Refer to rig specific JSA.
23		Tighten all bolts as required using proper wrenches.	Ensure all bolts are installed with full nut.
24		Install snub-lines and center BOP.	Turnbuckles should be installed so that adjustments can be made from the ground level.
25		Install kill line valves and check valve.	Use a weld-neck companion flange on the check valve on the kill line. OEM only. UNDER NO CONDITIONS are field fabrications permitted for the flange.
26		Tighten all bolts as required using proper wrenches.	Ensure all bolts are installed with full nut.
27		Install lines from accumulator to BOP stack.	Ensure air and electric pumps are connected to their power source and working properly.
28		Rig up remote BOP stations.	
29		Function test Rams, HCR and annular preventor and check all lines for hydraulic leaks.	Function test both accumulator and remote valves.
30		Install mud gas separator and flowlines as required.	Ensure proper grounding of the mud-gas separator. Ensure that only series 1502 hammer unions are used where required. Secure all flowlines, flarelines and separator with appropriate anchor.
		PRESSURE TEST BOP	
31		REFER TO BPS <u>"BOP PRESSURE TESTING PROCEDURE"</u>	
		END OF PROCEDURE	