

Assembling and Disassembling the Tubing Anchor Catcher

Assembly

NOTE: All threads, including screws, plugs 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. Slide the cap onto the body nut.
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 lower threads of the body and the middle portion of body 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. Place the slip spring sub assembly into the housing by collapsing all three slips onto one another (one wing under, one wing over). Insert this assembly through the end of the housing. Lightly bounce the housing on a table or the ground until the slips fall into place in the slip windows.
10. Slide the slips and housing over the body, making sure that you twist and push slips over the lower threads of the body instead of jamming the slips over threads, in order to avoid spring breakage.

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

11. Make up the cap on the housing and install the cap screw(s).
12. Grease the lower cone sleeve where the shear pins will sit. (Grease helps them stay in place.)
13. Slide the lower cone sleeve into the lower cone, line up the holes, and install desired amount of shear pins as equally as possible into the lower cone sleeve.

NOTE: Each shear pin takes 5,000 lbs of tension to shear. For example, a 50k shear would be 10 pins.

14. Make up the lower cone with the threads on the body, making sure that the shear pins do not fall out.
15. Check that the upper cone is bottomed out (i.e., the upper cone pin is in contact with body nut pin).
16. Make up the pipe plug(s) into the lower cone (and the upper cone on the 5.5" anchor).

NOTE: The upper cone pin MUST be in contact with the body nut pin when installing the pipe plugs in the cones. The pipe plugs in the lower cone should be roughly 1/8-1/4" from the end of the slot when the top cone is bottomed out. There should be equal space for the upper cone as well.

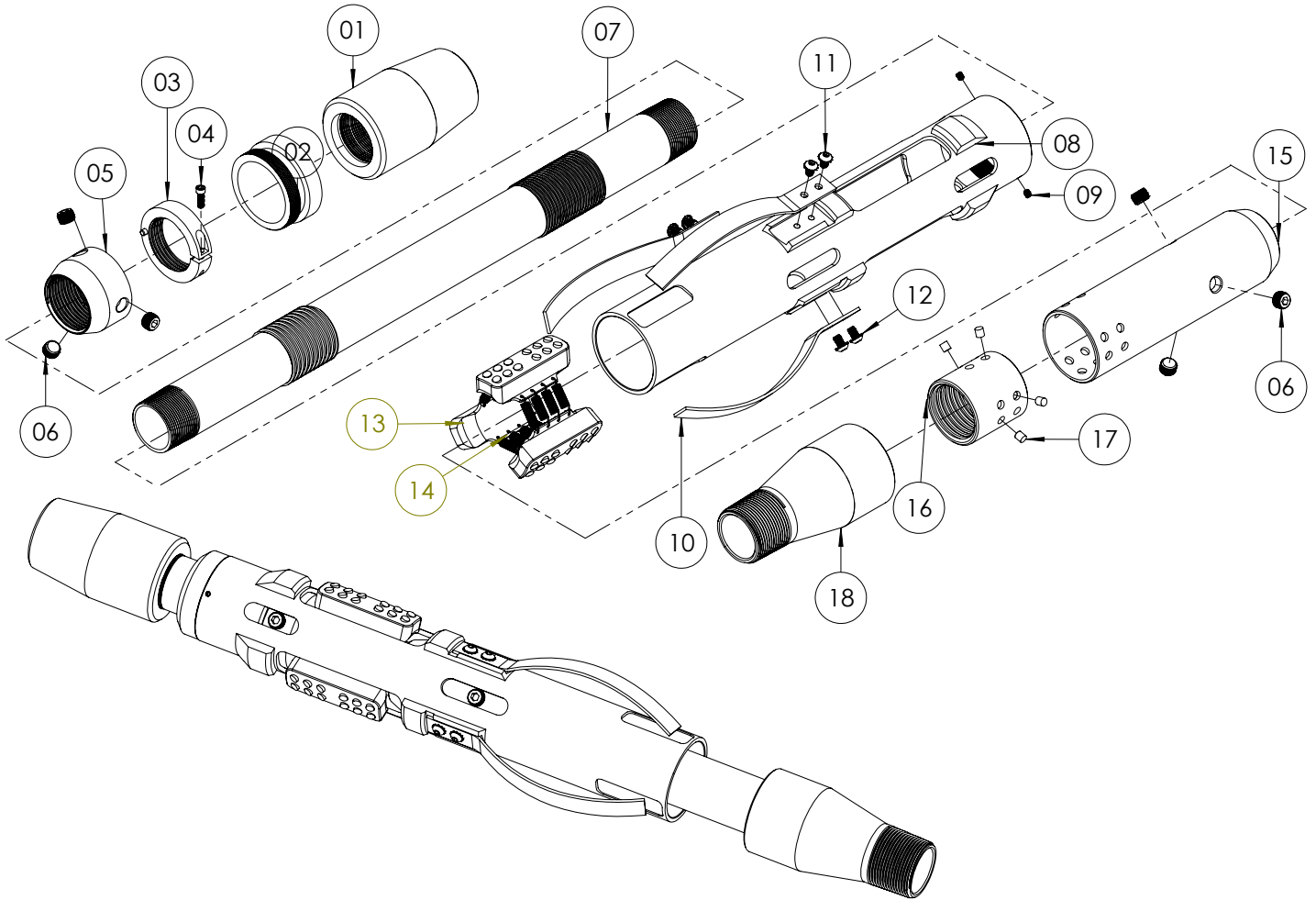
17. Actuate tool to make sure the slips will come out and that everything turns smoothly. Make sure that there is no obstruction in the setting process.
18. Install drag springs using the appropriate screws/washers.
19. Make up the bottom sub onto the body and tighten it through the tool.

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 pipe plug(s) for the lower cone. (On 5.5" TACs, also remove the pipe plug(s) for the upper cone.)
4. Unscrew the lower cone and the lower cone sleeve from the body.
5. Remove the cap screw(s).
6. Unscrew the cap from the housing.
7. Slide the housing and the slips off the bottom end of body. To prevent breaking the slip springs, spin the housing in a clockwise motion once they come in contact with the lower threads on the body.
8. Remove the body nut screw and unscrew the body nut from the body.
9. Unscrew the upper cone from the body.
10. Unscrew the body from the top sub.

Diagram and Parts List

(for the 5.5" Slimline[®] model)



Item No.	Part number/description	Qty.
01	55STFD, Top Sub	1
02	55SCP, Cap	1
03	55SBN, Body Nut	1
04	55SBNS, Body Nut Screw	1
05	55SUC, Upper Cone	1
06	55SPP, Pipe Plug	6
07	55SBD, Body	1
08	55SHO, Housing	1
09	55SCS, Cap Screw	2

Item No.	Part number/description	Qty.
10	55SDS1, Drag Spring	3
11	55SDSS, Drag Spring Screw	6
12	55SDSW, Drag Spring Star Washer	6
13	55SSL-C, Carbide Slip	3
14	55SSSP, Slip Spring	12
15	55SLC, Lower Cone	1
16	55SLCS, Lower Cone Sleeve	1
17	55PIN, Shear Pin (5,000 lbs./ea.)	10
18	55SBFD, Bottom Sub	1