



AS RETRIEVABLE BRIDGE PLUG
RIGHT-HAND SET / RELEASE
7", HEAVY DUTY MANDREL, MINIMUM
DAMAGE SLIPS, NC 38 TOOL JOINT

Manual No: DL-725-7000-1652
Revision: A
Revision Date: 02/15/2023

Authored by: J.Anderson

Approved by: K.Plunkett

A) DESCRIPTION

The AS Retrievable Bridge Plug is a high pressure plug for multiple zone and selective single zone operations such as acidizing, fracturing, cementing and testing. It features a large internal by-pass to reduce swabbing when running and retrieving. The by-pass closes during the setting of the plug and opens prior to releasing the upper slips to equalize pressure when unsetting. The by-pass is located directly below the upper slips to help wash debris when the by-pass is open.

This tool can be set in tension or compression. It can be set shallow in unsupported casing to contain pressure while working on wellhead equipment. It can be set in tension making it ideal for setting shallow to test wellhead equipment and also deep, high-pressure wells.

The ASW Retrievable Bridge Plug is a version of the AS Retrievable Bridge Plug that allows the plug to be set on wireline or with a hydraulic setting tool, and retrieved with tubing. It cannot be reset in the wellbore once it is unset, but it can be pulled, re-dressed and run again. A Wireline Adapter Kit is required for this version.

CAUTION₁: When running this tool with a packer, make sure the J-slots in the plug, running/ retrieving tool, and packer are all compatible.

B) RELATED TOOLS (sold separately)

B-1) 7" X NC 38 Tool Join Spring Loaded Retrieving Tool (P/N 57770-3-XBEC) – refer to technical manual *DL-577-7000-1132*.

B-2) 7" X NC 38 Tool Join Spring Loaded Retrieving Tool (P/N 57770-XBEC) – refer to technical manual *DL-577-7000-910*.

C) SPECIFICATION GUIDE

CASING			TOOL OD (INCHES)	THREAD CONNECTION PIN DOWN	PART NUMBER
SIZE (INCHES)	WEIGHT (LBS/FT)	RECOMMENDED HOLE SIZE (INCHES)			
7	26.0 – 32.0	6.094 – 6.276	5.875	NC 38 TOOL JOINT	72571RR3-1XBEC 72571RRH3-1XBEC ¹ 72571RRV3-1XBEC ²

Elastomer Trim Options: ¹HSN, ²Viton

NOTE₁: Tools listed are right-hand set / right-hand release. Additional J-slot designs are available.

DIFFERENTIAL PRESSURE (MAX)	HANGING WEIGHT ON SET TOOL (MAX)	TENSILE LOAD THRU TOOL (MAX)	TORQUE THRU TOOL (MAX)
10,000 PSI	80,000 LBS [†]	80,000 LBS	4,700 FT-LBS

[†]Casing must be cemented for this load rating.

D & L OIL TOOLS
P.O. BOX 52220 TULSA, OK 74152
PHONE: (800) 441-3504 www.dloiltools.com



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D) PRE-INSTALLATION INSPECTION PROCEDURES

CAUTION2: D&L ships tool connections made-up **HAND TIGHT**—labeled with hand-tight tape on the tool (Fig. 1) — unless stated otherwise. Tighten/torque all connections properly before operating tool.



Fig. 1

GENERAL THREAD CONNECTION TORQUE RECOMMENDATIONS			
STUB ACME / ACME THREADS	INTERNAL TAPERED TUBING THREADS		PREMIUM THREADS
	UP TO 2-3/8"	GREATER THAN 2-3/8"	
600 – 800 FT-LBS	600 – 800 FT-LBS	800 – 1,200 FT-LBS	Consult thread manufacturer's recommendations.

GENERAL SCREW TORQUE RECOMMENDATIONS									
SCREW SIZE (INCHES)	#6	#8	#10	1/4	5/16	3/8	7/16	1/2	5/8 and larger
TORQUE RANGE (INCH-POUNDS)	5 – 8	10 – 15	18 – 25	25 – 40	50 – 80	90 – 135	160 – 210	250 – 330	450 - 650

Before first use, D&L recommends disassembly and inspection of the tool unless stated otherwise. Ensure parts have not been damaged during shipping. Replace damaged parts with D&L replacement parts. Contact D&L sales for replacement part information.

Re-assemble the tool after inspection. Install parts in the correct order and orientation. Properly tighten connections.

Before re-using the tool, D&L recommends disassembly and inspection of the tool. Clean parts and ensure parts are in good working condition. Replace worn or damaged parts with D&L replacement parts.

When redressing the tool, D&L recommends replacement of all seals, elements, o-rings, shear screws, etc. Contact D&L sales for redress kit and/or other replacement part information.

E) SETTING PROCEDURES

CAUTION3: Do not run the tool without properly tightening connections. Running the tool with loose connections may damage the tool and cause malfunction.

CAUTION4: Lift the AS Retrieval Bridge Plug by placing the sling or chain just below the pulling head. **DO NOT** lift the bridge plug by the upper slip body assembly (Fig. 2).



Fig. 2

E-1) TENSION SET

Run to setting depth while latched to its spring loaded retrieving tool. Pick up, rotate 1/4 turn to the right at the plug, and lower work string to set lower slips. Pull tension to pack-off elements, slack off, and then pick up again to assure plug setting (14,000 lbs minimum). After setting plug, slack off work string weight, hold left-hand torque and pick up to free work string from plug.

E-2) COMPRESSION SET

Run to setting depth while latched to its spring-loaded retrieving tool. Pick up, rotate 1/4 turn to the right at the plug, and lower work string to set lower slips. Slack off sufficient weight to pack-off elements, then pick up to firmly set upper slips and slack off again (14,000 lbs minimum). After setting plug, slack off work string weight, hold left-hand torque and pick up to free work string from plug.



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F) RELEASING PROCEDURES

Lower work string until the retrieving tool automatically latches to the AS Retrievable Bridge Plug. Sand may be washed from the upper slip by circulating through the upper portion of the plug. Slack off weight, hold right-hand torque pick up to open the by-pass valve, and wait until differential pressure has equalized. Continue upward movement to release upper slips, relax packing elements and re-latch. The plug may now be removed or re-located.

F-1) EMERGENCY RELEASE

If the plug will not release conventionally, slack off re-set, then pick straight up to shear J-pins and release the plug (standard J-pins will shear at 40,000 lbs each – refer to Parts List for J-pins with other shear values). Once the J-pins are sheared, the tool cannot be moved down hole.

NOTE₂: Contact D&L Engineering if running tool equipped with lower than standard value shear J-pins.

G) STORAGE RECOMMENDATIONS

When preparing the tool for storage, follow the Pre-Installation Inspection Procedures. Re-assemble the tool with connections hand-tight only and in running position if applicable. Elements should be in a relaxed state—free from tension, compression or other deformation.

Store the tool, if possible, in an enclosed, temperature and humidity controlled environment. Avoid excessively high temperatures over long periods of time. Shield elastomeric parts from ultraviolet light sources. Keep tool dry and protected from condensation. Do not store in contact with or near volatile or corrosive chemicals. Do not store near ozone generating equipment or operations such as welding.

H) PRESSURE AFFECTED AREA GUIDE

When set downhole, the packer mandrel is subjected to a force created by differential pressure above or below the packer that acts on the pressure affected area (i.e., the piston effect). Depending on the tubing size and weight and the seal area of the packer the force created by differential pressure acts upwards or downwards on the packer mandrel. An upward force, designated as a negative (-) value, acts to push the packer mandrel up hole and must be accounted for when releasing the packer. A downward force, designated as a positive value, acts to push the packer mandrel down hole and must be accounted for when releasing the packer. Other factors (e.g., tubing movement due to temperature change) must be considered separately to determine all the forces acting on the packer.

PACKER SIZE (INCHES)	PRESSURE AFFECTED AREA (SQ. INCHES)	
	ABOVE	BELOW
7	4.312 (DOWN)	-4.312 (UP)

Example: Consider a 7" AS Bridge Plug set on tubing with a differential pressure of 3,000 psi in the annulus around the tubing above the packer. What is the force acting on the seal area of the mandrel?

To calculate the force (lbs) acting on the seal area of the mandrel, refer to the Pressure Affected Area Guide for a 7" AS Bridge Plug. In this example, the differential pressure from above the packer acts on the seal area of the packer mandrel across a pressure affected area of 4.312 in². Multiplying the differential pressure (3,000 psi) by the pressure affected area (4.312 in²) results in a force of 12,934 lbs. The piston effect on the packer mandrel is a downward force of 12,934 lbs.



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I) ELASTOMER TRIM TEMPERATURE GUIDE

NITRILE (STD)			
TEMPERATURE RANGE (F°)	DUROMETER		
	END	MIDDLE	END
40° - 125°	80	70	80
125° - 250°	90	70	90
150° - 250°	90	80	90
250° +	Contact D&L Sales		

RUBBER TYPE	TEMPERATURE RANGE
NITRILE	40° - 250°F
HSN (HNBR)	70° - 300°F
VITON	100° - 350°F

J) RECOMMENDED TOOLS

J-1) HAND TOOLS

- VISE
- GLOVES
- ALLEN WRENCHES
- TAPE MEASURE
- O-RING PICK
- BAR
 - 1/2-INCH
 - 3/4-INCH
- PAINT BRUSH, 2-INCH
- PIPE WRENCH, 3-FT (2 EA)
- "CHEATER" PIPE, 4-FT LONG
- ADJUSTABLE WRENCH, 12-INCH
- CORDLESS DRILL, 18V
- SNAP RING SPREADER PLIERS
- ALIGNING PUNCH
- SCREWDRIVER SET, FLAT-TIPPED
- SOCKET SETS
 - 3/8-INCH DRIVE
 - 1/2-INCH DRIVE
- HAMMERS
 - SLEDGE
 - BALL PEEN
 - DEAD BLOW

J-2) SPECIAL TOOLS

ITEM	QTY	DESCRIPTION	PART NUMBER
T1	1	DRAG BLOCK ASSEMBLY TOOL	AT070110

K) DISASSEMBLY

K-1) Clamp upper cone (9) in vise.

NOTE₃: If needed, align hole in upper cone (9) with slot in sealing mandrel (27) and insert punch (or other tool) to prevent tool components from rotating during disassembly.

K-1.1) Unscrew and remove changeover (39) from J-slot mandrel (20).

K-1.2) Unscrew and remove set screws (37) from lower end of body extension (28).

K-1.3) Unscrew and separate body extension (28) from J-pin body (23) (**NOTE₄:** Left-hand threads).

NOTE₅: Drag block body assembly must be free to rotate.

K-1.4) Remove J-pins (15) from J-pin body (23).

K-1.5) Remove J-pin body (23) from J-slot mandrel (20).

K-1.6) Compress drag blocks (22) with drag block assembly tool (T1). Unscrew and remove set screws (35) from drag block body (18). Rotate drag block retainer (21) as needed to access screws.

K-1.7) Unscrew and remove body extension (28) from drag block body (18) (**NOTE₄:** Left-hand threads).

K-1.7.1) Remove retaining ring (31) from body extension (28).

K-1.8) Remove drag block retainer (21) from drag block body (18).

K-1.9) Release drag blocks (22). Remove drag blocks (22) and drag block springs (3) from drag block body (18).

K-1.10) Unscrew and remove rubber mandrel cap (19) from lower slip sleeve (32).



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K) DISASSEMBLY (cont'd)

K-1.11) Wedge lower slips (17) outward (if needed). Remove drag block body assembly and disassemble:

K-1.11.1) Remove wedges (if needed). Remove lower slips (17) and lower slip springs (25) from drag block body (18).

K-1.12) Unscrew and remove set screws (36) from lower slip sleeve (32).

K-1.13) Unscrew and remove lower slip sleeve (32) from rubber mandrel (11).

K-1.14) Unscrew and remove set screws (36) from J-slot mandrel (20).

K-1.15) Unscrew and remove J-slot mandrel (20) from sealing mandrel (27).

K-1.16) Unscrew rubber mandrel (11) from center coupling (10).

K-1.17) Remove rubber mandrel assembly and disassemble:

K-1.17.1) Remove elements (13, 14), rubber spacers (12), and lower cone (16) from rubber mandrel (11).

K-1.18) Unscrew and remove gage ring (29) from center coupling (10).

K-1.19) Moving to upper end of tool, unscrew and remove set screws (37) from pulling head (1).

K-1.20) Unscrew and remove pulling head (1) from upper mandrel (2).

CAUTIONs: Compression spring (4) is compressed with spring tension against pulling head (1).

K-1.20.1) Unscrew and remove spring retaining ring (34) from pulling head (1).

K-1.21) Remove compression spring (4) from upper mandrel (2).

K-1.22) Wedge releasing slips (7) and upper slips (8) outward (if needed). Remove upper slip body assembly and disassemble:

K-1.22.1) Unscrew and remove upper slip pickup (33) from upper slip body (6).

K-1.22.2) Remove wedges (if needed). Remove releasing slips (7), upper slips (8), and upper slip springs (26) from upper slip body (6).

K-1.23) Unscrew and remove set screws (36) from upper mandrel (2).

K-1.24) Unscrew and remove upper mandrel (2) from sealing mandrel (27).

K-1.25) Remove plug (5) from sealing mandrel (27).

K-1.25.1) Remove o-ring (42) from plug (5).

K-1.26) Remove sealing mandrel (27) from center coupling (10).

K-1.27) Unscrew and remove set screws (36) from upper cone (9).

K-1.28) Unscrew and remove center coupling (10) from upper cone (9)

K-1.28.1) Remove bonded seals (24) and internal ring (38) from center coupling (10).

K-1.28.1.1) Remove o-rings (40) from bonded seals (24).

K-1.28.2) Remove o-ring (41) from center coupling (10).

K-1.29) Remove seal retaining ring (30) from upper cone (9).

K-2) Unclamp and remove upper cone (9) from vise.

NOTE: To redress tool assembly, follow disassembly instructions. It is recommended by D&L Oil Tools to replace all bonded seals, elements, o-rings, shear screws, etc. when redressing tool.



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L) ASSEMBLY

NOTE7: Clean and inspect all parts. Replace all worn and damaged parts. Install parts in proper order, and orientation and tighten/torque all connections properly.

CAUTION6: To ensure tool operates properly, install o-rings in o-ring grooves - **NOT** in thread reliefs (unless stated otherwise) (Fig. 3).

L-1) Clamp upper cone (9) in vise.

L-1.1) Install seal retaining ring (30) in upper cone (9).

L-1.2) Install o-ring (41) in o-ring groove in center coupling (10).

L-1.3) Install o-rings (40) in o-ring grooves in bonded seals (24).

L-1.4) Install bonded seals (24) and internal ring (38) in center coupling (10).

CAUTION7: Do not rip or tear o-rings during installation.

L-1.5) Screw center coupling (10) into upper cone (9).

L-1.6) Screw set screws (36) into upper cone (9).

L-1.7) Install sealing mandrel (27) through bonded seals in center coupling (10).

CAUTION8: Do not damage bonded seals during installation.

L-1.8) Install o-ring (42) in o-ring groove in plug (5).

L-1.9) Install plug (5) into end of sealing mandrel (27).

CAUTION7: Do not rip or tear o-ring during installation.

L-1.10) Screw upper mandrel (2) onto sealing mandrel (27).

NOTE3: If needed align hole in upper cone (9) with slot in sealing mandrel (27) and insert punch (or other tool) to prevent tool components from rotating during assembly.

L-1.11) Screw set screws (36) into upper mandrel (2).

L-1.12) Assemble upper slip body assembly and install:

L-1.12.1) Install releasing slips (7), upper slips (8) and upper slip springs (26) into upper slip body (6).

NOTE8: Install one (1ea) spring per slip (Fig. 4).

L-1.12.2) Wedge slips outward. Screw upper slip pickup (33) into upper slip body (6).

L-1.12.3) Install upper slip body assembly onto upper mandrel (2). Remove wedges.

L-1.13) Install compression spring (4) onto upper mandrel (2).

L-1.14) Screw spring retaining ring (34) onto pulling head (1).

L-1.15) Screw pulling head (1) onto upper mandrel (2).

CAUTION5: Compression spring (4) will be compressed with spring tension against pulling head (1).

L-1.16) Screw set screws (37) into pulling head (1).

L-1.17) Moving to lower end of tool, screw gage ring (29) onto center coupling (10).

L-1.18) Assemble rubber mandrel assembly and install:

L-1.18.1) Install lower cone (16), elements (13, 14) and rubber spacers (12) onto rubber mandrel (11).

L-1.18.2) Install rubber mandrel assembly onto sealing mandrel (27). Screw rubber mandrel (11) into center coupling (10).

CAUTION7: Do not rip or tear o-ring during installation.

L-1.19) Screw J-slot mandrel (20) onto sealing mandrel (27).

L-1.20) Screw set screws (36) into J-slot mandrel (20).

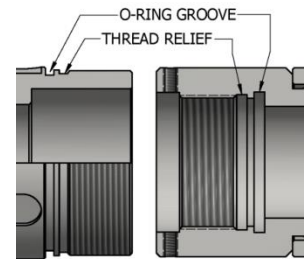


Fig. 3

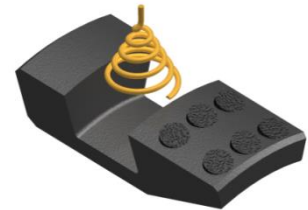


Fig. 4



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L) ASSEMBLY (cont'd)

L-1.21) Screw lower slip sleeve (32) onto rubber mandrel (11).

L-1.22) Screw set screws (36) into lower slip sleeve (32).

L-1.23) Assemble drag block body assembly and install:

L-1.23.1) Install lower slips (17) and lower slip springs (25) into drag block body (18). Wedge slips outward.

NOTE9: Install two (2ea) springs per slip (Fig. 5).

L-1.23.2) Install drag block body assembly onto lower slip sleeve (32). Remove wedges.

L-1.24) Screw rubber mandrel cap (19) onto lower slip sleeve (32).

L-1.25) Install drag blocks (22) and drag block springs (3) into drag block body (18). Compress drag blocks (22) with drag block assembly tool (T1).

NOTE10: Install six (6ea) springs per drag block (Fig. 6).

L-1.26) Install drag block retainer (21) onto drag block body (18) capturing ends of drag blocks (22).

L-1.27) Install retaining ring (31) onto body extension (28).

L-1.28) Screw body extension (28) into drag block body (18) (**NOTE4:** Left-hand threads). Move drag block retainer (21) as necessary to access threaded holes in drag block body (18).

L-1.29) Screw set screws (35) into drag block body (18). Release drag blocks (22).

L-1.30) Install J-pin body (23) onto J-slot mandrel (20).

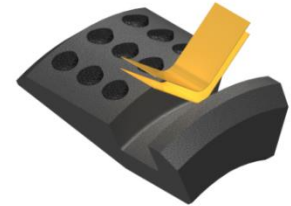
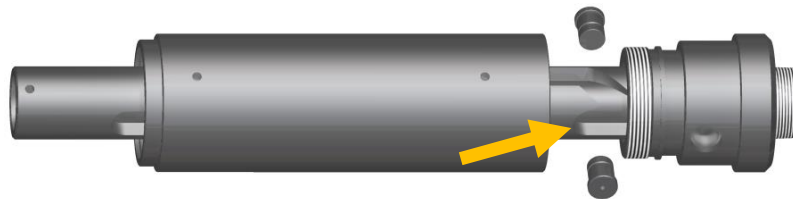


Fig. 5



Fig. 6

Fig. 7



L-1.31) Align holes in J-pin body (23) with lower tension shoulder of J-slot mandrel (20). Install J-pins (15) into J-pin body (23) (Fig. 7).

L-1.32) Slide drag block body assembly down and screw body extension (28) onto J-pin body (23) (**NOTE4:** Left-hand threads).

NOTE5: Drag block body assembly must be free to rotate.

L-1.33) Screw set screws (37) into body extension (28).

L-1.34) Screw changeover (39) onto J-slot mandrel (20).

L-2) Unclamp upper cone (9) from vise and remove assembled tool.



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M) PARTS LIST

ITEM	QTY	DESCRIPTION	MATERIAL	P/N 72571RR3-1XBEC
1	1	PULLING HEAD	DLMS110	72470711
2	1	UPPER MANDREL	DLMS110	72570212
3	24	DRAG BLOCK SPRING	-	9101900
4	1	COMPRESSION SPRING	DLMCRSP	72570920
5	1	PLUG	DLMS110	72570216
6	1	UPPER SLIP BODY	DLMS80	72471320
7	2	RELEASING SLIP	DLMS110	72571125
8	2	CARBIDE UPPER SLIP	DLMS110	72571115CMD
9	1	UPPER CONE	DLMS110	72470411
10	1	CENTER COUPLING	DLMS110	72570620
11	1	RUBBER MANDREL	DLMS110	72570220
12	2	RUBBER SPACER	DLMS35	72571840
13	1	ELEMENT	70 DURO NITRILE	72070511
14	2	ELEMENT	90 DURO NITRILE	72070513
15	2	J-PIN NOTE₁₁ : Shear value is stamped on J-pin.	DLMS110	72570870-25 (25,000#) 72570870-30 (30,000#) 72570870-35 (35,000#) 72570870-40 (STD 40,000#)
16	1	LOWER CONE	DLMS110	72571420
17	4	CARBIDE LOWER SLIP	DLMS110	60070135CMD
18	1	DRAG BLOCK BODY	DLMS35	60070335
19	1	RUBBER MANDREL CAP	DLMS110	72470230
20	1	J-SLOT MANDREL	DLMS110	72570230
21	1	DRAG BLOCK RETAINER	DLMS60	60070910
22	4	700 CARBIDE DRAG BLOCK	DLMSDB4	9070900C
23	1	J-PIN BODY	DLMS110	72570875
24	2	BONDED SEAL	90 DURO NITRILE	60045520
25	8	LOWER SLIP SPRING	-	7170901
26	4	UPPER SLIP SPRING	-	DL94830
27	1	SEALING MANDREL - HEAVY DUTY	DLMS110	72570213
28	1	BODY EXTENSION	DLMS110	72570370
29	1	GAGE RING	DLMS35	72571830
30	1	RETAINING RING	DLMS110	72570225
31	1	RETAINING RING	DLMS60	60070911
32	1	LOWER SLIP SLEEVE	DLMS110	72570912
33	1	UPPER SLIP PICKUP	DLMS110	72470345
34	1	SPRING RETAINING RING	DLMS110	72570820
35	3	5/16-18 UNC X 1/2 SOCKET SET SCREW	STEEL	SSS031C050



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M) PARTS LIST (cont'd)

ITEM	QTY	DESCRIPTION	MATERIAL	P/N 72571RR3-1XBEC
36	10	3/8-16 UNC X 3/8 SOCKET SET SCREW	STEEL	SSS037C037
37	6	3/8-16 UNC X 1/2 SOCKET SET SCREW	STEEL	SSS037C050
38	1	SMALLEY HEAVY DUTY INTERNAL RING	DLMSC	WHM-275
39	1	CHANGEOVER	DLMS110	CH-BAB-BEC-C
40	2	145 O-RING	90 DURO NITRILE	90145
41	1	234 O-RING	90 DURO NITRILE	90234
42	1	322 O-RING	90 DURO NITRILE	90322

REDRESS KIT (RDK)	72571050
ASSEMBLED WEIGHT	391 LBS

M-1) ELASTOMER TRIM OPTIONS

NOTE₁₂: For temperature range, refer to Elastomer Trim Temperature Guide.

M-1.1) HSN

ITEM	QTY	DESCRIPTION	MATERIAL	P/N 72571RRH3-1-XBEC
13	1	ELEMENT	70 DURO HSN	72070511H
14	2	ELEMENT	90 DURO HSN	72070513H
24	2	BONDED SEAL	90 DURO HSN	60045520H
40	2	145 O-RING	90 DURO HSN	90145H
41	1	234 O-RING	90 DURO HSN	90234H
42	1	322 O-RING	90 DURO HSN	90322H

REDRESS KIT (RDK)	72571050H
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M-1.2) VITON

ITEM	QTY	DESCRIPTION	MATERIAL	P/N 72571RRV3-1-XBEC
13	1	ELEMENT	70 DURO VITON	72070511V
14	2	ELEMENT	90 DURO VITON	72070513V
24	2	BONDED SEAL	90 DURO VITON	60045520V
40	2	145 O-RING	90 DURO VITON	90145V
41	1	234 O-RING	90 DURO VITON	90234V
42	1	322 O-RING	90 DURO VITON	90322V

REDRESS KIT (RDK)	72571050V
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AS RETRIEVABLE BRIDGE PLUG

RIGHT-HAND SET / RELEASE

7", HEAVY DUTY MANDREL, MINIMUM DAMAGE SLIPS, NC 38 TOOL JOINT

Manual No:
DL-725-7000-1652

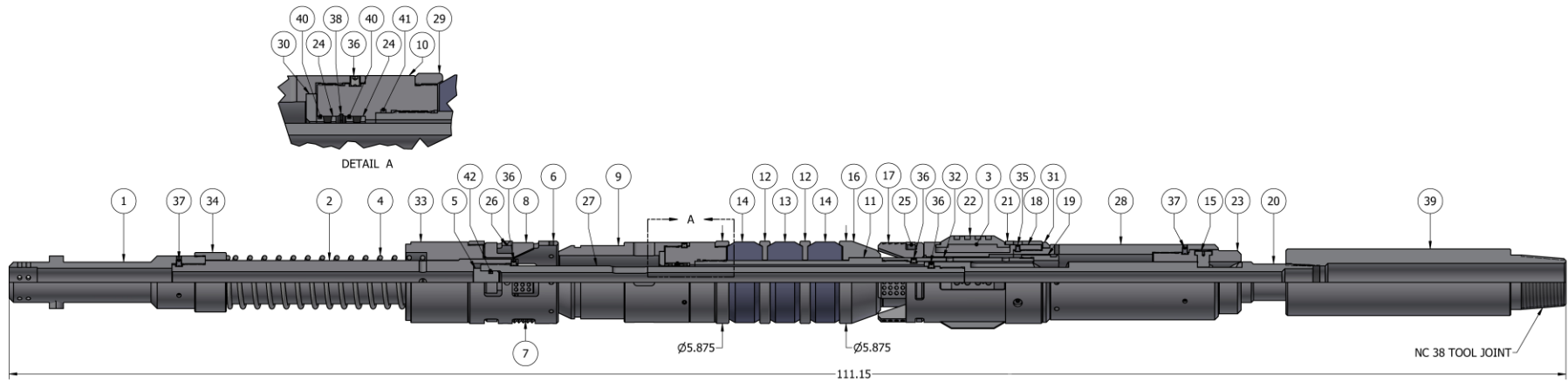
Revision: **A**

Revision Date:
02/15/2023

Authored by: *J.Anderson*

Approved by: *K.Plunkett*

N) TECHNICAL ILLUSTRATION



	AS RETRIEVABLE BRIDGE PLUG RIGHT-HAND SET / RELEASE 7", HEAVY DUTY MANDREL, MINIMUM DAMAGE SLIPS, NC 38 TOOL JOINT	Manual No: DL-725-7000-1652
		Revision: A
		Revision Date: 02/15/2023
<i>Authored by: J.Anderson</i>		<i>Approved by: K.Plunkett</i>

O) REVISION HISTORY

DATE	REVISION	DESCRIPTION OF CHANGES	REVISED BY	APPROVED BY
02/14/2023	A	Created manual	-	-