



ASI-X PACKER

8-5/8" X 2-7/8"

Manual No:
DL-603-8625-074

Revision: **E**

Revision Date:
01/06/2021

Authored by: *B.Mathis*

Approved by: *B.Oligschlaeger*

A) DESCRIPTION

The ASI-X Single String Double-Grip Production Packer is the most versatile of the mechanically set retrievable packers and may be used in any production application. This packer is suited for treating, testing, or injection applications, in pumping or flowing wells, either deep or shallow. This packer can be left in tension or compression depending on well conditions and the required application.

A large internal by-pass reduces swabbing when running and retrieving. The by-pass closes when the packer is set and opens prior to releasing the upper slips when retrieving to allow pressure equalization. The J-slot design allows easy setting and releasing; 1/4 turn right-hand set, 1/4 turn right-hand release.

The standard ASI-X Packer is designed for differential pressures up to 7,000 PSI (unless noted otherwise). This packer is also available in an HT version which is designed for differential pressures up to 10,000 PSI (unless noted otherwise). The HT version allows this packer to be utilized in completions where high pressure treating operations are performed and it is desirable to leave the tool in the well for production.

B) RELATED TOOLS (sold separately)

B-1)2-7/8" DT-2 On/Off Tool — refer to technical manual *DL-512-2875-146*.

B-2)2-7/8" Stinger—actual P/N varies depending on customer requirements.

C) SPECIFICATION GUIDE

CASING			TOOL		THREAD CONNECTION BOX UP / PIN DOWN	PART NUMBER
SIZE (INCHES)	WEIGHT (LBS/FT)	RECOMMENDED HOLE SIZE (INCHES)	GAGE OD (INCHES)	NOMINAL ID (INCHES)		
8-5/8	20.0 - 24.0	8.097 - 8.191	7.750	2.50	2-7/8 EUE	60384 60384H ¹ 60384V ² 60384C ³ 60384HC ⁴ 60384VC ⁵
	24.0 - 40.0	7.725 - 8.097	7.500	2.50	2-7/8 EUE	60385 60385H ¹ 60385V ² 60385C ³ 60385HC ⁴ 60385VC ⁵
	44.0 - 49.0	7.511 - 7.625	7.312	2.50	2-7/8 EUE	60386 60386H ¹ 60386V ² 60386C ³ 60386HC ⁴ 60386VC ⁵

Tool Options: ¹HSN, ²Viton, ³Nitrile, Carbide, ⁴HSN, Carbide, ⁵Viton, Carbide

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



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C) SPECIFICATION GUIDE (cont'd)

NOTE₁: Tools listed are right-hand set / right-hand release.

NOTE₂: Use of a Double Hook J-slot Packer is recommended when running with a pumpjack to help prevent the packer from unsetting during well production.

DIFFERENTIAL PRESSURE (MAX)	TENSILE LOAD THRU TOOL (MAX)
7,000 PSI	98,500 LBS

D) PRE-INSTALLATION INSPECTION PROCEDURES

CAUTION₁: 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 tools 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.

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 part information.

E) SETTING PROCEDURES

CAUTION₂: Do not run the tool without properly tightening connections. Running the tool with loose connections may damage the tool and cause malfunction.

E-1) COMPRESSION SET

Run the packer to setting depth. Pick up the work string to allow for setting stroke (12-13") plus desired work string load. Rotate the work string 1/4 right-hand turn at the packer, and then lower the work string while releasing torque. Slack off on the work string sufficient weight to set the packer (20,000 lbs minimum). Pull tension to assure that the upper slips are set. The work string can then be left in tension, compression or neutral. If insufficient weight is available to set the packer with compression, tension can be applied after slack-off to pack off the elements.



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E) SETTING PROCEDURES (cont'd)

E-2) TENSION SET

Run to setting depth, pick up on the work string and rotate 1/4 turn to the right at the packer then lower the work string slacking off available weight to set the packer lower slips. Pull tension to set upper slips and pack off elements (20,000 lbs minimum). After setting the packer, the tubing can be left in compression, tension or neutral.

F) RELEASING PROCEDURES

The releasing procedures are the same whether the packer has been tension or compression set. Set down weight on the packer to unseat the J-pin from the tension shoulder of the J-slot. Refer to the Pressure Affected Area Guide to determine necessary set down weight on the packer. Rotate the work string 1/4 right-hand turn at the packer and pick up while holding right-hand torque. Weight in addition to pipe weight may be required to pick up on packer - refer to Pressure Affected Area Guide. The internal by-pass will open, allowing pressure to equalize. After pressure is equalized, continue to pick up to release the upper slips, relax the elements and release the lower slips thus allowing the packer to be re-set or removed from the well.

In the event, the packer will not release in the normal manner, hard right-hand torque can be applied (800-1,000 Ft-lbs) which will break the tack weld on the J-pin ring. Continued rotation of approximately 15 turns will release the J-pin ring and allow the packer to be pulled. When released in this manner, the packer will reset when moved down the hole.

CAUTION: High differential pressure below the ASI-X Packer may cause the upper slips to wedge in tighter, requiring an extra amount of tension to release the upper slips.

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, and other stresses that could cause 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

PACKER SIZE (INCHES)	TUBING SIZE (INCHES)	PRESSURE AFFECTED AREA (SQ. INCHES)	
		ABOVE	BELOW
8-5/8	2.875	1.804 DOWN	3.616 UP

Example: Consider an 8-5/8" X 2-7/8" ASI-X Packer set on 2.875" tubing with a differential pressure of 3,000 PSI in the annulus around the tubing above the packer. How much force is 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 8-5/8" X 2-7/8" ASI-X Packer run on 2.875" tubing. In this example, the differential pressure from above the packer acts down on the seal area of the mandrel area across a pressure affected area of 1.804 in². Multiplying the differential pressure (3,000 PSI) by the pressure affected area (1.804 in²) results in a downward force of 5,412 lbs. 5,412 lbs is the amount of tension at the packer over tubing weight required to open the by-pass valve.



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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 (F°)
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	DRAW BLOCK ASSEMBLY TOOL	AT095110

K) DISASSEMBLY

NOTE₃: Ensure vise is capable of handling weight of tool.

NOTE₄: Support tool during disassembly and assembly with jack stands as necessary.

K-1) Clamp top sub (1) in vise.

K-1.1) Unscrew and remove set screws (34) from J-pin bottom sub (23). Move J-body (20) as needed.

K-1.2) Unscrew and remove J-pin bottom sub (23) from inner mandrel (2).

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

K-1.2.1) Remove o-ring (38) from J-pin bottom sub (23).

K-1.3) Compress drag blocks (22) with drag block assembly tool (T1).

K-1.4) Unscrew and remove set screws (35) from drag block body (18). Move drag block retainer (21) as needed.

K-1.5) Unscrew and remove J-body (20) from drag block body (18) (**NOTE₆:** Left-hand threads).

K-1.6) Remove drag block retainer (21) from drag block body (18).

K-1.7) Release drag blocks (22). Remove drag blocks (22) and drag block springs (3) from drag block body (18).

K-1.8) Unscrew and remove rubber mandrel cap (19) from rubber mandrel (11).

NOTE₇: For added leverage, insert rod through rubber retainer (15) and rubber mandrel (11) as needed.

K-1.9) Remove drag block body assembly and disassemble:

K-1.9.1) Unscrew and remove socket cap screws (36) from drag block body (18).

K-1.9.2) Wedge lower slips (17) outward (if needed). Remove the lower slip support (32).



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K) DISASSEMBLY (cont'd)

- K-1.9.3) Remove wedges. Remove lower slips (17) and lower slip springs (25) from drag block body (18).
- K-1.10) Unscrew and remove lower cone (16) from rubber retainer (15).
- K-1.11) Unscrew rubber mandrel (11) from center coupling (10).
- K-1.12) Remove rubber mandrel assembly and disassemble:
 - K-1.12.1) Remove gage ring (29), elements (13, 14), rubber spacers (12), and rubber retainer (15) from rubber mandrel (11).
- K-1.13) Unscrew and remove center coupling (10) from upper cone (9).
 - K-1.13.1) Remove o-ring (39) from center coupling (10).
 - K-1.13.2) Remove bonded seal (24) from center coupling (10).
 - K-1.13.2.1) Remove o-ring (37) from bonded seal (24).
- K-1.14) Remove upper cone (9) and bearing bushing (30) from inner mandrel (2).
- K-2) Unclamp and remove top sub (1) from vise. Clamp lower end of inner mandrel (2) in vise.

CAUTION4: Do NOT wrench or clamp on seal surface.

 - K-2.1) Unscrew and remove spring cage cap (27) from spring cage (5).

CAUTION5: Compression spring (4) is compressed with spring tension against upper slip body assembly.
 - K-2.2) Unscrew and remove top sub (1) from inner mandrel (2).
 - K-2.3) Remove compression spring (4) from spring cage (5).
 - K-2.4) Unscrew and remove spring cage (5) from upper slip support (33).
 - K-2.5) Remove spring retaining ring (28) from upper slip support (33).
 - K-2.6) Remove upper slip body assembly and disassemble:
 - K-2.6.1) Wedge releasing slip (7) and upper slips (8) outwards (if needed). Unscrew and remove upper slip support (33) from upper slip body (6).
 - K-2.6.2) Remove wedges (if needed). Remove releasing slip (7), upper slips (8), and upper slip springs (26) from upper slip body (6).
- K-3) Unclamp and remove inner mandrel (2) from vise.

L) ASSEMBLY

- NOTE2:** Ensure vise is capable of handling weight of tool.
- NOTE3:** Support tool during disassembly and assembly with jack stands as necessary.
- NOTE8:** 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 thread reliefs (Fig. 2).

- L-1) Clamp inner mandrel (2) in vise.

CAUTION4: Do NOT wrench or clamp on seal surface.

- L-1.1) Assemble upper slip body assembly and install:
 - L-1.1.1) Install spring retaining ring (28) into upper slip body (6).
 - L-1.1.2) Screw spring cage (5) into upper slip body (6).
 - L-1.1.3) Install upper slips (8), releasing slip (7), and upper slip springs (26) into upper slip body (6).
- NOTE9:** Install two (2ea) springs per slip (Fig. 3).

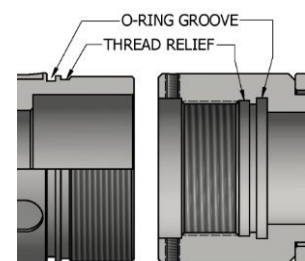


Fig. 2

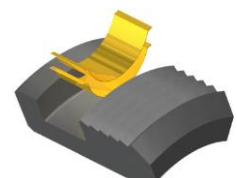


Fig. 3



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L) ASSEMBLY (cont'd)

L-1.1.4) Wedge releasing slip (7) and upper slips (8) outwards. Install upper slip body assembly onto upper slip support (33). Remove wedges.

L-1.1.5) Install upper slip body assembly onto inner mandrel (2).

L-1.2) Install compression spring (4) into spring cage (5).

L-1.3) Screw top sub (1) onto inner mandrel (2).

L-1.4) Screw spring cage cap (27) onto spring cage (5).

CAUTION: Compression spring (4) is compressed with spring tension against upper slip body assembly.

L-2) Unclamp and remove inner mandrel (2) from vise. Clamp top sub (1) in vise.

L-2.1) Install upper cone (9) and bearing bushing (30) onto inner mandrel (2).

L-2.2) Install o-ring (39) into o-ring groove in center coupling (10).

L-2.3) Install o-ring (37) into o-ring groove in bonded seal (24).

L-2.4) Install bonded seal (24) into center coupling (10).

CAUTION: Do not rip or tear o-ring or bonded seal during installation.

L-2.5) Screw center coupling (10) onto upper cone (9).

L-2.6) Assemble rubber mandrel assembly and install:

L-2.6.1) Install rubber retainer (15), elements (13, 14), rubber spacers (12), and gage ring (29) onto rubber mandrel (11).

L-2.6.2) Install rubber mandrel assembly onto inner mandrel (2) and screw into center coupling (10).

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

L-2.7) Screw lower cone (16) into rubber retainer (15).

L-2.8) Assemble drag block body assembly and install:

L-2.8.1) Install lower slips (17) and lower slip springs (25) into drag block body (18). Wedge slips outward.

NOTE: Install two (2ea) springs per slip (Fig. 4).

L-2.8.2) Install lower slip support (32) into drag block body (18).

L-2.8.3) Align holes in lower slip support (32) with threaded holes in drag block body (18). Screw socket cap screws (36) in drag block body (18).

L-2.8.4) Install drag block body assembly onto rubber mandrel (11).

L-2.9) Screw rubber mandrel cap (19) onto rubber mandrel (11).

NOTE: For added leverage, insert rod through rubber retainer (15) and rubber mandrel (11) as needed.

L-2.10) Install drag blocks (22) and drag block springs (3) into drag block body (18). Compress blocks with drag block assembly tool (T1).

NOTE: Install six (6ea) springs per drag block (Fig. 5).

L-2.11) Install drag block retainer (21) onto drag block body (18) to capture ends of drag blocks (22). Align holes in drag block retainer (21) with threaded holes in drag block body (18).

L-2.12) Install retainer ring (31) onto J-body (20).

L-2.13) Screw J-body (20) into drag block body (18) (**NOTE:** Left-hand threads).

L-2.14) Screw set screws (35) into drag block body (18). Release drag blocks (22).

L-2.15) Install o-ring (38) into o-ring groove in J-pin bottom sub (23).

L-2.16) Screw J-pin bottom sub (23) onto inner mandrel (2).

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

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



Fig. 4

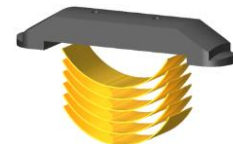


Fig. 5

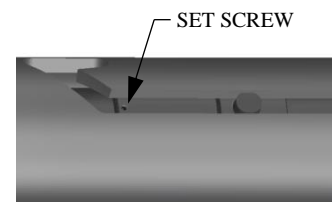


Fig. 6



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L) ASSEMBLY (cont'd)

- L-2.17) Screw set screws (34) into J-pin bottom sub (23). Move J-body (20) as needed to access threaded holes (Fig. 6).
- L-2.18) Move J-body (20) and drag block body assembly as needed to position J-pin in running position in J-slot (Fig. 7).
- L-3) Unclamp top sub (1) from vise and remove assembled tool.

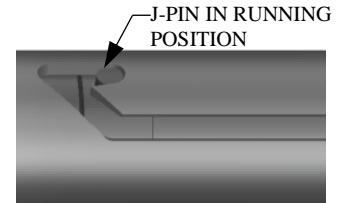




Fig. 7

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M) PARTS LIST

ITEM	QTY	DESCRIPTION	MATERIAL	P/N 60384	P/N 60385	P/N 60386
1	1	TOP SUB	DLMS80	60170610		
2	1	INNER MANDREL	DLMS41X80	60370210		
3	36	DRAG BLOCK SPRING	-	9101900		
4	1	COMPRESSION SPRING	DLMCRSP	60370920		
5	1	SPRING CAGE	DLMS60	60170310		
6	1	UPPER SLIP BODY	DLMS80	60384320	60385320	60386320
7	1	RELEASING SLIP	DLMS110	60085125		
8	2	UPPER SLIP	DLMS35	60085115		
9	1	UPPER CONE	DLMS60	60384410	60375410	60386410
10	1	CENTER COUPLING	DLMS35	60370620		
11	1	RUBBER MANDREL	DLMS35 / DLMS60	60385220		
12	2	RUBBER SPACER	DLMS35	60284840	60285840	60286840
13	1	ELEMENT	70 DURO NITRILE	60284511	60285511	60286511
14	2	ELEMENT	90 DURO NITRILE	60284513	60285513	60286513
15	1	RUBBER RETAINER	DLMS35	60284850	60285850	60286850
16	1	LOWER CONE	DLMS35	60385421		60386421
17	4	LOWER SLIP	DLMS35	60085135		
18	1	DRAG BLOCK BODY	DLMS35	60084335	60085335	60086335

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M) PARTS LIST (cont'd)

ITEM	QTY	DESCRIPTION	MATERIAL	P/N 60384	P/N 60385	P/N 60386
19	1	RUBBER MANDREL CAP	DLMS60	60170230		
20	1	J-BODY	DLMS60	60170340		
21	1	DRAG BLOCK RETAINER	DLMS60	60084910	60085910	60086910
22	6	DRAG BLOCK	DLMSDB8	9070900		
23	1	J-PIN BOTTOM SUB	DLMS110 / DLMS80	60370650		
24	1	BONDED SEAL	90 DURO NITRILE	60070520		
25	8	LOWER SLIP SPRING	-	7170901		
26	6	UPPER SLIP SPRING	-	7170902		
27	1	SPRING CAGE CAP	DLMS35	60170810		
28	1	SPRING RETAINING RING	DLMS60	60070820		
29	1	GAGE RING	DLMS35	60284830	60285830	60286830
30	1	BEARING BUSHING	DLMS60	60370224		
31	1	RETAINING RING	DLMS35	60085911		
32	1	LOWER SLIP SUPPORT	DLMS60	60384912	60385912	60386912
33	1	UPPER SLIP SUPPORT	DLMS60	60084880	60075880	60086880
34	2	SET SCREW 1/4-20 UNC X 3/8	STEEL	SSS025C037		
35	3	SET SCREW 5/16-18 UNC X 1/2	STEEL	SSS031C050		
36	3	SOCKET CAP SCREW 5/8-11 UNC X 1"	STEEL	SCS062C100		
37	1	153 O-RING	90 DURO NITRILE	90153		

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M) PARTS LIST (cont'd)

ITEM	QTY	DESCRIPTION	MATERIAL	P/N 60384	P/N 60385	P/N 60386
38	1	233 O-RING	90 DURO NITRILE	90233		
39	1	242 O-RING	90 DURO NITRILE	90242		

ASSEMBLED WEIGHT		418 LBS	399 LBS	390 LBS
REDRESS KIT (RDK)		60384050	60385050	60386050


M-1) ELASTOMER TRIM OPTIONS

NOTE11: For temperature range, refer to Elastomer Trim Temperature Guide.

M-1.1) HSN

ITEM	QTY	DESCRIPTION	MATERIAL	P/N 60384H	P/N 60385H	P/N 60386H
13	1	ELEMENT	70 DURO HSN	60284511H	60285511H	60286511H
14	2	ELEMENT	90 DURO HSN	60284513H	60285513H	60286513H
24	1	BONDED SEAL	90 DURO HSN	60070520H		
37	1	153 O-RING	90 DURO HSN	90153H		
38	1	233 O-RING	90 DURO HSN	90233H		
39	1	242 O-RING	90 DURO HSN	90242H		

REDRESS KIT (RDK)		60384050H	60385050H	60386050H
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M) PARTS LIST (cont'd)

M-1.2) VITON

ITEM	QTY	DESCRIPTION	MATERIAL	P/N 60384V	P/N 60385V	P/N 60386V
13	1	ELEMENT	70 DURO VITON	60284511V	60285511V	60286511V
14	2	ELEMENT	90 DURO VITON	60284513V	60285513V	60286513V
24	1	BONDED SEAL	90 DURO VITON	60070520V		
37	1	153 O-RING	90 DURO VITON	90153V		
38	1	233 O-RING	90 DURO VITON	90233V		
39	1	242 O-RING	90 DURO VITON	90242V		

REDRESS KIT (RDK)		60384050V	60385050V	60386050V
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M-2) CARBIDE OPTIONS

ITEM	QTY	DESCRIPTION	MATERIAL	P/N 60384C	P/N 60385C	P/N 60386C
8	2	CARBIDE UPPER SLIP	DLMS35	60085115C		
17	4	CARBIDE LOWER SLIP	DLMS35	60085135C		
22	6	CARBIDE DRAG BLOCK	DLMSDB8	9070900C		



ASI-X PACKER

8-5/8" X 2-7/8"

Manual No:
DL-603-8625-074

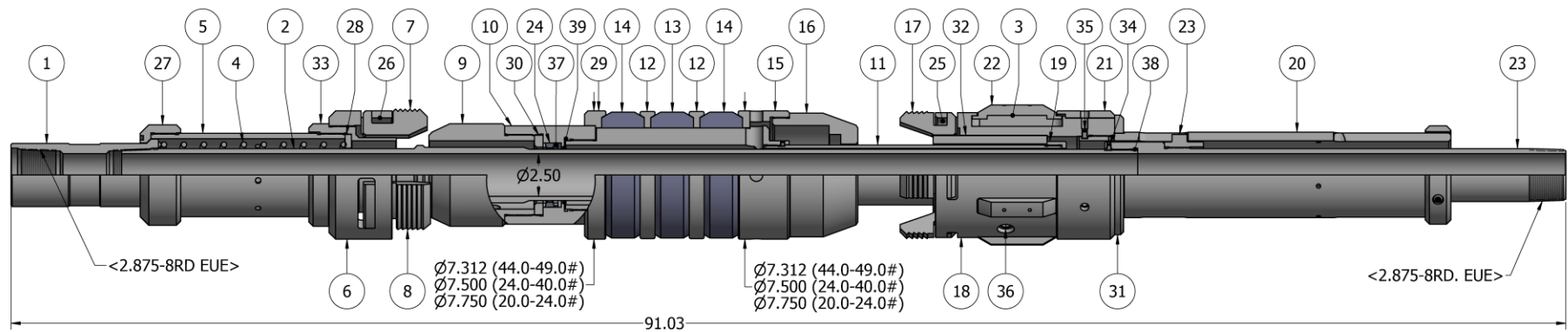
Revision: **E**


Revision Date:
01/06/2021

Authored by: B.Mathis

Approved by: B.Oligschlaeger

N) TECHNICAL ILLUSTRATION



	ASI-X PACKER	Manual No: DL-603-8625-074
	8-5/8" X 2-7/8"	Revision: E
		Revision Date: 01/06/2021
Authored by: <i>B.Mathis</i>		Approved by: <i>B.Oligschlaeger</i>

O) REVISION HISTORY

DATE	REVISION	DESCRIPTION OF CHANGES	REVISED BY	APPROVED BY
01/06/2021	E	Removed tool drift ID; Added carbide options; Revised elastomer trim temp. ratings, 60170610 was 60070610, 60170310 was 60370310, 60170230 was 60070230, 60170340 was 60370340, 60170810 was 60070810	J.Anderson	E.Visaez
01/16/2015	D	Added – Related Tools, P/N's 60384, 60384H, 60384V, Options P/N's 60385H, 60386V, 60386H, 60386V, Drift ID, NOTE ₂ - use of double hook J-slot packers, Tensile Load Thru Tool, Pre-Installation Inspection Procedures, Fig. 1, CAUTION ₂ , Storage Procedures, Recommended Hand Tools, NOTE ₃ , NOTE ₄ , Fig. 2, 3, 4, 5, 6, 7, L-2.1.8, NOTE ₉ , NOTE ₁₀ , HSN Option Parts List (60384H, 60385H, 60386H), Viton options (60384V, 60385V, 60386V), Revision History; Revised – Description, Releasing Procedures, Pressure Affected Area Guide – Pressure Below was 3.387 UP, ELASTOMER TRIM TEMPERATURE GUIDE was ELEMENT SELECTION GUIDE, Special Tools – P/N AT095110 was AT010110, Weight for P/N 60386 was 391 Lbs, 153 O-RING was 152 O-RING (P/N 90153 was 90152, P/N 90153H was 90152H, P/N 90153V was 90152V), Technical Illustration:	B.Mathis	R.Dyer