Society of Petroleum Engineers Drilling Systems Automation Technical Section (DSATS) International University Competition 2018 – 2019

Drillbotics™ Guidelines

Revised 25 November 2018

1. Introduction

This year marks the fifth competition for the title of Drillbotics champion and a chance for students to learn about the drilling process from industry experts and for winning team(s) to travel and present a paper at the next SPE/IADC Drilling Conference and at an event organized by DSATS. The past years involved undergraduates, masters and doctoral students from a variety of disciplines who built innovative drilling machines and downhole tools while developing a deeper understanding of automating the drilling process. The university teams freely share lessons learned, which more rapidly advances the science of drilling automation. Everyone involved claims to have had a lot of fun while learning things that are not in the textbooks or published papers. Students also participated in related events at conferences, workshop meetings and networking with industry leaders in drilling automation. This year's contest promises to be just as challenging and hopefully as much fun.

How did the competition first come about? The origins began in 2008 when a number of SPE members established the Drilling Systems Automation Technical Section (DSATS) help accelerate the uptake of automation in the drilling industry. DSATS' goal was to link the surface machines with downhole machines, tools and measurements in drilling systems automation (DSA), thereby improving drilling safety and efficiency. Later, at an SPE Forum in Paris, the idea of a student competition began to take shape. A DSATS sub-committee was formed to further develop the competition format and guidelines. Several universities were polled to find out the ability of academic institutions to create and manage multi-disciplinary teams. The Drillbotics committee began small in 2014-2015 to see if the format could succeed. With fine tuning, we continue along those lines as we start the 2019 process.

Version	Date	Section	Description
2019.01	10 Sept 2018	All	New Challenge, updated drillbit and formation, mandatory sensor requirements
2019.02	19 Nov 2018	3.1, 3.2, 3.4, 3.5, 3.7, 3.15, 8.2, Appendix A"	Modification to directional drilling target/objective/scoring, add details to bit specifications
2019.3	25 Nov 2018	3.6 3.7 7.0	Renumber section, allow for pilot hole and revise shipping info Bit diameter Timeline to reflect co-located tests

The 2019 competition has a few changes worth highlighting here:

- During previous competitions, the main focus was autonomously dealing with drillstring mechanics. Of course, this remains a concern, but the new test will focus on autonomous directional drilling.
- The 2019 rock sample shall be a homogeneous sandstone of known strength. Strength valuation will be provided well in advance of the competition date by the Drillbotics committee.
- Closed loop control of the rig based on downhole data is mandatory in this year's competition, not integrating this data set into the control algorithm is considered a "F - Failing grade" in this year's competition.
- Teams will kick off from vertical and are required to exit the rock sample within a defined target area, obtaining as much displacement as possible from well center along the north axis of the rock sample.
- The drill bit will be increased in diameter from last year's competitions by 1/8". Details will be provided via a post to the Drillbotics blog once the design is complete.
- Teams can choose to compete in Group B Competition, which would use the prior year's rules/guidelines.
- The competition is to take place at a single industry facility in the USA and another facility in Europe. All teams are permitted to attend the presentations and Q&A of the other teams. All competitors at each location will start drilling at the same time.
- To attain a higher rating by the judges, the Phase I report should include a summary paragraph or table in the design report containing details of the control algorithm proposed. See section 4.3.5.2.3. This should be updated for the Phase II presentation to judges at the on-site test.
- The 2019 design should allow for third-party plug and play interface. See section 4.14.4. This is optional for 2019, but it will likely be mandatory in 2020.

The DSATS technical section believes that this challenge benefits students in several ways. Petroleum, mechanical, electrical and control engineers gain hands-on experience in each person's area of expertise that forms a solid foundation for post-graduate careers. They also develop experience working in multi-disciplinary teams, which is so important in today's technology driven industries. Winning teams must possess a variety of skills. The mechanical and electrical engineers need to build a stable, reliable and functional drilling rig. Control engineers need to architect a system for real-time control, including selection of sensors, data handling and fast-acting control algorithms. The petroleum engineers need an understanding of drilling dysfunctions and mitigation techniques. Everyone must work collectively to establish system functional requirements understood by each team member, properly model the drilling issues, and then to create a complete package working seamlessly together.

The oil and gas industry today seeks lower costs through efficiency and innovation. Many of the student competitors may discover innovative tools and control processes that will assist drillers to speed the time to drill and complete a well. This includes more than faster ROP, such as problem avoidance for dysfunctions like excessive vibrations, stuck pipe, and wellbore stability issues. Student teams built new downhole tools using 3D printing techniques of designs that would be difficult, if not impossible to machine. They used creative hoisting and lowering systems. Teams modeled drilling performance in particular formations and adjusted the drilling parameters accordingly for changing downhole conditions. While they have a lot to learn yet about our business, we have a lot to learn about their fresh approach to today's problems. Good Luck!

the DSATS Drillbotics Committee

Shashi Talya	(chair)	Pat Derkacz	Joachim Oppelt
Aaron Logan	(co-chair)	Frode Efteland	Neil Panchal
Fred Florence	(co-chair)	James Franks	Luis Pereira
Trey Adams		Jana Hochard	Marco Perez
Víctor Hugo Soriano Arámbulo		Mark Hutchinson	Bhavesh Ranka
Mike Attrell		Jayesh Jain	Geir Skaugen
Vimlesh Bavadiya		John Macpherson	Sami Sultan
Sylvian Chambon		George Michalopulos	Majid Tariq
John Clegg		Alex Ngan	Suresh Venugopal
Dmitriy Dashevskiy		Nii Nunoo	Kurt West

Contents

1. Introduction 1
2. *Background* 5
3. *Competition Guidelines* 6
   - 3.1. Problem statement for the 2018-2019 competition: 6
   - 3.2. 2018-2019 High Level Challenge and Judging Changes 6
   - 3.3. Two Project Phases 8
   - 3.4. Phase I – Design Competition 9
   - 3.5. Phase II – Drilling Competition 12
   - 3.6. Rock Samples 13
   - 3.7. Bits 14
   - 3.8. Drillpipe 16
   - 3.9. Tool joints 17
   - 3.10. Bit sub/drill collar/stabilizers 17
   - 3.11. Automated Drilling 18
   - 3.12. Sensors 18
   - 3.13. Data collection and handling 18
   - 3.14. Data visualization 18
   - 3.15. Measure and analyze the performance 19
   - 3.16. The test well: 20
   - 3.17. Not included in the 2018-2019 competition 20
   - 3.18. Presentation to judges at Phase II Testing 20
   - 3.19. Project report 21
   - 3.20. Final report and paper 22
4. *Team Members* 23
5. *Expenditures* 24
6. *Other Considerations* 25
7. *Project Timeline* 26
8. *Evaluation Committee* 27
9. *Group A Prizes* 28
10. *Group B Prizes* 29
11. *Terms and conditions* 29
12. *Marketing* 30

Appendix 31

A. *Directional Objective Scoring* 31

Objectives for the 2019 Competition

1.1. During the school year beginning in the fall of 2018, a team of students will organize themselves to solve a drilling related problem outlined in item 3 below. The team should preferably be a multi-disciplinary team that will bring unique skills to the group to allow them to design and construct hardware and software to demonstrate that they understand the underlying physics, the drilling issues and the usual means to mitigate the issues. We cannot stress enough the need to involve students with different technical training and backgrounds. They will need to develop skills to understand drilling dysfunctions and mitigation strategies, but they must also have the mechanical engineering capabilities to design the rig/drilling package. In past years, some entrants have not adequately considered the control network and algorithms needed for autonomous drilling. They have often misunderstood the need for calibrated sensors and fast, accurate data handling. All of this and more is needed to build and operate a complete automated drilling system.

1.2. The students could produce novel ideas leading to new drilling models, improved drilling machines and sensors, and the ability to integrate the data, models and machines that will hopefully create new, more efficient ways to drill wells in the future. Any such innovation will belong to the students and their university in accordance with the university's written policies. DSATS and SPE waive any claims to students' intellectual property.

1.3. The students, working as a multi-disciplinary team, will gain hands-on experience that will be directly applicable to a career in the upstream drilling industry.

2. Background

2.1. What is DSATS?

2.1.1. DSATS is a technical section of the Society of Petroleum Engineers (SPE) organized to promote the adoption of automation techniques using surface and downhole machines and instrumentation to improve the safety and efficiency of the drilling process. More information is available about DSATS at the DSATS homepage (http://connect.spe.org/DSATS/Home/).

2.1.2. The Drillbotics website at www.Drillbotics.com includes official updates to the competition guidelines and schedule, as well as FAQs, photos, and previous entrants' submittals and reports. Any updates to the guidelines posted on the Drillbotics website via blog entries from the

Committee is considered to be an official revision to these Guidelines. Questions and suggestions can be posted there, or teams can email the sub-committee at 2019@Drillbotics.com.

2.2. Why an international competition?

2.2.1. DSATS, as part of the SPE, is a group of volunteers from many nations, connected by their belief that drilling automation will have a long-term, positive influence on the drilling industry. This diversity helped to shape the direction of the organization. The group feels that the industry needs to attract young professionals from all cultures and disciplines to advance drilling practices in all areas of the world. The winners of the Group A competition will receive a grant for economy class transportation and accommodations to attend the next SPE Drilling Conference and will present an SPE paper that will be added to the SPE archives of One Petro[1]. Winners of Group B will publicly receive recognition of their achievement, and have the opportunity to publish an SPE paper that will be added to the SPE archives of One Petro. DSATS believes recognition at one of the industry's leading technical conferences will help encourage student participation. Also, the practical experience with drilling automation systems increases the students' visibility to the companies that are leading automation activities.

3. Competition Guidelines

3.1. Problem statement for the 2018-2019 competition:

Design a rig and related equipment to autonomously drill a well, using downhole sensors, that obtains as much horizontal displacement from surface as possible along the rock's "north" direction, as quickly as possible while maintaining borehole quality and integrity of the drilling rig and drillstring.

3.2. 2018-2019 High Level Challenge and Judging Changes

3.2.1. The competition will take place on the same day for all teams in North America, and the same day (likely different from the North American teams) for all teams in Europe

3.2.1.1. The competition will take place at a facility capable of hosting all drilling rigs at the same time, and capable of having all drilling rigs start drilling at the same time (Group A and B)

3.2.2. Inclination and Azimuth directionality is part of the competition for 2019

[1] Publication is subject to the SPE program committee's acceptance of the abstract/paper. If the abstract is not accepted, DSATS will solicit other SPE events try to get the paper into OnePetro.

3.2.2.1. Downhole sensors are mandatory, and mandatory to implement into the control algorithm of the rig

3.2.2.2. A severe penalty will be applied to teams who do not use downhole sensors

3.2.3. Wellbore must be started vertically

3.2.3.1. Teams must pre-drill a 4" deep pilot hole, measured from the rock' top face

3.2.3.1.1. Location of the Pilot hole should be on the centerline of the upper face of the block, 6" from the North or South edge

3.2.3.2. Teams will kick off from vertical at any depth below the TD of the pilot hole

3.2.4. Homogeneous sandstone Rock Sample 12"x24"x24" provided by Drillbotics

3.2.4.1. Sandstone compressive strength will be provided to students by Drillbotics

3.2.4.2. Block will be oriented so that it rests on a 12"x24" face

3.2.5. Student rig orientation of the Rock Sample required to be in the North/South direction

3.2.5.1. Location of drilling to be conducted indoors, in a location that does not have an unusually distorted magnetic field

3.2.6. BHGE to provide a new bit with 1/8" larger diameter (1.25" new diameter) and 2" length.

3.2.7. Students are permitted to use their own drillbit for the 2019 competition

3.2.8. Teams are required to exit the Rock Sample as far away from the well center as possible, scoring more points if the displacement is in the north direction along the centerline of the rock (see Appendix "A" for scoring details)

3.2.9. Closed loop control of the rig based on downhole data is mandatory in this year's competition, not integrating this data set into the control algorithm is considered a "F- Failing grade" in this year's competition

3.2.10. Use 2018 (prior year) rules for Group B Competition, and those that compete in the Group A will be held to the 2019 challenge of directional drilling

3.2.10.1. Students can choose which Group they will compete in within one weeks' notice of the drilling competition date, newcomers are not limited from competing in Group A – each team can decide for themselves

3.2.10.2. The "big prize" will be for the Drillbotics challenge Group A

3.2.10.2.1. SPE Whitepaper published, economy class transportation and accommodations to attend the next SPE Drilling Conference, and rig presented at the drilling conference

3.2.10.3. The Group B prize will have their SPE Whitepaper published, and recognition of the accomplishment at the conference

3.2.11. Judging of the competition Challenge will be based on the following:

3.2.11.1. All rigs start the drilling competition at the same time (Group A and Group B)

3.2.11.2. Target of exit is a primary judging metric, landing within the defined target area scoring points as described in Appendix "A"

3.2.11.3. The ability to "run casing" is the secondary judging metric. Judges will run a "flexible" casing used as a gauge of borehole quality

3.2.11.4. Time will be stopped after 3 hours

3.2.11.5. No lateral forces may be applied above the rock face

3.3. Two Project Phases

Fall Semester 2018

The first phase of the project is to organize a team to design an automatic drilling machine to solve the project problem. It is not necessary to build any equipment in this phase, but it is okay to do so. Design considerations should include current industry practices and the team should evaluate the advantages and shortcomings of today's devices. The design effort may be assisted by university faculty, but the students are encouraged to introduce novel designs for consideration. The level of student, faculty and technical staff involvement shall be reported when submitting the design. For returning teams, the Phase I Design should include an analysis of data and learnings from previous ("offset") wells drilled.

Spring Semester 2019

During the second phase, the finalist teams selected by DSATS proceed to the construction and drilling operation will use the previous semester's design to build an automated drilling machine. As per industry practices, it is common during construction and initial operations to run into

problems that require a re-design. The team may change the design as needed in order to solve the problem subject to section 4.3.4. Teams may use all or part of a previous year's rig.

3.4. Phase I – Design Competition

Design an automated drilling machine in accordance with the rules below.

3.4.1. DSATS envisions a small (perhaps 2 meters high) drilling machine that can physically imitate the functionality of full-scale rig machinery. (Since the winning machines will be presented at the SPE conference, there may be height restrictions imposed by the conference facility, so machines that are too tall may not be allowed on the exhibit floor.) The machine will be the property of the university and can be used in future research and competitions. New and novel approaches that improve on existing industry designs are preferred. While innovative designs are welcome, they should have a practical application to drilling for oil and gas.

3.4.2. The drilling machine will use electrical power from the local grid not to exceed 25 horsepower. Lower power consumption resulting from energy efficient designs will receive additional consideration.

3.4.3. The design must provide an accurate and continuous measurement of Weight-On-Bit (WOB), inclination, azimuth, and depth; as well as other drilling parameters, that should be presented as a digital record across the period of the test. Appropriate statistical measurements should be made at frequencies and with an accuracy and appropriate frequency content for the dynamics of the drilling system both at surface and downhole. Discussion of such choices should be included in the design report.

3.4.4. The proposed design must be offered in Phase I of the project, but changes are allowed in Phase II, as long as they are reported to the Committee via students' monthly reports. A summary of all significant changes, including the reason modifications were necessary, must be included in the students' final report.

3.4.5. Design submittal by the students shall include:

3.4.5.1. Engineering drawings of the rig concept, mechanical and electrical and auxiliary systems, if any

3.4.5.2. Design notes and calculations

3.4.5.2.1. All engineering calculations shall be included in the Phase I report, even if the rig is built using previous years' designs. This ensures that the 2019 team reviewed and understood the previous design assumptions and calculations.

Calculations should include each formula considered in the design, a reference that shows the origins of the formula, why is was chosen, what engineering assumptions were made, a definition of all variables and the values used in the calculation.

Example

Buckling limit	Euler's Equation	(1) cite a reference here or in the reference section of your design report

The critical buckling load, bcr, is calculated:

$$Pbcr = \pi 2 * E * I / (K * L)^2$$

$Pbcr$: Critical buckling load

E: Modulus elasticity of the aluminum drill pipe

I: Area moment of inertia

L: Length of the column

K: Column effective length factor (explain how you chose the appropriate k or n factor)

3.4.5.2.2. The report should include a table that summarizes ALL calculations.

Example

Calculations	***Formula***	***Reference***	***Results***
Moment of Inertia	$I = \pi / 64\ (dp\ 4 - idp\ 4)$	*Thin wall approx. or ID/OD calc separately or other? List your reference*	$0.000546\ in4$
Buckling Limit	$Pbcr = \pi 2 * E * I / (K * L)^2$	*Euler's Eq*	$18.9\ kg$

3.4.5.3. Control system architecture. (The response time of measurements, data aggregation and control algorithms should be estimated.)

3.4.5.4. Key features for any models and control software.

3.4.5.5. Proposed data handling and display.

3.4.5.6. Specification for sensors, signal processing and instrumentation, (verifying their accuracy, precision, frequency response and environmental stability), including the methods planned for calibration before and after the Phase II testing.

3.4.5.7. Plan for instrumentation of sensors in the BHA, as well as a method to synchronize all measurements and utilize both the surface and downhole sensors for real-time control of the drilling process.

3.4.5.8. An explanation of the implementation of the output of the BHA sensors to improve the trajectory of the wellbore, drilling efficiency and other drilling concerns.

3.4.5.9. An explanation of the algorithm used to autonomously control the drilling rig based on the output of the BHA sensors

3.4.5.10. An explanation of the principles being applied to directionally steer the wellbore into the defined target area (see Appendix "A") with the intent to score the maximum amount of points

3.4.5.11. Cost estimate and funding plan

3.4.5.12. A design summary video used to outline the design submittal not to exceed five (5) minutes in length. Videos shall be the property of the university, but DSATS shall have the rights to use the videos on its websites and in its meetings or events.

3.4.5.13. All design, construction and operation of the project are subject to the terms and conditions of section 11.

3.4.5.14. A safety case shall be part of the Phase I design. Include a review of potential hazards during the planned construction and operation of the rig, and for the unloading and handling of any rock samples or other heavy items. An example of a safety case will be posted on the Drillbotics.com website.

3.4.6. A committee of DSATS members (the Committee) will review the Phase I designs and select the top five (5) teams[2] who will progress to Phase II of the competition.

3.4.7. DSATS shall also award a certificate of recognition and publication on its website for the most innovative design. The design video will also be shown at the DSATS automation symposium at SPE conferences.

3.4.8. DSATS will not fund any equipment, tools, software or other material, including labor, for the construction of the rig. Student teams are encouraged to find external funding from industry participants and suppliers.

3.5. Phase II – Drilling Competition

3.5.1. In the spring term of 2019, qualifying teams will build the rig and use it to drill rock samples provided by DSATS. Drilling a well, deviated toward the defined target area (see Appendix "A"), efficiently though the sample while controlling drilling dysfunctions is the primary technical objective of the competition. The exit point of the drillbit will be judged based on how much displacement from well center is obtained, with weighting applied according to the direction of the displacement. The use of both surface and downhole measurements to control the drilling process in real-time is mandatory, failure to do so will result in a failing grade. To avoid disqualification due to a downhole sensor failure, redundant or immediately replaceable items should be part of the design and implementation. Time to replace a sensor will be added to the drilling time for calculation of ROP.

3.5.2. The teams are to pre-drill a vertical pilot hole 4" deep measured from the rock's top face, this hole is to be drilled using the competition drilling rig

3.5.2.1. Location of this pilot hole should be on the centerline of the upper face of the block, and located 6" from the North or South edge

3.5.2.2. Teams competing in Group A will be required to kick off from the vertical pilot hole, at any depth below the TD of the pilot hole

[2] The number of finalists could be increased or decreased by the DSATS Board of Directors subject to available funding.

3.5.3. Once drilling commences, the test will continue until the drillbit exits the rock sample, or three (3) hours, whichever comes first.

3.5.4. Drilling performance will be observed and measured by DSATS members invited to attend and witness the test.

3.5.5. No lateral forces are allowed to be applied above the rocks top face

3.5.6. No forces are allowed to be applied external to the rock that will force the drillbit in a particular direction

3.5.7. External magnetic field effects from the drilling rigs will be present on the directional sensors used to drill the wellbore, the industry has accepted practice of magnetic ranging, this may be a technique of use worth investigating to improve the signal to noise of magnetic measurements

3.5.8. DSATS will judge the competitors primarily on their ability to obtain as much displacement from well center as possible along the north axis of the rock sample; closer proximity to this axis and larger amounts of displacement point receives higher marks in this category (see Appendix "A" for details)

3.5.9. DSATS will run a flexible "casing" into the wellbore, and use this to gauge the borehole quality

3.5.9.1. Casing will be nearly equal in diameter to the 1.25" drillbit

3.5.9.2. An over gauge, and under gauge Casing will also be used as a no-go measurement

3.5.10. The final test will be scheduled late in the school year or soon after graduation. The test will occur at two locations, so teams must allow time to ship their rig from their university in accordance with the timeline per section 7 below.

3.6. Rock Samples

3.6.1. DSATS will prepare a set of nearly identical homogeneous sandstone samples appx. 12"W x 24"L x 24"H (30 x 60 x 60 cm) that will be shipped to each test site. It will not be sent to the schools. A smaller sample could be provided (no smaller than 12"W x 12"L x 24"H), which will be announced not later than March 1st.

3.6.2. The rock sample will be homogeneous sandstone, and rock compressive strength values will be provided for the sandstone samples furnished by DSATS. The Drillbotics committee will mark the

surface of rock to indicate the well center where drilling will start. It will be located at the intersection of two lines drawn from opposite corners of the rock sample.

3.6.3. The university and/or students may acquire or produce rock samples as needed to verify the design and allow students to practice using their machine prior to the test. Drilling of the samples provided by DSATS prior to Phase II testing is not allowed and could lead to disqualification, except for the pilot hole. A pilot hole may be pre-drilled when rigging up at the test site, but it must be less than 1 inch deep.

3.6.4. The sandstone sample will be oriented during drilling so that it rests on a 12”x24” face

3.6.5. Teams may use glue or use a mechanical fastener to attach a bell nipple or diverter housing to the top of the rock to allow connection of a flowline for return mud flow. If you use a fastener, be careful not to break the rock.

3.7. Bits

3.7.1. Upon request, DSATS will send a drillstring and bit to the finalist teams for use in Phase II. It is expected that the BHA and pipe will cause some difficulty, both for causing drilling dysfunction and for sensor integration and data telemetry. The judges will look for creative concepts supported by sound reasoning showing an understanding of how the BHA, bit and drillstring function together, and how the downhole system measures, samples and transmits the drilling data.

3.7.2. Upon request, the bit shall be returned to the Committee following Phase II testing for reconditioning for use in future competitions.

3.7.3. One (1) PDC bit will be provided by DSATS to be used during the Phase II tests. For 2018-2019 the bit will be:

3.7.3.1. A micro-bit 1.25" in (31.75 mm) diameter and 2.0” in total length.

3.7.3.2. Low axial aggressiveness and high side aggressiveness (i.e. high bit anisotropy).

3.7.3.3. An error when posting information about the bit diameter may have led to confusion and could affect teams who designed equipment based on the erroneous diameter. Therefore, teams may substitute a bit of their own design or a purchased bit not to exceed 1.5 inches in diameter and not more than 2 inches long. While this may allow

some additional space for building the downhole equipment, it could also affect the build rate of the directional wellbore. It may also induce additional torque that could affect drillstring forces. Teams must evaluate the benefits and drawbacks of each and are encouraged to provide this analysis in their Phase I design report that describes what different forces are expected and their impact on drilling operations.

3.7.4. Students are encouraged to consider bit wear prior to the final test and its impact on drilling performance during the onsite testing. Based on prior competitions, bit wear should be minimal but some cutter damage is always possible.

3.7.5. Student teams may build or buy similar drill bits to test their design with the rock samples they sourced.

3.7.6. For the final competition, the students may use the directional drill bit provided by DSATS, or use their own bit design. However, the dimensions of their bits must not exceed 1.5 inches in diameter and 2 inches long. This provision is made to enable students to fully optimize the bit design for their specific directional system.

3.8. Drillpipe

3.8.1. The drill string provided by DSATS, if requested by the student teams, will be chosen to ensure drilling dysfunctions will be encountered. How these dysfunctions are mitigated is a key objective of the competition. Final details of the construction of this drill string will be furnished in late fall of 2018 to all entrants upon request. Preliminary specifications are listed below to assist with the mechanical and electrical design of the rig.

3.8.2. The drill pipe specifications for the 2018-2019 competition are subject to change, but should be:

3.8.3. Round Aluminum Tube 3/8 inch diameter x 36 inches long; 0.049 inch wall or equivalent

3.8.4. The material from KS Precision Metals is a typical low alloy material: "Our Aluminum tubing with wall thickness of .035 or .049 is 6061 T6"

3.8.5. DSATS will provide, upon request, the finalists four (4) joints of pipe. Any additional pipe needed can be purchased by the student teams or university if needed.

3.8.6. The use of a metric equivalent of the tubing is permitted.

3.8.7. Tubing is usually available from various hobby shops such as K-S Hobby and Craft Metal Tubing and via Amazon and other suppliers.

http://www.hobbylinc.com/htm/k+s/k+s9409.htm

ROUND ALUMINUM TUBING

OUTSIDE DIAMETER INCHES	WALL THICKNESS	ID
3/64 (.047)	.014	.019
1/16 (.0625)	.014	.035
5/64 (.078)	.014	.050
3/32 (.094)	.014	.066
	.016	.062
7/64 (.109)	.014	.081
1/8 (.125)	.014	.097
9/64 (.141)	.014	.113
5/32 (.156)	.014	.128
11/64 (.172)	.014	.144
3/16 (.187)	.014	.159
	.022	.143
	.035	.117
	.049	.089
13/64 (.203)	.014	.175
7/32 (.219)	.014	.191
	.022	.175
	.035	.149
15/64 (.235)	.014	.207
1/4 (.250)	.014	.222
	.016	.218
	.022	.206
	.035	.180
	.049	.152
9/32 (.281)	.014	.253
	.016	.249
5/16 (.312)	.014	.284
	.016	.280
	.035	.242
	.049	.214
11/32 (.344)	.016	.312
3/8 (.375)	.016	.343
	.035	.305
	.049	.277
13/32 (.406)	.016	.374
7/16 (.437)	.016	.405
	.035	.367
15/32 (.468)	.016	.436
1/2 (.500)	.016	.468
	.035	.430
17/32 (.531)	.016	.499
9/16 (.562)	.016	.530
5/8 (.625)	.016	.593

3.9. Tool joints

3.9.1. Students may design their own tooljoints as long as the design concept is included in the Phase I proposal.

3.9.2. Alternately, students may use commercially available connectors/fittings attached to the drillpipe using threads, epoxy cement or other material, and/or may use retaining screws if desired, as long as the design concept is included in the Phase I proposal.

3.9.2.1. A fitting used somewhat successfully in 2017 is available from Swagelock. In 2018, the winning team used a fitting from Vertex.

3.9.2.2. A fitting used successfully in 2016, but which did not work well in 2017, is available from Lenz (http://lenzinc.com/products/o-ring-seal-hydraulic-tube-fitting/hydraulic-straight-connectors) that uses a split-ring to allow a torque transfer across the fitting.

3.9.3. Students must state WHY they choose a tooljoint design in the Phase I proposal.

3.10. Bit sub/drill collar/stabilizers

3.10.1. It is expected that each team will design and build their own bit sub, instrumentation of the bit sub is ideal for directional sensors

3.10.2. Additional weight may be added to the bit sub, or surface weight/force (above the rock sample) may be applied to provide weight on bit and drillpipe tension

3.10.3. Stabilizers are permitted but will be limited in length. Advise the committee of your choice and why and include this in the Phase I design for committee consideration.

3.10.4. Students must add sensors to the drillstring, but are not permitted to instrument the rock samples. They must have a smaller diameter than the stabilizers and bit by at least 10%. Please include design concepts in the Phase I design.

3.10.5. The addition of along-string sensors to measure vibrations, verticality and/or tortuosity or other parameters will receive extra consideration. They must have a smaller diameter than the stabilizers and bit by at least 10%.

3.11. Automated Drilling

3.11.1. Drilling automation should be considered a combination of data, control AND dynamic modeling so that the control algorithm can determine how to respond to differences between the expected and actual performance. Process state detection can often enhance automation performance. Refer to documents posted on the DSATS website for more information.

3.11.2. Once drilling of the sample commences, the machine should operate autonomously. Remote operation and/or intervention is not allowed.

3.11.3. All directional steering should be autonomously controlled by the drilling rig

3.12. Sensors

3.12.1. The team may elect to use existing oilfield sensors or may look to other industries for alternate sensors.

3.12.2. The team may develop its own sensors if so desired.

3.12.3. Sensor quality differs from data quality. Both are important considerations in this competition.

3.12.4. The final report shall address which sensors were selected and why. The sensor calibration process shall also be explained.

3.13. Data collection and handling

3.13.1. The team may elect to use standard data collection and recording techniques or may develop their own. Data handling techniques and why they were chosen should be described in the Phase I submittal.

3.13.2. The final report shall address which data systems were selected and why.

3.13.3. The observed response time of measurements, data aggregation and control algorithms should be compared to the Phase I estimates.

3.14. Data visualization

3.14.1. Novel ways of presenting the data and progress of drilling in real time while drilling will receive particular attention from the judges.

3.14.2. Visualization of the processes (automation, optimization, drilling state, etc.) should be intuitive and easily understood by the judges, who will view this from the perspective of the driller operating a rig equipped with automated controls.

3.14.3. Data must be presented in a format that allows the judges to easily determine bit depth, elapsed drilling time, ROP, MSE, verticality/inclination, vibration, and any other calculated or measured variable used to outline the drilling rigs performance to the judges. Lack of an appealing and usable Graphic User Interface (GUI) will be noted to the detriment of the team.

3.14.4. All depths shall use the industry-standard datum of rotary/kelly bushing interface (RKB), which should be the top of the rig's "drill floor."

3.15. Measure and analyze the performance

3.15.1. The drilling machine should react to changing "downhole" conditions to select the optimal drilling parameters for improved performance, as measured by the rate of penetration (ROP), mechanical specific energy (MSE), verticality, cost per foot or meter, and other standard drilling measures or key performance indicators. Adding parameters such as MSE, or similar features, to the control algorithms will receive special attention from the judges.

3.15.2. Design limits of the drilling machine shall be determined and shall be incorporated in the programming of the controls during the construction phase.

3.15.3. Downhole measurements from directional sensors are to be used for adjusting drilling parameters and control of drilling machines used to aid in directional drilling

3.15.4. The final report (see Clause 3.19) shall outline drilling performance and efficiency criteria and measured results.

3.15.5. One of DSATS' goals is to promote plug and play capability to accelerate the implementation of drilling automation. A DSATS committee is preparing definitions and examples of proposed data communication protocols and interfaces. Once this is available, the Drillbotics competition will require the use of these standard protocols. This will not be a requirement for 2019 but it will be included in future competitions. Links to these standards will be added to the Drillbotics.com website when they are published.

3.16. The test well:

3.16.1. Prior to the commencement of the test, teams will attach a bell nipple per 3.6.2. They will then manually drill the pilot hole not to exceed 1" deep.

3.16.2. When the test begins, the teams will start drilling autonomously by continuing to drill the pilot hole, keeping the wellbore as vertical as possible until reaching the kick-off point.

3.16.3. The teams will kick off from vertical at any depth below the 4" vertical surface hole

3.16.4. The teams will target an exit of the directional wellbore within the defined target area (see Appendix "A" for details)

3.16.5. Should be drilled with a maximum allowable Weight-On-Bit dependent on the rig and dynamic drillstring integrity.

3.16.6. Will not require a closed-loop fluid circulation system, but could be of advantage for directional drilling, the bit and machinery should be cooled with air or fluid/water if needed. The design of the fluid system, if any, should be included in the Phase I design.

3.16.7. The rock sample will be homogeneous and will be capable of aiding in closed-loop fluid circulation. Note that the rock samples will leak once the drillbit punctures a rock face, so a rig design that includes a containment system is required.

3.16.8. Will require casing to fit in the directional wellbore

3.16.9. Will not require a rig move, walking or skidding, but the mobility of the rig will be considered in the design phase.

3.17. Not included in the 2018-2019 competition

3.17.1. The drilling will not include automating the making or breaking of connections. If connections are necessary due to the rig and drillstring design, connections should be made manually, and the time involved with the connections will be included with respect to its effect on drilling performance (rate of penetration reduction).

3.18. Presentation to judges at Phase II Testing

3.18.1. The judges will arrive at the centralized test site facility to meet with the student teams and advisors immediately prior to the Phase II testing. DSATS will provide a suitable meeting room for discussion lasting about two hours.

3.18.2. The students will present a BRIEF summary of their final design, highlighting changes from their Phase I design, if any. Include an explanation of why any changes were necessary, as this indicates to the judges how much students learned during the design and construction process. Explain what measurement and control features have been deployed. Describe novel developments or just something learned that was worthwhile. Also include how actual expenses compared with the initial estimate. (Previous teams used a short PowerPoint presentation of about ten slides or so. Use any format you like.) Be sure to include all your team members as presenters, not just one spokesperson. At some time during your talk, let us know who the team members are and what background they have that pertains to the project.

3.18.3. Judges will ask questions to ascertain additional details about the design and construction process and to see if all team members have a reasonable understanding how all the various disciplines used for the rig design and construction fit together.

3.18.4. All teams may sit in for the presentations and Q&A of the other teams. The order of presentation will be determined by drawing lots.

3.19. Project report

3.19.1. The student team shall submit to DSATS a short monthly project report that is no more than one page in length (additional pages will be ignored) due on or before the last day of each month that will include:

3.19.2. Phase I

- Key project activities over the past month.
- Rig design criteria, constraints, tradeoffs, and how critical decisions were determined
- Cost updates
- Significant new learning, if any

3.19.3. Phase II

- Construction issues and resolution
- Summary of recorded data and key events
- Drilling parameters [such as WOB] and how they impact the test
- Other items of interest

3.19.4. Report content

3.19.4.1. To teach students that their work involves economic trade-offs, the monthly report should include at a minimum a summary estimate of team member labor hours for each step in the project: design, construction, testing, reporting, and a cost summary for hardware and software related expenditures. Also include labor for non-students that affect the cost of the project. Labor rates are not considered, as to eliminate international currency effects. Labor is not considered in the cost limits of item 6.1, but should be discussed in the report and paper.

3.19.5. File naming convention

3.19.5.1. To avoid extra work by the committee to rename all files, please use this convention for:

3.19.5.1.1. Monthly reports

Year-Month# University Name (abbreviated)

(note this is the competition year (spring term))

Example 2019-09 UDC

3.19.5.1.2. Design reports

Year University Name (abbreviated)

(note this is the competition year (spring term))

Example 2019 University of Drillbotics Competition

3.20. Final report and paper

3.20.1. The finalists shall prepare a project report that addresses the items below. We suggest you use the format of most SPE papers. For reference, please see http://spe.org/authors/resources/

3.20.2. The winning team of Group A and Group B shall update the report as needed to comply with SPE paper submittal guidelines to write a technical paper for publication by the SPE at its Annual Drilling Conference. SPE typically requires that the manuscript is due in the fall following the Phase II test. While the Drillbotics committee will make every effort to have the paper presented during the Drilling Conference, the SPE Program Committee has authority over which papers will be accepted by the conference. If the paper is not accepted by the conference, the Drillbotics

committee will endeavor to have it presented at the DSATS Symposium and will use its contacts to have the paper published via other related SPE conferences.

3.20.3. The report, paper and all communications with DSATS shall be in the English language. The presentation will be made by at least one member of the student team.

3.20.4. The timing for submittal of the abstract and paper will be the published deadlines per the call for papers and conference guidelines as posted on the SPE's website (www.spe.org).

3.20.5. The abstract must generate sufficient interest with the SPE review committees to warrant publication, although DSATS will help promote acceptance where possible

3.20.6. The paper should address at a minimum

3.20.6.1. The technical and economic considerations for the rig design, including why certain features were chosen and why others were rejected.

3.20.6.2. The setup of the experimental test, the results and shortcomings.

3.20.6.3. Recommendations for improvements to the design and testing procedures.

3.20.6.4. Recommendations for improvements by DSATS of the competition guidelines, scheduling and provided material.

3.20.6.5. Areas of learning gained through the competition not covered in the university course material.

3.20.6.6. A brief bio or CV of the team members and their sponsoring faculty.

4. Team Members

4.1. DSATS envisions that the students would be at least senior undergraduate or Masters level, well versed in the disciplines needed for such a project. The maximum number of students per team is five (5) and the minimum shall be three (3). Any team that loses team members during the project can recruit a replacement.

4.2. At least one member of the team must be a Petroleum Engineering candidate with sufficient coursework completed to understand the physics relating to the drilling problems and the normal industry practices used to mitigate the problem.

4.3. Students with a background in mining, applied mathematics, mechanical and electrical engineering, as well as controls, mechatronics and automation or software development, are the most likely candidates, but students with any applicable background is encouraged.

4.4. A multi-disciplinary team simulates the working environment in the drilling industry today, as most products and services are produced with the cooperation of technical personnel from differing backgrounds and cultures.

4.5. A university may sponsor more than one team but must submit only one team/design for Phase II evaluation.

4.6. Students shall register their team not later than 30 November using the registration form on the Drillbotics website. Any changes to the team members or university supervisor over the course of the competition should be reported in the monthly reports.

5. *Expenditures*

5.1. Teams selected to advance to the second phase must limit the cost of the rig and materials to US$ 10,000 or its equivalent in other currencies. The students shall find a source of funding and report the source in the Phase I proposal. All funding and procurement should comply with university policy. These funds are intended to cover the majority of expenses for hardware, software and labor to construct and operate the team's equipment. DSATS shall not be liable for any expenditure other than DSATS provided material and specified travel expenses.

5.2. DSATS will assist when possible to obtain free PLCs or similar control devices from suppliers affiliated with the DSATS organization. Such "in-kind" donations shall not be included in the team's project costs.

5.3. Students and universities may use other "in-kind" contributions which will not be included in the team's project costs. Such contributions may include modeling software, laboratory equipment and supplies, and similar paraphernalia usually associated with university laboratory projects.

5.4. Any team spending more than US$ 10,000, or its equivalent in other currencies, may be penalized for running over budget.

5.5. DSATS reserves the right to audit the team's and university's expenditures on this project.

5.6. Any devices built for the project will become the property of the university and can be used in future research and competitions. Any maintenance or operating costs incurred after the competition will not be paid by DSATS.

6. *Other Considerations*

6.1. The design concepts shall be developed by the student team under the supervision of the faculty. Faculty and lab assistants should review the designs to ensure student safety.

6.2. Construction of the equipment shall be supervised by the student team, but may use skilled labor such as welders and lab technicians. The use of outside assistance shall be discussed in the reports and the final paper. DSATS encourages the students to gain hands-on experience with the construction of the rig since this experience will be helpful to the career of individuals in the drilling industry.

6.3. University coursework and credit: Each university will decide whether or not this project qualifies as a credit(s) towards any degree program.

7. *Project Timeline*

Phase I - Design:	Fall 2018
Submit monthly reports	On or before the final day of each month
Submit final design to DSATS	31 Dec 2018, midnight UTC
Submit an abstract to DSATS*	31 Dec 2018, midnight UTC

*DSATS will submit an abstract to the SPE that will include excerpts from the student abstracts by the conference paper-submittal deadline, typically in mid-summer, for consideration of a paper by the conference program committee.

Phase II – Construction and Testing	Spring 2019
DSATS to announce finalists	On or about 15 Jan 2019
Construction	Spring 2019
Monthly reports	On or before the final day of each month
Drilling Test	Specific on-site test locations and dates for the North American and European locations will be arranged not later than 31 March 2019. The testing will typically occur in late May and/or early June.
The timeline for the Phase II tests:	Day 0 Students arrive Day 1 Students rig up; judges arrive Day 2 Students present to judges Day 3 Performance tests Day 4 Students rig down and depart
Prepare and submit paper	Per SPE deadline*
Prepare and submit presentation	Per SPE deadline
Present paper at the Drilling Conf	Per SPE and DSATS schedule

8. *Evaluation Committee*

8.1. DSATS will select an evaluation committee from its membership

8.2. Criteria/Weighting (see chart):

Criteria	Parameter	Weighting
Phase I:		
a. Safety	Safety: construction and operation	10
b.Mobility of rig	Rig up, move, rig down	5
c.Design considerations and lessons learned		10
d.Mechanical design and functionality, versatility		25
e.Simulation/Model/Algorithm		25
f.Control scheme	Data, controls, response times	25
	Total	100%
Phase II:		
a.Creative Ability	Analysis, concepts, development	10
b.Engineering Skills	Problem/Goal, design criteria, feasibility	10
c.Construction Quality		10
d.Cost Control		10
e.Performance		30
Various parameters such as:	ROP, MSE, Landing Bit, Inclination, and other	
Are these used within the control algorithms		
Exit of drillbit within defined target area (see Appendix "A" for details)	Optimal landing of bit	
f.Quality of wellbore	Tested using the Go-No-Go flexible 'Casing'	10
	Verticality, tortuosity, caliper, other	
g. Data	Data handling, data visualization, data comparison to judges' wellbore logs, and other	20
h. Downhole Sensor Data Used in Control Algorithm	**Pass/Fail**	**Pass/Fail**
	Total	100%
Intangibles	Additional score may be added or subtracted by the judges at their discretion	

9. Group A Prizes

9.1. The winning team of Group A will be sponsored by DSATS to attend the next SPE/IADC Drilling Conference to present a paper that explains their project in detail.

9.1.1. The program committee of the Drilling Conference awarded the Drillbotics subcommittee a permanent slot in one of the drilling sessions at the conference. As per SPE's customary procedures, the paper will be archived in OnePetro. In addition, SPE has agreed to furnish a booth in the exhibition area during the conference where the team can erect their rig and describe its operation to the conference attendees. This is an excellent opportunity for students to network with the industry.

9.2. Upon submittal to DSATS of a valid expense statement (typically a spreadsheet supported by written receipts) of covered expenses will be reimbursed by the treasurer of DSATS for the following:

9.2.1. Reasonable shipping costs of the Drillbotics rig to and from the conference as long as charges are pre-approved by the chair or co-chair of the Drillbotics subcommittee.

9.2.2. Round trip economy airfare for the team and one university sponsor/supervisor to the gateway city of the next SPE/IADC Drilling Conference. Entrants should use the SPE approved carrier where possible to minimize cost. Airfares that exceed the SPE rate must be pre-approved by the committee or the reimbursement will be limited to the SPE rate. Information of reduced fare flights is available on the conference website. Please note that reservations must be made before the SPE published deadline. The departure point will be a city near the university, the student's home, or current place of work, subject to review by the Committee. Alternately, a mileage reimbursement will be made in lieu of airfare should the entrants decide to drive rather than fly to the conference. The reimbursement is based on current allowable mileage rates authorized by the US Internal Revenue Service.

9.2.3. One rental car/van at the gateway city for those teams that fly to the conference.

9.2.4. Lodging related to one hotel room per team member will be reimbursed at a rate not to exceed the SPE rate. Note that the room reservations are limited, so entrants must book their rooms early. Room and taxes for the night before the DSATS symposium, the night of the symposium and for the nights of the conference are covered. Charges for the room on the last day of the

conference need to be pre-approved by the Committee as most conference attendees depart on the last day of the conference unless there are unusual circumstances.

9.2.5. A per diem will be pre-approved by the Committee each year, which will vary with the cost of living in the gateway city. The per diem is intended to cover average meals (breakfast, lunch and dinner) and incidentals.

9.2.6. ATCE registration will be reimbursed. Students should register for the conference at the student rate. Early registration is appreciated.

9.3. Individual award certificates will be presented to all participants upon request, with special certificates given to all finalists.

9.4. DSATS may provide additional awards, at its sole discretion.

9.5. The evaluation and all decisions on any matter in the competition by the DSATS judges and DSATS board are final.

10. Group B Prizes

10.1. The winning team of Group B will submit a SPE Whitepaper that explains their project in detail. If the quality of the abstract is approved by the SPE Conference Program Committee, as per SPE's customary procedures, the paper will be archived in OnePetro

10.2. Individual award certificates will be presented to all participants upon request, with special certificates given to all finalists.

10.3. DSATS may provide additional awards, at its sole discretion.

10.4. The evaluation and all decisions on any matter in the competition by the DSATS judges and DSATS board are final.

11. Terms and conditions

11.1. In no event will SPE, including its directors, officers, employees and agents, as well as DSATS members and officers, and sponsors of the competition, be liable for any damages whatsoever, including without limitation, direct, indirect, special, incidental, consequential, lost profits, or punitive, whether based on contract, tort or any other legal theory, even if SPE or DSATS has been advised of the possibility of such damages.

11.2. Participants and Universities agree to indemnify and hold harmless SPE, its directors, officers, employees and agents, as well as DSATS members and officers, and sponsors of the competition, from all liability, injuries, loss damages, costs or expenses (including attorneys' fees) which are sustained, incurred or required arising out of participation by any parties involved in the competition.

11.3. Participants and Universities agree and acknowledge that participation in the competition is an agreement to all of the rules, regulations, terms and conditions in this document, including revisions and FAQs posted to the DSATS and Drillbotics websites (see section 2.1).

11.4. Winning teams and finalists must agree to the publication of their names, photographs and final paper on the DSATS web site.

11.5. All entries will be distributed to the Drillbotics Committee for the purpose of judging the competition. Design features will not be published until after all teams have been judged and a winner is announced. Previous years' submittals, reports, photos and similar documentation will be publicly available to foster an open exchange of information that will hopefully lead to faster learning for all participants, both new and experienced.

11.6. DSATS and the SPE cannot provide funding to sanctioned individuals and organization per current US law.

11.7. Participants must comply with all local laws applicable to this contest.

12. Marketing

12.1. Upon request, DSATS will provide a link on its website to all participating universities.

12.2. If university policy allows, various industry journals may send a reporter to witness the tests and interview students to publicize the project.

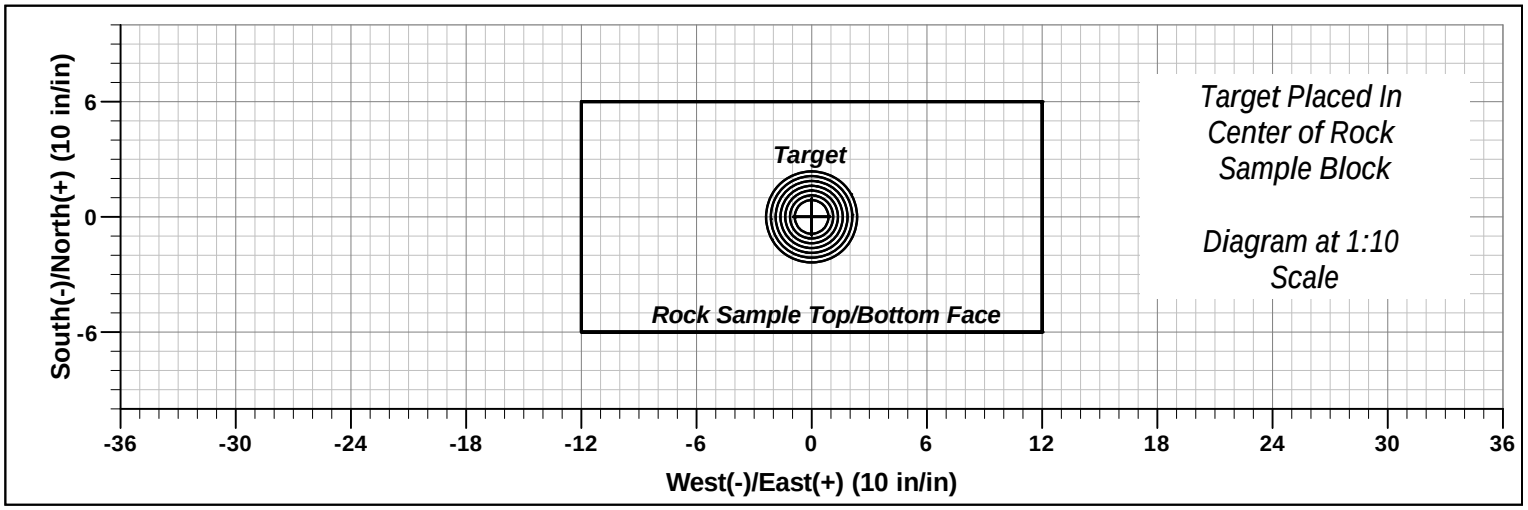
- End -

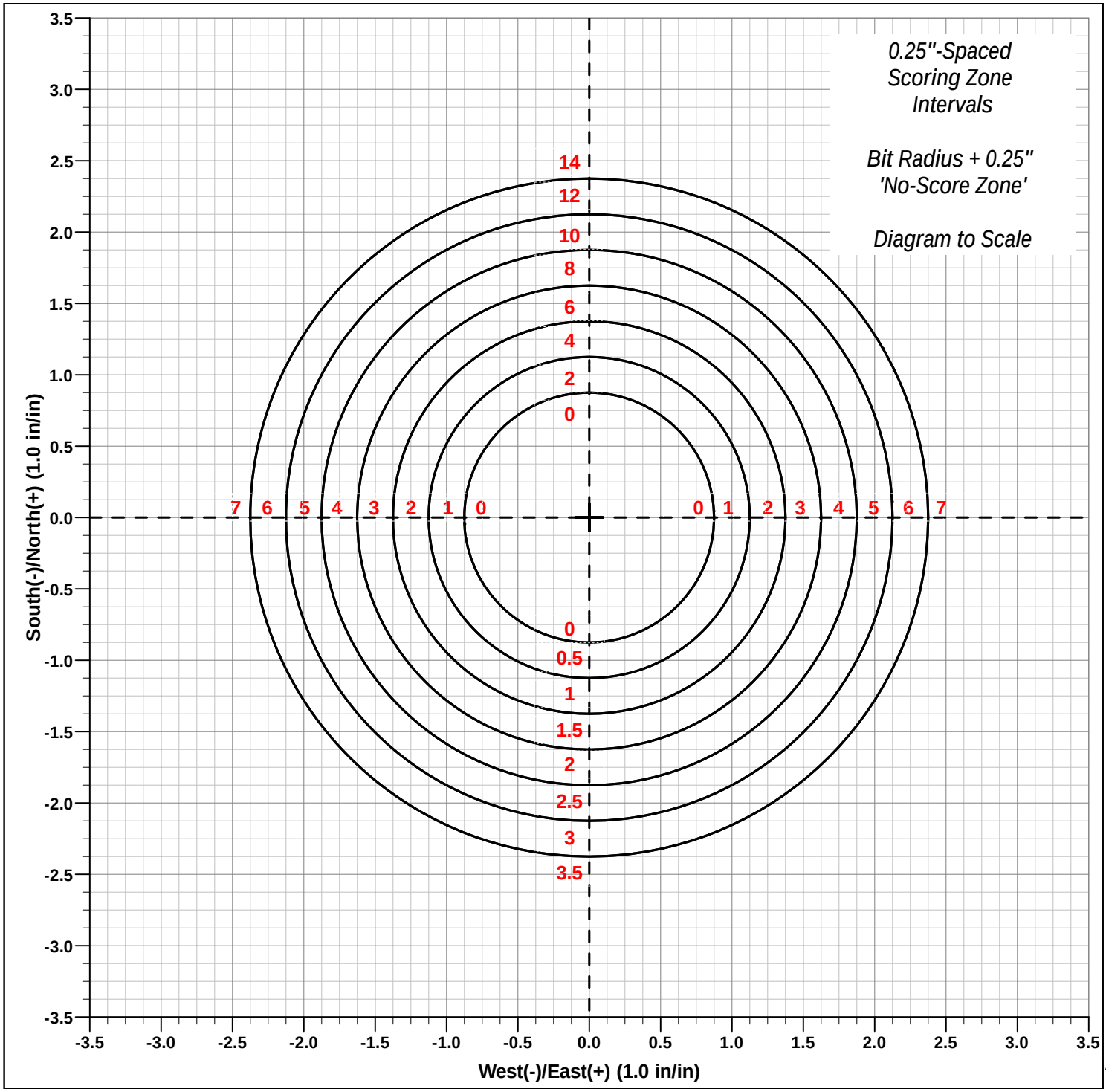
Appendix

A. Directional Objective Scoring

The following attached pages describe the directional target area, as well as the scoring for the directional competition objective. The maximum score is obtained by drilling at least 2 3/8” from well center along the north axis of the rock sample (see page A-A1 for details). Deviation from the north axis results in a reduced score for the same amount of displacement (see page A-A2 for a scoring example).

Directional Control Scoring Target





Directional Control Scoring Target Example

$$Total\ Score = [Min\ Score] + ([Max\ Score] - [Min\ Score]) * \frac{90° - [Deviation\ from\ Max\ Score]}{90°}$$

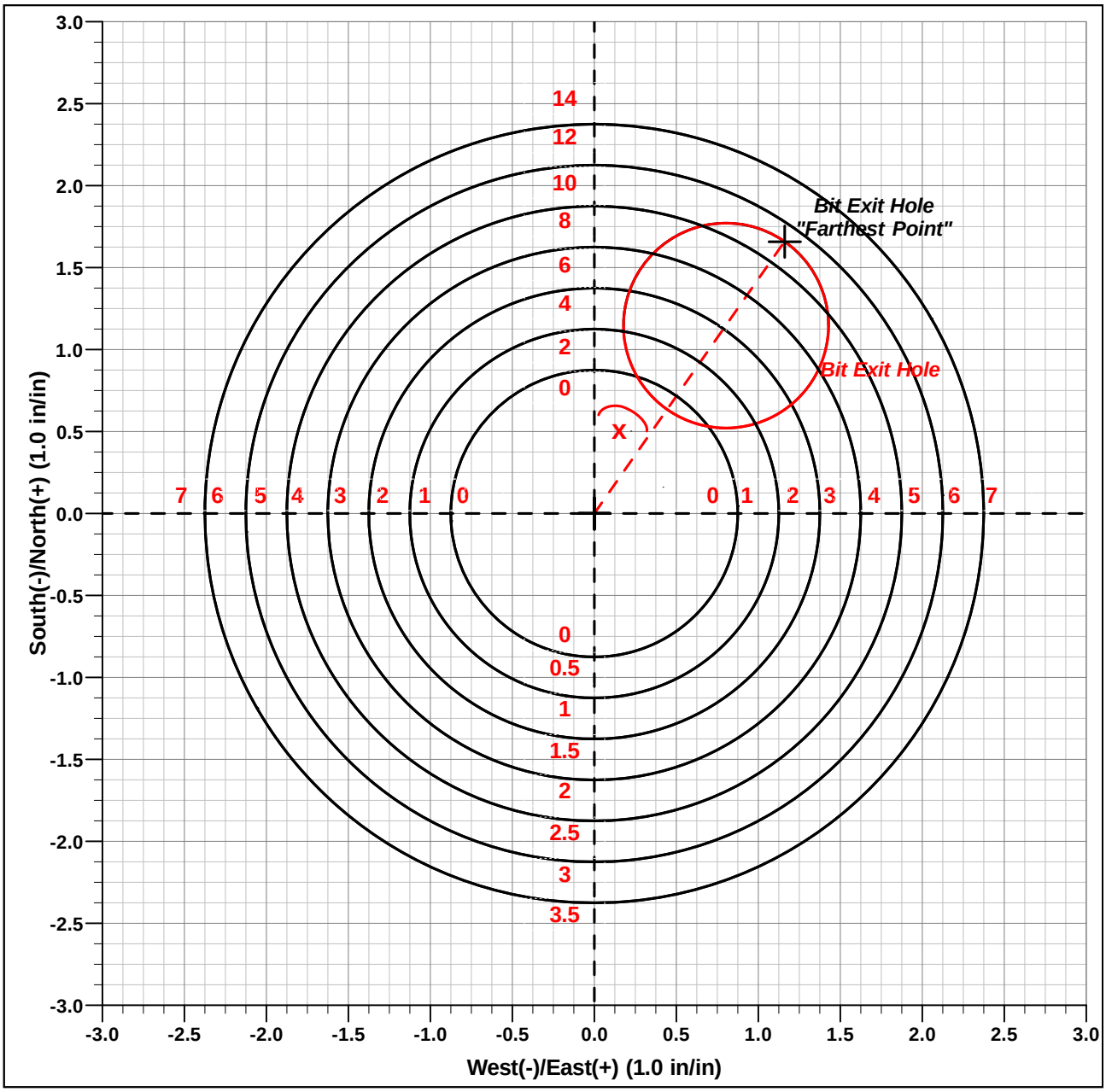
Max Score = 10 (North axis score)

Min Score = 5 (East axis score)

Deviation from Max Score = x = 35°

$$Total\ Score = [5] + ([10] - [5]) * \frac{90° - 35°}{90°}$$

$$Total\ Score = 5 + 5 * \frac{55°}{90°}$$

$$Total\ Score = 5 + 5 * \frac{55°}{90°}$$

$$\boldsymbol{Total\ Score = 8.06}$$