

ELECTRONICALLY ACTIVATED UNDERREAMER AND CALLIPER TOOL

FIELD OF THE INVENTION

[0001] This invention relates to an electronically activated expansion tool that is capable of enlarging and measuring borehole and tubular diameters, especially those drilled to construct wellbores in the oil and gas industry. The expansion operation is verified by data provided by the tool and this is used to optimise underreaming to meet cementing or casing tolerances. Such data may be the measurement of the underreamed wellbore diameter using an acoustic calliper or a mechanical calliper, or it may be the expandable cutter block position. The tool finds particular use as an underreaming and calliper tool, but can also be configured without cutting elements to provide downhole centralization, directional stabilisation, or as a means for expanding tubulars. The tool also finds particular use as an underreamer capable of sensing vibration, but can also be configured with other sensors such as callipers to measure wellbore diameter.

[0002] It is to be understood that the term 'expansion' as used herein refers to the capacity of the tool to expand outwardly towards and against the interior wall or walls of a passage, such as a borehole, especially a wellbore, or a tubular, and then to apply pressure or a cutting action against the wall or walls. It is not always essential that the passage itself be expanded, since the tool can be used for centralisation or stabilisation or like purposes without necessarily expanding the passage.

[0003] When constructing an exploration or production well, numerous downhole operations are conducted to drill and measure a borehole so that it meets the desired well-plan. Drilling itself may utilise a reamer to ensure that the hole diameter that has been drilled by the bit is maintained within the given tolerance. The hole diameters drilled by the bit and perfected by the reamer are substantially the same as the maximum cutting diameter of a reamer, which is fixed and is substantially the same as the bit diameter. This maximum cutting diameter is defined by the pass-through diameter of any restriction in the borehole above the

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operating location.

[0004] In contrast to a reamer, an underreamer is used to enlarge a borehole beyond its original drilled size. Enlargement is typically done below a restriction in the borehole, and the cutting diameter of an underreamer is always greater than that of the pass-through diameter of the restriction. Additionally, an underreamer is provided with activation and deactivation modes and mechanisms for extending and retracting cutting elements to ensure effective underreaming once it has passed below the restriction.

[0005] Measurement may involve the acquisition and communication to surface of various types of wellbore data such as drilling dynamics, resistivity, porosity, permeability, azimuth, inclination and borehole diameter or rugosity, formation dips or bedding angles.

[0006] Measurement itself occurs in two modes, either wireline or logging-while-drilling. Wireline is by far the most common measurement technique and is performed as a separate and consecutive activity to drilling involving the conveyance of measurement tools on a wire or cable. Wireline callipers use a plurality of fingers to take borehole diameter measurements. However, wireline callipers can only take measurements in an axial direction. Due to this limitation, they can only be used after drilling otherwise the rotational and impact forces of drilling would cause them to break. Hence a separate calliper run is required after drilling to measure borehole diameter.

[0007] Logging-while-drilling or measurement-while-drilling tools may acquire various data from the wellbore. For drilling dynamics measurement-while-drilling is the preferred means of acquiring drilling data such as vibration. Acoustic callipers may be incorporated within logging tools. As they can be rotated, acoustic callipers may be used while drilling to acquire measurement data. However, almost all logging tools are configured as complete systems and are only available at very high cost and are not used in all wells worldwide. Further they also suffer from limitations in applications with slide drilling, where a downhole

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motor rotates the bit and drags the drillstring and bottom-hole assembly, or BHA. Or in Rotary steerable applications where they are configured near to the bit. Therefore, the location of the sensor is within the BHA below the underreamer. It can only give readings after the section has been underreamed.

[0008] In the case of underreaming, measurements are taken a *posteriori* i.e. after underreaming, which means a separate calliper run and at times further corrective runs to attain the desired wellbore diameter.

[0009] Presently, activation of underreamers is limited to hydraulic or mechanical means based on internal flow restrictions configure as venturis or 'ball-drop' or 'shear pins'. In the case of flow, pumps are brought up to a pre-determined level which causes internal pressure to build-up and exceed the annular pressure. This causes a mechanical component to move and activate the tool. In the case of weight, the method relies on the use of shear pins which are rated to a given weight bearing and sheared with a mechanical force. Due to fluctuations in stand pipe pressure and the subsequent downhole pressures, pressure restrictions are not always the ideal means for activation. Further, drop-balls restrict any fishing or retrieval of components below the underreamer which means that highly sophisticated logging-while-drilling equipment such as nuclear sources may be lost in the hole. Shear pins are load bearing and therefore can present problems due to the progressive weakening the shear pin undergoes each time its bearing surface is subject to vibration or movement. This occurs until the true shear value is reduced and results in premature activation of the underreamer in the casing and damage to the wellbore as well as increased cost and delay.

[0010] The present invention allows for electronic activation of the expansion and calliper tool as well the ability to communicate commands and receive data from the tool during drilling. This provides an advantageous, independent and reliable means of

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activation which is not dependent on hydra-mechanical forces and allows the underreamer status to be controlled on command.

[0010A] Further, as drilling has already been completed and no vibration data acquired directly above the underreamer, there is no means of understanding the actual loads on the underreamer in real-time. The present invention is differentiated in this aspect as it provides real-time drilling dynamics data of the underreaming operation which would enable a driller to identify a vibration mode and change drilling conditions to eliminate the vibration. This would reduce harmful vibrations which are a major cause of a downhole tool failures as well as the lower rates of penetration related to underreaming in medium to hard formations or interbedded formations.

[0011] The present invention may be activated by means of electronic signal sent by a built-in mud-pulse telemetry means or a third party telemetry means. It may also be activated using other means such as fibre-optic or wireless transmission.

As will become apparent the tool and related apparatus may be configured in any number of ways so that object of the invention which is to reduce uncertainty and downtime is achieved.

BACKGROUND OF THE INVENTION

[0012] Oil and gas accumulations are found at depth in different geological basins worldwide. Exploration and production of such accumulations rely on the construction of a well according to a well plan.

[0013] Various well types exist and are defined according to usage such as wildcats or those used in exploration; delineation; and production and injection. Variations in well profile exist also according to vertical, slant, directional and horizontal trajectories. Each differs according to the oil company's objectives and the challenges that a given basin presents from the surface of the earth or the ocean to the hydrocarbon reservoir at

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a given underground depth.

[0014] Engineering challenges are related to the location of the well-site such as onshore or offshore, seawater depths, formation pressures and temperature gradients, formation stresses and movements and reservoir types such as carbonate or sandstone. To overcome these challenges, a highly detailed well plan is developed which contains the well objective, coordinates, legal, geological, technical, well engineering and drilling data and calculations.

[0015] The data is used to plot a well profile using precise bearings which is designed in consecutive telescopic sections surface, intermediate and reservoir. To deliver the well objective and maintain the integrity of well over its lifecycle, a given wellbore with multiple sections and diameters is drilled from surface. Although there are many variants, a simple vertical well design could include a surface or top-hole diameter of 17 " (445mm), intermediate sections of 13 5/8" (360mm) and 9 5/8" (245mm) narrowing down to the bottom-hole diameter of 8 " (216mm) in the reservoir section.

[0016] Each consecutive section is 'cased' with the specified diameter and a number of metal tubes placed into the wellbore according to the length of the section. Each must be connected to each other after which they are cemented into the appropriately sized hole with a given tolerance. In this way, a well is constructed in staged sections, each section dependent on the completion of the previous section until the well is isolated from the formation along the entire distance from surface to the reservoir.

[0017] Scarcity of oil and gas is driving oil and gas companies to explore and develop reserves in more challenging basins such as those in water-depths exceeding 6,000 ft (1830m) or below massive salt sections. These wells have highly complex directional trajectories with casing designs including 6 or more well sections. Known in the art as 'designer' or 'close tolerance casing' wells, these wells have narrow casing diameters with tight tolerances and have created a need to enlarge the wellbore to avoid very narrow diameter reservoir sections and lower production

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rates.

[0018] Therefore, the bottom-hole assemblies that are needed to drill these wells routinely include devices to underream the well-bore below a given casing diameter or other restriction. In this way, underreamed hole size has become an integral part of well construction and there is now an increased dependence on underreaming to meet planned wellbore diameters.

[0019] After underreaming, the underreamer is tripped out from the borehole and replaced by a calliper, which is an instrument for measuring the internal dimensions of the bore either mechanically, typically by means of extending fingers that contact the inside of the bore, or by acoustic or other echo-based sounding techniques.

[0020] Previously, the underreamer and calliper have been considered as two separate tools, each involved in distinct functions. Typically, an underreaming run could take 24 hours, after which a further 24 hours would be required for preparation of the calliper run. A further 24 hours could be taken in the calliper run before knowledge could be gained of actual wellbore diameters. The time-lag between underreaming and calliper measurements, therefore could easily exceed 48 hours depending on the depths involved. If the actual hole diameter did not match the planned diameter, casing tolerances would not be met and therefore a corrective run would be required and the whole cycle of underreaming and calliper measurements would need to be repeated.

[0021] In other applications such as tubular expansion casing or increased cementing thicknesses, the tolerances between the enlarged well-bore and the expanded tubular are very close. Variations of 1" (25mm) diameter can lead to the failure of the well construction activity.

[0022] Notwithstanding, the limitations of the prior art are overcome with the present invention, the wellbore construction process will continue to depend on given wellbore diameters for the placement of casing in a wellbore with a given tolerance which is determined by the required cementing thickness.

[0023] Consequently, where an undergauge (below tolerance) diameter goes undetected this would potentially jeopardize the wellbore construction activity. The present invention avoids this by measuring and verifying wellbore diameter and underreamer status and if either were insufficient, the tool performs automated diagnostics and may alert the user as required.

[0024] To those skilled in the art, it is known that underreaming generates uncertainty as to the activation status of the underreamer. This is because underreamers do not provide for clear activation status as described in Patent GB 2460096 which is incorporated herein as a reference.

[0025] The present invention is differentiated in this aspect as it provides for activation electronically as well as real-time verification of activation status by means of electronic signal which would enable a driller to activate a tool with certainty and eliminate reliance on hydra-mechanical activation. This would reduce time spent on activation as well as permit the exchange of data with the tool and surface.

[0025A] Drilling vibration occurs in two modes which are classed as resonant i.e. torsional, axial, lateral and non-resonant vibration, i.e. eccentric, sudden modes releasing stored torque known as backward rotation and whirl. Each mode maybe defined separately but in reality all modes are experienced during drilling, the severity of each level depends on the drilling BHA design, drilling dynamics and geological formations. Axial vibrations are often manifested as a stick-slip condition where weight applied at surface causes compression of the drill string. Due to the geometry of the wellbore and bending moments, the weight is concentrated at the widest and bending moments, the weight is concentrated at the widest diameters of the drill-string which is the underreamer, stabilizers, rotary steerable and the drill-bit.

[0025B] In the aspects of drilling dynamics, the ability to acquire accurate data on vibration, stick-slip, loads and other accelerations by means of the present invention optimally differentiates it from the prior art. Prior art underreamers do not provide for in-situ data measurements on drilling dynamics or loads and therefore their

performance, design or configuration cannot be optimized from one job to another.

[0026] The data may be transmitted in real-time by means of data transfer (mud pulse telemetry, fibre-optic or other) or maybe stored in memory and downloaded at a later time. The present invention would make underreamer status known in a clear manner and optimize underreaming operations thereby reducing failures and improving drilling efficiency and wellbore construction.

[0027] It is unsatisfactory to depend on indirect indicators such as whether cutter blocks are open or closed or whether fluid pathways are open and a pressure spike is seen at the rig floor to indicate activation. Such indicators do not provide actual measurements of the underreamed well-bore underreamed nor do they provide verification of underreaming performance; they simply give information on the mechanical or hydraulic status of an aspect of the tool which may or may not lead to the desired well diameter.

[0028] To those skilled in the art, it is known that the industry relies on even more rudimentary and time-consuming indicators of verification such as an increase in drilling torque as cutters interact with the formation or even pulling up the drill-string and underreamer to the previous hole size in order to see whether the top-drive stalls as the bottom-hole assembly gets stuck due to the expanded tool. Or by drilling a pilot hole section with the underreamer deactivated and pulling back into the pilot hole.

[0029] Therefore, the prior art does not lend itself to a reliable or certain means of measuring and verifying underreamed wellbore diameters in real-time or memory mode.

[0030] Further the prior art perpetuates drilling inefficiencies due to the uncertainty of the actual status of the underreamer.

[0031] Further the prior art generates time-consuming cycles of entry and exit into the well-bore.

[0032] Further the prior art relies on pressure restrictions or weight for activation.

[0033] Further the prior art does not detect variations in wellbore in real-time.

[0034] Further the prior art does not automatically troubleshoot undergauge hole or malfunction.

[0035] Further the prior art has limited practical application of a mechanical calliper outside the cutter block.

SUMMARY OF THE INVENTION

[0036] The present invention has for a principal object to provide an improvement on the prior art wherein the actual diameter of the underreamed hole is measured directly in real time, that is to say simultaneously with, or immediately after, an expansion operation.

[0036A] Another principal aspect of the present invention is to provide an improvement on the prior art wherein the actual drilling loads and vibration experiences in the underreamed hole is measured directly in real time, that is to say simultaneously with, or immediately after, an expansion operation.

[0036B] The present invention seeks to provide accurate input into underreaming and drilling models by using real-time or memory mode data based on in-situ vibration levels rather than the predicted values. The present invention optimizes drilling efficiency by identifying the optimal operational parameters to ensure minimized vibration thereby increasing tool life and minimizing the need for corrective underreaming runs by providing real-time drilling dynamics which allows the driller to respond earlier thereby saving time and money. It is thus an object of the present invention to provide sensors integrated with an underreamer, enabling the integrated device to give immediate measurement of the vibration levels sustained during the wellbore-widening operation and, if these are found to be critically high, to automatically reconfigure drilling parameters to bring vibration levels to satisfactory levels in real time.

[0037] The invention seeks to meet the need for an integrated underreamer and calliper equipped with wellbore diameter measurement means and electronic activation, which provides real time performance verification and automated troubleshooting. This

has not been forthcoming in the prior art due to design limitations inherent in the hydraulic or weight activation and the prior art cutter block retention mechanisms or prior art mechanical calliper designs.

[0038] Usage of the electronic activation means may further be provided as a means of communication with the tool wherein commands or data may be sent or received from the tool.

[0039] The present invention seeks to integrate and automate underreaming and calliper measurement offering performance verification and eliminates the need for separate calliper runs and minimizes the need for corrective underreaming runs by providing real-time data which allows the driller to respond earlier thereby saving time and money. This would allow measurement of required diameters for casing and cementing tolerances and thereby reduce uncertainty and improve wellbore construction.

[0040] It is thus an object of the present invention to provide callipers integrated with an underreamer, enabling the integrated device to give immediate measurement of the accuracy of the wellbore-widening operation and, if it is found insufficient or undergauge, to automatically detect and diagnose the faults, and to repeat underreaming until a satisfactory result is achieved in real-time.

[0041] Although underreaming is a principal route to wellbore enlargement, the invention envisages alternative enlargement means similarly integrated with calliper measurement of the enlarged bore. These alternative means could include bicentre bits, fixed wing bits, eccentric underreamers and expandable bits.

[0042] It is a further object to provide a tool capable of simultaneously conducting well-bore enlargement, taking calliper measurements preferably by an acoustic echo-pulser and sensor, and verifying performance through a processor arrangement that uses sensor data to detect undergauge hole and conducts diagnostics according to a logic circuit in order to ensure the underreamer is functioning correctly. If the corrective steps have been taken and the calliper indicates that the planned hole diameter is still not being delivered an alert signal may be sent to the rig-surface or

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to the location of the operating engineer so that further remedial action can be taken, such as tool replacement. A memory mode may store sensor information that can be downloaded at surface when the tool is retrieved, or sent to the surface by telemetry.

[0043] The tool may also be configured as a standalone tool with a built-in link to a mud-pulse telemetry system or alternatively the tool may be linked to a third party mud-pulser in the case of measurement while drilling or logging while drilling usage to allow real-time monitoring of the under-reaming operation (cutter-block position and acoustic calliper data simultaneously). One or more echo-pulsers may be optimally spaced in order to emit a number of sound waves during a given time period which are reflected back by the near wellbore or by the far formation in the case of a cavernous formation and picked up by the sensor. The distance may be calculated using the travel time and speed of return.

[0044] In a preferred embodiment the integrated tool or separate housings of the tool may incorporate electronic activation means from the surface to downhole where an electrical signal is used in part and converted to binary code and pulsed as pressure pulses through a fluid medium in the drill-pipe or annulus or to a transducer in the drill-pipe or annulus containing a decoder that converts the pressure pulses back into electrical signals.

[0045] In a further embodiment the electronic signal is transmitted from surface to the tool downhole via a hard wire or fibre optic cable.

[0046] In yet a further embodiment the electronic signal is transmitted from surface and converted to radio waves and transmitted by a short hop to a transponder where it is received and converted back into electronic signal.

[0047] A keyway may provide a channel for wiring from the sensors to the processor and transponder. The wiring can be used to transmit acoustic data retrieved by the acoustic sensors, as well as positional data from the mechanical blocks, to the processor and transponder. The keyway may be sealed and filled with a means to absorb vibration such as silicon gel or grease and to maintain wires in position.

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[0048] The transponder converts data so that it can be transmitted and is linked to the in-built or 3rd party mud-pulser which transmits the data to surface using a series of binary codes at a given frequency using drilling fluid as means of mud pulsing. Other means of data transfer may be used such as wireless transmission short hop using radio frequency or other electro-magnetic pulses. This allows up and downlink of the tool in order to receive and transmit data and commands. At surface a transducer may be incorporated within a decoder housing which decodes the binary code and may link to the driller's terminal or may be yet further transmitted by satellite or other means to a remote operations centre.

[0049] The preferred embodiment of the invention provides for an electronically activated wellbore underreaming tool (50), which is particularly applicable in oil and gas wells, comprising a tool body, cutter blocks and calliper with means for attachment to a drilling support and rotation so as to permit the simultaneous underreaming and measurement of the diameter of an wellbore characterized by at least one radially extendable cutter block (62) at least one calliper means (76 or 66, 64) to measure wellbore diameter and at least one radially extendable stabiliser block (63), an electronic means of activation, all of which are interlinked by a means of communication using receivers, sensors and microprocessors; a system that delivers a desired wellbore diameter (22) by simultaneously comparing and correlating measured wellbore diameter and activated cutter block position(62); inter-linked by means of sensors and microprocessors.

[0050] In further embodiments the invention provides for the incorporation of positional sensors adapted to measure the relative position of the cutter block to the tool, or to measure the relative position of the radially extendable stabiliser block relative to the tool.

[0051] The support to the tool may typically be a drill string or an extended length of coiled tubing, as used in downhole operations in oil and gas fields.

[0052] The tool body is typically a cylindrical high grade steel housing adapted to form part of a bottom-hole assembly (BHA). Thus the means for attaching the tool body to the support, whether

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it is a drill string or coiled tubing, may comprise a screw thread provided on the tool body which is engageable with a drill collar. The attachment to the drill string need not be direct, but may be indirect, as there will typically be many different functional elements to be included in the long and narrow BHA, and the arrangement of the successive elements may vary. The lower end of the BHA may be the drill bit, or a bull nose, and in between there may or may not be a means for directional control such as a rotary steerable system.

[0053] The wellbore underreaming is achieved by means of a cutter block or a plurality of cutter blocks. The set of cutters may comprise a cutter block carrying a plurality of cutter elements directed outwardly of the tool body. The cutter block may be received within the tool body in a cutter block chamber having an open mouth, and the cutter may be extendable from the chamber through the chamber mouth with the cutter elements projecting from the tool body, and retractable back into the chamber. The cutter elements may be polydiamondcrystalline inserts, or other inserts according to requirements. The tool body may be provided with an internal duct (90) receiving a source of drilling fluid flowing to an external nozzle adjacent the set of cutters.

[0054] The tool also has a housing for expandable stabilising elements which can be connected by means of a connection to the body. This can act to stabilize the tool against the wellbore wall during underreaming and measurement and if so required, increase or expand the diameter of a tubular or casing.

[0055] Other embodiments of the tool may provide for separate housings and sections for calliper means, mud-pulser means and stabilising means so that the separate housings and sections may be connected by means of a connection and inter-linked by means of sensors and processors for use in oil and gas wellbore underreaming, drilling or expansion operations.

[0056] It is to be noted that the description herein of the structure and operation of cutter or expansion blocks is applicable generally, irrespective of function, except to the extent that cutter inserts may be provided specifically for underreaming purposes and removed for expansion purposes of

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expandable casing.

[0057] The microprocessor may provide a means of control (68) and is programmed to receive data from the calliper means on the underreamed wellbore diameter as well as the cutter block positional data from the sensor which is placed on each cutter block and its housing. The microprocessor may therefore control the extension and retraction positions of the cutter block based on a logic circuit programmed within the microprocessor. In this way, an integrated tool which is capable of diagnosing under-performance and correcting it may be realised. The dimension data may prompt for tests and checks on the effective deployment of the expansion elements, may trigger a repeated cycle of expansion, and may provide data to a surface monitor to signal an opportunity for operator intervention.

[0058] The tool normally comprises a plurality of such cutter blocks, arranged symmetrically around the tool. Two cutter blocks would be on opposite sides of the tool, three blocks would be separated by 120 degrees, four by ninety degrees, and six by sixty degrees. In operation, the underreaming tool is typically rotated on the drill string as well as being moved axially along the wellbore.

[0059] In accordance with a particularly preferred aspect of the invention, the tool body is provided with an internal duct for directing drilling fluid from a source to an external nozzle adjacent the cutter elements. The source of drilling fluid may be the drill-string or other support for the tool, and the aforementioned through passage for the flow of drilling fluid from the drill string to the drill bit. In each case, the nozzle provides a fluid flow that can help to keep the cutters clean and prevent the build-up of clogging debris from the reaming operation, remove such material altogether from the underreaming zone, and provide a cooling and lubricating function for the cutters. In one preferred aspect the present invention incorporates a non-mechanical means of measurement which is practically applicable and may be an acoustic calliper.

[0060] Thus, in the case of an underreaming tool with acoustic calliper means, acoustic reflections from an echo-pulser may be

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transmitted to a sensor and calculated as distance by multiplying time by speed. The processor correlates the borehole data from the distance allowing for variations in fluid or formation caverns. The processor uses this data to correlate whether the pre-programmed wellbore diameter is actually being underreamed and measured. The underreamed wellbore diameter callipers are generally located above the underreamer but in an alternative configuration may be placed within the cutter block itself among the most radially extended cutting elements.

[0060A] In another aspect of the present invention housing for a mechanical calliper is provided within the cutter block which offers a robust location. This has not been possible with previous underreamer blocks due to their inherent design limitations which rely on the block base as a retention mechanism or hydraulic activation through drilling fluid pressure.

[0061] The skilled man will readily appreciate that other procedures may be implemented by the logic circuit within the processor, which can be programmed to cover other scenarios.

[0061A] In a further aspect, the invention provides a method of operating an expansion tool to enlarge a borehole or tubular or the like to a target dimension below a restriction, which comprises locating a tool according to the invention in a borehole on a support below a restriction, extending the expansion element to an expansion diameter greater than the restriction, in a preferred embodiment a set of cutter to an underreaming diameter greater than the restriction, rotating the tool and moving it axially along the borehole on the drill string or other support, measuring drilling dynamics by the vibration sensor means, measuring the bore diameter by the calliper means, and continuing the expansion operation until the target dimension is achieved.

BRIEF DESCRIPTION OF THE DRAWINGS

[0062] Embodiments of the invention are illustrated by way of non-limiting examples in the accompanying drawings, in which:

[0063] Figure 1 is a general diagrammatic view of an oil or gas

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well showing surface structures and the underground wellbore, with a tool in accordance with the invention as part of a bottomhole assembly;

[0064] Figure 2a is a side elevation, part cut away to show the expansion elements in a deactivated state, of the tool of Figure 1;

[0065] Figure 2b is a side elevation corresponding to Figure 2a showing the expansion elements in an activated state;

[0066] Figure 3 is a diagrammatic cross section through an underreaming and sensing tool in accordance with the invention similar to that shown in the previous Figures, but having an additional stabiliser section at the trailing uphole end;

[0067] Figure 4 is an exemplary logic circuit showing the reduction of uncertainty and automated diagnostics that the tool provides

DETAILED DESCRIPTION OF THE INVENTION

[0068] As shown in Figure 1, an exemplary exploration or production rig comprises a surface structure 10 at the wellhead, a wellbore 20, and a drill string 30 in the wellbore with a bottom-hole assembly 40 at its lower end. The bottom-hole assembly includes an underreamer and calliper tool 50 in accordance with the invention, and a drill-bit (not shown).

[0069] The integrated expansion and sensing tool 50 is illustrated in Figures 2a and 2b, and comprises a tubular steel body 52 provided with a drilling collar 54 at its downhole end and a mud-pulser 56 at its other end, which is adapted to be engaged by a further drill collar (not shown) to connect it other elements of the bottom-hole assembly 40, and then to the drill string 30.

[0070] The tool body also carries a calliper 76 and an expansion element assembly 60 between the calliper and the drill collar 54. The expansion element assembly 60 comprises a number of expansion blocks 62 disposed symmetrically, radially around the tool body 52, and in the deactivated condition shown in Figure 2a the blocks

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are withdrawn into the tool body, but in the activated condition shown in Figure 2b the blocks are extended beyond the tool body against the wellbore 20.

[0070A] The tool body also carries a vibration sensor with the expansion element assembly 60 between the vibration sensor and the drill collar 54.

[0071] Figure 3 illustrates diagrammatically the aforementioned elements of the tool 50, together with a stabiliser section 61. As will become apparent the tool sections can be connected directly or indirectly to each other according to requirement. In this way, a plurality of embodiments may be outlined within the scope of the invention including variations such as the stabiliser section connected to the underreamer or the stabiliser may simply house a caliper means with or without a mud-pulser means or the stabiliser section may house underreaming blocks.

[0072] As the sensor means 76 indicated in Figure 3, further sensors may be incorporated in 64 or 66. Data is processed using a micro-processor 68, shown in two alternative locations, that correlates data from the sensor 66 to detect a critical condition or simply store data for further analysis. The tool is also programmed and automated to conduct diagnostics according to a logic circuit or diagnostic program stored in processor 68 in order to ensure the underreamer is functioning correctly. Once corrective steps have been taken, and if drilling dynamics are still not optimised, an alert signal is sent via the mud-pulser 56 to the rig-surface 10 or to a remote operator so that further remedial action such as the replacement of the BHA 40 can be considered. A memory module associated with processor 68 may store sensor information that can be downloaded at surface when the tool is retrieved, or sent to the surface by telemetry through mud-pulser 56.

[0073] The tool is provided with a built-in link to a data transfer system 56 which may also serve to monitor real-time wellbore diameter. One or more callipers are placed in 76, 64 or 66 are spaced within the tool body 52 in order to measure wellbore diameter in real-time or memory.

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[0074] As further shown in Figure 3, a keyway 74 provides a channel for wiring from the sensors 66 to the processor 68, and also to a transponder 72. The wiring is used to transmit data retrieved by the sensors to the processor and transponder. The keyway may be sealed and filled with a means to absorb vibration and maintain wires in position such as silicon gel or grease.

[0074A] Additionally one or more sensors are spaced within the tool body 52 in order to detect vibrations during drilling caused by formation in the near well-bore 20.

[0075] The transponder 72 converts data from microprocessor 68 so that it can be transmitted to surface 10 and is linked to the mud-pulsar 56 which transmits the data to surface using a series of binary codes at a given frequency using drilling fluid as means of mud pulsation. Other means of data transfer may be used such as wireless transmission, short hop using radio frequency or electromagnetic pulses.

[0076] Figure 3 also shows an alternative location for a sensor, in housing 66 or 64 connected to wiring in keyway 74 and further wiring 78 to alternative processor location 68 Figure 3 also shows a central axial through passage 90 for the flow of drilling fluid through the whole bottom-hole assembly 40.

[0077] The sensor means 76, 58, or 64, 66, is typically housed within the tool body 52 above the underreamer 60, but in a variation a calliper 76, 122 may be located within the tool.

[0078] The tool body 52 is a cylindrical high grade steel housing adapted to form part of a bottom-hole assembly (BHA) 40. Figure 3 shows an internal connection 82 joining two parts of tool body 52. At the leading downhole end of the tool is a section housing the cutter blocks 62. Connection 82 joins this to a central section housing measurement and control functions. A further section 61 at the uphole end, joined by connection 65, houses stabiliser blocks 63 which are constructed and housed substantially identically to the underreamer components generally designated 60, except that in place of cutter elements on cutter blocks there is at least one surface which is hard faced or coated with a hard abrasion-resistant material. A similar construction can be used to expand a deformable bore, such as a steel tubular. The means for attaching

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the tool body to a drill string or coiled tubing comprises a screw thread (not shown) provided on the tool body which is engageable with a drill collar (not shown).

[0079] In this alternative configuration the tool is configured, in addition to underreaming capacity, with the underreaming tool body incorporating hard facing cutter blocks to act as a stabiliser. The hard facing acts to prevent cutter abrasion while reaming or stabilising the underreamed hole. This eliminates some of the problems associated with loss of directional control due to the undergauge stabiliser above the underreamer.

[0080] In yet another configuration the tool is provided with a stabilizer directly or indirectly connected to the underreamer

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housing where the stabiliser housing may also be provided with electronic activation means and may be linked to a calliper means so that the stabilizer and calliper is used to perform essentially the same function as the integrated underreamer and calliper except that the stabiliser is stabilising the tool and BHA.

[0081] The stabiliser may be directly or indirectly connected to the underreamer and hard-wired accordingly so as to ensure the mud-pulser may transmit data to surface. The tool may be provided with a mud-pulser as a standalone tool or the mud pulser itself may be provided by a third party as would be the case when a measurement while drilling or logging while drilling suite of tools is located in the BHA below the present invention. The hard wiring configuration of the tool may be changed to suit such an application.

[0082] The tool normally comprises a plurality of such cutter blocks 62, arranged symmetrically around the tool. Two cutter blocks are on opposite sides of the tool, three blocks are separated by 120 degrees, four by ninety degrees, and six by sixty degrees. In operation, the underreaming tool 50 is typically rotated on the drill string as well as being moved axially along the wellbore.

[0083] As noted above, the invention provides a method of operating an underreaming tool to enlarge a borehole to a target dimension below a restriction, which comprises locating a tool as claimed in any one of the preceding claims in a borehole on a drill string below a restriction, activating the tool electronically, extending the set of cutters to an underreaming diameter greater than the restriction, rotating the tool and moving it axially along the borehole on the drill string, measuring wellbore diameter by the calliper means, and continuing the underreaming operation until the target depth is achieved.

[0084] In addition to the above, the tool may be provided with a

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calliper means and cutter extension control means responsive to dimension data received from the calliper means.

[0085] Those skilled in the art will appreciate that the examples of the invention given by the specific illustrated and described embodiments show a novel underreaming tool and system and method for underreaming using electronic activation, with numerous variations being possible. These embodiments are not intended to be limiting with respect to the scope of the invention. Substitutions, alterations and modifications not limited to the variations suggested herein may be made to the disclosed embodiments while remaining within the ambit of the invention.

CLAIMS

1 An electronically activated integrated expansion and calliper tool that permits simultaneous underreaming and measurement of the diameter of a wellbore as drilled by an oil and gas rig, comprising at least, one radially extendable cutter block to underream, at least one vibration sensor to detect a stick-slip condition, and at least, one calliper to measure wellbore diameter housed within a tool body

2 The tool of Claim 1 which is inter-linked by a means of communication using sensors and a microprocessor to deliver a desired wellbore diameter

3 The tool of Claim 1 which is activated electronically by using wires, wireless telemetry or electro-magnetic pulses or hard-wiring or a short-hop or combination thereof to built-in mud-pulse telemetry, or using wires, wireless telemetry or electro-magnetic pulses or hard-wiring or a short-hop or combination thereof via a third party mud-pulser either using the annular or drill-pipe

4 The tool of any of the preceding claims where measurements are processed by a downhole microprocessor that compares the measured diameter with a minimum programmed diameter and communication to surface is made via a built-in mud-pulser linked by a short hop or a hard wire or combination thereof which is also used to communicate commands, and receive data from the underreamer or calliper or processor in real-time or memory either using the annular or drill-pipe

5 The tool of any of the preceding claims where communication to surface is made via a third party mud-pulser incorporating a short hop or hard wiring or combination thereof which is also used to communicate commands, and receive data from the underreamer or calliper or processor in real-time or memory either using the annular or drill-pipe

6 The tool of any of the preceding claims where measurements are taken downhole and stored in memory for processing at surface or downhole

7 The tool of any of the preceding claims where the wellbore diameter measurement is used in real-time or memory to deliver or determine the wellbore diameter for a required cementing thickness or a minimum tolerance for casing

8 The tool of any of the preceding claims where the cementing thickness and casing tolerance is required to isolate a well section from the formation or isolate an entire well from the surface formation to the reservoir

9 The tool of any of the preceding claims where the measurement is used to deliver or to calculate the cementing thickness or casing tolerance for an expandable tubular and to

isolate the surface from the reservoir

10 The tool of any of the preceding claims using fibre-optics or wireless transmission for surface communication which is also used to communicate commands, and receive data from the underreamer or calliper or processor during drilling in real-time or memory

11 The tool of Claim 1 where an alert signal is sent to a surface controller in the event of the processor detecting a condition

12 The tool of Claim 11 where the condition detected is related to a minimum or undergauge wellbore diameter or a maximum desired wellbore diameter or a tool fault or tool failure or tool wear or other user defined logic in accordance with Figure 5

13 An apparatus comprising the tool of any one of the preceding claims wherein expansion and calliper means are housed in separate elongate sections or separate tool bodies connected to each other directly or indirectly by means of a connection, (Fig 3) with at least one of said expansion element and at least one calliper located at longitudinally separated positions each connected to a tool body, a first said housing being adapted to underream the wellbore or being adapted to stabilise the tool within the walls of the wellbore during expansion or non-expansion and a second said housing to measure wellbore diameter

14 The apparatus of Claim 13 inter-linked by a means of communication using sensors and a microprocessor to deliver a desired wellbore diameter

15 The apparatus of Claim 13, wherein said housings, sections or bodies include a stabiliser element coupled by means of a connection and where the stabiliser module includes at least one radially extendable stabilising block

16 The apparatus of Claim 15, wherein the calliper is housed within a stabiliser housing, section or body and the calliper measures wellbore diameter and the stabiliser stabilises the tool during expansion or non-expansion

17 The apparatus of any of the preceding claims wherein the cutter blocks are provided with high abrasion and impact resistant cutter inserts and where the stabiliser blocks are provided with smooth resistant surfaces and where the tool body is provided with a through passage for the flow of drilling fluid from the support (90) which exits the tool within a nozzle situated next to or within the cutters

18 The apparatus of any of the preceding claims activated using an electronic signal sent via wireless telemetry or electro-magnetic pulses or hard-wiring or a short-hop or combination

thereof to built-in mud-pulse telemetry, or using wireless telemetry or electro-magnetic pulses or hard-wiring or a short-hop or combination thereof to a third party mud-pulser either using the annular or drill-pipe

19 The apparatus of any of the preceding claims where measurements are processed by a downhole microprocessor that compares the measured diameter with a minimum programmed diameter and communication to surface is made via a built-in mud-pulser linked by a short hop or a hard wire or combination thereof which is also used to communicate commands, and receive data from the underreamer or calliper or processor in real-time or memory either using the annular or drill-pipe

20 The apparatus of any of the preceding claims where communication to surface is made via a third party mud-pulser incorporating a short hop or hard wiring or combination thereof which is also used to communicate commands, and receive data from the underreamer or calliper or processor in real-time or memory either using the annular or drill-pipe

21 The apparatus of Claims 13, 15 and 16 to measure and record wellbore diameter in memory mode by at least one section of the tool and permit transfer of the diameter measurements when the tool is brought to surface.

22 The apparatus of any of the preceding claims using fibre-optics or wireless transmission for surface communication which is also used to communicate commands, and receive data from the underreamer or calliper or processor during drilling in real-time or memory

23 The apparatus of any of the preceding claims where an alert signal is sent to a surface controller in the event of the processor detecting a condition

24 The apparatus of Claim 23 where the condition detected is related to a minimum or undergauge wellbore diameter or a maximum desired wellbore diameter or a tool fault or tool failure or tool wear or other user defined logic in accordance with Figure 5

25 The apparatus of Claims 13, 15 and 16 where the telemetry means is hard wired or uses fibre-optics or includes a short hop or wireless telemetry means or combination thereof to transmit data recorded by said tool to a telemetry pulser for further transmission to the surface

26 The apparatus of any of the preceding where the wellbore diameter measurement is used in real-time or memory to deliver or determine the wellbore diameter for a required cementing thickness or a minimum tolerance for casing

27 The apparatus of Claim 26 where the cementing thickness and casing tolerance is required to isolate a well section from the formation or isolate an entire well from the surface formation to the reservoir

28 The apparatus of Claim 26 where the measurement is used to deliver or to calculate the cementing thickness or casing tolerance for an expandable tubular and to isolate the surface from the reservoir

29 A tool or apparatus as claimed in any one of the preceding claims further comprising telemetry means (56) for communicating sensor data (76), and other control signals between the tool and a surface I/O decoder (14) and user interface (16 or 18) or remote user in real-time so as to optimize performance

30 A tool or apparatus as claimed in any one of the preceding claims connected to a drill-bit, bullnose or rotary steerable or other drill-string or downhole work-string component

31 A tool or apparatus as claimed in any one of the preceding claims where the calliper is an acoustic calliper

32 A tool or apparatus as claimed in any one of the preceding claims where the calliper is a mechanical calliper

33 A tool or apparatus as claimed in any one of the preceding claims wherein at least one positional sensor determines the block position relative to the tool

34 A tool or apparatus as claimed in any one of the preceding claims where measurements are taken downhole and stored in memory for processing at surface or downhole

35 A method of operating an expansion tool or apparatus to enlarge a borehole or tubular or like passage to a target dimension beyond a restriction, which comprises locating a tool as claimed in any one of the preceding claims in a borehole on a support below a restriction, extending the expansion element to an expansion diameter greater than the restriction, rotating the tool and moving it axially along the borehole on the support, measuring wellbore diameter by calliper means, and using the processor acting in response to data received from the calliper means to optimize drilling so as to achieve a target wellbore diameter and depth and reduce common causes of errors or failures.

36 A method as claimed in the preceding claim wherein the surface interface activates the tool or apparatus using electronic means or controls the drill string during the underreaming operation.

37 Underreaming control apparatus comprising an integrated or separately housed calliper and underreamer tool and a processor in

data reception contact with the calliper and in control contact with the underreamer adapted to control the underreamer in response to the calliper data measuring wellbore diameter

38 Underreaming control apparatus according to Claims 29, 31, 32 and 33 further including a surface control and communications and data exchange means between said surface means and processor