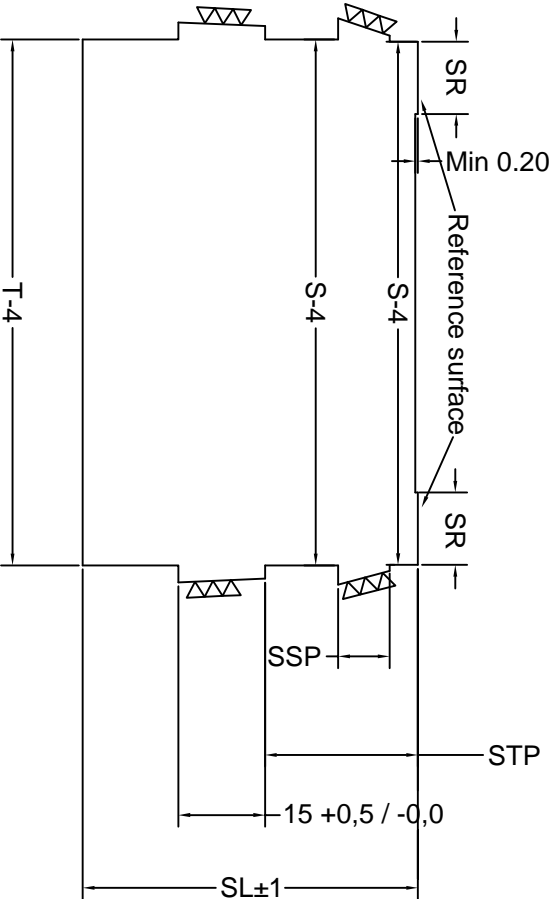
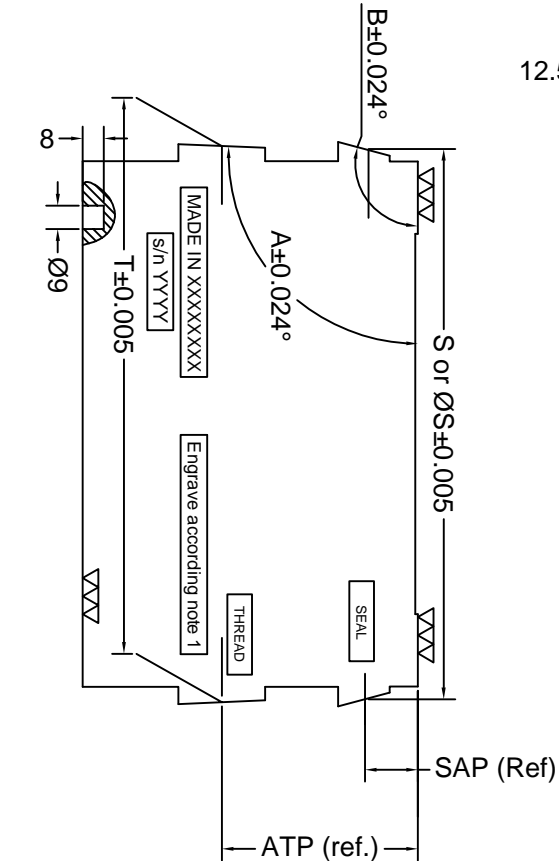
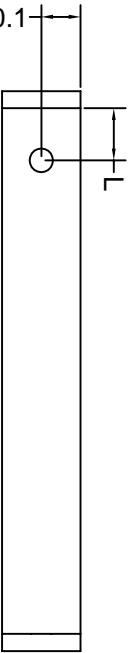
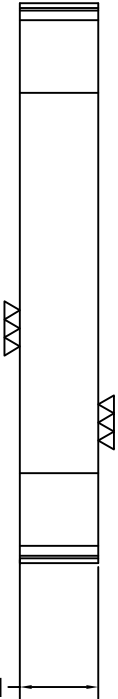


REVISIONS			
Rev	DESCRIPTION	DATE	APPROVED
01	First issued.	23-Aug-13	NCRDWELEY
02	Added Pos. 3 and 4. Updated note 10.	03-Sep-13	NCRDWELEY
03	Added Pos. 5 and 6. Updated note 10.	31-Mar-14	NCRDWELEY
04	Added Pos. 7. and Pos. Rev. column Updated notes 1 & 10.	17-Jul-14	NCRDWELEY



Option (Flat or circular surface)



NOTICE

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PREPARED	ADGGERD	23/Aug/13
CHECKED	EMARTINEZ	23/Aug/13
ENGINEER		
MFG		
QA		
APPROVED	NCRDWELEY	23/Aug/13
RELEASED		

TenarisHydril			
Tenarishydril Blue Max			
Pin Seal and Thread Standard			
SIZE	CODE	IDENT NO.	DRAWING NO.
A4			TSH-GD-79.0001
SCALE	WT.		SHEET 1 OF 2

ENGINEERING CHANGE

PARTS DISPOSITION	WORK SHEET	DWG NO.	REV
RAW MAT'L	1	5	9
IN PROCESS	2	6	10
COMPLETED	3	7	11
ASSEMBLED	4	8	12

REASON FOR CHANGE/S AND/OR DISPOSITION NOTED
Added new position. Updated notes 1 & 10.

REVISIONS				
Rev	DESCRIPTION	DATE	APPROVED	
01	First Issued.	23-Aug-13	NCDWLEY	
02	Added Pos. 3 and 4. Updated note 10.	03-Sep-13	NCDWLEY	
03	Added Pos. 5 and 6. Updated note 10.	31-Mar-14	NCDWLEY	
04	Added Pos. 7 and Pos. Rev. column) Updated notes 1 & 10.	17-Jul-14	NCDWLEY	


- Notes:
- Engrave "TSH-GD-07.0010 Rev ...Pos" Rev. number according to Pos. Revision column of the table. Pos. Revision is independent from drawing revision.
 - Engrave Thread and Seal. Words shall be 0.8mm deep.
 - Material: Thyrodur 2990.

Heat treatment:

- Stress Relief at 650°CX 2 hours, as an intermediate step between machining and grinding.
- Vacuum quenching from an austenitising temperature of 1070 - 1080°C to room temperature.
- Cooling: Subzero up to -80°C and then tempered twice at 520°C. Hardness required 58-60 HRC.

- Serial Number - (according to vendor's identification).
- Taper surfaces for thread and seal axis shall be perpendicular to the reference surface.
- Dimensions S, SAP, T, ATP, Angle A and Angle B shall be certified.
- Corrosion protection and packaging shall be according to TenarisConnections specification.
- Certificate shall be according TenarisConnections specification.
- Mark seal setting point on both seal pads.
- Setting standard Pos. 1 IAW PREN drawings PREN-PC-TBM Rev. 02 and TBM-9875-6880-SD-PDDS-C.
- Setting standard Pos. 2 IAW PREN drawings PREN-PC-TBM Rev. 02 and TBM-13625-8820-PDDS-D.
- Setting standard Pos. 3 IAW PREN drawings PREN-PC-TBM Rev. 02 and TBM-10125-7930-PDDS-D.
- Setting standard Pos. 4 IAW PREN drawings PREN-PC-TBM Rev. 02 and TBM-14000-11400-PDDS-B.
- Setting standard Pos. 5 IAW PREN drawings PREN-PC-TBM Rev. 02 and TBM-7000-4100-PDDS-C.
- Setting standard Pos. 6 IAW PREN drawings PREN-PC-TBM Rev. 02 and TBM-10000-7390-PDDS-A.
- Setting standard Pos. 7 IAW PREN drawings PREN-PC-TBM Rev. 03 and TBM-7750-4610-PDDS-B.

TSH-GD-79.0001 - Pin Seal and Thread Standard													
Position	Pos. Revision	Diameter	A	ATP (ref.)	T or ØT	B	SAP (ref.)	S or ØS	STP	SSP	SL	L	SR
5	01	7"	92.348	47.715	175.550	94.092	17.955	169.380	40	15	69	35	40
7	01	7 3/4"	92.348	47.715	194.750	94.092	17.955	188.580	40	15	69	38	40
1	01	9 7/8"	92.348	51.895	249.980	94.092	22.955	243.880	44	15	73	49	40
6	01	10"	92.348	51.895	249.980	94.092	22.955	243.880	44	15	73	49	40
3	01	10 1/8"	92.348	51.895	254.080	94.092	22.955	247.980	44	15	73	50	40
2	01	13 5/8"	92.348	53.655	342.030	94.092	22.955	335.780	46	15	83	68	50
4	01	14"	92.348	53.665	351.530	94.092	22.955	345.280	46	15	83	70	50

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						CHECKED	EMARTINEZ	23/Aug/13			
						ENGINEER					
						MFG					
						QA			<div> <p>Pin Seal and Thread Standard</p> <p>SIZE</p> <p>A4</p> <p>CODE IDENT NO.</p> <p>TSH-GD-79.0001</p> <p>DRAWING NO.</p> <p>REVISION</p> <p>04</p> </div>		
						APPROVED	NCDWLEY	23/Aug/13			
						APPROVED					
						RELEASED					
									SCALE	WT.	SHEET 2 OF 2