

01

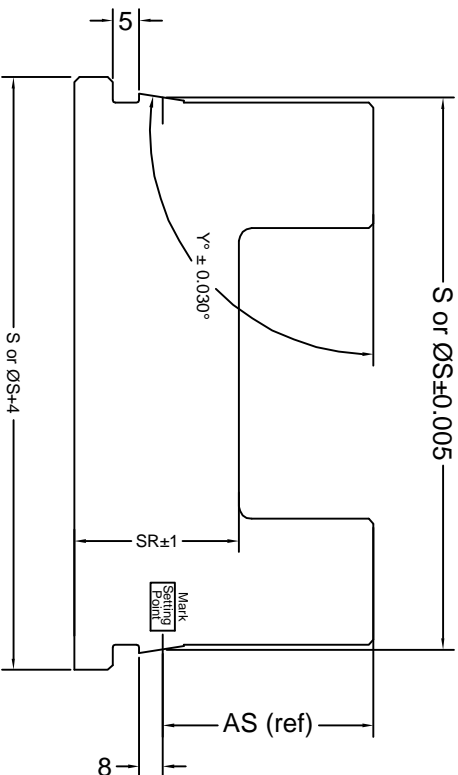
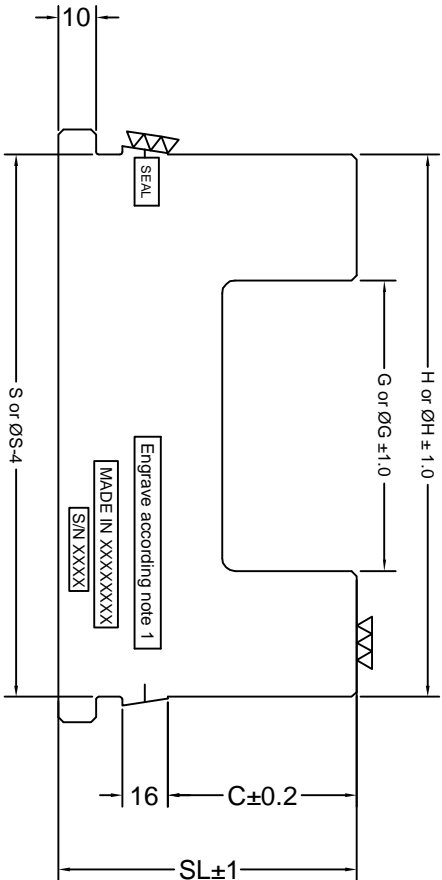
02

03

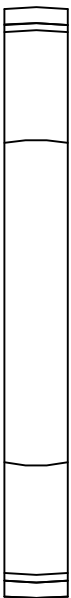
04

05

Engrave "Base"



Option (Circular or flat surface)



Notes: -Tolerance $S \pm 0.005 \text{ mm}$ is for the manufacturing supplier and

$\pm 0.010 \text{ mm}$ for the hubs.

-The standard will be verify once arrives to the hubs and the measurement will be loaded into the MTR.

- No compensation values will be allowed. If the hub find tolerances out of $\pm 0.010 \text{ mm}$ has to contact Tenaris Connection.

Notes:

- 1.- Engrave "TSH-GD.04.0002 Rev ... Pos"
- 2.- Engrave Seal. Words shall be 0.8mm deep.
- 3.- Material: Thyrodur 2990 Heat treatment:
- a) Stress Relief at $650^\circ\text{C} \times 2 \text{ hours}$, as an intermediate step between machining and grinding.
- b) Vacuum quenching since a temperature of austenitising 1070°C - 1080°C at room temperature
- c) Cooling: Subcoero up to -80°C and then tempered twice at 520°C . Hardness requested 58-60 HRC
- 4.- Serial Number- (according to the supplier identification)
- 5.- Taper surfaces for thread and seal axes shall be perpendicular to the reference surface.
- 6.- Dimensions S, AS and Angle Y shall be certified.
- 7.- The Corrosion Protection and Packaging shall be according to TenarisConnections specification.
- 8.- The Certificate shall be according TenarisConnections specification.

TenarisConnections

MODIFICATIONS


Rev	Description	Draw	Chk	App	Date
02	Added pos. 32 and changed seal length	JPA	ELT	NCR	17.5.10
03	Added new positions & engrave block	JPA	BTL	NCR	15.03.10

OBJECT: Tenarishydril Blue Near Flush

DETAIL: Pin External Seal Standard

Scale:	NOT	Date:	23/Sep/09	DRAWING N.:	TSH-GD.04.0002	R E V	N
Drawn by:	JPA	Checked by:	ELT	Approved by:	NCR	03	1/2

Std Rev	Diameter	lb/ft	Wall Thickness	Position	Angle Y°	AS Ref	S or Diam S	C	G	H	SR	SL
01	5	18.00	0.36	31	94.764	99.760	125.920	91.8	20.9	120.9	55.0	122.8
0	5	20.30	0.41	0	0.000	0.000	0.000	0.0	0.0	0.0	0.0	0.0
0	5	20.80	0.42	0	0.000	0.000	0.000	0.0	0.0	0.0	0.0	0.0
0	5	21.40	0.44	0	0.000	0.000	0.000	0.0	0.0	0.0	0.0	0.0
0	5	23.20	0.48	0	0.000	0.000	0.000	0.0	0.0	0.0	0.0	0.0
01	5.5	23.00	0.42	1	94.764	99.815	137.950	91.8	33.0	133.0	55.0	122.8
0	5.5	26.00	0.48	0	0.000	0.000	0.000	0.0	0.0	0.0	0.0	0.0
0	6.625	28.00	0.42	0	0.000	0.000	0.000	0.0	0.0	0.0	0.0	0.0
0	6.625	32.00	0.48	0	0.000	0.000	0.000	0.0	0.0	0.0	0.0	0.0
02	7	26.00	0.36	32	94.764	116.442	177.400	108.4	72.4	172.4	60.0	139.4
01	7	29.00	0.41	2	94.764	107.325	177.160	99.3	72.2	172.2	60.0	130.3
01	7	32.00	0.45	3	94.764	132.721	176.880	124.7	71.9	171.9	60.0	155.7
01	7	35.00	0.50	4	94.764	113.672	176.650	105.7	71.7	171.7	60.0	136.7
01	7	38.00	0.54	5	94.764	132.719	175.660	124.7	70.7	170.7	60.0	155.7
03	7	41.00	0.59	33	94.764	126.369	175.460	118.4	70.5	170.5	60.0	149.4
03	7.625	29.70	0.38	34	94.764	111.358	192.800	103.4	87.8	187.8	60.0	134.4
01	7.625	33.70	0.43	6	94.764	120.019	192.640	112.0	87.6	187.6	60.0	143.0
01	7.625	39.00	0.50	7	94.764	120.019	192.110	112.0	87.1	187.1	60.0	143.0
01	7.625	42.80	0.56	8	94.764	139.070	191.900	131.1	86.9	186.9	60.0	162.1
03	7.625	45.30	0.60	35	94.764	139.070	191.480	131.1	86.5	186.5	60.0	162.1
03	7.625	47.10	0.63	36	94.764	139.069	191.390	131.1	86.4	186.4	60.0	162.1
01	7.75	46.10	0.60	9	94.764	126.371	194.280	118.4	89.3	189.3	60.0	149.4
03	7.75	48.60	0.64	37	94.764	145.419	194.640	137.4	89.6	189.6	60.0	168.4
03	8.625	36.00	0.40	38	94.764	121.522	218.320	113.5	93.3	213.3	70.0	144.5
03	8.625	40.00	0.45	39	94.764	120.019	218.070	112.0	93.1	213.1	70.0	143.0
03	8.625	44.00	0.50	40	94.764	126.369	217.910	118.4	92.9	212.9	70.0	149.4
03	8.625	49.00	0.56	41	94.764	126.369	217.410	118.4	92.4	212.4	70.0	149.4
0	8.625	52.00	0.60	0	0.000	0.000	0.000	0.0	0.0	0.0	0.0	0.0
03	9.625	40.00	0.40	42	94.764	111.359	243.420	103.4	118.4	238.4	70.0	134.4
01	9.625	43.50	0.44	10	94.764	107.319	243.910	99.3	118.9	238.9	70.0	130.3

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MODIFICATIONS										OBJECT: TenarisHydril Blue™ Near Flush										
Rev	Description					Draw	Chk	App	Date	DETAIL: Pin External Seal Standard										
02	Added pos. 32 and changed seal length					JPA	ELT	NCR	7-5-10											
03	Added new positions & engrave BSRG					JPA	BTL	NCR	9-5-10											
Scale:	NOT				Date:	23/Sep/09				DRAWING N.:										
Drawn by:	JPA		Checked by:		ELT		Approved by:		NCR		TSH-GD.04.0002 03 2/3									
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