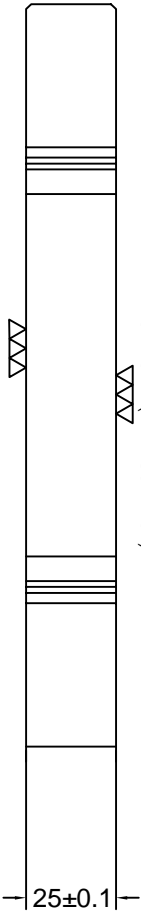
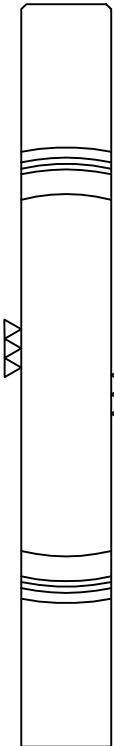


OPTION 1 (FLAT SURFACE)



OPTION 2 (CIRCULAR SURFACE)



Notes:

- 1.- Engrave "TSH-GD-25.0001 Rev.. Pos"
- 2.- Engrave "Thread" where written thread. Words shall be 0.8mm deep.
- 3.- Material: Thyrodur 2990 Heat treatment:
 - a) Stress Relief at 650°C X 2 hours, as an intermediate step between machining and grinding.
 - b) Vacuum quenching from an austenitising temperature of 1070 - 1080 °C to room temperature
 - c) Cooling: Subzero up to -80°C and then tempered twice at 520°C. Required hardness 58-60 HRC
- 4.- Serial Number - (according to the supplier identification)
- 5.- Taper surfaces for thread and seal axis shall be perpendicular to the reference surface.
- 6.- Dimensions T, ATP and Angle TA shall be certified.
- 7.- Corrosion Protection and Packaging shall be according to TenarisConnections specifications.
- 8.- Certificate shall be according TenarisConnections specifications.



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OBJECT:

Tenaris XP
Buttress XTC

MODIFICATIONS


Rev	Description	Draw	Chk	App	Date
01	First issued	BTL	JPA	NCR	11-Aug-10
02	New positions added	OGA	BTL	NCR	In process

Scale: NOT Date: 30-Oct-12

Drawn by:	Checked by:	Approved by:	DRAWING N.:	R E V	Ni
OGA	BTL	NCR	TSH-GD-25.0001	02	1/2

TSH-GD-25.0001															
Position	Updated on Revision	Diameter	Weight	ATP (Ref)	T or Diam T	Angle TA	R	SW	STP	SZ	SR	SL	S	AS	SP
1	01	4 1/2	All	47.854	111.785	88.210	116.785	216.785	39.854	16.000	60.000	179.006	112.090	99.506	5.000
2	01	5 1/2	All	45.314	137.185	88.210	142.185	242.185	37.314	16.000	60.000	183.782	137.033	104.282	5.000
3	01	7	All	45.314	175.285	88.210	180.285	280.285	37.314	16.000	60.000	193.307	174.523	113.807	5.000
4	01	9 5/8	All	45.314	241.960	88.210	246.960	346.960	37.314	16.000	60.000	201.231	240.716	121.731	5.000
5	02	5	All	45.314	124.485	88.210	129.500	230.000	37.314	16.000	60.000	182.000	124.435	102.681	5.000
6	02	6 5/8	All	45.314	165.760	88.210	171.000	271.000	37.314	16.000	60.000	188.500	165.303	109.031	5.000
7	02	7 5/8	All	45.314	191.160	88.210	196.000	296.000	37.314	16.000	60.000	198.000	190.119	118.556	5.000
8	02	8 5/8	All	45.314	216.560	88.210	222.000	322.000	37.314	16.000	60.000	201.000	215.316	121.731	5.000
9	02	10 3/4	All	45.314	270.535	88.210	276.000	395.000	37.314	16.000	70.000	211.000	269.291	121.731	5.000
10	02	11 3/4	All	45.314	295.935	88.210	301.000	440.000	37.314	16.000	80.000	221.000	294.691	121.731	5.000
11	02	13 3/8	All	45.314	337.210	88.210	342.000	482.000	37.314	16.000	80.000	221.000	335.966	121.731	5.000
12	02	16	All	33.350	403.479	87.615	409.000	549.000	25.350	16.000	80.000	221.000	399.694	121.731	5.000

Notes: - T dimension Manufacturing Tolerances: +/- 0.005 mm or (+/- .0002"). Tolerances used for manufacturing purposes.
- T dimension Calibration Tolerances: +/- 0.010 mm or (+/- .0004"). Tolerances used for calibration purposes only.
- No compensation values are allowed. If tolerances are found out of specification (+/- 0.010 mm) or (+/- .0004") Manufacturing Services Gages Manager shall be contacted.



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MODIFICATIONS

Rev	Description	Draw	Chk	App	Date
01	First issued	BTL	JPA	NCR	1 May 16
02	New positions added	OGA	BTL	NCR	provisional

OBJECT:

Tenaris XP
Buttress XTC

DETAIL:

Box Thread & Cylinder
Diameter Standard

Scale: NOT

Drawn by: OGA

Checked by: BTL

Date: 30-Oct-12

Approved by: NCR

DRAWING N.:

TSH-GD-25.0001

R E V

M page

02 2/2