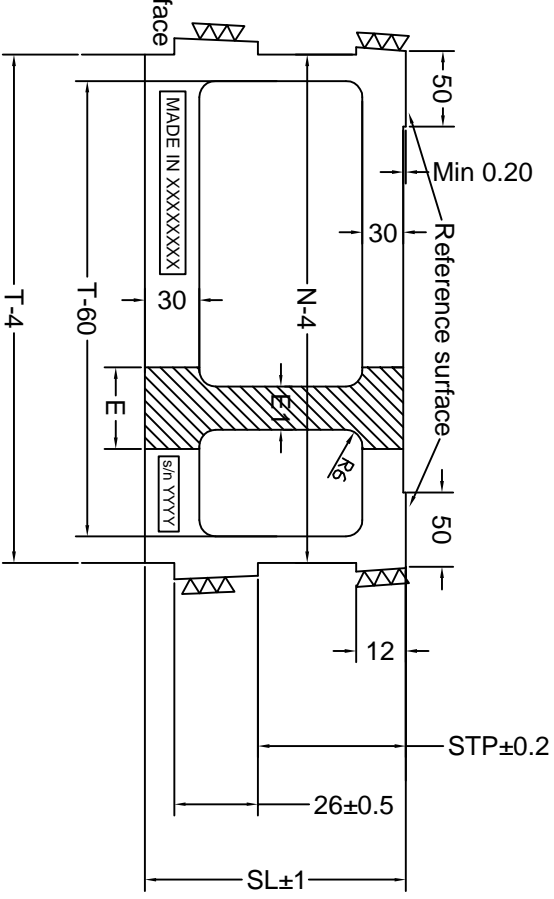


Options (Flat or circular surface)



Notes:

- 1.- Engrave "TSH-GD-08.0003 Rev ... Pos. ...."
- 2.- Engrave Thread and seal. 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 since a temperature of austenitising 1070- 1080 °C at room temperature
  - c) Cooling: Subzero 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 T, N, Ref 3.962 and 59.970 and Angles 93.576° shall be certified.
- 7.- The Corrosion Protection and Packaging shall be according to TenarisConnections specification.
- 8.- The Certificate shall be according TenarisConnections specification.



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MODIFICATIONS

Rev	Description	Draw	Chk	App	Date
05	Position N° 7 changed T value	JPA	BTI	NCR	02/01/2
04	Added position N°11	JPA	ELT	NCR	04/27/1
03	Changed length L	JPA	ELT	NCR	04/06/1
02	Added a hole at the base on one side	JPA	ELT	NCR	01/09/0

DETAIL:

Pin Nose and Thread  
Std 18 5/8" to 24 1/2"



DRAWING N.:

Drawn by: JPA	Checked by: ELT	Approved by: NCR	TSH-GD-08.0003	05	1/2
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All the changes do not affect the functionality of the Standards made with previous revisions.

Pos	Diameter	Drawing N°	T	ATP	STP	N	B°	SL	E	E1	L
1	18 5/8"	CT4-8617	468.225	59.970	47.0	456.469	93.576	90	30	16	103
2	18 5/8"	CT4-8307	468.225	27.470	14.5	461.170	90.000	99	30	16	103
3	18 5/8"	CT4-8353	468.225	39.970	27.0	458.969	93.576	99	30	16	103
4	20"	CT4-8369	503.125	27.470	14.5	496.070	90.000	103	30	16	111
5	20"	CT4-8201 / 8768/ 8808	503.125	39.970	27.0	493.869	93.576	103	30	16	111
6	22"	CT4-8525	553.925	59.970	47.0	542.169	93.576	100	35	19	122
7	24"	CT4-8745	604.725	27.470	14.5	597.670	90.000	109	35	19	133
8	24"	CT4-8754	604.725	39.970	27.0	595.469	93.576	109	35	19	133
9	24 1/2"	CT4-8332	617.425	27.470	14.5	610.370	90.000	109	35	19	136
10	24 1/2"	CT4-8313	617.425	39.970	27.0	608.169	93.576	109	35	19	136
11	22"	PREN-PC-TER-2200-27540	550.245	59.970	47.0	538.489	93.576	100	35	19	122

Notes: -Tolerances T and N according drawing are for the manufacturing supplier.  
-Tolerances T and N increased +/-0.005mm are for the hubs.  
-The original certificate submitted by the supplier will be loaded into the MTR.  
- No compensation values will be allowed. If the hub find tolerances out has to contact Tenaris Connections

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MODIFICATIONS						OBJECT:	
Tenarishydril ER							
Rev	Description	Draw	Chk	App	Date	DETAIL:	
05	Position N° 7 changed T value.	JPA	BTL	NCR	02/01/2	Pin Nose and Thread	
04	Added position N°11	JPA	ETL	NCR	04/27/1	Std 18 5/8" to 24 1/2"	
03	Changed length L	JPA	ETL	NCR	04/06/1		
02	Added a hole at the base of one side	JPA	ETL	NCR	01/09/0		
		Scale: NOT		Date: 06/07/10		DRAWING N.:	
Drawn by: JPA		Checked by: ETL		Approved by: NCR		TSH-GD-08.0003	
						R E V	
						N	
						05	
						2/2	
						pages	

All the changes do not affect the functionality of the Standards made with previous revisions.