



- Notes:
- 1.- Engrave "TSH-GD-03.0002 Rev. ... Pos. ..."
 - 2.- Engrave Thread and Cylinder letters 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 S, Ref 4.00, T, ATP, Angle TA and TB shall be certified.
 - 7.- The Corrosion Protection and Packaging shall be according to TenarisConnections specification.
 - 8.- The Certificate shall be according TenarisConnections specification.

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



MODIFICATIONS

Rev	Description	Draw.	Chk.	App.	Date
01	New Issued	JPA	ELT	NCR	Issue
02	Changed TA and 90° angles tolerances	JPA	ELT	NCR	Issue

OBJECT: TenarisHydril Blue Thermal Liner

DETAIL: Box Thread and Cylinder Std - 6 5/8" to 10 3/4"

Scale:	NOT	Date:	15-Oct-09
Drawn by:	JPA	Checked by:	ELT
		Approved by:	NCR

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Position	Diameter	TA	T or ØT	ATP	R or ØR	STP	Tol A	E2 or ØE2	SW	SR	SL
1	6 5/8"	92.434	164.900	47.1	168.0	39.1	0.015	161.550	268	60	150.1
2	7"	92.434	174.800	42.4	178.0	34.4	0.030	170.600	278	60	145.4
3	8 5/8"	92.434	217.460	40.0	221.0	32.0	0.030	211.980	341	60	143.0
4	9 5/8"	92.434	243.120	40.0	246.0	32.0	0.030	236.550	366	70	153.0
5	10 3/4"	92.434	272.000	40.0	275.0	32.0	0.030	264.900	395	70	153.0

- Notes: -Tolerances T +/- 0.005 mm and E2 +/-A are for the manufacturing supplier.
- Tolerances T +/- 0.010 mm and E2 +/- A increased by +/- 0.005mm are for the hubs.
 - The standard will be verify at the local hub once it is received and will be loaded into the MTR.
 - No compensation values will be allowed.



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Rev	Description	Draw	Chk	App	Date	
01	New Issued	JPA	ELT	NCR	Issue	DETAIL: TenarisHydril Blue Thermal Liner
02	Changed TA" and 90° angles	JPA	ELT	NCR	Issue	
	Tolerances					

Scale: NOT

Drawn By: JPA

Checked by: ELT

Date: 15-Oct-09

Approved by: NCR

DRAWING N.:

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