

REVISIONS				
Rev	DESCRIPTION	DATE	APPROVED	
01	First issued.	05-May-14	NCRDWLEY	
02	ATP is 106,921, was 85,291. T or ØT is 262,323, was 262,338. STP is 990, was 774. SL is 217, was 195. SS is 151,112, was 128,482 Added column Pos. Revision. Updated notes 1, 10 and gauge name.	05-May-14	NCRDWLEY	

- Notes:
- 1.- Engrave "TSH-GD-74.0002 Pos. :.. Rev. :.." Rev. number according to Pos. Revision column of the table. Pos. Revision is independant from drawing revision.
 - 2.- Engrave Thread and Seal. Words shall be 0.8mm deep.
 - 3.- Material: Thyrodur 2990.
- Heat treatment:
- a) Stress Relief at 650°CX 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. Hardness required 58-60 HRC.
- 4.- Serial Number - (according to vendor's identification).
 - 5.- Taper surfaces for thread and seal axis shall be perpendicular to the reference surface.
 - 6.- Dimensions S, SAP, T, ATP, SS; Angle A and Angle B shall be certified.
 - 7.- Corrosion protection and packaging shall be according to TenarisConnections specification.
 - 8.- Certificate shall be according TenarisConnections specification.
 - 9.- Mark seal setting point on both seal pads.
 - 10.- Setting standard Pos. 1 IAW PREN drawings PREN-PC-TBL-K-10750 Rev. 04.
 - 11.- Face to shoulder gage contact tip diameter shall be 0.096".

Position	Pos. Revision	Diameter	A	ATP (ref.)	T or ØT	B	SAP (ref.)	S or ØS	STP	SL	SR	R or ØR	SW	SS
1	02	10 3/4"	92.434	106.921	262.323	94.764	2.292	257.989	99.0	217	77	267	387	151.112

NOTICE

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MFG

QA

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RELEASED

ADGGERD

S.NEVLUD

NCRDWLEY

15-Apr-14

05-May-14

05-May-14

TenarisHydril

TenarisHydril Blue /K

Box Internal Seal and Thread Standard

SIZE

A4

CODE

IDENT NO.

DRAWING NO.

TSH-GD-74.0002

REVISION

02

SCALE

WT.

SHEET

2

OF

2