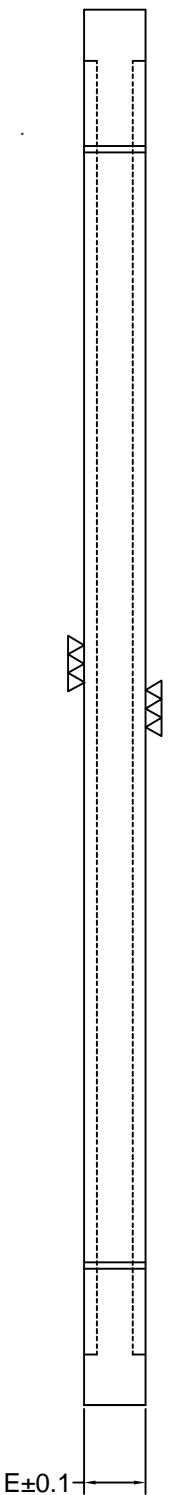



OPTION (FLAT OR CIRCULAR SURFACE)



Notes:


- 1.- Engrave "TSH-GD-08.0004 Rev... Pos ..."
- 2.- 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
- 3.- Serial Number- (according to the supplier identification)
- 4.- Taper surfaces for thread and seal axes shall be perpendicular to the reference surface.
- 5.- Dimensions T, C, D1, Ref 36.0; Angles 93.5/6 and 90 shall be certified.
- 6.- The Corrosion Protection and Packaging shall be according to TenarisConnections specification.
- 7.- The Certificate shall be according TenarisConnections specification.

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

 TenarisConnection						<p>Confidential property of Tenaris Connections AG. Copy, use or disclosure of this document or any data contained herein without the written consent of Tenaris Connections AG is prohibited. Copyrighted (2002) as an unpublished work. ALL RIGHTS RESERVED.</p>	
MODIFICATIONS						OBJECT:	
Rev	Description	Draw	Chk	App	Date	DETAIL: Box Cylinder & Thread Std - 18 5/8" to 24 1/2"	
03	Added position N° 11	JPA	ELT	NCR	4/27/10		
02	Changed T and axial T reference	JPA	ELT	NCR	6/6/10		
01	New Issued	JPA	ELT	NCR	6/07/10		
Scale: NOT		Date:		06/07/10			
Drawn by: JPA		Checked by: ELT		Approved by: NCR		DRAWING N.:	
						TSH-GD-08.0004	
						03 1/2	

Pos	Diameter	Drawing	T or ØT	C or ØC	SL	SW	E1	E	L1	D1
1	18 5/8"	CT4-8617	469.100	458.200	191	582	16	30	60	139.820
2	18 5/8"	CT4-8307	469.100	462.300	191	595	16	30	60	107.420
3	18 5/8"	CT4-8353	469.100	460.700	191	595	16	30	60	119.920
4	20"	CT4-8369	504.000	497.200	191	634	16	30	60	107.420
5	20"	CT4-8201/8768/8808	504.000	495.600	191	634	16	30	60	119.920
6	22"	CT4-8525	554.800	543.900	201	684	19	35	70	139.820
7	24"	CT4-8745	605.600	598.800	201	756	19	35	70	107.420
8	24"	CT4-8754	605.600	597.200	201	756	19	35	70	119.920
9	24 1/2"	CT4-8332	618.300	611.500	201	768	19	35	70	107.420
10	24 1/2"	CT4-8313	618.300	609.900	201	768	19	35	70	119.920
11	22"	PREN-PC-TER-2200-27540	554.800	540.200	201	684	19	35	70	168.820

Notes: -Tolerances T, C and D1 according drawing are for the manufacturing supplier.
-Tolerances T, C and D1 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

Rev	Description	Draw	Chk	App	Date
03	Added position W* 11	JPA	ELT	NCR	4/27/11
02	Changed T and axial T reference	JPA	ELT	NCR	9/16/11
01	New Issued	JPA	ELT	NCR	6/07/10

OBJECT: TenarisHydril ER

DETAIL: Box Cylinder & Thread Std - 18 5/8" to 24 1/2"

Scale: NOT

Date: 06/07/10

DRAWING N.:

Drawn by: JPA

Checked by: ELT

Approved by: NCR

TSH-GD-08.0004

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

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