



**TEC-LOCK WEDGE
SPECIFICATIONS**

SECTION	V	
Prepared By	GJR	03/30/20
Engineer	SJH	03/31/20
GGM QA	ALR	03/31/20
REVISION	001	04/01/20

SUBJECT: VISUAL THREAD INSPECTION

1.0 SCOPE

1.1 This document sets forth the broad guidelines for the field visual thread inspection of Hunting’s **TEC-LOCK WEDGE** connection by independent inspection agencies.

2.0 DEFINITION

2.1 Visual thread inspection shall be defined as the inspections that may be performed on Hunting’s proprietary connections without the use of proprietary thread element gages.

3.0 PIN/FIELD END INSPECTION

3.1 Pin Face

- 3.1.1 Ensure that the pin nose radius is fully blended and is free from sharp edges or burrs.
- 3.1.2 Visually inspect the pin face for surface irregularities. Minor dents or dings to the pin face are allowed and can be repaired by lightly filing to remove all protrusions. The repair of such conditions during the running of the connection is at the discretion of Hunting’s service representative.
- 3.1.3 The pin face, ID chamfer and OD chamfer are to be smooth and free from burrs.

3.2 Threaded Area

3.2.1 Visually inspect the full form thread for damage. Small areas of impact damage or galls occurring during handling must be repaired. Field repairable thread damage on new connectors shall not exceed 1/4 revolution in circumferential length or 0.010" in depth. All repairs shall be covered with anti-gall and anti-corrosion compound such as Molybdenum Disulfide Spray.

3.2.2 Allowable corrosion pitting in the full form thread area shall be 1/4 revolution or 0.010" in depth as defined in the **ANCILLARY SPECIFICATION** title **STEEL IMPERFECTIONS**.

4.0 BOX/ MILL END INSPECTION

4.1 Threaded Area

4.1.1 Visually inspect the full form threaded area for damage. Small areas of impact damage or galls occurring during handling must be repaired. Field repairable thread damage on new connectors shall not exceed 1/4" revolution in circumferential length or 0.010" in depth. All repaired areas should be covered with an anti-gall and anti-corrosion compound such as Molybdenum Disulfide Spray.

4.1.2 Allowable corrosion pitting in the full form thread area shall be 1/4 revolution or 0.010" in depth as defined in the **ANCILLARY SPECIFICATION** title **STEEL IMPERFECTIONS**.

4.2 Box Face

4.2.1 Visually inspect the box connection face and OD chamfer for impact damage. Impact damage. Minor impact damage may be repaired by a light filing.

5.0 CONNECTION GAGING

5.1 The gaging of Hunting’s proprietary connections shall only be performed by a Hunting Quality Assurance or Service Representative or an approved Licensee. Hunting personnel or Licensee are the only persons that have access to the proprietary gages used to perform dimensional inspection of the manufactured products.



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6.0 STORAGE COMPOUND

6.1 Upon completion of visual thread inspection verify appropriate storage compound is being applied to both ends of the tube. The approved storage compound shall be as stated in the applicable "FIELD RUNNING AND HANDLING PROCEDURE".

NOTE: Notify Hunting Northchase, Houston, Texas, Quality Assurance Department immediately if storage compound being applied is not listed in the applicable "FIELD RUNNING AND HANDLING PROCEDURE".

7.0 LONG TERM STORAGE

For long term storage (more than 30 days), the connections shall be properly protected with a storage compound and properly tightened thread protectors. Hunting recommends the use of Kendex as the approved storage compound.

7.1 Remove the thread protectors.

7.2 Clean the connections using soap and water (preferable). Thoroughly dry the connectors and thread protectors.

NOTE: Care must be taken to ensure that the cleaning process does not cause environmental pollution.

7.3 Verify that the connection is clean and free from contaminants.

7.4 Verify that there is no visual damage on the thread of the connection. If any damage is found, please contact Hunting's QA Department.

7.5 Apply WD-40, CRC SP-350 or any other water displacing corrosion inhibitor prior to applying Kendex.

7.6 Apply Kendex on all areas of the connection. Please verify that there is no holidays or places without storage compound. Failure to do so, may lead to oxidation or pitting of the areas not covered by the storage compound.

7.7 Clean the thread protectors. The protectors shall be free from debris, dirt, oil and any other contaminant.

7.8 Apply the thread protectors and verify that they are tight.

8.0 RIG PREP

NOTE: For thread compounds, please refer to Hunting's website to verify the current Recommended Thread Compounds approved by Hunting—Per Connection List.

To access the list, visit www.hunting-intl.com, click on "Connection Technology" and look for the link: "Recommended Thread Compounds approved by Hunting."

8.1 Remove the thread protectors.

8.2 Clean the connections using soap and water (preferable). Thoroughly dry the connectors and thread protectors.



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NOTE: Care must be taken to ensure that the cleaning process does not cause environmental pollution.

- 8.3 Verify that the connection is clean and free from contaminants.
- 8.4 Verify that there is no visual damage on the thread of the connection. If any damage is found, please contact Hunting's QA Department.
- 8.5 Apply the water displacing corrosion inhibitor (WD-40, CRC-3-36, CRC SP-350 or equivalent) on the entire area of the connectors. A thin and even coat shall be applied.
- 8.6 Apply Kendex or recommended thread compound.
- 8.7 Clean and dry the thread protectors. The protectors shall be free from debris, oil and any other contaminant.
- 8.8 Apply the thread protectors and verify that they are tight.

Failure to follow these direction can be detrimental to the connections.

9.0 REJECTION

- 9.1 Any thread that does not meet the specified requirements, shall be considered a reject.
- 9.2 All rejects shall have the entire thread area painted red.
- 9.3 All rejects shall be clearly identified as "reject" to protect against out-of-tolerance material being shipped as prime material.
- 9.4 Rejection may be reworked by removing the defective condition and re-threading the parts within the appropriate tolerances.
- 9.5 Any discrepancies shall be clarified and dispositioned by Hunting's Q.A. Department before any further processing or delivery.