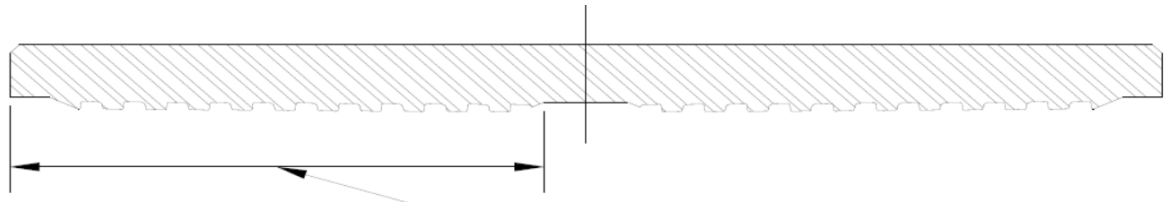
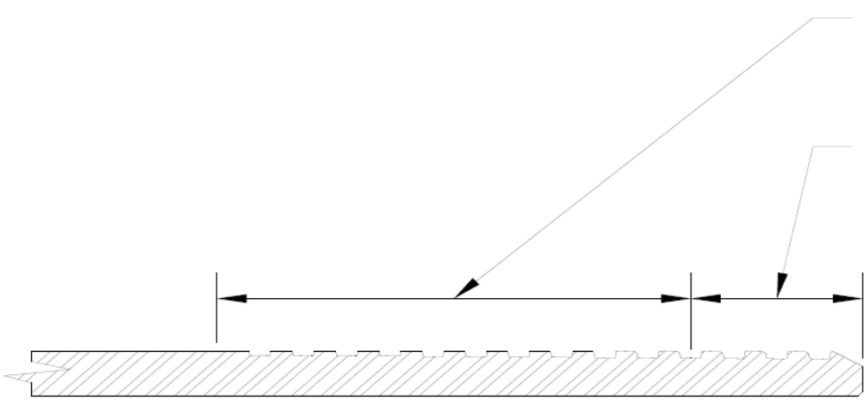


**Thread Compound Application
TKC-LOCK BTC**



Even light application of API MODIFIED
THREAD COMPOUND over



Even light application of API MODIFIED
THREAD COMPOUND to

No thread API MODIFIED THREAD COM-
POUND applied to the full

Figure A

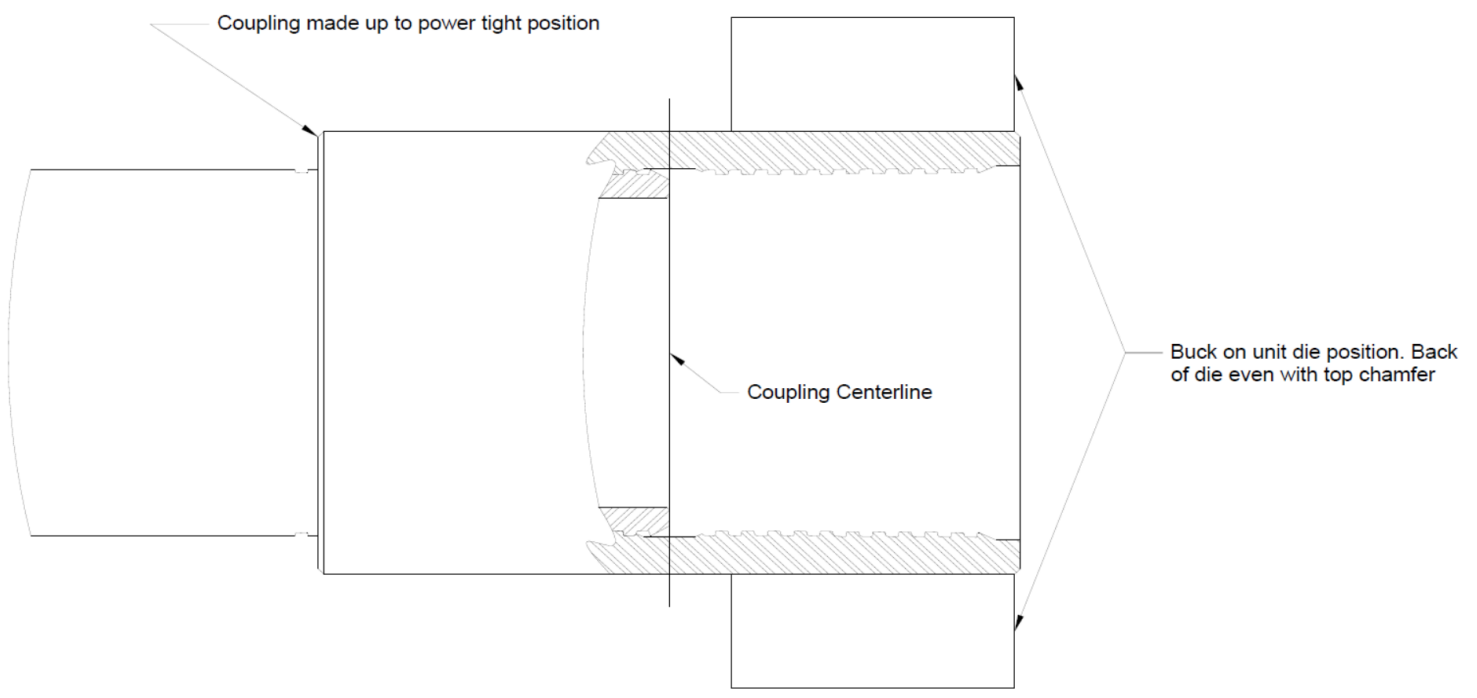


Figure B

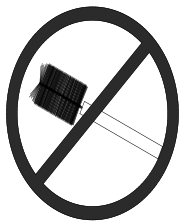


**TEC-LOCK BTC
ANCILLARY
SPECIFICATION**

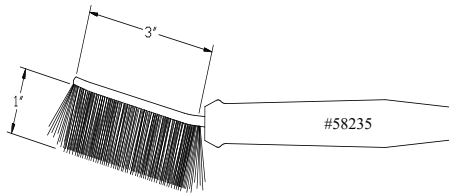
SECTION	V	
Prepared By	ED	09/13/18
Engineer	SJH	09/14/18
GM QA	GJR	09/13/18
REVISION	000	09/14/18

SUBJECT: COUPLING MAKE-UP

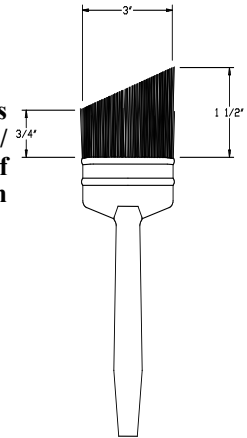
NOTE: A light to moderate, even coating of thread compound is defined as all thread surfaces, root and crest, and pin face/ torque shoulder covered with an even coating of threadcompound. However, the thread form should remain clearly visible.



Do Not Use
Bottle Brush



Preferred Moustache Brush #58235



Alternate Acceptable
Modified Paint Brush

- 5.3 Apply the box or coupling to the pin end by hand to the hand-tight position.
- 5.4 Position the connection in the power tongs. See Figure B for the proper buck on unit die position.
- 5.5 Apply the specified torque to the connection at 5-15 RPM. Make-up speed should not exceed 15 rpm. Make-up speed should not vary excessively during make-up and should be continuous with no gear changing.

NOTE: The TEC-LOCK BTC connection is a position make-up connection, and the pin connector on the mill end shall be located in the middle of the coupling (see Figure B and D). The tolerance is “Make-up Loss Length -1/32” - 1/8”.

- 5.6 **OPTIONAL** Make-up Torque/Turn Monitoring
 - 5.6.1 Optional Torque-Turn Equipment - A torque-turn /time or torque/turn monitoring system may be utilized. Monitoring equipment should be capable of resolving torque to 1/100th of a turn increments as a minimum but equipment capable of resolving torque to 1/1000th of a turn should be utilized when available. An enhanced computer display should be part of the torque-turn monitoring equipment and should be utilized to monitor make-up. The load cells used with the torque monitoring equipment should be calibrated every four (4) months, traceable to the appropriate national standard.
 - 5.6.2 If the optional torque/turn monitoring equipment is used, a make-up torque/turn graph should be generated for every connection.

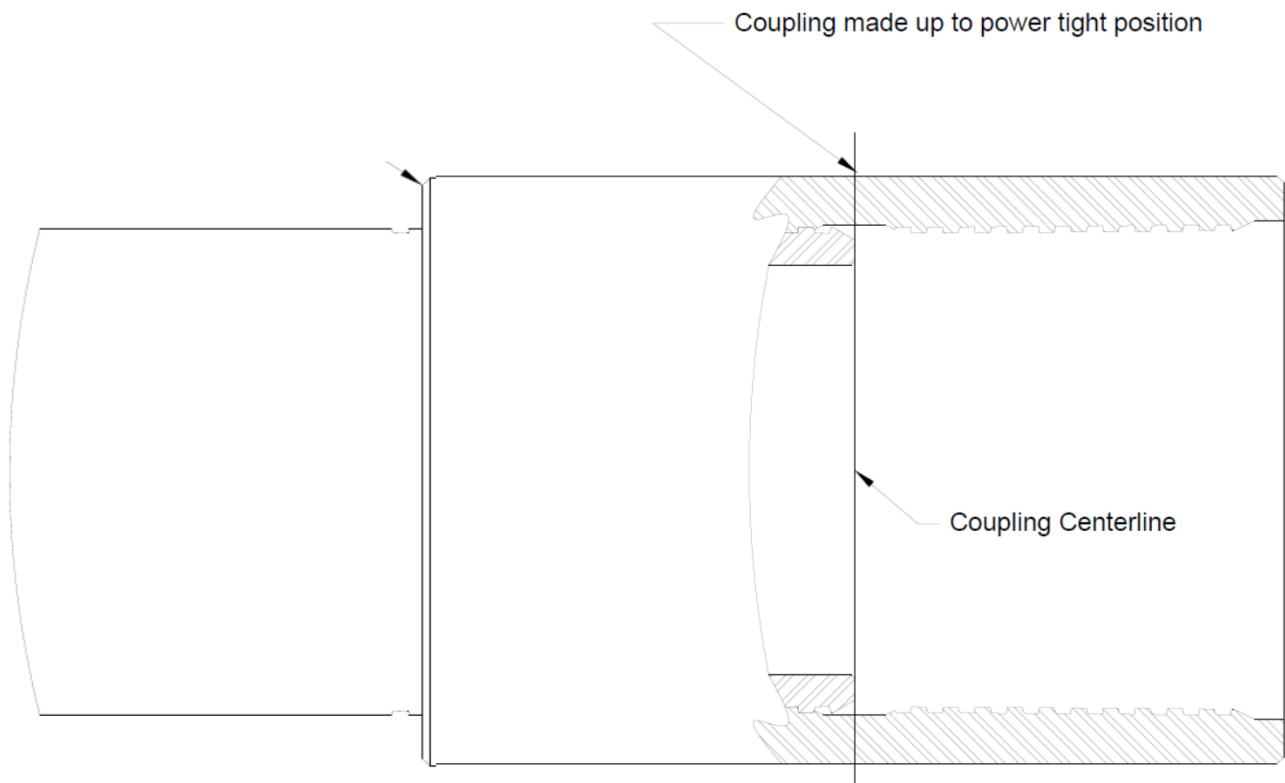
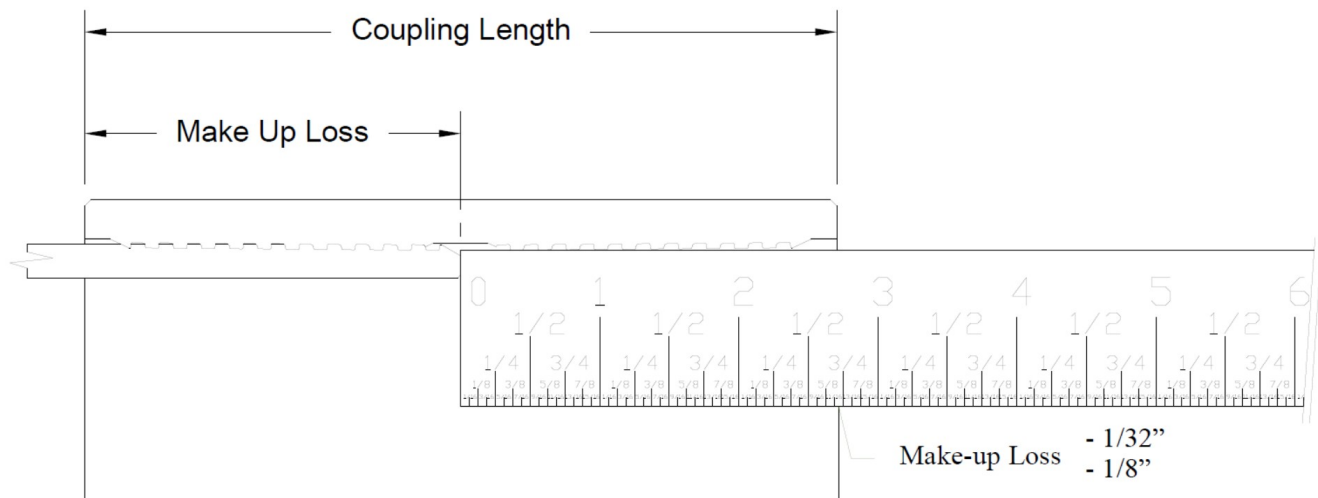


Figure C



NOTE: The TEC-LOCK BTC connection is a position make-up connection, and the pin connector on the mill end shall be located in the middle of the coupling. The tolerance is: "Make-up Loss Length -1/32" - 1/8".

Figure D



**TEC-LOCK BTC
ANCILLARY
SPECIFICATION**

SECTION	V	
Prepared By	ED	09/13/18
Engineer	SJH	09/14/18
GM QA	GJR	09/13/18
REVISION	000	09/14/18

SUBJECT: COUPLING MAKE-UP

NOTE: If an appreciable amount of thread lubricant is being pushed to the tube ID and/or the tube OD during make-up, too much thread lubricant is being applied to the connection.

NOTE: The TEC-LOCK BTC connection is a position make-up connection. The internal torque shoulders on box accessories determines the correct make-up position on accessory connections.

6.0 MAKE-UP ACCEPTANCE AND REJECTION

- 6.1 For an acceptable make-up both position and torque requirements must be met.
 - 6.1.1 The criteria for proper make-up shall be as described in Section 5.5 of this document.
 - 6.1.2 The torque applied to the connection should meet the minimum published torque when the position requirements are met.
 - 6.1.3 Accessory connections must exhibit a positive shoulder; pin face to box shoulder engagement. The delta torque of the shouldered connection shall be a minimum of 10% of the actual shoulder torque. The maximum published torque may be exceeded on thick wall accessories but shall not exceed 80% of the published minimum yield torque.
- 6.2 Connections which do not meet the criteria of Paragraph 6.1 should be set aside and a Hunting representative contacted as soon as possible.
- 6.3 Following buck-up, the ovality or out-of-roundness shall be within the specified manufacturing tolerances for the product when measured on the open end of the coupling.
- 6.4 End drift the made-up connection in accordance with the Hunting "**Full Length Drift/End Drift Inspection Procedure**" (Generic).

7.0 REWORK

- 7.1 If the connection does not reach to the proper position during make-up, remove the coupling, clean and visually examine both pin and box for damage. If no damage is found remake up as directed in Section 5.0 and visually inspect.
- 7.2 Connections which will not meet the criteria of Section 6.0 should be set aside and a Hunting representative contacted.