



**SEAL-LOCK HT  
ANCILLARY  
SPECIFICATIONS**

SECTION	V	
Prepared By	GTF	05/15/08
Engineer	RJH	05/15/08
Dir Engr	DR	05/16/08
GM QA	GTF	05/15/08
<b>REVISION</b>	<b>002</b>	<b>05/13/08</b>

**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 **SEAL-LOCK HT** connections.

**2.0 DEFINITION**

2.1 Visual thread inspection shall be defined as those inspections that may be performed on Hunting's **SEAL-LOCK HT** proprietary connections without the use of proprietary thread element gages.

**3.0 PIN/FIELD END INSPECTION**

3.1 Pin Face

- 3.1.1. Visually inspect for the presence of a square pin face by placing a straight edge across the pin end and sighting between the straight edge and the end of the tube.
- 3.1.2. Visually inspect the pin face for surface irregularities. Minor dents or dings to the pin face are detrimental to the connection, however, most can be repaired by lightly filing to remove all protrusions.
- 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 for full form thread length. The full form thread length is measured from the thread start point axially along the thread crests. **SEAL-LOCK HT** connections are required to have a minimum of the following full form threads.

	<u>SIZE</u>	<u>MINIMUM FULL FORM THREADS</u>		<u>SIZE</u>	<u>MINIMUM FULL FORM THREADS</u>
8 Pitch	2 3/8"	4	5 Pitch	5"	7
	2 7/8"	5		5 1/2"	7
	3 1/2"	8		7"	8
	4"	8			
	4 1/2"	9			

**NOTE: Even though a portion of a thread has a black crest, it may conform to Hunting's requirement for a full form thread. This is determined by a thread height measurement with a proprietary thread height gage.**

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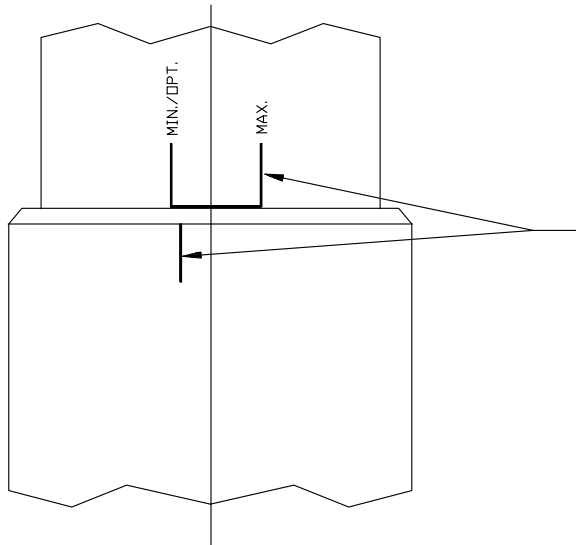
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**4.0 COUPLING/MILL END INSPECTION**

4.1 Mill Make-up

4.1.1 Visually inspect the powertight connection for indications of proper make-up.



**BARRETT MAKE-UP MARKS  
INDICATE PROPER MAKE-UP.**

**Reapply barrett make-up marks  
if the marks are faint.**

4.2 Internal Torque Shoulder - Mill End Pin Face

4.2.1 Visually inspect the internal torque shoulder i.e. the mill end pin face. It shall be free from protrusions due to corrosion pitting or impact damage and free from burrs for 360°. The mill end pin face should be positioned approximately half the length of the coupling groove width.

4.3 Threaded Area

4.3.1 Visually inspect the full form threaded area for damage. Small areas of impact damage or galls must be repaired. Field repairable thread damage shall not exceed 0.250" in circumferential length, span across more than two (2) full form threads, or be more than 0.005" in depth. All repaired areas should be covered with an anti-gall and anti-corrosion compound such as Moly-Kote.

4.3.2 Allowable corrosion pitting in the full form thread area shall be as defined in the Ancillary Specification titled **STEEL IMPERFECTIONS**.

4.4 Coupling Face

4.4.1 Visually inspect the coupling face and ID chamfer for impact damage. Impact damage that has caused the starting thread crest to be indented sufficiently to cause interference with the field pin connector thread root on make-up is cause for rejection.

**5.0 CONNECTION GAGING**

5.1 The gaging of Hunting's proprietary connections shall only be performed by an Hunting Quality Assurance or Service Representative or an approved Licensee. Hunting personnel or Licensee are the only persons that have availability to the proprietary gages to which the products are manufactured.



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- 6.0 THREAD/STORAGE COMPOUND**
- 6.1 Upon completion of visual thread inspection verify appropriate thread or storage compound is being applied to both ends of the tube. The approved thread/storage compound shall be as stated in the applicable "**FIELD RUNNING AND HANDLING PROCEDURE**".
- NOTE: Notify Hunting Northpoint, Houston, Texas, Quality Assurance Department immediately if thread/storage compound being applied is not listed in the applicable "FIELD RUNNING AND HANDLING PROCEDURE".**
- 7.0 REJECTION**
- 7.1 Any thread that does not meet the specified requirements, shall be considered a reject.
- 7.2 All rejects shall have the entire thread area painted red.
- 7.3 All rejects shall be clearly identified as "reject" to protect against out-of-tolerance material being shipped as prime material.
- 7.4 Rejection may be reworked by removing the defective condition and re-threading the parts within the appropriate tolerances.
- 7.5 Any discrepancies shall be clarified and dispositioned by Hunting's Q.A. Department before any further processing or delivery.