SECTION	V	
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HUNTING

CONNECTION TECHNOLOGY PRODUCT SPECIFICATION

SUBJECT: VISUAL THREAD INSPECTION

1.0 SCOPE

1.1 This document sets forth the broad guidelines for the field visual thread inspection of Hunting threaded and coupled proprietary connections.

1.2 This specification is applicable for the following proprietary connections: SL-APEX (all), SL-XD, SL-XP PC, SL-HC/GS, SL-HT (all) and SL-BOSS.

2.0 DEFINITION

2.1 Visual thread inspection shall be defined as those inspections that shall 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 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. For premium connections, care shall be taken to avoid damaging the seals when filing. Dents or dings on connections that are sufficiently deep to cause a raised area or protrusion on the seal surface are rejectable.

3.1.2 The pin face, ID chamfer and OD chamfer are to be smooth and free from burrs.

3.2 Seal Surface

3.2.1 Galls, burrs, dents, or dings on a seal surface is cause for rejection.

3.2.2 Repair of a seal surface by wire brushing, sanding, or filing is unacceptable. Evaluation methods of seal imperfections or defects can include polishing with 000 and 0000 steel wool, or medium or fine grit Scotch Brite. For additional details, please see **Hunting Ancillary Specification for Steel Imperfections**.

3.3 Threaded Area

3.3.1 Visually inspect for defects on threads. No burrs are allowed on the pins starting thread or thread pull-out area. Dents or dings on threads shall be removed using a metal file, sandpaper, emery cloth or Scotch Brite. For additional details, please see **Hunting Ancillary Specification for Steel Imperfections**.

NOTE 1: When a repair is made to any surface of the connection, molybdenum disulfide dry film lubricant spray shall be applied to the area where the work was performed. In the case that the connection is in the as-machined condition, the molybdenum disulfide spray shall be applied to the entire surface of the connection.

4.0 COUPLING/MILL END AND FIELD END INSPECTION

4.1 Mill Make-up

4.1.1 Visually inspect the power tight connection for indications of proper make-up. For internally shouldering connections, the pin face shall be in contact with the coupling torque shoulder. This may be checked by trying to pass a 0.005" feeler gage between the mill pin face and the ID torque shoulder. For SL-HT and SL-BOSS, the make up indicator lines must be properly aligned for the connection to function as designed.

4.1.2 Visually inspect the made-up pin ID on internally shouldered connections. It should show no signs of the seal buckling to the tube ID or torque shoulder rollover due to an over-torque condition during mill make-up.

4.2 Internal Torque Shoulder

4.2.1 Visually inspect the internal torque shoulder. The torque shoulder height should be approximately the same height around the circumference. It shall be free from protrusions due to corrosion pitting or impact damage and free from burrs around the circumference.

4.2.2 Verify that the internal torque shoulder and seal surface on the field side of the coupling has not been damaged by the drift inspection.

4.3 Seal Surface

4.3.1 Visually inspect the thread-to-seal radius and the seal surface. The radius shall present a smooth, burr free transition from the thread relief groove to the seal surface. Galls, burrs, dents, or dings (hydrotest or drift created defects) on couplings or box connectors are rejectable. Evaluation methods of seal imperfections or defects can include polishing with 000 and 0000 steel wool, or medium or fine grit Scotch Brite. For additional details, please see **Hunting Ancillary Specification for Steel Imperfections**.

4.4 Threaded Area

4.4.1 Visually inspect for defects on threads. No burrs are allowed on the pins starting thread or thread pull-out area. Dents or dings on threads shall be removed using a metal file, sandpaper, emery cloth or Scotch Brite. For additional details, please see **Hunting Ancillary Specification for Steel Imperfections**.

4.5 Coupling Face

4.5.1 Visually inspect the coupling face and OD chamfer for impact damage. Impact damage that has caused the starting thread crest to be indented sufficiently to cause interference with the pin connector thread root on make-up is cause for rejection. Minor impact damage may be repaired by lightly filing away all protrusions.

5.0 THREAD/STORAGE COMPOUND

5.1 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.**

5.2 Notify Hunting Connection Technology Quality Assurance (HCTQA) immediately if thread/storage compound being applied is not listed in the applicable documentation or on the Hunting Connection Technology website.

SUBJECT: VISUAL THREAD INSPECTION

6.0 REJECTION

6.1 Any thread that does not meet the specified requirements shall be considered a reject.

6.2 All rejects shall have the entire thread area painted red.

6.3 All rejects shall be clearly identified as “reject” to protect against out-of-tolerance material being used as prime material.

6.4 Rejection may be reworked by removing the defective condition and re-threading the parts within the appropriate tolerances.

6.5 Any discrepancies shall be clarified and dispositioned by HCTQA before any further processing or delivery.