



CONNECTION  
TECHNOLOGY  
PRODUCT  
SPECIFICATION

SECTION	II	
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**SUBJECT: VISUAL THREAD INSPECTION**

**1.0 SCOPE**

1.1. This document sets forth the broad guidelines for the field visual inspection of Hunting Connection Technology (HCT) **TEC-LOCK FJ** connection by independent inspection agencies.

**2.0 DEFINITION**

2.1. Visual thread inspection shall be defined as those inspections that may be performed on HCT proprietary connections without the use of proprietary thread gages.

**3.0 PIN/FIELD END INSPECTION**

3.1. Pin Face

3.1.1. Place a straight edge across the pin face. Sight between the pin fac and the straight edge to determine that the pin face has either been cut at a negative angle or is square depending upon the connector being inspected. Ensure that the pin nose radius, if applicable, 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 detrimental to the connection; however, most can be repaired by lightly filing to remove all protrusions. Dents or dings on new connections that are sufficiently deep to cause a raised area or protrusion on the seal surface are rejectable. The repair of such conditions during the running of the connection is at the discretion of HCT service representative.

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

3.2. Threaded Area

3.2.1. Visually inspect for full form threads. The full form thread is inspected from the thread start point axially along the thread crests to the relief groove.

3.2.2. Field repairable thread damage on new connectors shall not exceed ¼ revolution in circumferential length or 0.010” in depth. All repaired areas shall be covered with a dry film lubricant such as molybdenum disulfide.

3.3. External Shoulder

3.3.1. Visually inspect the external shoulder. The shoulder shall be free of protrusions due to corrosion pitting or impact damage and free from burrs for 360°.

**4.0 BOX END INSPECTION**

4.1. Internal Shoulder

4.1.1. Visually inspect the internal shoulder. The shoulder shall be free from protrusions due to corrosion pitting or impact damage and free from burrs for 360°.

4.2. Threaded Area

4.2.1. Visually inspect the full formed threaded area for damage. Small areas of impact damage or galls occurring during hydrostatic test must be repaired. Field repairable thread damage on new connectors shall not exceed ¼ revolution in circumferential length or 0.010” in depth. All repaired areas shall be covered with a dry film lubricant such as molybdenum disulfide.

4.2.2. Allowable corrosion pitting in the full form thread area shall be as defined in the **DEFINITION OF TERMS** under Minor Pitting.



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- 4.3. Box Face
  - 4.3.1. Visually inspect the box 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.

**5.0 CONNECTION GAGING**

- 5.1. The gaging of HCT proprietary connections shall only be performed by an HCT Quality Assurance or Service Representative or an approved Licensee. Hunting personnel or Licensee are the only entity which have access to the proprietary gages for which the products are manufactured.

**6.0 THREAD/STORAGE COMPOUND**

- 6.1. Upon completion of the visual 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 1: Notify HCT Quality Assurance 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 threaded area painted red.
- 7.3. All rejects shall be clearly identified as “REJECT” to protect against out of tolerance material being shipped as prime.
- 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 HCT Quality Assurance before any further processing or delivery.