

Field Inspection and Repairing Procedure of MO-3TP

Rev. 0: Document issued for new connection.

1. Pipes should be placed on the inspection table to provide enough space so that they can be rotated in a full turn for cleaning and inspection.
2. Pin and Box protectors shall be removed, and each end shall be cleaned thoroughly to remove storage compound and dirt.
 - 2.1 Remove protectors. Should a pipe wrench be used, care must be exercised to ensure that jaws of the wrench do not come in contact with thread.
 - 2.2 Blow out pipe ID (from Box to Pin) to completely remove dirt and rust.
 - 2.3 Clean connections using one of the following methods:
 - a) A nonmetallic brush and cleaning solvent
 - b) Steam cleaner with water and cleaning solvent
 - c) A rotary non-metallic bristle brush with water jet and cleaning solvents
 - 2.4 Dry the connections and wipe or blow out solvents and water from thread roots.
 - 2.5 Clean thread protectors, replace any damaged ones.
3. Thread inspection
 - 3.1 Imperfection in the full crest thread length on Pin

Full crest threads shall be free from burrs, tears, cuts, shoulders, dings, galling or any other imperfection which could break the continuity of the thread.

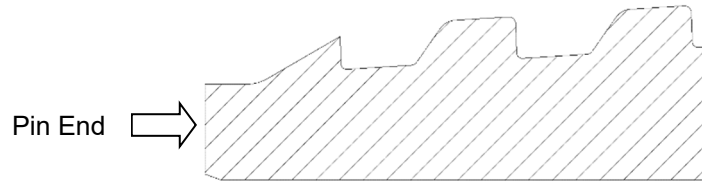
Burrs on the starting thread of pin shall be removed by using a fine file or emery cloth.

Minor scratch, discoloration and minor corrosion pits and step are acceptable provided the surface does not protrude from the original contour of the crest or flanks. Thread found to have such slight imperfection or discoloration may be hand repaired using a fine file or emery cloth.
 - 3.2 Imperfections on the imperfect threads on Pin are acceptable unless it protrudes on the flanks. Minor protrusion on the crest is acceptable.
 - 3.3 Defects on the box thread shall be rejected due to difficulty of hand repairing. Coupling may be replaced.
 - 3.4 Mash on pin or box (No mash is allowed on pin or box.)
 - 3.5 Used tubing - galling or wear
 - a) Check distortion of threads with thread profile gauge (New thread insert).
 - b) Minor galling may be hand repaired with fine file or emery cloth.

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4. Visual Inspection of Pin end

- 4.1 Pin end shall be visually examined. Pin end plays a role not only in torque stop shoulder, but also in metal seal function.
- 4.2 Pin end shall be free from any imperfection and damage which is protruding from original surface contour.
- 4.3 No burrs allowed on entire circumference.



5. Before placing thread protectors back on the pipe ends after visual inspection, remove all dirt and foreign particles from protectors.

All damaged protectors shall be replaced. Threads shall be re-doped with a suitable thread compound.

Ensure that the entire threads are covered with compound.

6. Connection found to be unserviceable should be clearly identified.

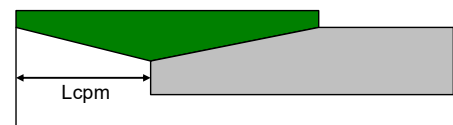
In case that the coupling shows damage beyond repair, the coupling may be removed, and new coupling should be installed.

7. Lcpm length inspection

When Lcpm length inspection is necessary, field inspection range as per the following shall be applied.

Table-1 Field inspection range of Lcpm length

OD	Lcpm (inch)		
	Lcpm 0 (Aiming)	Lcpm 1 (Min.)	Lcpm 2 (Max.)
16" x 65.0# ~ 75.0#	4.274"	4.230"	4.318"
16" x 84.0# ~ 109.0# 18-5/8" to 20"	4.773"	4.730"	4.817"



*The following is recommended for the Lcpm length inspection:

- (1) An assembled coupling at field end and an assembled pin end face at mill end shall be cleaned completely to get stable Lcpm length.
- (2) When thread compound or storage compound is not cleaned out, reading of the Lcpm length may not be correct.

(3) A depth gauge shall be used with an extension arm across coupling end face.

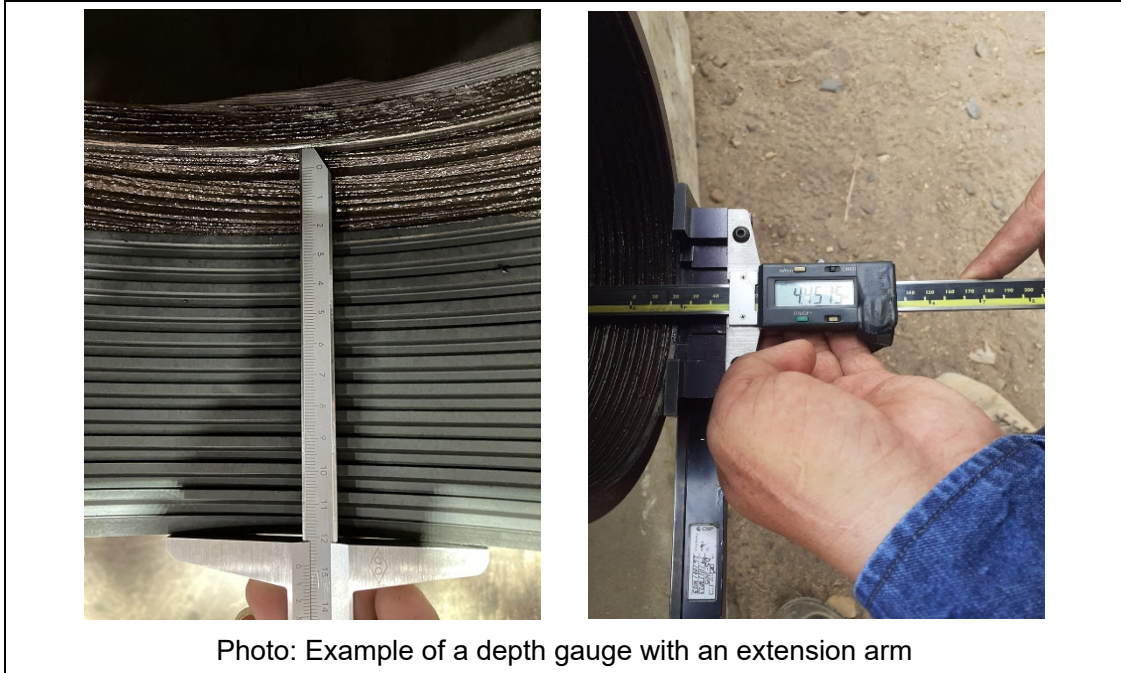


Photo: Example of a depth gauge with an extension arm