

Field Inspection Recommended Procedure of NK-DSTJ Tool Joint

1. Field Inspection of the NKK DSTJ High Rotary Connection
 - a) DSTJ is modified API Connection and interchangeable with the same API connection.
 - See Appendix 1.
 - b) The inspection of the DSTJ connection except the items described in this procedure shall be carried out in accordance with API RP7G by experienced inspectors.
- 1.1. Box connection
 - Visual /Dimensional Inspection
 - See Appendix 2.

NK-DSTJ BOX



<u>Box-External Seal Shoulder</u>	: Sealing Shoulder and Torque Stop Shoulder
<u>Box-Internal Seal Shoulder</u>	: Torque Stop Shoulder

- a) The thread elements, B-ESS, bore-back and the B-ISS must be thoroughly cleaned with a rotary power wire brush in order to remove dope, dirt, rust, mud, etc. to enable a good visual inspection of all above mentioned areas.
- b) The thread profile must be checked with the appropriate API profile gauge.
- c) Check boxes for widening (swelling)
 - See API RP7G Para.13.3.2
- d) The B-ISS is not a sealing shoulder. Light corrosion or indentations without protrusion are acceptable.
- e) The depth of the box shoulder should be measured using depth micrometer.
 - See Appendix 3.
 - Measured data should be recorded.
- f) Field re-facing of the B-ESS and B-ISS is not be permitted.
 - B-ESS and B-ISS with damages within the re-facing limits shall be identified with a green band around the box OD to be refaced in a NK- DSTJ licensed machine shop.

Nk Dstj Connections

M Walker



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