

ISO 10424-2:2007-11 (E)

Petroleum and natural gas industries - Rotary drilling equipment - Part 2: Threading and gauging of rotary shouldered thread connections

Contents	Page
Foreword	v
Introduction	vi
1 Scope	1
2 Conformance -- Units of measurement	1
3 Normative references	2
4 Terms, abbreviated terms, definitions and symbols	2
4.1 Terms and definitions	2
4.2 Design types and definitions	4
4.3 Abbreviations and symbols	6
5 Information to be supplied by purchaser	8
6 Threading	8
6.1 Thread profile and dimensions	8
6.2 Bevels for drill collars and tools that mate directly with drill collars	15
6.3 Low-torque feature	16
7 Product optional features	18
7.1 General	18
7.2 Stress-relief features	18
7.3 Benchmarks	21
7.4 Surface treatment	23
7.5 Cold working	23
7.6 Break-in	23
8 Product gauging	23
8.1 Gauging	23
8.2 Stand-off measurement	24
8.3 Gauge contact points	24
8.4 Lead measurement	25
8.5 Taper measurement	27
8.6 Thread height measurement and gauges	27
9 Gauge relationships for rotary shouldered connections	27
9.1 Gauge relationship	27
9.2 Gauge specifications	28
10 Gauge calibration	40
10.1 Calibration system	40
10.2 Acceptance criteria	40
10.3 Gauge measurement methods	40
10.4 Gauge certification	46
Annex A (informative) Tables in USC units	47
Annex B (informative) Care and use of regional master gauges	56

Annex C (normative) Shipment of reference master gauges	58
Annex D (normative) Care and use of working gauges	60
Annex E (informative) API gauge certification requirements	61
Annex F (informative) Other rotary shouldered connections	64
Annex G (informative) USC units conversion table	85
Annex H (informative) Recommended practice for gauging new rotary shouldered connections	86
Annex I (informative) Calculations	92
Annex J (informative) API grand and regional master rotary connection gauges	96