

5.1.4 Shoulder Contact Face

Shoulder contact faces of rotary shouldered connections shall be plane, and square with the thread axis, within 0.05 mm (0.002 in.). The surface finish of the contact face, before any surface treatment, shall be $5\text{ }\mu\text{m}$ (125 $\mu\text{in.}$) R_a or better, so as to assure a reliable sealing surface.

5.1.5 Standoff

Rotary shouldered connections shall be produced with standoff tolerances as specified in 7.2.

5.1.6 Lead Tolerance

The lead tolerance of rotary shouldered connections shall be as follows:

- $\pm 0.038\text{ mm}$ per 25.4 mm (0.0015 in. per in.) for any 25.4 mm (1.0 in.) between first and last full depth threads; and
- $\pm 0.114\text{ mm}$ (0.0045 in.) between first and last full depth threads, or the sum of 0.0254 mm (0.001 in.) for each 25.4 mm (1 in.) between first and last full depth threads, whichever is greater.

The method for determining lead is described in 7.4.

5.1.7 Taper Tolerance

The taper tolerance of rotary shouldered connections shall be as follows:

- pin thread: $+0.0025\text{ mm/mm}$ to 0 mm/mm ($+0.030\text{ in./ft}$ to 0 in./ft) average taper between first and last full depth threads; and
- box thread: 0 mm/mm to -0.0025 mm/mm (0 in./ft to -0.030 in./ft) average taper between first and last full depth threads.

The method for determining taper is described in 7.5.

5.1.8 Box Counterbore

The box counterbore shall have the diameter, D_{CB} , specified in Table B.1, and taper, T , as shown in the detail of Figure 3. The depth of the counterbore shall be L_{OC} as specified in Table B.1. The angle of the bevel at the intersection of the counterbore and the first threads is optional to the manufacturer but is typically 25° to 45° .

5.1.9 Thread Form

The thread form shall be as defined in Table B.2 and shown in Figures 4 and 5. The surface finish of the thread flanks and root before any surface treatment shall be $2.5\text{ }\mu\text{m}$ (63 $\mu\text{in.}$) R_a or better in order to maximize the fatigue life of the connection. This may be demonstrated using a sacrificial test piece on a process qualification basis.

The design intent for root radius, R , in Figure 4 is a tolerance of $\pm 0.025\text{ mm}$ ($\pm 0.001\text{ in.}$); this is not an auditable dimension but it is indirectly verified through the truncated thread height.

5.2 Bevels for Drill Collars and Tools that Mate Directly with Drill Collars

5.2.1 General

All connections shall have bevels on the outside surface with diameters detailed below. The bevel design is based on an angle of 45° .

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